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O7778 (38619-0000 7/12/2017)

(T2 PROGRAM FOR TSUGAMI\_BO38T POST PROCESSOR VERSION 18.0)

(SAFTEY CODES)

G0 G18 G40 G99 G80 T0

M151 (C-AXIS MODE OFF)

G50 S2000

(COLLET RECHUCK)

G28 W0

G310 X0 Z12.7953 T4000

G150 Z1.312

(END RECHUCK PROCESS)

M500 P7 (WAIT FOR H1 AND H3)

M524 P7 (WAIT FOR H1 AND H3)

(SUPPORT PART)

M526 P7 (WAIT FOR H1 AND H3)

G28 W0

T4000 M104 S2500 M21 (SUB OPEN)

G0 Z3.1927 (.05 FROM FACE)

G98 G1 Z1.1427 F50.0

G99 M20 (SUB CLOSE)

M705 P3 Q1 (Z1-Z2 SYNCH ON)

M528 P7 (WAIT FOR H1 AND H3)

M704 P3(Z1-Z2 SYNC OFF)

(WAIT FOR PHASE SYNC ON HEAD 1)

M530 P7 (WAIT FOR H1 AND H3)

G0 G28 W0 M105

M532 P7 (WAIT FOR H1 AND H3)

M534 P7 (WAIT FOR H1 AND H3)

N11 (SUB SPINDLE DRILL DRILL\_0.2376)

T4343 (SPOT DRILL\_0.375:2 )

G97 S1017 M103

M8 (STANDARD COOLANT ON)

G99 G0 Z0.05

X0.

G83 Z-0.125 P1000 F0.01

G80

G0 Z0.05

M9 (STANDARD COOLANT OFF)

G153 Z12.7953

M1

N12 (SUB SPINDLE DRILL DRILL\_0.2376)

T4747 (DRILL 0.250 )

G97 S1526 M103

M8 (STANDARD COOLANT ON)

G99 G0 Z0.05

X0.

G83 Z-0.5 F0.01

G80

G0 Z0.05

M9 (STANDARD COOLANT OFF)

G153 Z12.7953

M1

N100 (PART EJECTION)

G153 Z12.7953 T0

G0 X0. M17 (WORK CATCHER ADVANCE)

Z0.

M21 (SUB OPEN)

M37 (EJECTOR PIN ADVANCE)

M38 (EJECTOR PIN RETRACT)

G4 U0.5

G0 Z12.7953

M18

M19

(CHUCK CLEANING)

/M160 (SUB SPINDLE HPC ON)

M103 S200

G04 U.75

M161 (SUB SPINDLE HPC OFF)

M105

M1