

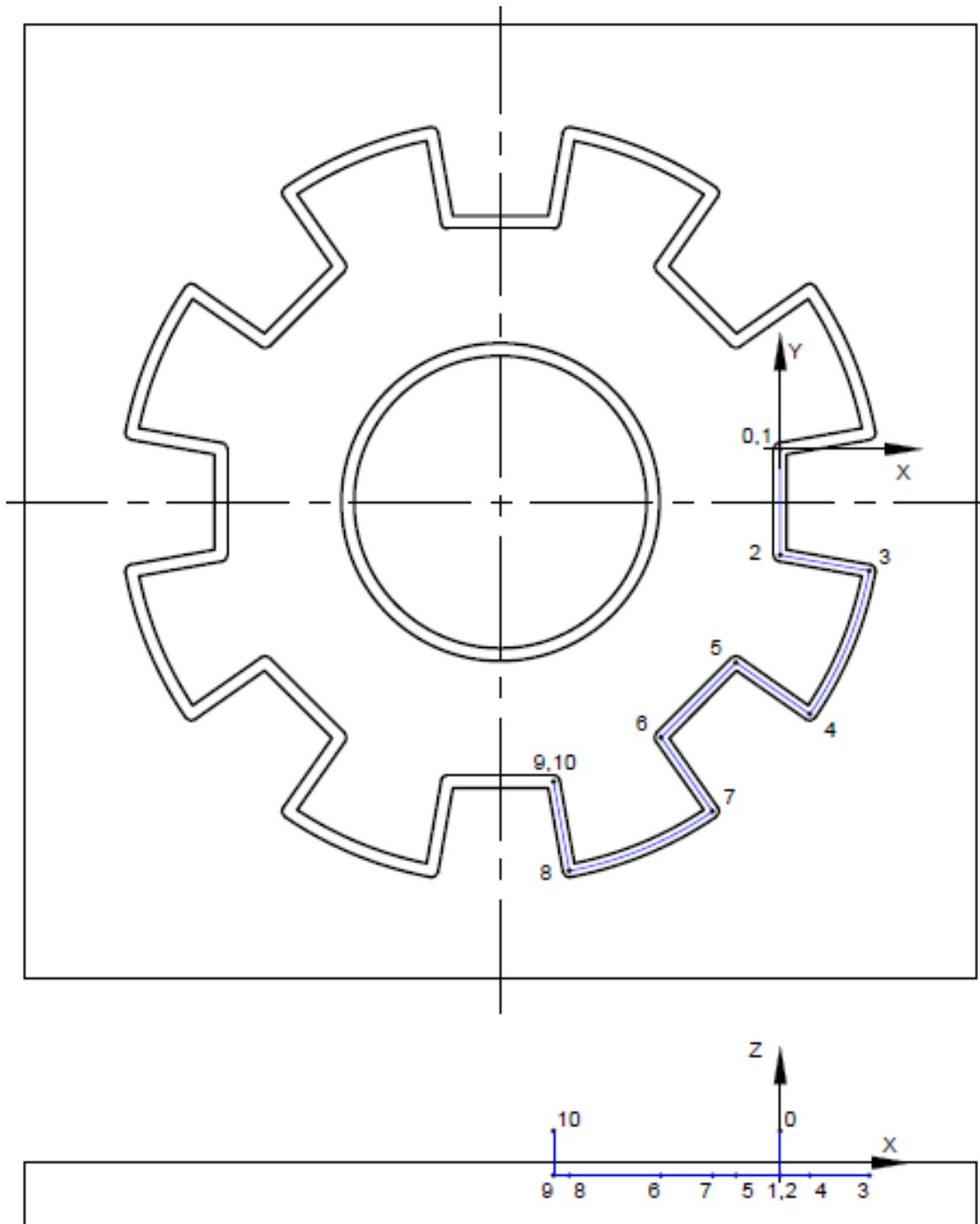
Field of education:
Mechanical engineering

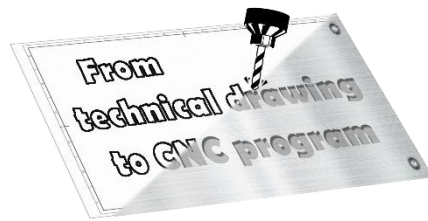
Professional qualification:
CNC operator

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

Variant:
Task 56 – Sprocket 4.3.

Solution:





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

G1 Z-2

Y-16,678

X14,002 Y-19,147

G2 X4,656 Y-41,71 R59

G1 X-6,991 Y-33,555

X-18,784 Y-45,348

X-10,629 Y-56,995

G2 X-33,192 Y-66,341 R59

G1 X-35,661 Y-52,339

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

Y-16,678 %Straight milling; point 2

X14,002 Y-19,147 %Straight milling; point 3

G2 X4,656 Y-41,71 R59 %Radial milling; point 4

G1 X-6,991 Y-33,555 %Straight milling; point 5

X-18,784 Y-45,348 %Straight milling; point 6

X-10,629 Y-56,995 %Straight milling; point 7

G2 X-33,192 Y-66,341 R59 %Radial milling; point 8

G1 X-35,661 Y-52,339 %Straight milling; point 9

Z5 %Lifting of tool; point 10

M30 %End of program