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O7779 (38619-0000 7/12/2017)

(T3 PROGRAM FOR TSUGAMI\_BO38T POST PROCESSOR VERSION 18.0)

(SAFTEY CODES)

G0 G18 G40 G99 G80 T0

(COLLET RECHUCK)

G320 X14.1732 T2100

M500 P7 (WAIT FOR H1 AND H2)

M502 P5 (WAIT FOR H1)

N7 (FRONT DRILL\_0.2502)

M504 P5 (WAIT FOR H1)

M765 (Z1-Z3 CONTROL ON)

T2122 (SPOT DRILL\_0.2502 )

M8 (STANDARD COOLANT ON)

G97 S1525 M3

G99 G0 Y0 Z-0.05

X0.

G83 Z0.125 P1000 F0.01

G80

G0 Z-0.05

M9 (STANDARD COOLANT OFF)

G0 X14.1732 T0

M1

N8 (FRONT DRILL\_0.2502)

T2727 (DRILL\_0.250 )

M8 (STANDARD COOLANT ON)

G97 S1525 M3

G99 G0 Y0 Z-0.05

X0.

G83 Z3.125 Q0125 F0.01

G80

G0 Z-0.05

M764 (Z1-Z3 CONTROL OFF)

M9 (STANDARD COOLANT OFF)

G0 X14.1732 T0

M1

M506 P5 (WAIT FOR H1)

M508 P5 (WAIT FOR H1)

N4 (FRONT THREAD 1)

M510 P5 (WAIT FOR H1)

M765 (Z1-Z3 CONTROL ON)

T2222 (THREADING:1 )

M8 (STANDARD COOLANT ON)

G97 S978 M3

G50 W-0.025

G99 G0 Y0 Z-0.02

X0.53

G76 P010160 Q0005 R0

G76 X0.3687 Z0.75 P0307 Q0200 F0.05

M764 (Z1-Z3 CONTROL OFF)

M9 (STANDARD COOLANT OFF)

G50 Z0.025

G0 X14.1732 T0

M1

M512 P5 (WAIT FOR H1)

M514 P5 (WAIT FOR H1)

N5 (FRONT THREAD 2)

M516 P5 (WAIT FOR H1)

M765 (Z1-Z3 CONTROL ON)

T2222 (THREADING:1 )

M8 (STANDARD COOLANT ON)

G97 S978 M3

G50 W-0.025

G99 G0 Y0 Z0.7

X0.53

G76 P010160 Q0005 R0

G76 X0.3687 Z1.1875 P0307 Q0200 F0.05

M764 (Z1-Z3 CONTROL OFF)

M9 (STANDARD COOLANT OFF)

G50 Z0.025

G0 X14.1732 T0

M1

M518 P5 (WAIT FOR H1)

M520 P5 (WAIT FOR H1)

N10 (MILL CYLINDER SLOT )

M765 (Z1-Z3 CONTROL ON)

T2302 (END MILL\_0.1875 )

M522 P5 (WAIT FOR H1)

M223 S1000 A1.0

M8 (STANDARD COOLANT ON)

G50 W-0.5

G98 G0 X0.562Y0.0Z-0.281 C0.0

G1 G18 W0 H0

G07.1 C0.231 (CYL ON)

G1 C-184.083 F50.0

X0.562

X0.2745 Z1.5421 F5.0

G41 Z2.9292 C-194.0416 F10.0

C-212.1123

Z2.9277 C-223.0549

C-239.9309

Z1.5651 C-224.2482

C-206.1789

G40 Z1.5665 C-195.8169

G18

X0.562 F50.0

Z1.5421 C-184.083

X0.3745

X0.2502 F5.0

G41 Z2.9292 C-194.0416 F10.0

C-212.1123

Z2.9277 C-223.0549

C-239.9309

Z1.5651 C-224.2482

C-206.1789

G40 Z1.5665 C-195.8169

G18

X0.562 F50.0

G07.1 C0 (CYL OFF)

M764 (Z1-Z3 CONTROL OFF)

M9 (STANDARD COOLANT OFF)

G50 Z0.5

G0 X14.1732 M225 T0

M1

M524 P7 (WAIT FOR H1 AND H2)

(SUPPORT PART)

T2200

G0 X14.1732 (TURRET SAFE POS)

M526 P7 (WAIT FOR H1 AND H2)

M528 P7 (WAIT FOR H1 AND H2)

M530 P7 (WAIT FOR H1 AND H2)

(PARK SUB SPINDLE)

M532 P7 (WAIT FOR H1 AND H2)

M534 P7 (WAIT FOR H1 AND H2)