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O7777 (38619-0000 7/12/2017)

(T1 PROGRAM FOR TSUGAMI\_BO38T POST PROCESSOR VERSION 18.0)

#531=0.5 (STOCK OD)

M27777 (CALL T2 PROGRAM)

M37777 (CALL T3 PROGRAM)

M91 (SAFE CUT OFF)

(SAFTEY CODES)

G0 G18 G40 G99 G80 T0

M51 (C-AXIS MODE OFF)

G50 S2000

(COLLET RECHUCK)

M11 (MAIN OPEN)

G300 X-0.04 Z3.872 T0404

G150 Z0.

M10 (MAIN CLOSE)

G0 Z-.05

G0 X4.252 T0

(END RECHUCK PROCESS)

M500 P7 (WAIT FOR H2 AND H3)

N1 (FRONT FACE OFF )

T0606 (OD TURN 80-RIGHT )

M8 (STANDARD COOLANT ON)

G97 S760 M3

G99 G0 Z0.

X0.502

G96 S100

G42 G1 X0.462 F0.001

X0.

G40 X-0.04

M9 (STANDARD COOLANT OFF)

G0 X4.252 T0

M1

M502 P5 (WAIT FOR H3)

T0100 (CLEAR GANG FOR TURRET)

V-.800

M504 P5 (WAIT FOR H3)

M765 (Z1-Z3 CONTROL ON)

N7 (DRILL\_0.2502 ON H3)

M764 (Z1-Z3 CONTROL OFF)

M506 P5 (WAIT FOR H3)

N2 (FRONT TURN 1 )

T0606 (OD TURN 80-RIGHT )

M8 (STANDARD COOLANT ON)

G97 S879 M3

G99 G0 Z0.012

X0.43

G96 S100

G1 Z0.032 F0.001

Z0.752

Z0.772

M9 (STANDARD COOLANT OFF)

G0 X4.252 T0

M1

M508 P5 (WAIT FOR H3)

T0100 (CLEAR GANG FOR TURRET)

V-.800

M510 P5 (WAIT FOR H3)

M765 (Z1-Z3 CONTROL ON)

N4 (THREAD 1 ON H3)

M764 (Z1-Z3 CONTROL OFF)

M512 P5 (WAIT FOR H3)

N3 (FRONT TURN 2 )

T0606 (OD TURN 80-RIGHT )

M8 (STANDARD COOLANT ON)

G97 S879 M3

G99 G0 Z0.732

X0.43

G96 S100

G1 Z0.752 F0.001

Z1.4382

X0.4608 Z1.4536

X0.4891 Z1.4677

M9 (STANDARD COOLANT OFF)

G0 X4.252 T0

M1

M514 P5 (WAIT FOR H3)

T0100 (CLEAR GANG FOR TURRET)

V-.800

M516 P5 (WAIT FOR H3)

M765 (Z1-Z3 CONTROL ON)

N5 (THREAD 2 ON H3)

M764 (Z1-Z3 CONTROL OFF)

M518 P5 (WAIT FOR H3)

N6 (FRONT TURN 3 )

T0606 (OD TURN 80-RIGHT )

M8 (STANDARD COOLANT ON)

G97 S819 M3

G99 G0 Z1.435

X0.462

G96 S100

G1 Z1.455 F0.001

Z2.9323

X0.4607 Z2.9921

G2 Z2.9923 R0.002

G1 X0.3986 Z3.2874

X0.3777 Z3.3868

M9 (STANDARD COOLANT OFF)

G0 X4.252 T0

M5

M1

M520 P5 (WAIT FOR H3)

M50 (C-AXIS ON)

G28 H0

N10 (MILL CYLINDER SLOT )

M765 (Z1-Z3 CONTROL ON)

N10 (SLOT ON H3)

T0100 (CLEAR GANG FOR TURRET)

V-.800

M522 P5 (WAIT FOR H3)

M764 (Z1-Z3 CONTROL OFF)

M51 (C-AXIS OFF)

M524 P7 (WAIT FOR H2 AND H3)

N9 (FRONT CUT OFF )

T0404 (BACK TURNING )

M8 (STANDARD COOLANT ON)

G97 S760 M3

G50 W-0.06

G0 G99 X0.502

G0 Z3.312

M56 (SPIN SYNC ON)

M53 (SPIN SYNC ARRIVE)

M58 (SPINDLE TORQUE DOWN)

(SUPPORT PART)

M526 P7 (WAIT FOR H2 AND H3)

M705 P3 Q1 (Z1-Z2 SYNCH ON)

G96 S100

G1 X0.462 F0.01

X0.

X-0.04

M528 P7 (WAIT FOR H2 AND H3)

M704 P3(Z1-Z2 SYNC OFF)

M57 (SPIN SYNC OFF)

M59 (SPIN TORQUE NORMAL)

M530 P7 (WAIT FOR H2 AND H3)

(PARK SUB SPINDLE)

M532 P7 (WAIT FOR H2 AND H3)

M9 (STANDARD COOLANT OFF)

G50 Z0.06

M1

M534 P7 (WAIT FOR H2 AND H3)