

| Block | Description | Purpose |
|-------------------------------|--|------------------|
| % | Start of program. | Start Program |
| 00001 (PROJECT1) | Program number (Program Name). | |
| (T1 0.25 END MILL | Tool description for operator. | |
| N1 G17 G20 G40 G49 G80 G90 | Safety block to ensure machine is in safe mode. | |
| N2 T1 M6 | Load Tool #1. | Change Tool |
| N3 S9200 M3 | Spindle Speed 9200 RPM, On cW. | |
| N4 G54 | Use Fixture Offset #1. | Move To Position |
| N5 M8 | Coolant On. | |
| N6 G00 X-0.025 Y-0.275 | Rapid above part. | |
| N7 G43Z1. H1 | Rapid to safe plane, use Tool Length Offset #1. | |
| N8 Z0.1 | Rapid to feed plane. | |
| N9 G01 Z-0.1 F18. | Line move to cutting depth at 18 IPM. | Machine Contour |
| N10G41 Y0.1 D1 F36. | CDC Left, Lead in line, Dia. Offset #1, 36 IPM. | |
| N11 Y2.025 | Line move. | |
| N12 X2.025 | Line move. | |
| N13 Y-0.025 | Line move. | |
| N14 X-0.025 | Line move. | |
| N15 G40 X-0.4 | Turn CDC off with lead-out move. | |
| N16 G00 Z1. | Rapid to safe plane. | Change Tool |
| N17 M5 | Spindle Off. | |
| N18 M9 | Coolant Off. | |
| (T2 0.25 DRILL) | Tool description for operator. | |
| N19 T2 M6 | Load Tool #2. | Move To Position |
| N20 S3820 M3 | Spindle Speed 3820 RPM, On CW. | |
| N21 M8 | Coolant On. | |
| N22X1. Y1. | Rapid above hole. | Drill Hole |
| N23 G43 Zz1. H2 | Rapid to safe plane, use Tool Length Offset 2. | |
| N24 Z0.25 | Rapid to feed plane. | End Program |
| N25 G98 G81 Z-0.325 R0.1 F12. | Drill hole (canned) cycle, Depth z- 325, F12. | |
| N26 G80 | Cancel drill cycle. | |
| N27 Z1. | Rapid to safe plane. | |
| N28 M5 | Spindle Off. | End Program |
| N29 M9 | Coolant Off. | |
| N30 G91 G28 Z0 | Return to machine Home position in Z. | |
| N31 G91 G28 XOYO | Return to machine Home position in XY. | |
| N32 G90 | Reset to absolute positioning mode (for safety). | |
| N33 M30 | Reset program to beginning. | |
| % | End Program. | |

M G Code Tsugami Machine

RJ Shavelson



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