



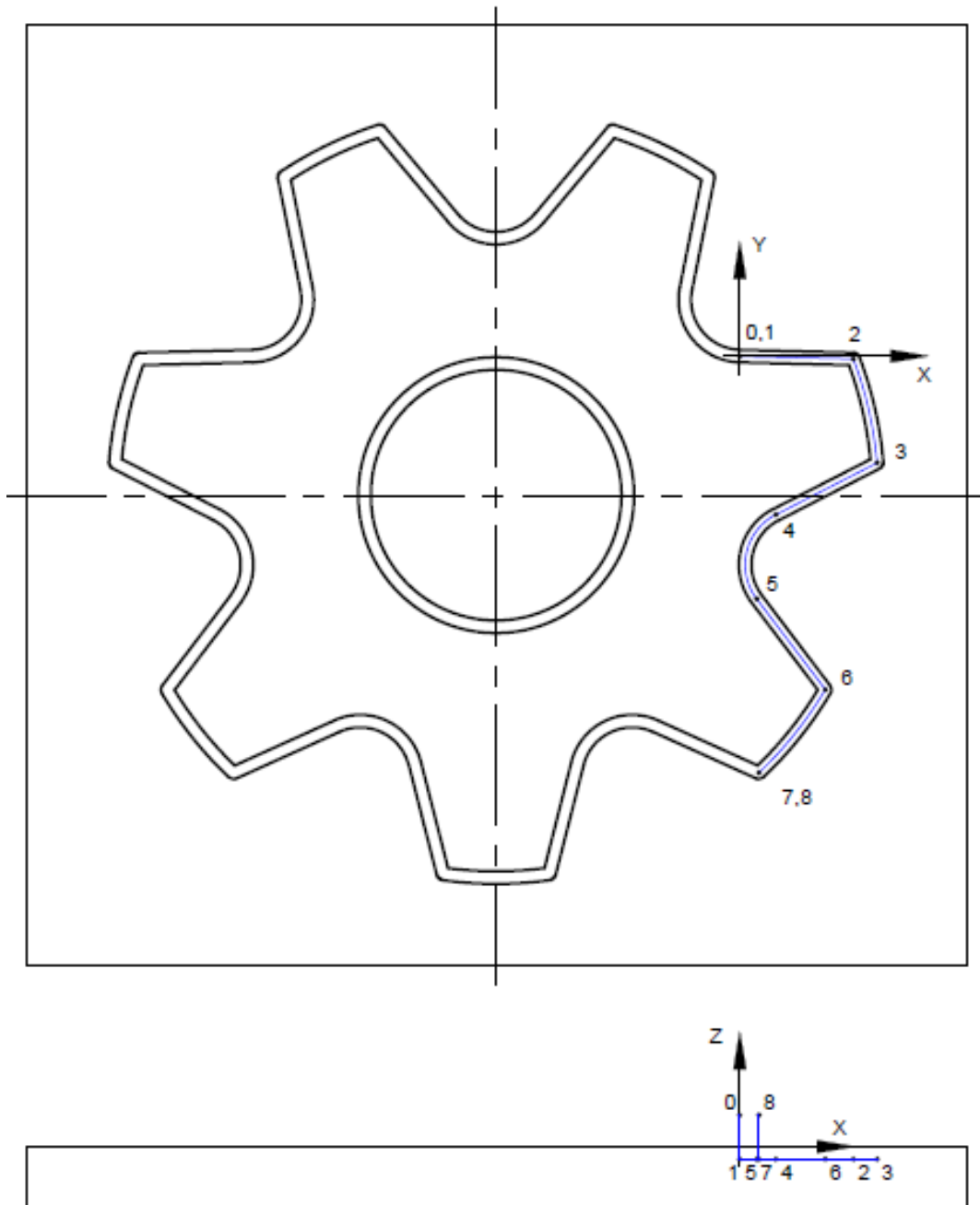
Field of education:
Mechanical engineering

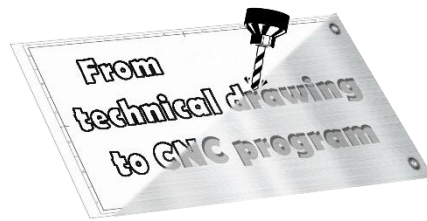
Professional qualification:
CNC operator

Exercise:
**Programming of CNC machine
(solution)**

Variant:
Task 45 – Sprocket 2.3.

Solution:





Required written code that should be inserted into the control unit:

G1 Z-2

X18,133 Y-0,452

G2 X21,914 Y-17,019 R61

G1 X5,773 Y-25,294

G3 X2,705 Y-38,738 R9

G1 X13,657 Y-53,196

G2 X3,062 Y-66,482 R61

G1 Z5

M30

Explanation of the G-code:

%Setting the coordinate system x=0, y=0, z=5; point 0

G1 Z-2 %Tool entry into material; point 1

X18,133 Y-0,452 %Straight milling; point 2

G2 X21,914 Y-17,019 R61 %Radial milling; point 3

G1 X5,773 Y-25,294 %Straight milling; point 4

G3 X2,705 Y-38,738 R9 %Radial milling; point 5

G1 X13,657 Y-53,196 %Straight milling; point 6

G2 X3,062 Y-66,482 R61 %Radial milling; point 7

G1 Z5 %Lifting of tool; point 8

M30 %End of program