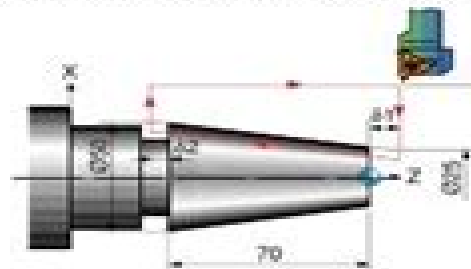


Example 1) STRAIGHT lead

G32 X(w) Z(w) F : Because it is taper, it is applied to both axis at the same time.



Lead of screw : 3mm

Δ1 : 5mm

Δ2 : 1.5mm

Depth of cut : 1mm(2cut two times)

(ABSOLUTE)

G50 S800 T0100 :

G97 S800 M03 :

G00 X90.0 Z5.0 T0101 :

X22.026 :

G32 X49.562 Z-71.5 F3.0 :

G00 X90.0 :

Z5.0 :

X21.052 :

G32 X48.588 Z-71.5 :

G00 X90.0 :

Z5.0 :

X150.0 Z150.0 T0100 :

M30 :

(INCREMENTAL)

G50 S800 T0100 :

G97 S800 M03 :

G00 X90.0 Z5.0 T0101 :

U-67.974 :

G32 U27.321 W-76.5 F3.0 :

G00 U40.438 :

W76.5 :

U-68.948 :

G32 U27.321 W-76.5 :

G00 X90.0 :

W76.5 :

X150.0 Z150.0 T0100 :

M30 :

Reference)

Values of incomplete thread Δ1 and Δ2.

$$\Delta 1 = \frac{3.6 \times L \times n}{1800}$$

L = Lead of thread
n = Rotating time of main spindle

$$\Delta 2 = \frac{L \times n}{1800}$$

Fanuc Ot Maintenance Manual

Roman Wölfel



Fanuc Ot Maintenance Manual:

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