



NC Software
340 490-05
340 491-05
340 492-05
340 493-05
340 494-05



About this Manual

The symbols used in this manual are described below.



This symbol indicates that important notes about the function described must be adhered to.



This symbol indicates that there is one or more of the following risks when using the described function:

- Danger to workpiece
- Danger to fixtures
- Danger to tool
- Danger to machine
- Danger to operator



This symbol indicates that the described function must be adapted by the machine tool builder. The function described may therefore vary depending on the machine.



This symbol indicates that you can find detailed information about a function in another manual.

Do you desire any changes, or have you found any errors?

We are continuously striving to improve documentation for you. Please help us by sending your requests to the following e-mail address: **tnc-userdoc@heidenhain.de**.



TNC Model, Software and Features

This manual describes functions and features provided by TNCs as of the following NC software numbers.

TNC model	NC software number
iTNC 530	340 490-05
iTNC 530 E	340 491-05
iTNC 530	340 492-05
iTNC 530 E	340 493-05
iTNC 530 programming station	340 494-05

The suffix E indicates the export version of the TNC. The export version of the TNC has the following limitations:

- Simultaneous linear movement in up to 4 axes

The machine tool builder adapts the usable features of the TNC to his machine by setting machine parameters. Some of the functions described in this manual may therefore not be among the features provided by the TNC on your machine tool.

TNC functions that may not be available on your machine include:

- Tool measurement with the TT

Please contact your machine tool builder to become familiar with the features of your machine.

Many machine manufacturers, as well as HEIDENHAIN, offer programming courses for the TNCs. We recommend these courses as an effective way of improving your programming skill and sharing information and ideas with other TNC users.



User's Manual:

All TNC functions that have no connection with cycles are described in the User's Manual of the iTNC 530. Please contact HEIDENHAIN if you require a copy of this User's Manual.

Conversational Programming User's Manual,
ID: 670 387-xx.

DIN/ISO User's Manual, ID: 670 391-xx.



smarT.NC user documentation:

The smarT.NC operating mode is described in a separate Pilot. Please contact HEIDENHAIN if you require a copy of this Pilot. ID: 533 191-xx.



Software options

The iTNC 530 features various software options that can be enabled by your machine tool builder. Each option is to be enabled separately and contains the following respective functions:

Software option 1

Cylinder surface interpolation (Cycles 27, 28, 29 and 39)

Feed rate in mm/min for rotary axes: **M116**

Tilting the machining plane (Cycle 19, **PLANE** function and 3-D ROT soft key in the Manual Operation mode)

Circle in 3 axes with tilted working plane

Software option 2

Block processing time 0.5 ms instead of 3.6 ms

5-axis interpolation

Spline interpolation

3-D machining:

- **M114:** Automatic compensation of machine geometry when working with swivel axes
- **M128:** Maintaining the position of the tool tip when positioning with swivel axes (TCPM)
- **FUNCTION TCPM:** Maintaining the position of the tool tip when positioning with swivel axes (TCPM) in selectable modes
- **M144:** Compensating the machine's kinematics configuration for ACTUAL/NOMINAL positions at end of block
- Additional parameters for **finishing/roughing** and **tolerance for rotary axes** in Cycle 32 (G62)
- **LN** blocks (3-D compensation)

DCM collision software option

Function which dynamically monitors areas defined by the machine manufacturer to prevent collisions.

Additional conversational language software option

Function for enabling the conversational languages Slovenian, Slovak, Norwegian, Latvian, Estonian, Korean, Turkish, Romanian, Lithuanian

DXF Converter software option

Extract contours from DXF files (R12 format).



Global Program Settings software option

Function for superimposing coordinate transformations in the Program Run modes.

AFC software option

Function for adaptive feed-rate control for optimizing the machining conditions during series production.

KinematicsOpt software option

Touch-probe cycles for inspecting and optimizing the machine accuracy.

Feature content level (upgrade functions)

Along with software options, significant further improvements of the TNC software are managed via the Feature Content Level (**FCL**) upgrade functions. Functions subject to the FCL are not available simply by updating the software on your TNC.



All upgrade functions are available to you without surcharge when you receive a new machine.

Upgrade functions are identified in the manual with **FCL n**, where **n** indicates the sequential number of the feature content level.

You can purchase a code number in order to permanently enable the FCL functions. For more information, contact your machine tool builder or HEIDENHAIN.

FCL 4 functions	Description
Graphical depiction of the protected space when DCM collision monitoring is active	User's Manual
Handwheel superimposition in stopped condition when DCM collision monitoring is active	User's Manual
3-D basic rotation (set-up compensation)	Machine manual

FCL 3 functions	Description
Touch probe cycle for 3-D probing	Page 439
Touch probe cycles for automatic datum setting using the center of a slot/ridge	Page 333
Feed-rate reduction for the machining of contour pockets with the tool being in full contact with the workpiece	User's Manual



FCL 3 functions	Description
PLANE function: Entry of axis angle	User's Manual
User documentation as a context-sensitive help system	User's Manual
smarT.NC: Programming of smarT.NC and machining can be carried out simultaneously	User's Manual
smarT.NC: Contour pocket on point pattern	smarT.NC Pilot
smarT.NC: Preview of contour programs in the file manager	smarT.NC Pilot
smarT.NC: Positioning strategy for machining point patterns	smarT.NC Pilot

FCL 2 functions	Description
3-D line graphics	User's Manual
Virtual tool axis	User's Manual
USB support of block devices (memory sticks, hard disks, CD-ROM drives)	User's Manual
Filtering of externally created contours	User's Manual
Possibility of assigning different depths to each subcontour in the contour formula	User's Manual
DHCP dynamic IP-address management	User's Manual
Touch-probe cycle for global setting of touch-probe parameters	Page 444
smarT.NC: Graphic support of block scan	smarT.NC Pilot
smarT.NC: Coordinate transformation	smarT.NC Pilot
smarT.NC: PLANE function	smarT.NC Pilot

Intended place of operation

The TNC complies with the limits for a Class A device in accordance with the specifications in EN 55022, and is intended for use primarily in industrially-zoned areas.



New Functions of Software 340 49x-02

- New machine parameter for defining the positioning speed (see "Touch trigger probe, rapid traverse for positioning: MP6151" on page 305)
- New machine parameter for consideration of basic rotation in Manual Operation (see "Consider a basic rotation in the Manual Operation mode: MP6166" on page 304)
- Cycles 420 to 431 for automatic tool measurement were improved so that the measuring log can now also be displayed on the screen (see "Recording the results of measurement" on page 385)
- A new cycle that enables you to set global touch probe parameters was introduced (see "FAST PROBING (Cycle 441, DIN/ISO: G441, FCL 2 function)" on page 444)

New Functions of Software 340 49x-03

- New cycle for setting a datum in the center of a slot (see "SLOT CENTER REF PT (Cycle 408, DIN/ISO: G408, FCL 3 function)" on page 333)
- New cycle for setting a datum in the center of a ridge (see "RIDGE CENTER REF PT (Cycle 409, DIN/ISO: G409, FCL 3 function)" on page 337)
- New 3-D probing cycle (see "MEASURING IN 3-D (Cycle 4, FCL 3 function)" on page 439)
- Cycle 401 now also allows you to compensate workpiece misalignment by rotating the rotary table (see "BASIC ROTATION from two holes (Cycle 401, DIN/ISO: G401)" on page 313)
- Cycle 402 now also allows you to compensate workpiece misalignment by rotating the rotary table (see "BASIC ROTATION over two studs (Cycle 402, DIN/ISO: G402)" on page 316)
- In the cycles for datum setting, the results of measurement are available in the Q parameters **Q15X** (see "Measurement results in Q parameters" on page 387)



New Functions of Software

340 49x-04

- New cycle for saving a machine's kinematic configuration (see "SAVE KINEMATICS (Cycle 450, DIN/ISO: G450; option)" on page 450)
- New cycle for testing and optimizing a machine's kinematic configuration (see "MEASURE KINEMATICS (Cycle 451, DIN/ISO: G451; option)" on page 452)
- Cycle 412: Number of measuring points selectable through parameter Q423 (see "DATUM FROM INSIDE OF CIRCLE (Cycle 412, DIN/ISO: G412)" on page 348)
- Cycle 413: Number of measuring points selectable through parameter Q423 (see "DATUM FROM OUTSIDE OF CIRCLE (Cycle 413, DIN/ISO: G413)" on page 352)
- Cycle 421: Number of measuring points selectable through parameter Q423 (see "MEASURE HOLE (Cycle 421, DIN/ISO: G421)" on page 395)
- Cycle 422: Number of measuring points selectable through parameter Q423 (see "MEAS. CIRCLE OUTSIDE (Cycle 422, DIN/ISO: G422)" on page 399)
- Cycle 3: Error message can be suppressed if the stylus is already deflected when a cycle starts (see "MEASURING (Cycle 3)" on page 437)

New Functions of Software 340 49x-05

- New machining cycle for single-fluted deep-hole drilling (see "SINGLE-FLUTED DEEP-HOLE DRILLING (Cycle 241, DIN/ISO: G241)" on page 94)
- Touch Probe Cycle 404 (SET BASIC ROTATION) was expanded by parameter Q305 (Number in table) in order to write basic rotations to the preset table (see page 322)
- Touch Probe Cycles 408 to 419: The TNC now also writes to line 0 of the preset table when the display value is set (see "Saving the calculated datum" on page 332)
- Touch Probe Cycle 412: Additional parameter Q365 "type of traverse" (see "DATUM FROM INSIDE OF CIRCLE (Cycle 412, DIN/ISO: G412)" on page 348))
- Touch Probe Cycle 413: Additional parameter Q365 "type of traverse" (see "DATUM FROM OUTSIDE OF CIRCLE (Cycle 413, DIN/ISO: G413)" on page 352)
- Touch Probe Cycle 416: Additional parameter Q320 (setup clearance, see "DATUM CIRCLE CENTER (Cycle 416, DIN/ISO: G416)," page 365)
- Touch Probe Cycle 421: Additional parameter Q365 "type of traverse" (see "MEASURE HOLE (Cycle 421, DIN/ISO: G421)" on page 395)
- Touch Probe Cycle 422: Additional parameter Q365 "type of traverse" (see "MEAS. CIRCLE OUTSIDE (Cycle 422, DIN/ISO: G422)" on page 399)
- Touch Probe Cycle 425 (MEASURE SLOT) was expanded by parameters Q301 (Move to clearance height) and Q320 (setup clearance) (see "MEASURE INSIDE WIDTH (Cycle 425, DIN/ISO: G425)," page 411)
- Touch Probe Cycle 450 (SAVE KINEMATICS) was expanded by input option 2 (Display saving status) in parameter Q410 (mode) (see "SAVE KINEMATICS (Cycle 450, DIN/ISO: G450; option)" on page 450)
- Touch Probe Cycle 451 (MEASURE KINEMATICS) was expanded by parameters Q423 (Number of circular measurements) and Q432 (Set preset) (see "Cycle parameters" on page 461)
- New Touch Probe Cycle 452 (PRESET COMPENSATION) simplifies the measurement of tool changer heads (see "PRESET COMPENSATION (Cycle 452, DIN/ISO: G452, option)" on page 466)
- New Touch Probe Cycle 484 for calibrating the wireless TT 449 tool touch probe (see "Calibrating the wireless TT 449 (Cycle 484, DIN/ISO: G484)" on page 484)



Functions Changed in Software 340 49x-05

- The cylindrical surface cycles 27, 28, 29 and 39 can now also be used with modulo rotary axes. In the past, Machine Parameter 810.x = 0 was required.
- Cycle 403 does not check whether touch points and compensation axis match. As a result, probing is also possible in a tilted coordinate system (see "BASIC ROTATION compensation via rotary axis (Cycle 403, DIN/ISO: G403)" on page 319)

Functions Changed Since the Predecessor Versions 340 422-xx/340 423-xx

- The management of more than one block of calibration data was changed (see Conversational Programming User's Manual).



Table of Contents

Fundamentals / Overviews	1
Using Cycles	2
Canned Cycles: Drilling	3
Canned Cycles: Tapping / Thread Milling	4
Canned Cycles: Pocket Milling / Stud Milling / Slot Milling	5
Canned Cycles: Pattern Definitions	6
Canned Cycles: Contour Pocket	7
Canned Cycles: Cylindrical Surface	8
Canned Cycles: Contour Pocket with Contour Formula	9
Canned Cycles: Multipass Milling	10
Cycles: Coordinate Transformations	11
Cycles: Special Functions	12
Using Touch Probe Cycles	13
Touch Probe Cycles: Automatic Measurement of Workpiece Misalignment	14
Touch Probe Cycles: Automatic Datum Setting	15
Touch Probe Cycles: Automatic Workpiece Inspection	16
Touch Probe Cycles: Special Functions	17
Touch Probe Cycles: Automatic Kinematics Measurement	18
Touch Probe Cycles: Automatic Tool Measurement	19

1 Fundamentals / Overviews 39

- 1.1 Introduction 40
- 1.2 Available Cycle Groups 41
 - Overview of canned cycles 41
 - Overview of touch probe cycles 42



2 Using Canned Cycles 43

- 2.1 Working with Canned Cycles 44
 - Machine-specific cycles 44
 - Defining a cycle using soft keys 45
 - Defining a cycle using the GOTO function 45
 - Calling cycles 46
 - Working with the secondary axes U/V/W 49
- 2.2 Program Defaults for Cycles 50
 - Overview 50
 - Entering GLOBAL DEF definitions 51
 - Using GLOBAL DEF information 51
 - Global data valid everywhere 52
 - Global data for drilling operations 52
 - Global data for milling operations with pocket cycles 25x 53
 - Global data for milling operations with contour cycles 53
 - Global data for positioning behavior 53
 - Global data for probing functions 54
- 2.3 Pattern Definition PATTERN DEF 55
 - Application 55
 - Entering PATTERN DEF definitions 56
 - Using PATTERN DEF 56
 - Defining individual machining positions 57
 - Defining a single row 58
 - Defining a single pattern 59
 - Defining individual frames 60
 - Defining a full circle 61
 - Defining a circular arc 62
- 2.4 Point Tables 63
 - Application 63
 - Creating a point table 63
 - Hiding single points from the machining process 64
 - Selecting a point table in the program 65
 - Calling a cycle in connection with point tables 66



3 Canned Cycles: Drilling 67

- 3.1 Fundamentals 68
 - Overview 68
- 3.2 CENTERING (Cycle 240, DIN/ISO: G240) 69
 - Cycle run 69
 - Please note while programming: 69
 - Cycle parameters 70
- 3.3 DRILLING (Cycle 200) 71
 - Cycle run 71
 - Please note while programming: 71
 - Cycle parameters 72
- 3.4 REAMING (Cycle 201, DIN/ISO: G201) 73
 - Cycle run 73
 - Please note while programming: 73
 - Cycle parameters 74
- 3.5 BORING (Cycle 202, DIN/ISO: G202) 75
 - Cycle run 75
 - Please note while programming: 76
 - Cycle parameters 77
- 3.6 UNIVERSAL DRILLING (Cycle 203, DIN/ISO: G203) 79
 - Cycle run 79
 - Please note while programming: 80
 - Cycle parameters 81
- 3.7 BACK BORING (Cycle 204, DIN/ISO: G204) 83
 - Cycle run 83
 - Please note while programming: 84
 - Cycle parameters 85
- 3.8 UNIVERSAL PECKING (Cycle 205, DIN/ISO: G205) 87
 - Cycle run 87
 - Please note while programming: 88
 - Cycle parameters 89
- 3.9 BORE MILLING (Cycle 208) 91
 - Cycle run 91
 - Please note while programming: 92
 - Cycle parameters 93
- 3.10 SINGLE-FLUTED DEEP-HOLE DRILLING (Cycle 241, DIN/ISO: G241) 94
 - Cycle run 94
 - Please note while programming: 94
 - Cycle parameters 95
- 3.11 Programming examples 97



4 Canned Cycles: Tapping / Thread Milling 101

- 4.1 Fundamentals 102
 - Overview 102
- 4.2 TAPPING NEW with a floating tap holder (Cycle 206, DIN/ISO: G206) 103
 - Cycle run 103
 - Please note while programming: 103
 - Cycle parameters 104
- 4.3 RIGID TAPPING without a floating tap holder NEW (Cycle 207, DIN/ISO: G207) 105
 - Cycle run 105
 - Please note while programming: 106
 - Cycle parameters 107
- 4.4 TAPPING WITH CHIP BREAKING (Cycle 209, DIN/ISO: G209) 108
 - Cycle run 108
 - Please note while programming: 109
 - Cycle parameters 110
- 4.5 Fundamentals of thread milling 111
 - Prerequisites 111
- 4.6 THREAD MILLING (Cycle 262, DIN/ISO: G262) 113
 - Cycle run 113
 - Please note while programming: 114
 - Cycle parameters 115
- 4.7 THREAD MILLING / COUNTERSINKING (Cycle 263, DIN/ISO: G263) 116
 - Cycle run 116
 - Please note while programming: 117
 - Cycle parameters 118
- 4.8 THREAD DRILLING/MILLING (Cycle 264, DIN/ISO: G264) 120
 - Cycle run 120
 - Please note while programming: 121
 - Cycle parameters 122
- 4.9 HELICAL THREAD DRILLING/MILLING (Cycle 265, DIN/ISO: G265) 124
 - Cycle run 124
 - Please note while programming: 125
 - Cycle parameters 126
- 4.10 OUTSIDE THREAD MILLING (Cycle 267, DIN/ISO: G267) 128
 - Cycle run 128
 - Please note while programming: 129
 - Cycle parameters 130
- 4.11 Programming examples 132



5 Canned Cycles: Pocket Milling / Stud Milling / Slot Milling 135

- 5.1 Fundamentals 136
 - Overview 136
- 5.2 RECTANGULAR POCKET (Cycle 251, DIN/ISO: G251) 137
 - Cycle run 137
 - Please note while programming: 138
 - Cycle parameters 139
- 5.3 CIRCULAR POCKET (Cycle 252, DIN/ISO: G252) 142
 - Cycle run 142
 - Please note while programming: 143
 - Cycle parameters 144
- 5.4 SLOT MILLING (Cycle 253, DIN/ISO: G253) 146
 - Cycle run 146
 - Please note while programming: 147
 - Cycle parameters 148
- 5.5 CIRCULAR SLOT (Cycle 254, DIN/ISO: G254) 151
 - Cycle run 151
 - Please note while programming: 152
 - Cycle parameters 153
- 5.6 RECTANGULAR STUD (Cycle 256, DIN/ISO: G256) 156
 - Cycle run 156
 - Please note while programming: 157
 - Cycle parameters 158
- 5.7 CIRCULAR STUD (Cycle 257, DIN/ISO: G257) 160
 - Cycle run 160
 - Please note while programming: 161
 - Cycle parameters 162
- 5.8 Programming examples 164



6 Canned Cycles: Pattern Definitions 167

- 6.1 Fundamentals 168
 - Overview 168
- 6.2 CIRCULAR PATTERN (Cycle 220, DIN/ISO: G220)) 169
 - Cycle run 169
 - Please note while programming: 169
 - Cycle parameters 170
- 6.3 LINEAR PATTERN (Cycle 221, DIN/ISO: G221) 172
 - Cycle run 172
 - Please note while programming: 172
 - Cycle parameters 173
- 6.4 Programming examples 174



7 Canned Cycles: Contour Pocket 177

- 7.1 SL Cycles 178
 - Fundamentals 178
 - Overview 180
- 7.2 CONTOUR GEOMETRY (Cycle 14, DIN/ISO: G37) 181
 - Please note while programming: 181
 - Cycle parameters 181
- 7.3 Overlapping contours 182
 - Fundamentals 182
 - Subprograms: overlapping pockets 183
 - Area of inclusion 184
 - Area of exclusion 185
 - Area of intersection 185
- 7.4 CONTOUR DATA (Cycle 20, DIN/ISO: G120) 186
 - Please note while programming: 186
 - Cycle parameters 187
- 7.5 PILOT DRILLING (Cycle 21, DIN/ISO: G121) 188
 - Cycle run 188
 - Please note while programming: 188
 - Cycle parameters 189
- 7.6 ROUGH-OUT (Cycle 22, DIN/ISO: G122) 190
 - Cycle run 190
 - Please note while programming: 191
 - Cycle parameters 192
- 7.7 FLOOR FINISHING (Cycle 23, DIN/ISO: G123) 194
 - Cycle run 194
 - Please note while programming: 194
 - Cycle parameters 194
- 7.8 SIDE FINISHING (Cycle 24, DIN/ISO: G124) 195
 - Cycle run 195
 - Please note while programming: 195
 - Cycle parameters 196
- 7.9 CONTOUR TRAIN (Cycle 25, DIN/ISO: G125) 197
 - Cycle run 197
 - Please note while programming: 197
 - Cycle parameters 198
- 7.10 CONTOUR TRAIN DATA (Cycle 270, DIN/ISO: G270) 199
 - Please note while programming: 199
 - Cycle parameters 200
- 7.11 Programming examples 201



8 Canned Cycles: Cylindrical Surface 209

- 8.1 Fundamentals 210
 - Overview of cylindrical surface cycles 210
- 8.2 CYLINDER SURFACE (Cycle 27, DIN/ISO: G127, software option 1) 211
 - Execution of cycle 211
 - Please note while programming: 212
 - Cycle parameters 213
- 8.3 CYLINDER SURFACE slot milling (Cycle 28, DIN/ISO: G128, software option 1) 214
 - Cycle run 214
 - Please note while programming: 215
 - Cycle parameters 216
- 8.4 CYLINDER SURFACE ridge milling (Cycle 29, DIN/ISO: G129, software option 1) 217
 - Cycle run 217
 - Please note while programming: 218
 - Cycle parameters 219
- 8.5 CYLINDER SURFACE outside contour milling (Cycle 39, DIN/ISO: G139, software option 1) 220
 - Cycle run 220
 - Please note while programming: 221
 - Cycle parameters 222
- 8.6 Programming Examples 223



9 Canned Cycles: Contour Pocket with Contour Formula 227

- 9.1 SL Cycles with Complex Contour Formula 228
 - Fundamentals 228
 - Selecting a program with contour definitions 230
 - Defining contour descriptions 230
 - Entering a complex contour formula 231
 - Overlapping contours 232
 - Contour machining with SL Cycles 234
- 9.2 SL Cycles with Simple Contour Formula 238
 - Fundamentals 238
 - Entering a simple contour formula 240
 - Contour machining with SL Cycles 240



10 Canned Cycles: Multipass Milling 241

- 10.1 Fundamentals 242
 - Overview 242
- 10.2 RUN 3-D DATA (Cycle 30, DIN/ISO: G60) 243
 - Cycle run 243
 - Please note while programming: 243
 - Cycle parameters 244
- 10.3 MULTIPASS MILLING (Cycle 230, DIN/ISO: G230) 245
 - Cycle run 245
 - Please note while programming: 245
 - Cycle parameters 246
- 10.4 RULED SURFACE (Cycle 231, DIN/ISO: G231) 247
 - Cycle run 247
 - Please note while programming: 248
 - Cycle parameters 249
- 10.5 FACE MILLING (Cycle 232, DIN/ISO: G232) 251
 - Cycle run 251
 - Please note while programming: 253
 - Cycle parameters 253
- 10.6 Programming examples 256



11 Cycles: Coordinate Transformations 259

- 11.1 Fundamentals 260
 - Overview 260
 - Effect of coordinate transformations 261
- 11.2 DATUM SHIFT (Cycle 7, DIN/ISO: G54) 262
 - Effect 262
 - Cycle parameters 262
- 11.3 DATUM shift with datum tables (Cycle 7, DIN/ISO: G53) 263
 - Effect 263
 - Please note while programming: 264
 - Cycle parameters 265
 - Selecting a datum table in the part program 265
 - Editing the datum table in the Programming and Editing mode of operation 266
 - Editing a pocket table in a Program Run operating mode 266
 - Transferring the actual values into the datum table 267
 - Configuring the datum table 268
 - To leave a datum table 268
- 11.4 DATUM SETTING (Cycle 247, DIN/ISO: G247) 269
 - Effect 269
 - Please note before programming: 269
 - Cycle parameters 269
- 11.5 MIRROR IMAGE (Cycle 8, DIN/ISO: G28) 270
 - Effect 270
 - Please note while programming: 270
 - Cycle parameters 271
- 11.6 ROTATION (Cycle 10, DIN/ISO: G73) 272
 - Effect 272
 - Please note while programming: 272
 - Cycle parameters 273
- 11.7 SCALING (Cycle 11, DIN/ISO: G72) 274
 - Effect 274
 - Cycle parameters 275
- 11.8 AXIS-SPECIFIC SCALING (Cycle 26) 276
 - Effect 276
 - Please note while programming: 276
 - Cycle parameters 277



11.9 WORKING PLANE (Cycle 19, DIN/ISO: G80, software option 1)	278
Effect	278
Please note while programming:	279
Cycle parameters	279
Resetting	279
Position the axis of rotation	280
Position display in the tilted system	282
Workspace monitoring	282
Positioning in a tilted coordinate system	282
Combining coordinate transformation cycles	283
Automatic workpiece measurement in the tilted system	283
Procedure for working with Cycle 19 WORKING PLANE	284
11.10 Programming examples	286



12 Cycles: Special Functions 289

- 12.1 Fundamentals 290
 - Overview 290
- 12.2 DWELL TIME (Cycle 9, DIN/ISO: G04) 291
 - Function 291
 - Cycle parameters 291
- 12.3 PROGRAM CALL (Cycle 12, DIN/ISO: G39) 292
 - Cycle function 292
 - Please note while programming: 292
 - Cycle parameters 293
- 12.4 ORIENTED SPINDLE STOP (Cycle 13, DIN/ISO: G36) 294
 - Cycle function 294
 - Please note while programming: 294
 - Cycle parameters 294
- 12.5 TOLERANCE (Cycle 32, DIN/ISO: G62) 295
 - Cycle function 295
 - Influences of the geometry definition in the CAM system 296
 - Please note while programming: 297
 - Cycle parameters 298



13 Using Touch Probe Cycles 299

- 13.1 General Information about Touch Probe Cycles 300
 - Method of function 300
 - Cycles in the Manual and El. Handwheel Modes 301
 - Touch probe cycles for automatic operation 301
- 13.2 Before You Start Working with Touch Probe Cycles 303
 - Maximum traverse to touch point: MP6130 303
 - Safety clearance to touch point: MP6140 303
 - Orient the infrared touch probe to the programmed probe direction: MP6165 303
 - Consider a basic rotation in the Manual Operation mode: MP6166 304
 - Multiple measurement: MP6170 304
 - Confidence interval for multiple measurement: MP6171 304
 - Touch trigger probe, probing feed rate: MP6120 305
 - Touch trigger probe, rapid traverse for positioning: MP6150 305
 - Touch trigger probe, rapid traverse for positioning: MP6151 305
 - KinematicsOpt: Tolerance limit in Optimization mode: MP6600 305
 - KinematicsOpt, permissible deviation of the calibration ball radius: MP6601 305
 - Executing touch probe cycles 306



14 Touch Probe Cycles: Automatic Measurement of Workpiece Misalignment 307

- 14.1 Fundamentals 308
 - Overview 308
 - Characteristics common to all touch probe cycles for measuring workpiece misalignment 309
- 14.2 BASIC ROTATION (Cycle 400, DIN/ISO: G400) 310
 - Cycle run 310
 - Please note while programming: 310
 - Cycle parameters 311
- 14.3 BASIC ROTATION from two holes (Cycle 401, DIN/ISO: G401) 313
 - Cycle run 313
 - Please note while programming: 313
 - Cycle parameters 314
- 14.4 BASIC ROTATION over two studs (Cycle 402, DIN/ISO: G402) 316
 - Cycle run 316
 - Please note while programming: 316
 - Cycle parameters 317
- 14.5 BASIC ROTATION compensation via rotary axis (Cycle 403, DIN/ISO: G403) 319
 - Cycle run 319
 - Please note while programming: 319
 - Cycle parameters 320
- 14.6 SET BASIC ROTATION (Cycle 404, DIN/ISO: G404) 322
 - Cycle run 322
 - Cycle parameters 322
- 14.7 Compensating workpiece misalignment by rotating the C axis (Cycle 405, DIN/ISO: G405) 323
 - Cycle run 323
 - Please note while programming: 324
 - Cycle parameters 325



15 Touch Probe Cycles: Automatic Datum Setting 329

- 15.1 Fundamentals 330
 - Overview 330
 - Characteristics common to all touch probe cycles for datum setting 331
- 15.2 SLOT CENTER REF PT (Cycle 408, DIN/ISO: G408, FCL 3 function) 333
 - Cycle run 333
 - Please note while programming: 334
 - Cycle parameters 334
- 15.3 RIDGE CENTER REF PT (Cycle 409, DIN/ISO: G409, FCL 3 function) 337
 - Cycle run 337
 - Please note while programming: 337
 - Cycle parameters 338
- 15.4 DATUM FROM INSIDE OF RECTANGLE (Cycle 410, DIN/ISO: G410) 340
 - Cycle run 340
 - Please note while programming: 341
 - Cycle parameters 341
- 15.5 DATUM FROM OUTSIDE OF RECTANGLE (Cycle 411, DIN/ISO: G411) 344
 - Cycle run 344
 - Please note while programming: 345
 - Cycle parameters 345
- 15.6 DATUM FROM INSIDE OF CIRCLE (Cycle 412, DIN/ISO: G412) 348
 - Cycle run 348
 - Please note while programming: 349
 - Cycle parameters 349
- 15.7 DATUM FROM OUTSIDE OF CIRCLE (Cycle 413, DIN/ISO: G413) 352
 - Cycle run 352
 - Please note while programming: 353
 - Cycle parameters 353
- 15.8 DATUM FROM OUTSIDE OF CORNER (Cycle 414, DIN/ISO: G414) 356
 - Cycle run 356
 - Please note while programming: 357
 - Cycle parameters 358
- 15.9 DATUM FROM INSIDE OF CORNER (Cycle 415, DIN/ISO: G415) 361
 - Cycle run 361
 - Please note while programming: 362
 - Cycle parameters 362
- 15.10 DATUM CIRCLE CENTER (Cycle 416, DIN/ISO: G416) 365
 - Cycle run 365
 - Please note while programming: 366
 - Cycle parameters 366
- 15.11 DATUM IN TOUCH PROBE AXIS (Cycle 417, DIN/ISO: G417) 369
 - Cycle run 369
 - Please note while programming: 369
 - Cycle parameters 370



15.12 DATUM AT CENTER OF 4 HOLES (Cycle 418, DIN/ISO: G418) 371

Cycle run 371

Please note while programming: 372

Cycle parameters 372

15.13 DATUM IN ONE AXIS (Cycle 419, DIN/ISO: G419) 375

Cycle run 375

Please note while programming: 375

Cycle parameters 376



- 16.1 Fundamentals 384
 - Overview 384
 - Recording the results of measurement 385
 - Measurement results in Q parameters 387
 - Classification of results 387
 - Tolerance monitoring 388
 - Tool monitoring 388
 - Reference system for measurement results 389
- 16.2 REF. PLANE (Cycle 0, DIN/ISO: G55) 390
 - Cycle run 390
 - Please note while programming: 390
 - Cycle parameters 390
- 16.3 POLAR REFERENCE PLANE (Cycle 1, DIN/ISO) 391
 - Cycle run 391
 - Please note while programming: 391
 - Cycle parameters 391
- 16.4 MEASURE ANGLE (Cycle 420, DIN/ISO: G420) 392
 - Cycle run 392
 - Please note while programming: 392
 - Cycle parameters 393
- 16.5 MEASURE HOLE (Cycle 421, DIN/ISO: G421) 395
 - Cycle run 395
 - Please note while programming: 395
 - Cycle parameters 396
- 16.6 MEAS. CIRCLE OUTSIDE (Cycle 422, DIN/ISO: G422) 399
 - Cycle run 399
 - Please note while programming: 399
 - Cycle parameters 400
- 16.7 MEAS. RECTAN. INSIDE (Cycle 423, DIN/ISO: G423) 403
 - Cycle run 403
 - Please note while programming: 404
 - Cycle parameters 404
- 16.8 MEAS. RECTAN. OUTSIDE (Cycle 424, ISO: G424) 407
 - Cycle run 407
 - Please note while programming: 408
 - Cycle parameters 408
- 16.9 MEASURE INSIDE WIDTH (Cycle 425, DIN/ISO: G425) 411
 - Cycle run 411
 - Please note while programming: 411
 - Cycle parameters 412

16.10 MEASURE RIDGE WIDTH (Cycle 426, ISO: G426)	414
Cycle run	414
Please note while programming:	414
Cycle parameters	415
16.11 MEASURE COORDINATE (Cycle 427, DIN/ISO: G427)	417
Cycle run	417
Please note while programming:	417
Cycle parameters	418
16.12 MEAS. BOLT HOLE CIRC. (Cycle 430, DIN/ISO: G430)	420
Cycle run	420
Please note while programming:	420
Cycle parameters	421
16.13 MEASURE PLANE (Cycle 431, DIN/ISO: G431)	424
Cycle run	424
Please note while programming:	425
Cycle parameters	426
16.14 Programming examples	428



17 Touch Probe Cycles: Special Functions 433

- 17.1 Fundamentals 434
 - Overview 434
- 17.2 CALIBRATE TS (Cycle 2) 435
 - Cycle run 435
 - Please note while programming: 435
 - Cycle parameters 435
- 17.3 CALIBRATE TS LENGTH (Cycle 9) 436
 - Cycle run 436
 - Cycle parameters 436
- 17.4 MEASURING (Cycle 3) 437
 - Cycle run 437
 - Please note while programming: 437
 - Cycle parameters 438
- 17.5 MEASURING IN 3-D (Cycle 4, FCL 3 function) 439
 - Cycle run 439
 - Please note while programming: 439
 - Cycle parameters 440
- 17.6 MEASURE AXIS SHIFT (touch probe cycle 440, DIN/ISO: G440) 441
 - Cycle run 441
 - Please note while programming: 442
 - Cycle parameters 443
- 17.7 FAST PROBING (Cycle 441, DIN/ISO: G441, FCL 2 function) 444
 - Cycle run 444
 - Please note while programming: 444
 - Cycle parameters 445



18 Touch Probe Cycles: Automatic Kinematics Measurement 447

- 18.1 Kinematic Measurement with TS Touch Probes (Option KinematicsOpt) 448
 - Fundamentals 448
 - Overview 448
- 18.2 Prerequisites 449
- 18.3 SAVE KINEMATICS (Cycle 450, DIN/ISO: G450; option) 450
 - Cycle run 450
 - Please note while programming: 450
 - Cycle parameters 451
 - Log function 451
- 18.4 MEASURE KINEMATICS (Cycle 451, DIN/ISO: G451; option) 452
 - Cycle run 452
 - Positioning direction 454
 - Machines with Hirth-coupled axes 455
 - Choice of number of measuring points 456
 - Choice of the calibrating ball position on the machine table 456
 - Notes on the accuracy 457
 - Notes on various calibration methods 458
 - Backlash 459
 - Please note while programming: 460
 - Cycle parameters 461
 - Log function 464
- 18.5 PRESET COMPENSATION (Cycle 452, DIN/ISO: G452, option) 466
 - Cycle run 466
 - Please note while programming: 468
 - Cycle parameters 469
 - Adjustment of tool changer heads 471
 - Drift Compensation 473
 - Log function 475



19 Touch Probe Cycles: Automatic Tool Measurement 477

- 19.1 Fundamentals 478
 - Overview 478
 - Differences between Cycles 31 to 33 and Cycles 481 to 483 479
 - Setting the machine parameters 479
 - Entries in the tool table TOOL.T 481
 - Display the results of measurement 482
- 19.2 Calibrating the TT (Cycle 30 or 480, DIN/ISO: G480) 483
 - Cycle run 483
 - Please note while programming: 483
 - Cycle parameters 483
- 19.3 Calibrating the wireless TT 449 (Cycle 484, DIN/ISO: G484) 484
 - Fundamentals 484
 - Cycle run 484
 - Please note while programming: 484
 - Cycle parameters 484
- 19.4 Measuring the tool length (Cycle 31 or 481, DIN/ISO: G481) 485
 - Cycle run 485
 - Please note while programming: 486
 - Cycle parameters 486
- 19.5 Measuring the tool radius (Cycle 32 or 482, ISO: G482) 487
 - Cycle run 487
 - Please note while programming: 487
 - Cycle parameters 488
- 19.6 Measuring tool length and radius (Cycle 33 or 483, ISO: G483) 489
 - Cycle run 489
 - Please note while programming: 489
 - Cycle parameters 490





1

**Fundamentals /
Overviews**



1.1 Introduction

Frequently recurring machining cycles that comprise several working steps are stored in the TNC memory as standard cycles. Coordinate transformations and several special functions are also available as cycles.

Most cycles use Q parameters as transfer parameters. Parameters with specific functions that are required in several cycles always have the same number: For example, **Q200** is always assigned the setup clearance, **Q202** the plunging depth, etc.



Danger of collision!

Cycles sometimes execute extensive operations. For safety reasons, you should run a graphical program test before machining .



If you use indirect parameter assignments in cycles with numbers greater than 200 (e.g. **Q210 = Q1**), any change in the assigned parameter (e.g. Q1) will have no effect after the cycle definition. Define the cycle parameter (e.g. **Q210**) directly in such cases.

If you define a feed-rate parameter for canned cycles greater than 200, then instead of entering a numerical value you can use soft keys to assign the feed rate defined in the **TOOL CALL** block (F AUTO soft key). You can also use the feed-rate alternatives **FMAX** (rapid traverse), **FZ** (feed per tooth) and **FU** (feed per rev), depending on the respective cycle and the function of the feed-rate parameter.

Note that, after a cycle definition, a change of the **FAUTO** feed rate has no effect, because internally the TNC assigns the feed rate from the **TOOL CALL** block when processing the cycle definition.

If you want to delete a block that is part of a cycle, the TNC asks you whether you want to delete the whole cycle.

1.2 Available Cycle Groups

Overview of canned cycles



► The soft-key row shows the available groups of cycles.

Cycle group	Soft key	Page
Cycles for pecking, reaming, boring, and counterboring	DRILLING/ THREAD	Page 68
Cycles for tapping, thread cutting and thread milling	DRILLING/ THREAD	Page 102
Cycles for milling pockets, studs and slots	POCKETS/ STUDS/ SLOTS	Page 136
Cycles for producing point patterns, such as circular or linear hole patterns	PATTERN	Page 168
SL (Subcontour List) cycles which allow the contour-parallel machining of relatively complex contours consisting of several overlapping subcontours, cylinder surface interpolation	SL II	Page 180
Cycles for multipass milling of flat or twisted surfaces	MULTIPASS MILLING	Page 242
Coordinate transformation cycles which enable datum shift, rotation, mirror image, enlarging and reducing for various contours	COORD. TRANSF.	Page 260
Special cycles such as dwell time, program call, oriented spindle stop and tolerance	SPECIAL CYCLES	Page 290



► If required, switch to machine-specific canned cycles.
These canned cycles can be integrated by your machine tool builder.



Overview of touch probe cycles



► The soft-key row shows the available groups of cycles.

Cycle group	Soft key	Page
Cycles for automatic measurement and compensation of workpiece misalignment		Page 308
Cycles for automatic workpiece presetting		Page 330
Cycles for automatic workpiece inspection		Page 384
Calibration cycles, special cycles		Page 434
Cycles for automatic kinematics measurement		Page 448
Cycles for automatic tool measurement (enabled by the machine tool builder)		Page 478



► If required, switch to machine-specific touch probe cycles. These touch probe cycles can be integrated by your machine tool builder.





2

Using Canned Cycles



2.1 Working with Canned Cycles

Machine-specific cycles

In addition to the HEIDENHAIN cycles, many machine tool builders offer their own cycles in the TNC. These cycles are available in a separate cycle-number range:

- Cycles 300 to 399
Machine-specific cycles that are to be defined through the CYCLE DEF key
- Cycles 500 to 599
Machine-specific touch probe cycles that are to be defined through the TOUCH PROBE key



Refer to your machine manual for a description of the specific function.

Sometimes, machine-specific cycles also use transfer parameters that HEIDENHAIN already used in the standard cycles. The TNC executes DEF-active cycles as soon as they are defined (See also “Calling cycles” on page 46). It executes CALL-active cycles only after they have been called (See also “Calling cycles” on page 46). When DEF-active cycles and CALL-active cycles are used simultaneously, it is important to prevent overwriting of transfer parameters already in use. Use the following procedure:

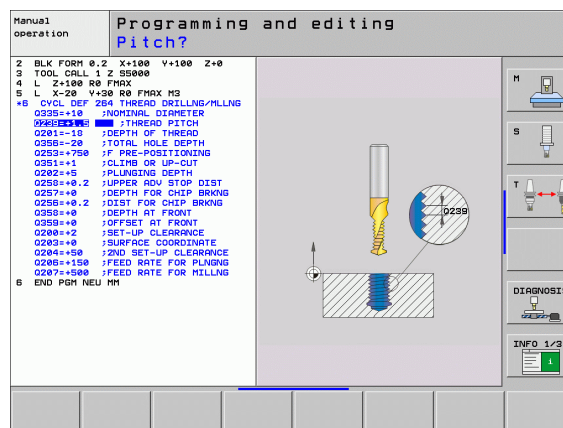
- As a rule, always program DEF-active cycles before CALL-active cycles.
- If you do want to program a DEF-active cycle between the definition and call of a CALL-active cycle, do it only if there is no common use of specific transfer parameters.

Defining a cycle using soft keys

CYCL
DEFDRILLING/
THREAD

282

- ▶ The soft-key row shows the available groups of cycles.
- ▶ Press the soft key for the desired group of cycles, for example DRILLING for the drilling cycles.
- ▶ Select the desired cycle, for example THREAD MILLING. The TNC initiates the programming dialog and asks all required input values. At the same time a graphic of the input parameters is displayed in the right screen window. The parameter that is asked for in the dialog prompt is highlighted
- ▶ Enter all parameters requested by the TNC and conclude each entry with the ENT key.
- ▶ The TNC ends the dialog when all required data has been entered.



Defining a cycle using the GOTO function

CYCL
DEF

GOTO

- ▶ The soft-key row shows the available groups of cycles.
- ▶ The TNC shows an overview of cycles in a pop-up window.
- ▶ Choose the desired cycle with the arrow keys, or
- ▶ Choose the desired cycle with CTRL and the arrow keys (for pagewise scrolling), or
- ▶ Enter the cycle number and confirm it with the ENT key. The TNC then initiates the cycle dialog as described above.

Example NC blocks

7 CYCL DEF 200 DRILLING

Q200=2 ;SETUP CLEARANCE

Q201=3 ;DEPTH

Q206=150 ;FEED RATE FOR PLNGNG

Q202=5 ;PLUNGING DEPTH

Q210=0 ;DWELL TIME AT TOP

Q203=+0 ;SURFACE COORDINATE

Q204=50 ;2ND SETUP CLEARANCE

Q211=0.25 ;DWELL TIME AT DEPTH

Calling cycles



Prerequisites

The following data must always be programmed before a cycle call:

- **BLK FORM** for graphic display (needed only for test graphics)
- Tool call
- Direction of spindle rotation (M functions M3/M4)
- Cycle definition (CYCL DEF)

For some cycles, additional prerequisites must be observed. They are detailed in the descriptions for each cycle.

The following cycles become effective automatically as soon as they are defined in the part program. These cycles cannot and must not be called:

- Cycle 220 for point patterns on circles and Cycle 221 for point patterns on lines
- SL Cycle 14 CONTOUR GEOMETRY
- SL Cycle 20 CONTOUR DATA
- Cycle 32 TOLERANCE
- Coordinate transformation cycles
- Cycle 9 DWELL TIME
- All touch probe cycles

You can call all other cycles with the functions described as follows.



Calling a cycle with CYCL CALL

The **CYCL CALL** function calls the most recently defined canned cycle once. The starting point of the cycle is the position that was programmed last before the CYCL CALL block.



- ▶ To program the cycle call, press the CYCL CALL key.
- ▶ Press the CYCL CALL M soft key to enter a cycle call.
- ▶ If necessary, enter the miscellaneous function M (for example **M3** to switch the spindle on), or end the dialog by pressing the END key

Calling a cycle with CYCL CALL PAT

The **CYCL CALL PAT** function calls the most recently defined canned cycle at all positions that you defined in a PATTERN DEF pattern definition (see "Pattern Definition PATTERN DEF" on page 55) or in a point table (see "Point Tables" on page 63).



Calling a cycle with CYCL CALL POS

The **CYCL CALL POS** function calls the most recently defined canned cycle once. The starting point of the cycle is the position that you defined in the **CYCL CALL POS** block.

The TNC moves using positioning logic to the position defined in the **CYCL CALL POS** block.

- If the current position in the tool axis is greater than the top surface of the workpiece (Q203), the TNC moves the tool to the programmed position first in the machining plane and then in the tool axis.
- If the current tool position in the tool axis is below the top surface of the workpiece (Q203), the TNC moves the tool to the programmed position first in the tool axis to the clearance height and then in the working plane to the programmed position.



Three coordinate axes must always be programmed in the **CYCL CALL POS** block. With the coordinate in the tool axis you can easily change the starting position. It serves as an additional datum shift.

The feed rate most recently defined in the **CYCL CALL POS** block applies only for traverse to the start position programmed in this block.

As a rule, the TNC moves without radius compensation (R0) to the position defined in the **CYCL CALL POS** block.

If you use **CYCL CALL POS** to call a cycle in which a start position is defined (for example Cycle 212), then the position defined in the cycles serves as an additional shift to the position defined in the **CYCL CALL POS** block. You should therefore always define the start position to be set in the cycle as 0.

Calling a cycle with M99/89

The **M99** function, which is active only in the block in which it is programmed, calls the last defined canned cycle once. You can program **M99** at the end of a positioning block. The TNC moves to this position and then calls the last defined canned cycle.

If the TNC is to execute the cycle automatically after every positioning block, program the first cycle call with **M89** (depending on MP 7440).

To cancel the effect of **M89**, program:

- **M99** in the positioning block in which you move to the last starting point, or
- Define with **CYCL DEF** a new canned cycle

Working with the secondary axes U/V/W

The TNC performs infeed movements in the axis that was defined in the TOOL CALL block as the spindle axis. It performs movements in the working plane only in the principal axes X, Y or Z. Exceptions:

- You program secondary axes for the side lengths in Cycles 3 SLOT MILLING and 4 POCKET MILLING.
- You program secondary axes in the first block of the contour geometry subprogram of an SL cycle.
- In Cycles 5 (CIRCULAR POCKET), 251 (RECTANGULAR POCKET), 252 (CIRCULAR POCKET), 253 (SLOT) and 254 (CIRCULAR SLOT), the TNC machines the cycle in the axes that you programmed in the last positioning block before the cycle call. When tool axis Z is active, the following combinations are permissible:
 - X/Y
 - X/V
 - U/Y
 - U/V



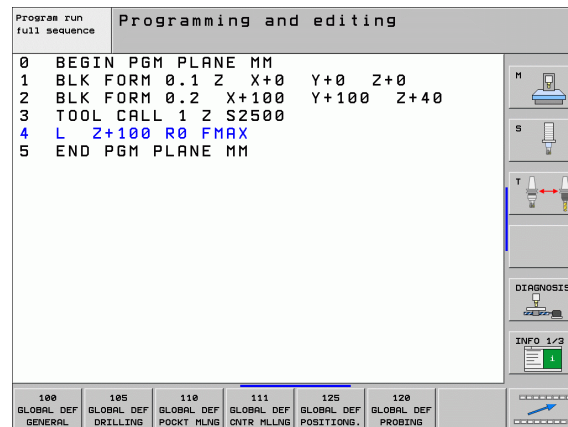
2.2 Program Defaults for Cycles

Overview

All Cycles 20 to 25, as well as all of those with numbers 200 or higher, always use identical cycle parameters, such as the setup clearance **Q200**, which you must enter for each cycle definition. The **GLOBAL DEF** function gives you the possibility of defining these cycle parameters once at the beginning of the program, so that they are effective globally for all canned cycles used in the program. In the respective canned cycle you then simply link to the value defined at the beginning of the program.

The following GLOBAL DEF functions are available:

Machining pattern	Soft key	Page
GLOBAL DEF COMMON Definition of generally valid cycle parameters	100 GLOBAL DEF GENERAL	Page 52
GLOBAL DEF DRILLING Definition of specific drilling cycle parameters	105 GLOBAL DEF DRILLING	Page 52
GLOBAL DEF POCKET MILLING Definition of specific pocket-milling cycle parameters	110 GLOBAL DEF POCKET MLNG	Page 53
GLOBAL DEF CONTOUR MILLING Definition of specific contour milling parameters	111 GLOBAL DEF CNTR MILLNG	Page 53
GLOBAL DEF POSITIONING Definition of the positioning behavior for CYCL CALL PAT	125 GLOBAL DEF POSITIONG.	Page 53
GLOBAL DEF PROBING Definition of specific touch probe cycle parameters	120 GLOBAL DEF PROBING	Page 54



Entering GLOBAL DEF definitions



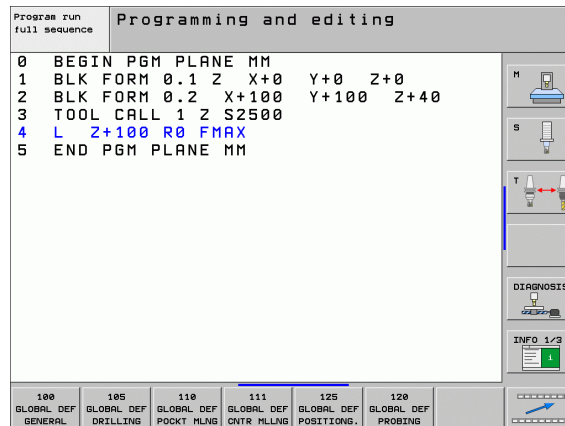
SPEC
FCT

PROGRAM
DEFAULTS

GLOBAL
DEF

100
GLOBAL DEF
GENERAL

- ▶ Select the Programming and Editing operating mode.
- ▶ Press the Special Functions key.
- ▶ Select the functions for program defaults.
- ▶ Select **GLOBAL DEF** functions.
- ▶ Select the desired GLOBAL DEF function, e.g. **GLOBAL DEF COMMON**
- ▶ Enter the required definitions, and confirm each entry with the ENT key.



Using GLOBAL DEF information

If you have entered the corresponding GLOBAL DEF functions at the beginning of the program, then you can link to these globally valid values when defining any canned cycle.

Proceed as follows:



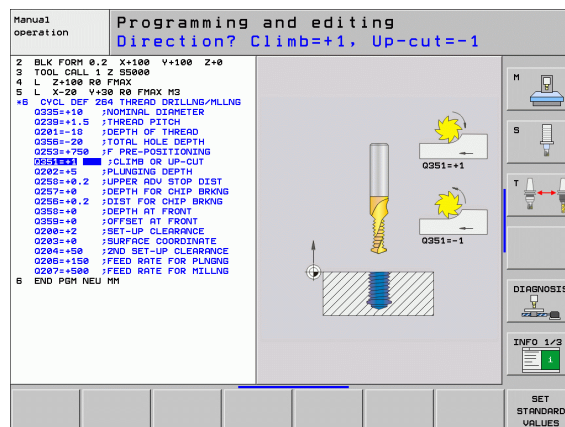
CYCL
DEF

DRILLING/
THREAD

200

SET
STANDARD
VALUES

- ▶ Select the Programming and Editing operating mode.
- ▶ Select the canned cycles.
- ▶ Select the desired group of cycles, for example: drilling cycles.
- ▶ Select the desired cycle, e.g. **DRILLING**.
- ▶ The TNC displays the SET STANDARD VALUES soft key, if there is a global parameter for it.
- ▶ Press the SET STANDARD VALUES soft key. The TNC enters the word **PREDEF** (predefined) in the cycle definition. You have now created a link to the corresponding **GLOBAL DEF** parameter that you defined at the beginning of the program.



Danger of collision!

Please note that later changes to the program settings affect the entire machining program, and can therefore change the machining procedure significantly.

If you enter a fixed value in a canned cycle, then this value will not be changed by the **GLOBAL DEF** functions.



Global data valid everywhere

- ▶ **Setup clearance:** Distance between tool tip and workpiece surface for automated approach of the cycle start position in the tool axis.
- ▶ **2nd set-up clearance:** Position to which the TNC positions the tool at the end of a machining step. The next machining position is approached at this height in the machining plane.
- ▶ **F positioning:** Feed rate at which the TNC traverses the tool within a cycle.
- ▶ **F retraction:** Feed rate at which the TNC retracts the tool.



The parameters are valid for all canned cycles with numbers greater than 2xx.

Global data for drilling operations

- ▶ **Retraction rate for chip breaking:** Value by which the TNC retracts the tool during chip breaking.
- ▶ **Dwell time at depth:** Time in seconds that the tool remains at the hole bottom.
- ▶ **Dwell time at top:** Time in seconds that the tool remains at the setup clearance.



The parameters apply to the drilling, tapping and thread milling cycles 200 to 209, 240, and 262 to 267.

Global data for milling operations with pocket cycles 25x

- ▶ **Overlap factor:** The tool radius multiplied by the overlap factor equals the lateral stepover.
- ▶ **Climb or up-cut:** Select the type of milling.
- ▶ **Plunging type:** Plunge into the material helically, in a reciprocating motion, or vertically.



The parameters apply to milling cycles 251 to 257.

Global data for milling operations with contour cycles

- ▶ **Setup clearance:** Distance between tool tip and workpiece surface for automated approach of the cycle start position in the tool axis.
- ▶ **Clearance height:** Absolute height at which the tool cannot collide with the workpiece (for intermediate positioning and retraction at the end of the cycle).
- ▶ **Overlap factor:** The tool radius multiplied by the overlap factor equals the lateral stepover.
- ▶ **Climb or up-cut:** Select the type of milling.



The parameters apply to SL cycles 20, 22, 23, 24 and 25.

Global data for positioning behavior

- ▶ **Positioning behavior:** Retraction in the tool axis at the end of the machining step: Return to the 2nd setup clearance or to the position at the beginning of the working unit.



The parameters apply to each canned cycle that you call with the **CYCL CALL PAT** function.

Global data for probing functions

- ▶ **Setup clearance:** Distance between stylus and workpiece surface for automated approach of the probing position.
- ▶ **Clearance height:** The coordinate in the touch probe axis to which the TNC traverses the touch probe between measuring points, if the **Move to clearance height** option is activated.
- ▶ **Move to clearance height:** Select whether the TNC moves the touch probe to the setup clearance or clearance height between the measuring points.



Applies for all Touch Probe Cycles 4xx.

2.3 Pattern Definition PATTERN DEF

Application

You use the **PATTERN DEF** function to easily define regular machining patterns, which you can call with the **CYCL CALL PAT** function. As with the cycle definitions, support graphics that illustrate the respective input parameter are also available for pattern definitions.



PATTERN DEF is to be used only in connection with the tool axis Z.

The following machining patterns are available:

Machining pattern	Soft key	Page
POINT Definition of up to any 9 machining positions		Page 57
ROW Definition of a single frame, straight or rotated		Page 58
PATTERN Definition of a single pattern, straight, rotated or distorted		Page 59
FRAME Definition of a single frame, straight, rotated or distorted		Page 60
CIRCLE Definition of a full circle		Page 61
PITCH CIRCLE Definition of a pitch circle		Page 62



Entering **PATTERN DEF** definitions

SPEC
FCTCONTOUR
+ POINT
MACHININGPATTERN
DEF

- ▶ Select the Programming and Editing operating mode.
- ▶ Press the Special Functions key.
- ▶ Select the functions for contour and point machining.
- ▶ Open a **PATTERN DEF** block.
- ▶ Select the desired machining pattern, e.g. a single row.
- ▶ Enter the required definitions, and confirm each entry with the ENT key.

Using **PATTERN DEF**

As soon as you have entered a pattern definition, you can call it with the **CYCL CALL PAT** function (see "Calling a cycle with CYCL CALL PAT" on page 47). The TNC then performs the most recently defined machining cycle on the machining pattern you defined.



A machining pattern remains active until you define a new one, or select a point table with the **SEL PATTERN** function.

You can use the mid-program startup function to select any point at which you want to start or continue machining (see User's Manual, Test Run and Program Run sections).

Defining individual machining positions



You can enter up to 9 machining positions. Confirm each entry with the ENT key.

If you have defined a **workpiece surface in Z** not equal to 0, then this value is effective in addition to the workpiece surface **Q203** that you defined in the machining cycle.



- ▶ **X coord. of machining position** (absolute): Enter X coordinate.
- ▶ **Y coord. of machining position** (absolute): Enter Y coordinate.
- ▶ **Workpiece surface coordinate** (absolute): Enter Z coordinate at which machining is to begin.

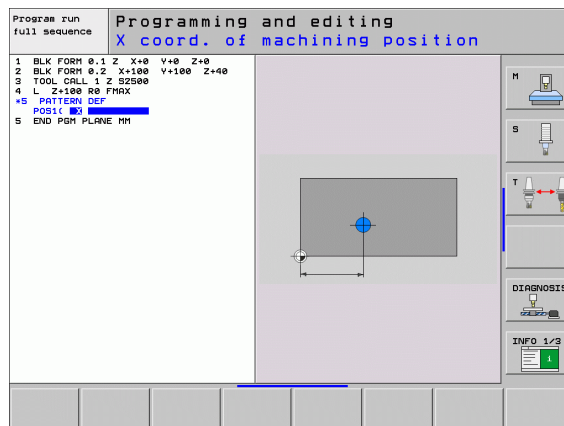
Example: NC blocks

```
10 L Z+100 R0 FMAX
```

```
11 PATTERN DEF
```

```
POS1 (X+25 Y+33.5 Z+0)
```

```
POS2 (X+50 Y+75 Z+0)
```



Defining a single row



If you have defined a **workpiece surface in Z** not equal to 0, then this value is effective in addition to the workpiece surface **Q203** that you defined in the machining cycle.

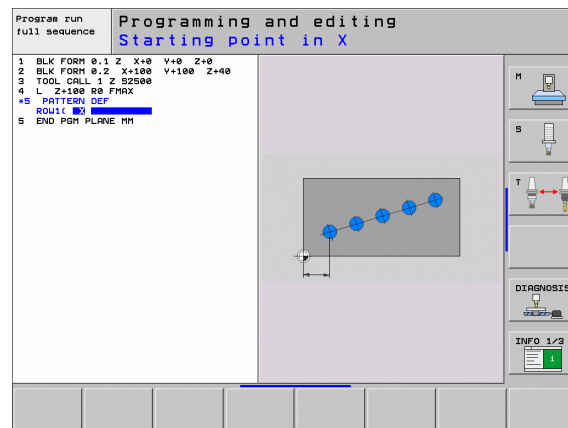


- ▶ **Starting point in X** (absolute): Coordinate of the starting point of the row in the X axis.
- ▶ **Starting point in Y** (absolute): Coordinate of the starting point of the row in the Y axis.
- ▶ **Spacing of machining positions (incremental)**: Distance between the machining positions. You can enter a positive or negative value.
- ▶ **Number of positions**: Total number of machining positions.
- ▶ **Rot. position of entire pattern (absolute)**:: Angle of rotation around the entered starting point. Reference axis: Major axis of the active machining plane (e.g. X for tool axis Z). You can enter a positive or negative value.
- ▶ **Workpiece surface coordinate** (absolute): Enter Z coordinate at which machining is to begin.

Example: NC blocks

```
10 L Z+100 R0 FMAX
```

```
11 PATTERN DEF
ROW1 (X+25 Y+33.5 D+8 NUM5 ROT+0 Z+0)
```



Defining a single pattern



If you have defined a **workpiece surface in Z** not equal to 0, then this value is effective in addition to the workpiece surface **Q203** that you defined in the machining cycle.

The **Rotary pos. ref. ax.** and **Rotary pos. minor ax.** parameters are added to a previously performed **rotated position** of the entire pattern.

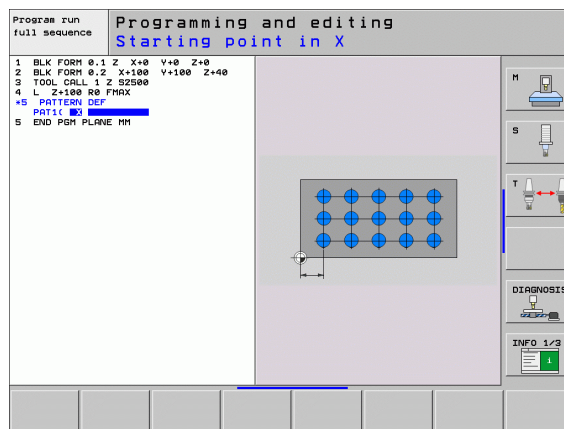


- ▶ **Starting point in X** (absolute): Coordinate of the starting point of the pattern in the X axis.
- ▶ **Starting point in Y** (absolute): Coordinate of the starting point of the pattern in the Y axis.
- ▶ **Spacing of machining positions X (incremental)**: Distance between the machining positions in the X direction. You can enter a positive or negative value.
- ▶ **Spacing of machining positions Y (incremental)**: Distance between the machining positions in the Y direction. You can enter a positive or negative value.
- ▶ **Number of columns**: Total number of columns in the pattern
- ▶ **Number of lines**: Total number of rows in the pattern
- ▶ **Rot. position of entire pattern (absolute)**: Angle of rotation by which the entire pattern is rotated around the entered starting point. Reference axis: Major axis of the active machining plane (e.g. X for tool axis Z). You can enter a positive or negative value.
- ▶ **Rotary pos. ref. ax.:** Angle of rotation around which only the principal axis of the machining plane is distorted with respect to the entered starting point. You can enter a positive or negative value.
- ▶ **Rotary pos. minor ax.:** Angle of rotation around which only the minor axis of the machining plane is distorted with respect to the entered starting point. You can enter a positive or negative value.
- ▶ **Workpiece surface coordinate** (absolute): Enter Z coordinate at which machining is to begin.

Example: NC blocks

```
10 L Z+100 R0 FMAX
```

```
11 PATTERN DEF
PAT1 (X+25 Y+33.5 DX+8 DY+10 NUMX5
NUMY4 ROT+0 ROTX+0 ROTY+0 Z+0)
```



Defining individual frames



If you have defined a **workpiece surface in Z** not equal to 0, then this value is effective in addition to the workpiece surface **Q203** that you defined in the machining cycle.

The **Rotary pos. ref. ax.** and **Rotary pos. minor ax.** parameters are added to a previously performed **rotated position** of the entire pattern.



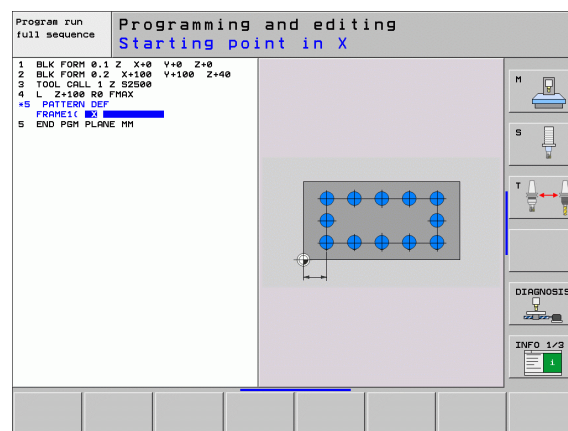
- ▶ **Starting point in X (absolute):** Coordinate of the starting point of the frame in the X axis.
- ▶ **Starting point in Y (absolute):** Coordinate of the starting point of the frame in the Y axis.
- ▶ **Spacing of machining positions X (incremental):** Distance between the machining positions in the X direction. You can enter a positive or negative value.
- ▶ **Spacing of machining positions Y (incremental):** Distance between the machining positions in the Y direction. You can enter a positive or negative value.
- ▶ **Number of columns:** Total number of columns in the pattern
- ▶ **Number of lines:** Total number of rows in the pattern
- ▶ **Rot. position of entire pattern (absolute):** Angle of rotation by which the entire pattern is rotated around the entered starting point. Reference axis: Major axis of the active machining plane (e.g. X for tool axis Z). You can enter a positive or negative value.
- ▶ **Rotary pos. ref. ax.:** Angle of rotation around which only the major axis of the machining plane is distorted around the entered starting point. You can enter a positive or negative value.
- ▶ **Rotary pos. minor ax.:** Angle of rotation around which only the minor axis of the machining plane is distorted around the entered starting point. You can enter a positive or negative value.
- ▶ **Workpiece surface coordinate (absolute):** Enter Z coordinate at which machining is to begin.

Example: NC blocks

```
10 L Z+100 R0 FMAX
```

```
11 PATTERN DEF
```

```
FRAME1 (X+25 Y+33.5 DX+8 DY+10 NUMX5  
NUMY4 ROT+0 ROTX+0 ROTY+0 Z+0)
```



Defining a full circle



If you have defined a **workpiece surface in Z** not equal to 0, then this value is effective in addition to the workpiece surface **Q203** that you defined in the machining cycle.



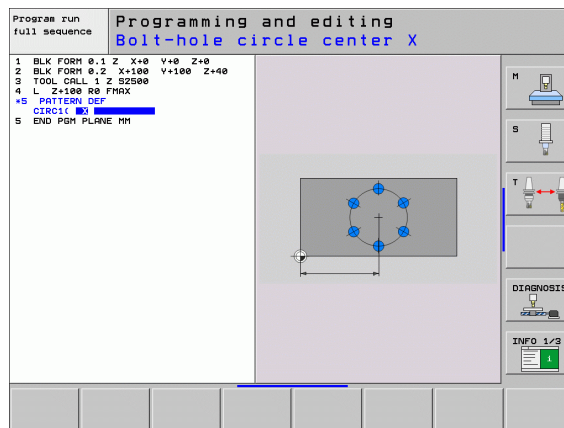
- ▶ **Bolt-hole circle center X** (absolute): Coordinate of the circle center in the X axis.
- ▶ **Bolt-hole circle center Y** (absolute): Coordinate of the circle center in the Y axis.
- ▶ **Bolt-hole circle diameter**: Diameter of the bolt-hole circle.
- ▶ **Starting angle**: Polar angle of the first machining position. Reference axis: Major axis of the active machining plane (e.g. X for tool axis Z). You can enter a positive or negative value.
- ▶ **Number of positions**: Total number of machining positions on the circle.
- ▶ **Workpiece surface coordinate** (absolute): Enter Z coordinate at which machining is to begin.

Example: NC blocks

```
10 L Z+100 R0 FMAX
```

```
11 PATTERN DEF
```

```
CIRC1 (X+25 Y+33 D80 START+45 NUM8 Z+0)
```



Defining a circular arc



If you have defined a **workpiece surface in Z** not equal to 0, then this value is effective in addition to the workpiece surface **Q203** that you defined in the machining cycle.

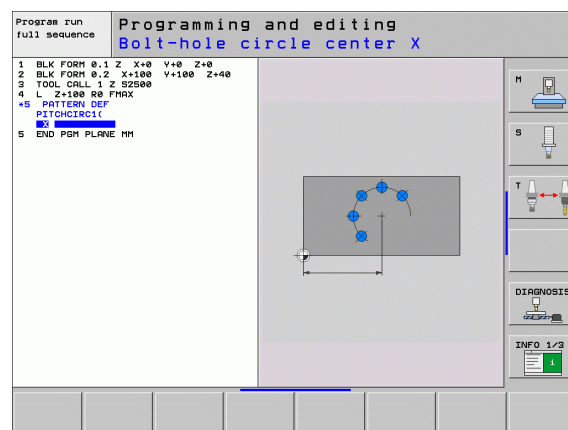


- ▶ **Bolt-hole circle center X** (absolute): Coordinate of the circle center in the X axis.
- ▶ **Bolt-hole circle center Y** (absolute): Coordinate of the circle center in the Y axis.
- ▶ **Bolt-hole circle diameter**: Diameter of the bolt-hole circle.
- ▶ **Starting angle**: Polar angle of the first machining position. Reference axis: Major axis of the active machining plane (e.g. X for tool axis Z). You can enter a positive or negative value.
- ▶ **Stepping angle/end angle**: Incremental polar angle between two machining positions. You can enter a positive or negative value. As an alternative you can enter the end angle (switch via soft key).
- ▶ **Number of positions**: Total number of machining positions on the circle.
- ▶ **Workpiece surface coordinate** (absolute): Enter Z coordinate at which machining is to begin.

Example: NC blocks

```
10 L Z+100 R0 FMAX
```

```
11 PATTERN DEF
PITCHCIRC1 (X+25 Y+33 D80 START+45 STEP30
NUM8 Z+0)
```



2.4 Point Tables

Application

You should create a point table whenever you want to run a cycle, or several cycles in sequence, on an irregular point pattern.

If you are using drilling cycles, the coordinates of the working plane in the point table represent the hole centers. If you are using milling cycles, the coordinates of the working plane in the point table represent the starting-point coordinates of the respective cycle (e.g. center-point coordinates of a circular pocket). Coordinates in the spindle axis correspond to the coordinate of the workpiece surface.

Creating a point table

Select the **Programming and Editing** mode of operation.



Press the PGM MGT key to call the file manager.

FILE NAME ?



Enter the name and file type of the point table and confirm your entry with the ENT key.



To select the unit of measure, press the MM or INCH soft key. The TNC changes to the program blocks window and displays an empty point table.



With the soft key INSERT LINE, insert new lines and enter the coordinates of the desired machining position.

Repeat the process until all desired coordinates have been entered.



With the soft keys X OFF/ON, Y OFF/ON, Z OFF/ON (second soft-key row), you can specify which coordinates you want to enter in the point table.



Hiding single points from the machining process

In the **FADE** column of the point table you can specify if the defined point is to be hidden during the machining process.



In the table, select the point to be hidden.



Select the FADE column.



Activate hiding, or



Deactivate hiding.

Selecting a point table in the program

In the Programming and Editing mode of operation, select the program for which you want to activate the point table:

PGM
CALL

Press the PGM CALL key to call the function for selecting the point table.

POINT
TABLE

Press the POINT TABLE soft key.

Enter the name of the point table and confirm your entry with the END key. If the point table is not stored in the same directory as the NC program, you must enter the complete path.

Example NC block

```
7 SEL PATTERN "TNC:\DIRKT5\NUST35.PNT"
```

Calling a cycle in connection with point tables



With **CYCL CALL PAT** the TNC runs the point table that you last defined (even if you defined the point table in a program that was nested with **CALL PGM**).

If you want the TNC to call the last defined canned cycle at the points defined in a point table, then program the cycle call with **CYCLE CALL PAT**:



- ▶ To program the cycle call, press the CYCL CALL key.
- ▶ Press the CYCL CALL PAT soft key to call a point table.
- ▶ Enter the feed rate at which the TNC is to move from point to point (if you make no entry the TNC will move at the last programmed feed rate; **FMAX** not valid).
- ▶ If required, enter a miscellaneous function M, then confirm with the END key.

The TNC retracts the tool to the safety clearance between the starting points. Depending on which is greater, the TNC uses either the spindle axis coordinate from the cycle call or the value from cycle parameter Q204 as the safety clearance.

If you want to move at reduced feed rate when pre-positioning in the spindle axis, use the miscellaneous function M103 .

Effect of the point tables with SL cycles and Cycle 12

The TNC interprets the points as an additional datum shift.

Effect of the point tables with Cycles 200 to 208 and 262 to 267

The TNC interprets the points of the working plane as coordinates of the hole centers. If you want to use the coordinate defined in the point table for the spindle axis as the starting point coordinate, you must define the workpiece surface coordinate (Q203) as 0.

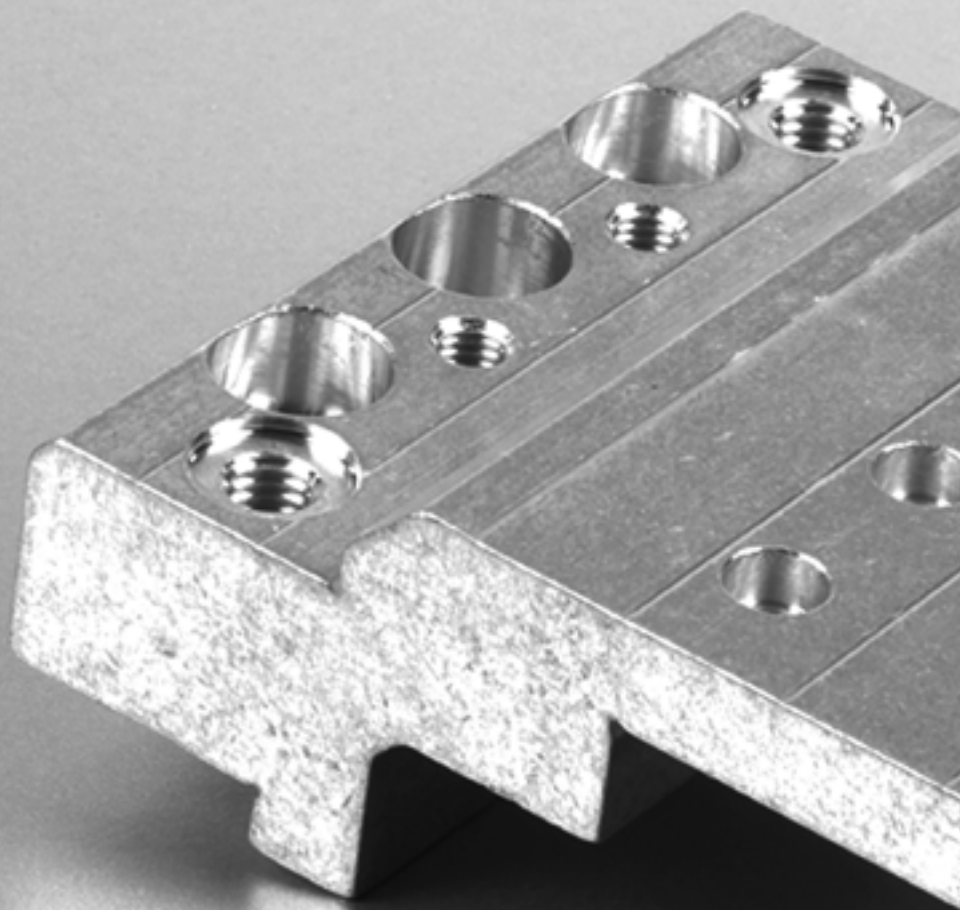
Effect of the point tables with Cycles 210 to 215

The TNC interprets the points as an additional datum shift. If you want to use the points defined in the point table as starting-point coordinates, you must define the starting points and the workpiece surface coordinate (Q203) in the respective milling cycle as 0.

Effect of the point tables with Cycles 251 to 254

The TNC interprets the points of the working plane as coordinates of the cycle starting point. If you want to use the coordinate defined in the point table for the spindle axis as the starting point coordinate, you must define the workpiece surface coordinate (Q203) as 0.





3

Canned Cycles: Drilling



3.1 Fundamentals

Overview

The TNC offers 9 cycles for all types of drilling operations:

Cycle	Soft key	Page
240 CENTERING With automatic pre-positioning, 2nd set-up clearance, optional entry of the centering diameter or centering depth		Page 69
200 DRILLING With automatic pre-positioning, 2nd setup clearance		Page 71
201 REAMING With automatic pre-positioning, 2nd setup clearance		Page 73
202 BORING With automatic pre-positioning, 2nd setup clearance		Page 75
203 UNIVERSAL DRILLING With automatic pre-positioning, 2nd setup clearance, chip breaking, and decrementing		Page 79
204 BACK BORING With automatic pre-positioning, 2nd setup clearance		Page 83
205 UNIVERSAL PECKING With automatic pre-positioning, 2nd setup clearance, chip breaking, and advanced stop distance		Page 87
208 BORE MILLING With automatic pre-positioning, 2nd setup clearance		Page 91
241 SINGLE-FLUTED DEEP-HOLE DRILLING With automatic pre-positioning to deepened starting point, shaft speed and coolant definition		Page 94

3.2 CENTERING (Cycle 240, DIN/ISO: G240)

Cycle run

- 1 The TNC positions the tool in the spindle axis at rapid traverse **FMAX** to the setup clearance above the workpiece surface.
- 2 The tool is centered at the programmed feed rate **F** to the entered centering diameter or centering depth.
- 3 If defined, the tool remains at the centering depth.
- 4 Finally, the tool moves to setup clearance or—if programmed—to the 2nd setup clearance at rapid traverse **FMAX**.

Please note while programming:



Program a positioning block for the starting point (hole center) in the working plane with radius compensation **R0**.

The algebraic sign for the cycle parameter **Q344** (diameter) or **Q201** (depth) determines the working direction. If you program the diameter or depth = 0, the cycle will not be executed.



Danger of collision!

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

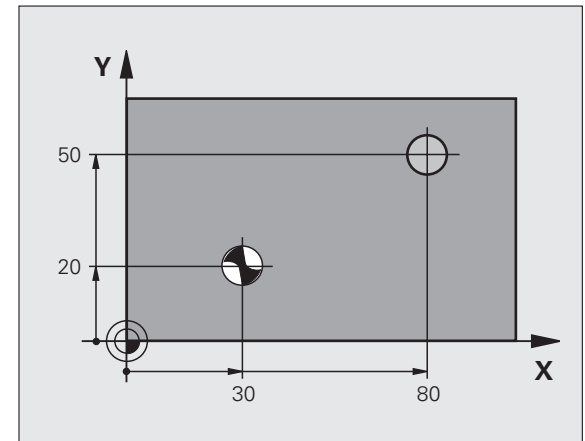
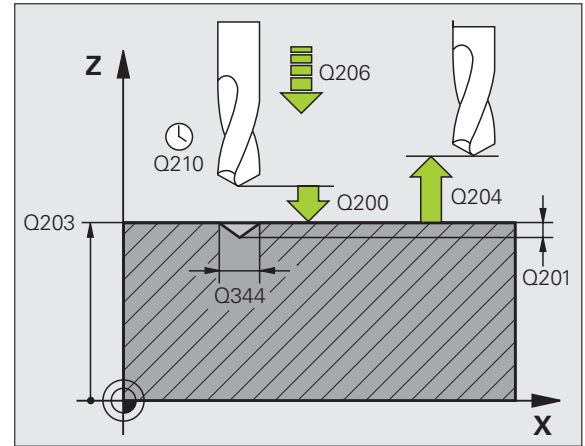
Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive diameter or depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!



Cycle parameters



- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface. Enter a positive value. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Select Depth/Diameter (0/1)** Q343: Select whether centering is based on the entered diameter or depth. If the TNC is to center based on the entered diameter, the point angle of the tool must be defined in the **T-ANGLE** column of the tool table TOOL.T.
0: Centering based on the entered depth
1: Centering based on the entered diameter
- ▶ **Depth** Q201 (incremental value): Distance between workpiece surface and centering bottom (tip of centering taper). Only effective if Q343=0 is defined. Input range: -99999.9999 to 99999.9999
- ▶ **Diameter (algebraic sign)** Q344: Centering diameter. Only effective if Q343=1 is defined. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging** Q206: Traversing speed of the tool during centering in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU**.
- ▶ **Dwell time at depth** Q211: Time in seconds that the tool remains at the hole bottom. Input range 0 to 3600.0000, alternatively **PREDEF**
- ▶ **Workpiece surface coordinate** Q203 (absolute): Coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**



Example: NC blocks

```

10 L Z+100 R0 FMAX
11 CYCL DEF 240 CENTERING
    Q200=2    ;SETUP CLEARANCE
    Q343=1    ;SELECT DEPTH/DIA.
    Q201=+0   ;DEPTH
    Q344=-9   ;DIAMETER
    Q206=250  ;FEED RATE FOR PLNGNG
    Q211=0.1  ;DWELL TIME AT DEPTH
    Q203=+20  ;SURFACE COORDINATE
    Q204=100  ;2ND SETUP CLEARANCE
12 CYCL CALL POS X+30 Y+20 Z+0 FMAX M3
13 CYCL CALL POS X+80 Y+50 Z+0 FMAX
    
```

3.3 DRILLING (Cycle 200)

Cycle run

- 1 The TNC positions the tool in the spindle axis at rapid traverse **FMAX** to the setup clearance above the workpiece surface.
- 2 The tool drills to the first plunging depth at the programmed feed rate **F**.
- 3 The TNC returns the tool at **FMAX** to the setup clearance, dwells there (if a dwell time was entered), and then moves at **FMAX** to the setup clearance above the first plunging depth.
- 4 The tool then advances with another infeed at the programmed feed rate **F**.
- 5 The TNC repeats this process (2 to 4) until the programmed depth is reached.
- 6 The tool is retracted from the hole bottom to the setup clearance or—if programmed—to the 2nd setup clearance at **FMAX**.

Please note while programming:



Program a positioning block for the starting point (hole center) in the working plane with radius compensation **R0**.

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.



Danger of collision!

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

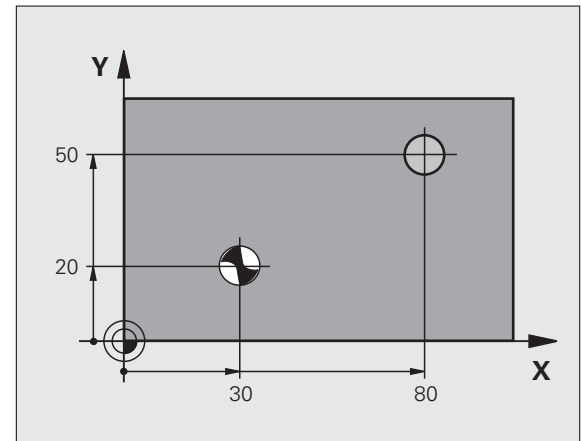
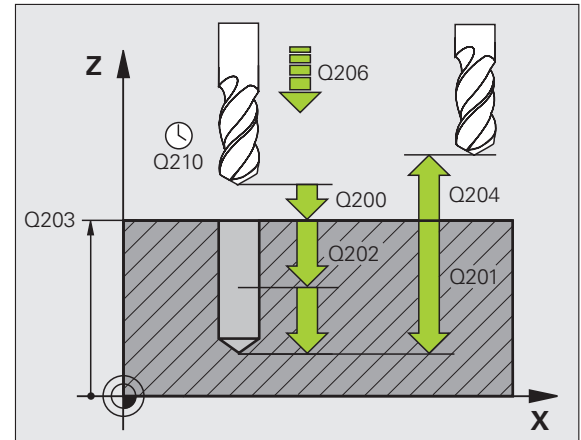
Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!



Cycle parameters



- ▶ **Setup clearance Q200** (incremental): Distance between tool tip and workpiece surface. Enter a positive value. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Depth Q201** (incremental): Distance between workpiece surface and bottom of hole (tip of drill taper). Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging Q206**: Traversing speed of the tool during drilling in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU**.
- ▶ **Plunging depth Q202** (incremental): Infeed per cut. Input range 0 to 99999.9999. The depth does not have to be a multiple of the plunging depth. The TNC will go to depth in one movement if:
 - the plunging depth is equal to the depth
 - the plunging depth is greater than the depth
- ▶ **Dwell time at top Q210**: Time in seconds that the tool remains at setup clearance after having been retracted from the hole for chip release. Input range 0 to 3600.0000, alternatively **PREDEF**
- ▶ **Workpiece surface coordinate Q203** (absolute): Coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance Q204** (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Dwell time at depth Q211**: Time in seconds that the tool remains at the hole bottom. Input range 0 to 3600.0000, alternatively **PREDEF**



Example: NC blocks

```

11 CYCL DEF 200 DRILLING
    Q200=2    ;SETUP CLEARANCE
    Q201=-15  ;DEPTH
    Q206=250  ;FEED RATE FOR PLNGNG
    Q202=5    ;PLUNGING DEPTH
    Q210=0    ;DWELL TIME AT TOP
    Q203=+20  ;SURFACE COORDINATE
    Q204=100  ;2ND SETUP CLEARANCE
    Q211=0.1  ;DWELL TIME AT DEPTH
12 L X+30 Y+20 FMAX M3
13 CYCL CALL
14 L X+80 Y+50 FMAX M99
    
```

3.4 REAMING (Cycle 201, DIN/ISO: G201)

Cycle run

- 1 The TNC positions the tool in the spindle axis to the entered setup clearance above the workpiece surface at rapid traverse **FMAX**.
- 2 The tool reams to the entered depth at the programmed feed rate **F**.
- 3 If programmed, the tool remains at the hole bottom for the entered dwell time.
- 4 The tool then retracts to the setup clearance at the feed rate **F**, and from there—if programmed—to the 2nd setup clearance at **FMAX**.

Please note while programming:



Program a positioning block for the starting point (hole center) in the working plane with radius compensation **R0**.

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.



Danger of collision!

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

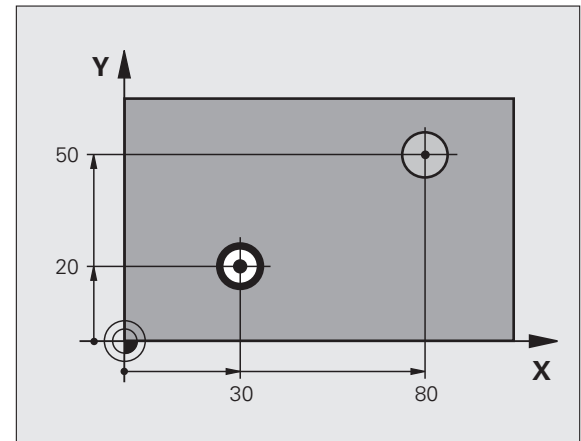
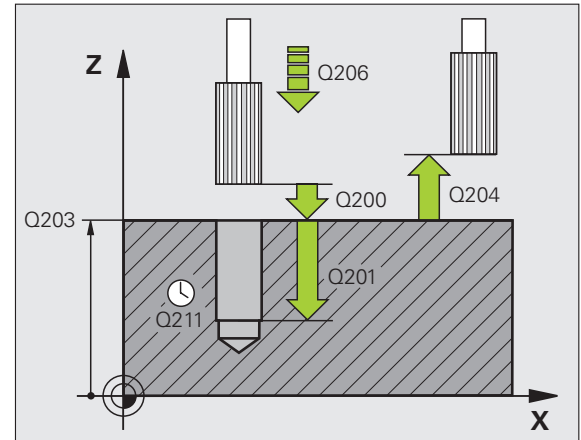
Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!



Cycle parameters



- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Depth** Q201 (incremental): Distance between workpiece surface and bottom of hole. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging** Q206: Traversing speed of the tool during reaming in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU**.
- ▶ **Dwell time at depth** Q211: Time in seconds that the tool remains at the hole bottom. Input range 0 to 3600.0000, alternatively **PREDEF**
- ▶ **Retraction feed rate** Q208: Traversing speed of the tool in mm/min when retracting from the hole. If you enter Q208 = 0, the tool retracts at the reaming feed rate. Input range: 0 to 99999.999
- ▶ **Workpiece surface coordinate** Q203 (absolute): Coordinate of the workpiece surface. Input range: 0 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**



Example: NC blocks

```

11 CYCL DEF 201 REAMING
    Q200=2    ;SETUP CLEARANCE
    Q201=-15  ;DEPTH
    Q206=100  ;FEED RATE FOR PLNGNG
    Q211=0.5  ;DWELL TIME AT DEPTH
    Q208=250  ;RETRACTION FEED RATE
    Q203=+20  ;SURFACE COORDINATE
    Q204=100  ;2ND SETUP CLEARANCE
12 L X+30 Y+20 FMAX M3
13 CYCL CALL
14 L X+80 Y+50 FMAX M9
15 L Z+100 FMAX M2
  
```

3.5 BORING (Cycle 202, DIN/ISO: G202)

Cycle run

- 1** The TNC positions the tool in the spindle axis at rapid traverse **FMAX** to the setup clearance above the workpiece surface.
- 2** The tool drills to the programmed depth at the feed rate for plunging.
- 3** If programmed, the tool remains at the hole bottom for the entered dwell time with active spindle rotation for cutting free.
- 4** The TNC then orients the spindle to the position that is defined in parameter Q336.
- 5** If retraction is selected, the tool retracts in the programmed direction by 0.2 mm (fixed value).
- 6** The TNC moves the tool at the retraction feed rate to the setup clearance and then, if entered, to the 2nd setup clearance at **FMAX**. If Q214=0, the tool point remains on the wall of the hole.



Please note while programming:



Machine and TNC must be specially prepared by the machine tool builder for use of this cycle.

This cycle is effective only for machines with servo-controlled spindle.



Program a positioning block for the starting point (hole center) in the working plane with radius compensation **R0**.

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.

After the cycle is completed, the TNC restores the coolant and spindle conditions that were active before the cycle call.



Danger of collision!

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!

Select a disengaging direction in which the tool moves away from the edge of the hole.

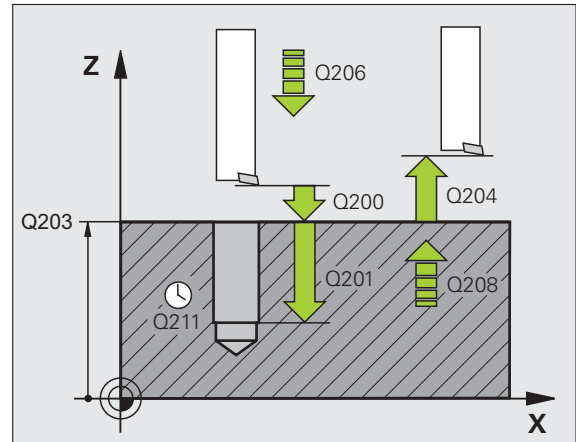
Check the position of the tool tip when you program a spindle orientation to the angle that you enter in Q336 (for example, in the Positioning with Manual Data Input mode of operation). Set the angle so that the tool tip is parallel to a coordinate axis.

During retraction the TNC automatically takes an active rotation of the coordinate system into account.

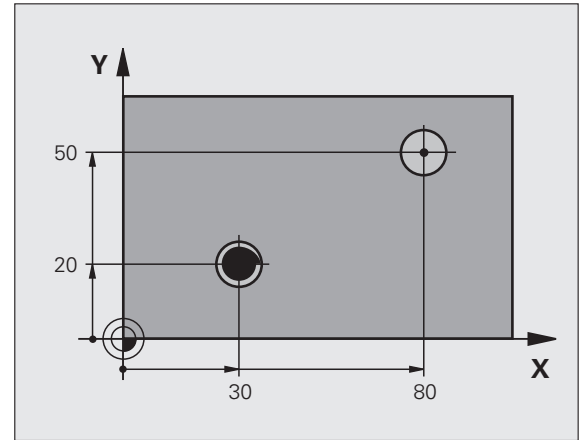
Cycle parameters



- ▶ **Setup clearance Q200** (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Depth Q201** (incremental): Distance between workpiece surface and bottom of hole. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging Q206**: Traversing speed of the tool during boring at mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU**.
- ▶ **Dwell time at depth Q211**: Time in seconds that the tool remains at the hole bottom. Input range 0 to 3600.0000, alternatively **PREDEF**
- ▶ **Retraction feed rate Q208**: Traversing speed of the tool in mm/min when retracting from the hole. If you enter $Q208 = 0$, the tool retracts at feed rate for plunging. Input range 0 to 99999.999, alternatively **FMAX, FAUTO, PREDEF**
- ▶ **Workpiece surface coordinate Q203** (absolute): Coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance Q204** (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.999, alternatively **PREDEF**



- **Disengaging direction (0/1/2/3/4) Q214:**
Determine the direction in which the TNC retracts the tool at the hole bottom (after spindle orientation).
- 0** Do not retract tool
- 1** Retract tool in the negative ref. axis direction
- 2** Retract tool in the neg. minor axis direction
- 3** Retract tool in the positive ref. axis direction
- 4** Retract tool in the pos. minor axis direction
- **Angle for spindle orientation Q336 (absolute):**
Angle at which the TNC positions the tool before retracting it. Input range: -360.000 to 360.000



Example:

```

10 L Z+100 R0 FMAX
11 CYCL DEF 202 BORING
    Q200=2 ;SETUP CLEARANCE
    Q201=-15 ;DEPTH
    Q206=100 ;FEED RATE FOR PLNGNG
    Q211=0.5 ;DWELL TIME AT DEPTH
    Q208=250 ;RETRACTION FEED RATE
    Q203=+20 ;SURFACE COORDINATE
    Q204=100 ;2ND SETUP CLEARANCE
    Q214=1 ;DISENGAGING DIRECTN
    Q336=0 ;ANGLE OF SPINDLE
12 L X+30 Y+20 FMAX M3
13 CYCL CALL
14 L X+80 Y+50 FMAX M99

```

3.6 UNIVERSAL DRILLING (Cycle 203, DIN/ISO: G203)

Cycle run

- 1** The TNC positions the tool in the spindle axis to the entered setup clearance above the workpiece surface at rapid traverse **FMAX**.
- 2** The tool drills to the first plunging depth at the programmed feed rate **F**.
- 3** If you have programmed chip breaking, the tool then retracts by the entered retraction value. If you are working without chip breaking, the tool retracts at the retraction feed rate to the setup clearance, remains there—if programmed—for the entered dwell time, and advances again at **FMAX** to the setup clearance above the first PLUNGING DEPTH.
- 4** The tool then advances with another infeed at the programmed feed rate. If programmed, the plunging depth is decreased after each infeed by the decrement.
- 5** The TNC repeats this process (2 to 4) until the programmed total hole depth is reached.
- 6** The tool remains at the hole bottom—if programmed—for the entered dwell time to cut free, and then retracts to the setup clearance at the retraction feed rate. If programmed, the tool moves to the 2nd setup clearance at **FMAX**.



Please note while programming:

Program a positioning block for the starting point (hole center) in the working plane with radius compensation **R0**.

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.

**Danger of collision!**

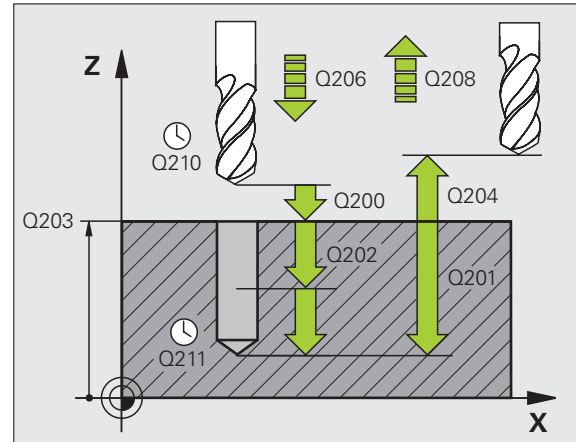
Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!

Cycle parameters



- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Depth** Q201 (incremental): Distance between workpiece surface and bottom of hole (tip of drill taper). Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging** Q206: Traversing speed of the tool during drilling in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU**.
- ▶ **Plunging depth** Q202 (incremental): Infeed per cut. Input range 0 to 99999.9999. The depth does not have to be a multiple of the plunging depth. The TNC will go to depth in one movement if:
 - the plunging depth is equal to the depth
 - the plunging depth is greater than the depth and no chip breaking is defined
- ▶ **Dwell time at top** Q210: Time in seconds that the tool remains at setup clearance after having been retracted from the hole for chip release. Input range 0 to 3600.0000, alternatively **PREDEF**
- ▶ **Workpiece surface coordinate** Q203 (absolute): Coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Decrement** Q212 (incremental): Value by which the TNC decreases the plunging depth Q202 after each infeed. Input range: 0 to 99999.9999



- ▶ **No. of breaks before retracting** Q213: Number of chip breaks after which the TNC is to withdraw the tool from the hole for chip release. For chip breaking, the TNC retracts the tool each time by the value in Q256. Input range: 0 to 99999
- ▶ **Minimum plunging depth** Q205 (incremental): If you have entered a decrement, the TNC limits the plunging depth to the value entered with Q205. Input range: 0 to 99999.9999
- ▶ **Dwell time at depth** Q211: Time in seconds that the tool remains at the hole bottom. Input range 0 to 3600.0000, alternatively **PREDEF**
- ▶ **Retraction feed rate** Q208: Traversing speed of the tool in mm/min when retracting from the hole. If you enter Q208 = 0, the TNC retracts the tool at the feed rate in Q206. Input range 0 to 99999.999, alternatively **FMAX, FAUTO, PREDEF**
- ▶ **Retraction rate for chip breaking** Q256 (incremental): Value by which the TNC retracts the tool during chip breaking. Input range 0.1000 to 99999.9999, alternatively **PREDEF**

Example: NC blocks

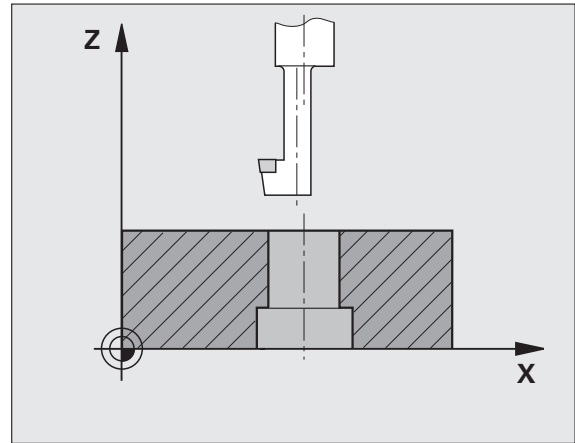
11	CYCL DEF 203	UNIVERSAL DRILLING
Q200=2	;SETUP CLEARANCE	
Q201=-20	;DEPTH	
Q206=150	;FEED RATE FOR PLNGNG	
Q202=5	;PLUNGING DEPTH	
Q210=0	;DWELL TIME AT TOP	
Q203=+20	;SURFACE COORDINATE	
Q204=50	;2ND SETUP CLEARANCE	
Q212=0.2	;DECREMENT	
Q213=3	;BREAKS	
Q205=3	;MIN. PLUNGING DEPTH	
Q211=0.25	;DWELL TIME AT DEPTH	
Q208=500	;RETRACTION FEED RATE	
Q256=0.2	;DIST. FOR CHIP BRKNG	

3.7 BACK BORING (Cycle 204, DIN/ISO: G204)

Cycle run

This cycle allows holes to be bored from the underside of the workpiece.

- 1 The TNC positions the tool in the spindle axis at rapid traverse **FMAX** to the setup clearance above the workpiece surface.
- 2 The TNC then orients the spindle to the 0° position with an oriented spindle stop, and displaces the tool by the off-center distance.
- 3 The tool is then plunged into the already bored hole at the feed rate for pre-positioning until the tooth has reached the setup clearance on the underside of the workpiece.
- 4 The TNC then centers the tool again over the bore hole, switches on the spindle and the coolant and moves at the feed rate for boring to the depth of bore.
- 5 If a dwell time is entered, the tool will pause at the top of the bore hole and will then be retracted from the hole again. Another oriented spindle stop is carried out and the tool is once again displaced by the off-center distance.
- 6 The TNC moves the tool at the pre-positioning feed rate to the setup clearance and then – if entered – to the 2nd setup clearance at **FMAX**.



Please note while programming:



Machine and TNC must be specially prepared by the machine tool builder for use of this cycle.

This cycle is effective only for machines with servo-controlled spindle.

Special boring bars for upward cutting are required for this cycle.



Program a positioning block for the starting point (hole center) in the working plane with radius compensation **R0**.

The algebraic sign for the cycle parameter depth determines the working direction. Note: A positive sign bores in the direction of the positive spindle axis.

The entered tool length is the total length to the underside of the boring bar and not just to the tooth.

When calculating the starting point for boring, the TNC considers the tooth length of the boring bar and the thickness of the material.



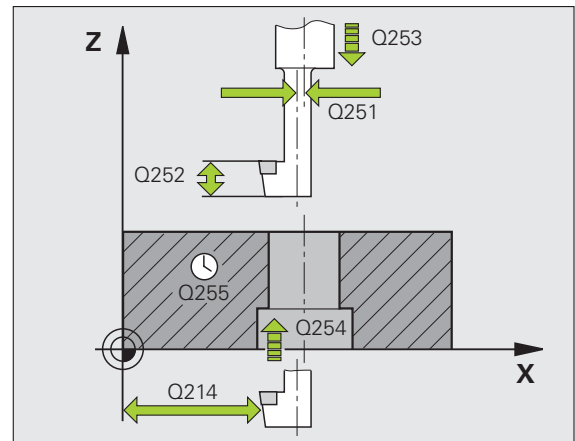
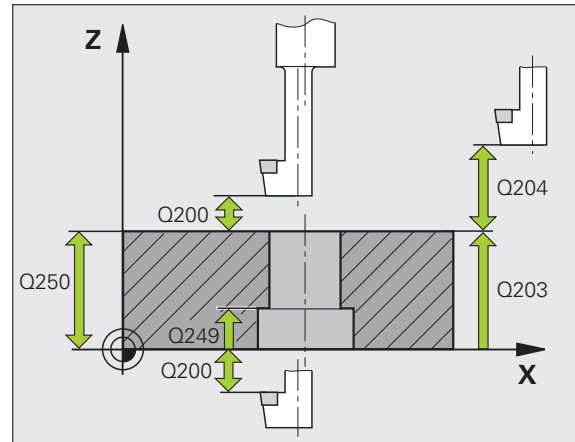
Danger of collision!

Check the position of the tool tip when you program a spindle orientation to the angle that you enter in **Q336** (for example, in the Positioning with Manual Data Input mode of operation). Set the angle so that the tool tip is parallel to a coordinate axis. Select a disengaging direction in which the tool moves away from the edge of the hole.

Cycle parameters



- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Depth of counterbore** Q249 (incremental): Distance between underside of workpiece and the top of the hole. A positive sign means the hole will be bored in the positive spindle axis direction. Input range: -99999.9999 to 99999.9999
- ▶ **Material thickness** Q250 (incremental): Thickness of the workpiece. Input range: 0.0001 to 99999.9999
- ▶ **Off-center distance** Q251 (incremental): Off-center distance for the boring bar; value from tool data sheet. Input range: 0.0001 to 99999.9999
- ▶ **Tool edge height** Q252 (incremental): Distance between the underside of the boring bar and the main cutting tooth; value from tool data sheet. Input range: 0.0001 to 99999.9999
- ▶ **Feed rate for pre-positioning** Q253: Traversing speed of the tool in mm/min when plunging into the workpiece, or when retracting from the workpiece. Input range 0 to 99999.999, alternatively **FMAX**, **FAUTO**, **PREDEF**.
- ▶ **Feed rate for back boring** Q254: Traversing speed of the tool during back boring in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO**, **FU**.
- ▶ **Dwell time** Q255: Dwell time in seconds at the top of the bore hole. Input range: 0 to 3600.000



- ▶ **Workpiece surface coordinate** Q203 (absolute):
Coordinate of the workpiece surface. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range: 0 to 99999.9999
- ▶ **Disengaging direction (0/1/2/3/4)** Q214:
Determine the direction in which the TNC displaces the tool by the off-center distance (after spindle orientation). Input of 0 is not permitted.
 - 1 Retract tool in the negative ref. axis direction
 - 2 Retract tool in the neg. minor axis direction
 - 3 Retract tool in the positive ref. axis direction
 - 4 Retract tool in the pos. minor axis direction
- ▶ **Angle for spindle orientation** Q336 (absolute):
Angle at which the TNC positions the tool before it is plunged into or retracted from the bore hole. Input range: -360.0000 to 360.0000

Example: NC blocks

11 CYCL DEF 204 BACK BORING	
Q200=2	; SETUP CLEARANCE
Q249=+5	; DEPTH OF COUNTERBORE
Q250=20	; MATERIAL THICKNESS
Q251=3.5	; OFF-CENTER DISTANCE
Q252=15	; TOOL EDGE HEIGHT
Q253=750	; F PRE-POSITIONING
Q254=200	; F COUNTERSINKING
Q255=0	; DWELL TIME
Q203=+20	; SURFACE COORDINATE
Q204=50	; 2ND SETUP CLEARANCE
Q214=1	; DISENGAGING DIRECTN
Q336=0	; ANGLE OF SPINDLE

3.8 UNIVERSAL PECKING (Cycle 205, DIN/ISO: G205)

Cycle run

- 1** The TNC positions the tool in the spindle axis to the entered setup clearance above the workpiece surface at rapid traverse **FMAX**.
- 2** If you enter a deepened starting point, the TNC moves at the defined positioning feed rate to the setup clearance above the deepened starting point.
- 3** The tool drills to the first plunging depth at the programmed feed rate **F**.
- 4** If you have programmed chip breaking, the tool then retracts by the entered retraction value. If you are working without chip breaking, the tool is moved at rapid traverse to the setup clearance, and then at **FMAX** to the entered starting position above the first plunging depth.
- 5** The tool then advances with another infeed at the programmed feed rate. If programmed, the plunging depth is decreased after each infeed by the decrement.
- 6** The TNC repeats this process (2 to 4) until the programmed total hole depth is reached.
- 7** The tool remains at the hole bottom—if programmed—for the entered dwell time to cut free, and then retracts to the setup clearance at the retraction feed rate. If programmed, the tool moves to the 2nd setup clearance at **FMAX**.



Please note while programming:

Program a positioning block for the starting point (hole center) in the working plane with radius compensation **R0**.

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.

If you enter advance stop distances **Q258** not equal to **Q259**, the TNC will change the advance stop distances between the first and last plunging depths at the same rate.

If you use **Q379** to enter a deepened starting point, the TNC merely changes the starting point of the infeed movement. Retraction movements are not changed by the TNC, therefore they are calculated with respect to the coordinate of the workpiece surface.

**Danger of collision!**

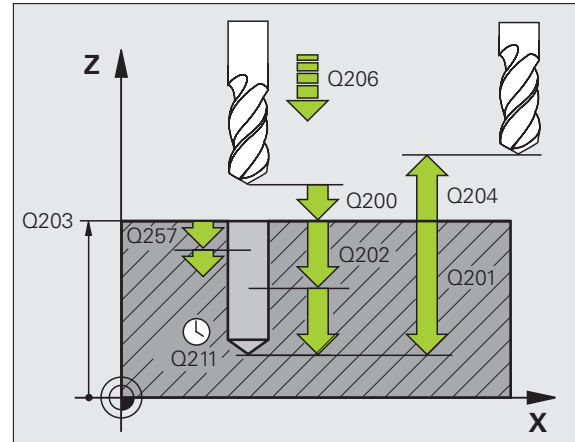
Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!

Cycle parameters



- ▶ **Setup clearance Q200** (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Depth Q201** (incremental): Distance between workpiece surface and bottom of hole (tip of drill taper). Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging Q206**: Traversing speed of the tool during drilling in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU**.
- ▶ **Plunging depth Q202** (incremental): Infeed per cut. Input range 0 to 99999.9999. The depth does not have to be a multiple of the plunging depth. The TNC will go to depth in one movement if:
 - the plunging depth is equal to the depth
 - the plunging depth is greater than the depth
- ▶ **Workpiece surface coordinate Q203** (absolute): Coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance Q204** (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Decrement Q212** (incremental): Value by which the TNC decreases the plunging depth Q202. Input range: 0 to 99999.9999
- ▶ **Minimum plunging depth Q205** (incremental): If you have entered a decrement, the TNC limits the plunging depth to the value entered with Q205. Input range: 0 to 99999.9999
- ▶ **Upper advanced stop distance Q258** (incremental): Setup clearance for rapid traverse positioning when the TNC moves the tool again to the current plunging depth after retraction from the hole; value for the first plunging depth. Input range: 0 to 99999.9999
- ▶ **Lower advanced stop distance Q259** (incremental): Setup clearance for rapid traverse positioning when the TNC moves the tool again to the current plunging depth after retraction from the hole; value for the last plunging depth. Input range: 0 to 99999.9999



- ▶ **Infeed depth for chip breaking** Q257 (incremental): Depth at which the TNC carries out chip breaking. No chip breaking if 0 is entered. Input range: 0 to 99999.9999
- ▶ **Retraction rate for chip breaking** Q256 (incremental): Value by which the TNC retracts the tool during chip breaking. The TNC retracts the tool at a feed rate of 3000 mm/min. Input range 0.1000 to 99999.9999, alternatively **PREDEF**.
- ▶ **Dwell time at depth** Q211: Time in seconds that the tool remains at the hole bottom. Input range 0 to 3600.0000, alternatively **PREDEF**
- ▶ **Deepened starting point** Q379 (incremental with respect to the workpiece surface): Starting position of drilling if a shorter tool has already pilot drilled to a certain depth. The TNC moves at the **feed rate for pre-positioning** from the setup clearance to the deepened starting point. Input range: 0 to 99999.9999
- ▶ **Feed rate for pre-positioning** Q253: Traversing velocity of the tool during positioning from the setup clearance to a deepened starting point in mm/min. Effective only if Q379 is entered not equal to 0. Input range 0 to 99999.999, alternatively **FMAX**, **FAUTO**, **PREDEF**

Example: NC blocks

11	CYCL DEF 205	UNIVERSAL PECKING
Q200=2	;SETUP CLEARANCE	
Q201=-80	;DEPTH	
Q206=150	;FEED RATE FOR PLNGNG	
Q202=15	;PLUNGING DEPTH	
Q203=+100	;SURFACE COORDINATE	
Q204=50	;2ND SETUP CLEARANCE	
Q212=0.5	;DECREMENT	
Q205=3	;MIN. PLUNGING DEPTH	
Q258=0.5	;UPPER ADV. STOP DIST.	
Q259=1	;LOWER ADV. STOP DIST.	
Q257=5	;DEPTH FOR CHIP BRKNG	
Q256=0.2	;DIST. FOR CHIP BRKNG	
Q211=0.25	;DWELL TIME AT DEPTH	
Q379=7.5	;STARTING POINT	
Q253=750	;F PRE-POSITIONING	



3.9 BORE MILLING (Cycle 208)

Cycle run

- 1** The TNC positions the tool in the spindle axis at rapid traverse **FMAX** to the programmed setup clearance above the workpiece surface and then moves the tool to the bore hole circumference on a rounded arc (if enough space is available).
- 2** The tool mills in a helix from the current position to the first plunging depth at the programmed feed rate **F**.
- 3** When the drilling depth is reached, the TNC once again traverses a full circle to remove the material remaining after the initial plunge.
- 4** The TNC then positions the tool at the center of the hole again.
- 5** Finally the TNC returns to the setup clearance at **FMAX**. If programmed, the tool moves to the 2nd setup clearance at **FMAX**.



Please note while programming:



Program a positioning block for the starting point (hole center) in the working plane with radius compensation **R0**.

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.

If you have entered the bore hole diameter to be the same as the tool diameter, the TNC will bore directly to the entered depth without any helical interpolation.

An active mirror function **does not** influence the type of milling defined in the cycle.

Note that if the infeed distance is too large, the tool or the workpiece may be damaged.

To prevent the infeeds from being too large, enter the maximum plunge angle of the tool in the **ANGLE** column of the tool table. The TNC then automatically calculates the max. infeed permitted and changes your entered value accordingly.



Danger of collision!

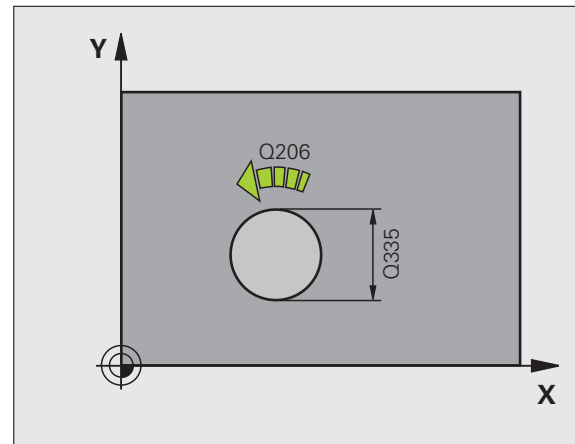
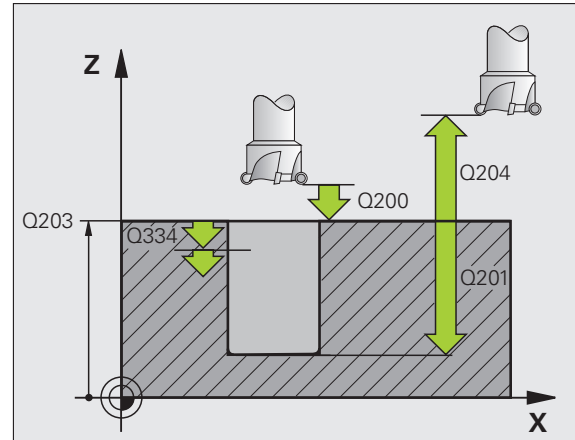
Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!

Cycle parameters



- ▶ **Setup clearance** Q200 (incremental): Distance between tool lower edge and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Depth** Q201 (incremental): Distance between workpiece surface and bottom of hole. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging** Q206: Traversing speed of the tool during helical drilling in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU, FZ**.
- ▶ **Infeed per helix** Q334 (incremental): Depth of the tool plunge with each helix (=360°). Input range: 0 to 99999.9999
- ▶ **Workpiece surface coordinate** Q203 (absolute): Coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Nominal diameter** Q335 (absolute value): Bore-hole diameter. If you have entered the nominal diameter to be the same as the tool diameter, the TNC will bore directly to the entered depth without any helical interpolation. Input range: 0 to 99999.9999
- ▶ **Roughing diameter** Q342 (absolute): As soon as you enter a value greater than 0 in Q342, the TNC no longer checks the ratio between the nominal diameter and the tool diameter. This allows you to rough-mill holes whose diameter is more than twice as large as the tool diameter. Input range: 0 to 99999.9999
- ▶ **Climb or up-cut** Q351: Type of milling operation with M3
 - +1** = climb milling
 - 1** = up-cut milling
 - PREDEF** = use the default value from **GLOBAL DEF**



Example: NC blocks

```

12 CYCL DEF 208 BORE MILLING
Q200=2    ;SETUP CLEARANCE
Q201=-80  ;DEPTH
Q206=150  ;FEED RATE FOR PLNGNG
Q334=1.5  ;PLUNGING DEPTH
Q203=+100 ;SURFACE COORDINATE
Q204=50   ;2ND SETUP CLEARANCE
Q335=25   ;NOMINAL DIAMETER
Q342=0    ;ROUGHING DIAMETER
Q351=+1   ;CLIMB OR UP-CUT
  
```



3.10 SINGLE-FLUTED DEEP-HOLE DRILLING (Cycle 241, DIN/ISO: G241)

Cycle run

- 1 The TNC positions the tool in the spindle axis to the entered setup clearance above the workpiece surface at rapid traverse **FMAX**.
- 2 Then the TNC moves the tool at the defined positioning feed rate to the setup clearance above the deepened starting point and switches on the drilling speed (**M3**) and the coolant.
- 3 The tool drills to the entered drilling depth at the programmed feed rate **F**.
- 4 If programmed, the tool remains at the hole bottom for chip breaking. Then the TNC switches off the coolant and resets the drilling speed to the value defined for retraction.
- 5 After the dwell time at the hole bottom, the tool is retracted to the setup clearance at the retraction feed rate. If programmed, the tool moves to the 2nd setup clearance at **FMAX**.

Please note while programming:



Program a positioning block for the starting point (hole center) in the working plane with radius compensation **R0**.

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.



Danger of collision!

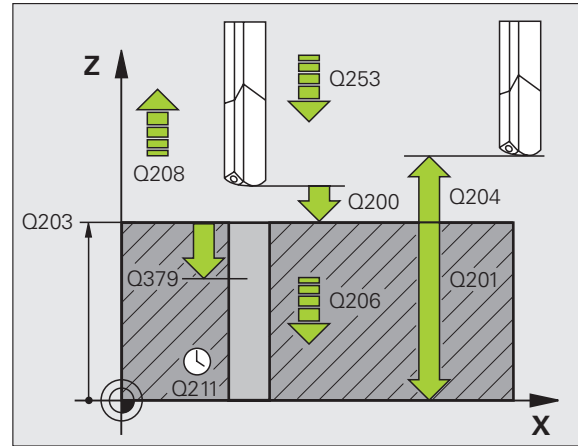
Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!

Cycle parameters



- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Depth** Q201 (incremental): Distance between workpiece surface and bottom of hole. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging** Q206: Traversing speed of the tool during drilling in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU**.
- ▶ **Dwell time at depth** Q211: Time in seconds that the tool remains at the hole bottom. Input range 0 to 3600.0000, alternatively **PREDEF**
- ▶ **Workpiece surface coordinate** Q203 (absolute): Coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Deepened starting point** Q379 (incremental with respect to the workpiece surface): Starting position for actual drilling operation. The TNC moves at the **feed rate for pre-positioning** from the setup clearance to the deepened starting point. Input range: 0 to 99999.9999
- ▶ **Feed rate for pre-positioning** Q253: Traversing velocity of the tool during positioning from the setup clearance to the deepened starting point in mm/min. Effective only if Q379 is entered not equal to 0. Input range 0 to 99999.999, alternatively **FMAX, FAUTO, PREDEF**
- ▶ **Retraction feed rate** Q208: Traversing speed of the tool in mm/min when retracting from the hole. If you enter Q208 = 0, the TNC retracts the tool at the feed rate in Q206. Input range 0 to 99999.999, alternatively **FMAX, FAUTO, PREDEF**



- ▶ **Rotat. dir. of entry/exit** Q426: Desired direction of spindle rotation when tool moves into and retracts from the hole Input range:
3: Spindle rotation with M3
4: Spindle rotation with M4
5: Movement with stationary spindle
- ▶ **Spindle speed of entry/exit** Q427: Desired spindle speed when tool moves into and retracts from the hole Input range: 0 to 99999
- ▶ **Drilling speed** Q428: Desired speed for drilling Input range: 0 to 99999
- ▶ **M function for coolant on?** Q429: M function for switching on the coolant The TNC switches the coolant on if the tool is in the hole at the deepened starting point Input range: 0 to 999
- ▶ **M function for coolant off?** Q430: M function for switching off the coolant The TNC switches the coolant off if the tool is at the hole depth. Input range: 0 to 999

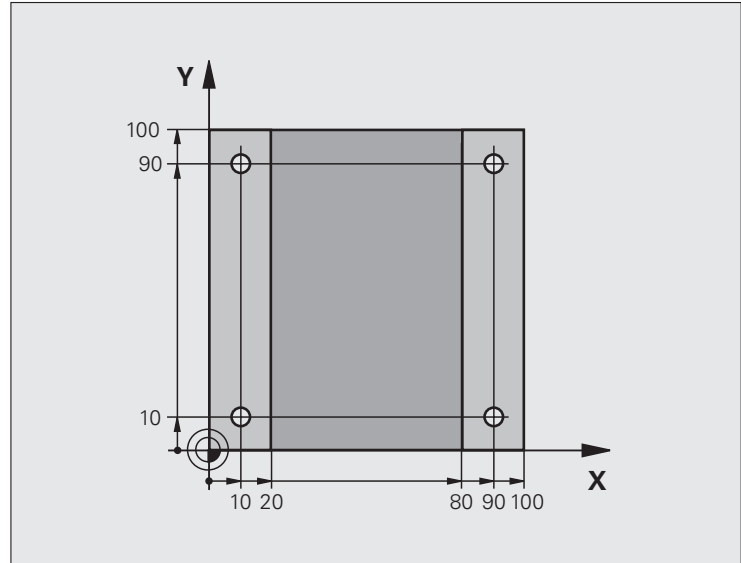
Example: NC blocks

11 CYCL DEF 241 SINGLE-LIP DEEP-HOLE DRILLING	
Q200=2	;SETUP CLEARANCE
Q201=-80	;DEPTH
Q206=150	;FEED RATE FOR PLNGNG
Q211=0.25	;DWELL TIME AT DEPTH
Q203=+100	;SURFACE COORDINATE
Q204=50	;2ND SETUP CLEARANCE
Q379=7.5	;STARTING POINT
Q253=750	;F PRE-POSITIONING
Q208=1000	;RETRACTION FEED RATE
Q426=3	;DIR. OF SPINDLE ROT.
Q427=25	;ROT. SPEED INFEED/OUT
Q428=500	;DRILLING SPEED
Q429=8	;COOLANT ON
Q430=9	;COOLANT OFF



3.11 Programming examples

Example: Drilling cycles



0 BEGIN PGM C200 MM	
1 BLK FORM 0.1 Z X+0 Y+0 Z-20	Definition of workpiece blank
2 BLK FORM 0.2 X+100 Y+100 Z+0	
3 TOOL CALL 1 Z S4500	Tool call (tool radius 3)
4 L Z+250 R0 FMAX	Retract the tool
5 CYCL DEF 200 DRILLING	Cycle definition
Q200=2 ;SETUP CLEARANCE	
Q201=-15 ;DEPTH	
Q206=250 ;FEED RATE FOR PLNGN	
Q202=5 ;PLUNGING DEPTH	
Q210=0 ;DWELL TIME AT TOP	
Q203=-10 ;SURFACE COORDINATE	
Q204=20 ;2ND SET-UP CLEARANCE	
Q211=0.2 ;DWELL TIME AT DEPTH	

6 L X+10 Y+10 R0 FMAX M3	Approach hole 1, spindle ON
7 CYCL CALL	Cycle call
8 L Y+90 R0 FMAX M99	Approach hole 2, call cycle
9 L X+90 R0 FMAX M99	Approach hole 3, call cycle
10 L Y+10 R0 FMAX M99	Approach hole 4, call cycle
11 L Z+250 R0 FMAX M2	Retract in the tool axis, end program
12 END PGM C200 MM	



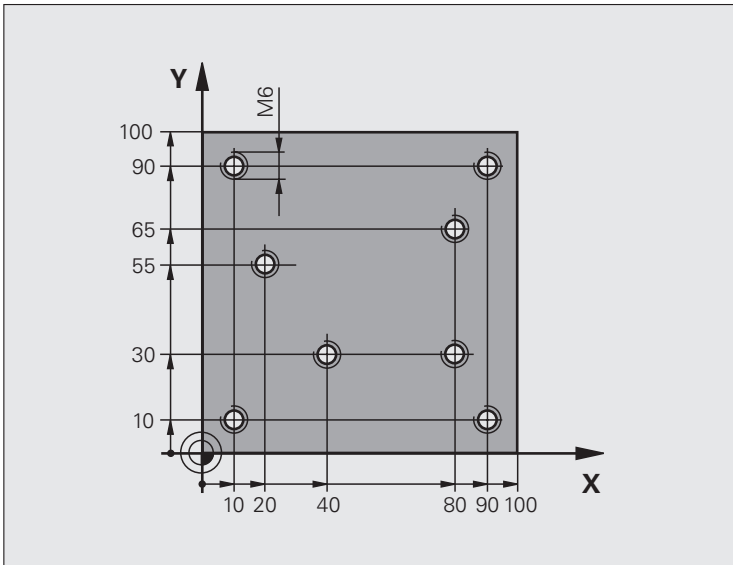
Example: Using drilling cycles in connection with PATTERN DEF

The drill hole coordinates are stored in the pattern definition **PATTERN DEF POS** and are called by the TNC with **CYCL CALL PAT**:

The tool radii are selected so that all work steps can be seen in the test graphics.

Program sequence

- Centering (tool radius 4)
- Drilling (tool radius 2,4)
- Tapping (tool radius 3)



0 BEGIN PGM 1 MM	
1 BLK FORM 0.1 Z X+0 Y+0 Z-20	Definition of workpiece blank
2 BLK FORM 0.2 X+100 Y+100 Y+0	
3 TOOL CALL 1 Z S5000	Call the centering tool (tool radius 4)
4 L Z+10 R0 F5000	Move tool to clearance height (enter a value for F)
	The TNC positions to the clearance height after every cycle
5 PATTERN DEF	Define all drilling positions in the point pattern
POS1(X+10 Y+10 Z+0)	
POS2(X+40 Y+30 Z+0)	
POS3(X+20 Y+55 Z+0)	
POS4(X+10 Y+90 Z+0)	
POS5(X+90 Y+90 Z+0)	
POS6(X+80 Y+65 Z+0)	
POS7(X+80 Y+30 Z+0)	
POS8(X+90 Y+10 Z+0)	



6 CYCL DEF 240 CENTERING	Cycle definition: CENTERING
Q200=2 ;SETUP CLEARANCE	
Q343=0 ;SELECT DEPTH/DIA.	
Q201=-2 ;DEPTH	
Q344=-10 ;DIAMETER	
Q206=150 ;FEED RATE FOR PLNGN	
Q211=0 ;DWELL TIME AT DEPTH	
Q203=+0 ;SURFACE COORDINATE	
Q204=50 ;2ND SETUP CLEARANCE	
7 CYCL CALL PAT F5000 M13	Call the cycle in connection with point pattern
8 L Z+100 R0 FMAX	Retract the tool, change the tool
9 TOOL CALL 2 Z S5000	Call the drilling tool (radius 2,4)
10 L Z+10 R0 F5000	Move tool to clearance height (enter a value for F)
11 CYCL DEF 200 DRILLING	Cycle definition: drilling
Q200=2 ;SETUP CLEARANCE	
Q201=-25 ;DEPTH	
Q206=150 ;FEED RATE FOR PECKING	
Q202=5 ;PLUNGING DEPTH	
Q210=0 ;DWELL TIME AT TOP	
Q203=+0 ;SURFACE COORDINATE	
Q204=50 ;2ND SETUP CLEARANCE	
Q211=0.2 ;DWELL TIME AT DEPTH	
12 CYCL CALL PAT F5000 M13	Call the cycle in connection with point pattern
13 L Z+100 R0 FMAX	Retract the tool
14 TOOL CALL 3 Z S200	Call the tapping tool (radius 3)
15 L Z+50 R0 FMAX	Move tool to clearance height
16 CYCL DEF 206 TAPPING NEW	Cycle definition for tapping
Q200=2 ;SETUP CLEARANCE	
Q201=-25 ;DEPTH OF THREAD	
Q206=150 ;FEED RATE FOR PECKING	
Q211=0 ;DWELL TIME AT DEPTH	
Q203=+0 ;SURFACE COORDINATE	
Q204=50 ;2ND SETUP CLEARANCE	
17 CYCL CALL PAT F5000 M13	Call the cycle in connection with point pattern
18 L Z+100 R0 FMAX M2	Retract in the tool axis, end program
19 END PGM 1 MM	





4









**Canned Cycles:
Tapping / Thread Milling**



4.1 Fundamentals

Overview

The TNC offers 8 cycles for all types of threading operations:

Cycle	Soft key	Page
206 TAPPING NEW With a floating tap holder, with automatic pre-positioning, 2nd setup clearance		Page 103
207 RIGID TAPPING NEW Without a floating tap holder, with automatic pre-positioning, 2nd setup clearance		Page 105
209 TAPPING W/ CHIP BREAKING Without a floating tap holder, with automatic pre-positioning, 2nd setup clearance, chip breaking		Page 108
262 THREAD MILLING Cycle for milling a thread in pre-drilled material		Page 113
263 THREAD MILLING/CNTSNKG Cycle for milling a thread in pre-drilled material and machining a countersunk chamfer		Page 116
264 THREAD DRILLING/MILLING Cycle for drilling into the solid material with subsequent milling of the thread with a tool		Page 120
265 HEL.THREAD DRILLING/MILLING Cycle for milling the thread into the solid material		Page 124
267 OUTSIDE THREAD MLLNG Cycle for milling an external thread and machining a countersunk chamfer		Page 124

4.2 TAPPING NEW with a floating tap holder (Cycle 206, DIN/ISO: G206)

Cycle run

- 1 The TNC positions the tool in the spindle axis to the entered setup clearance above the workpiece surface at rapid traverse **FMAX**.
- 2 The tool drills to the total hole depth in one movement.
- 3 Once the tool has reached the total hole depth, the direction of spindle rotation is reversed and the tool is retracted to the setup clearance at the end of the dwell time. If programmed, the tool moves to the 2nd setup clearance at **FMAX**.
- 4 At the setup clearance, the direction of spindle rotation reverses once again.

Please note while programming:



Program a positioning block for the starting point (hole center) in the working plane with radius compensation **R0**.

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.

A floating tap holder is required for tapping. It must compensate the tolerances between feed rate and spindle speed during the tapping process.

When a cycle is being run, the spindle speed override knob is disabled. The feed-rate override knob is active only within a limited range, which is defined by the machine tool builder (refer to your machine manual).

For tapping right-hand threads activate the spindle with **M3**, for left-hand threads use **M4**.



Danger of collision!

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!



Cycle parameters



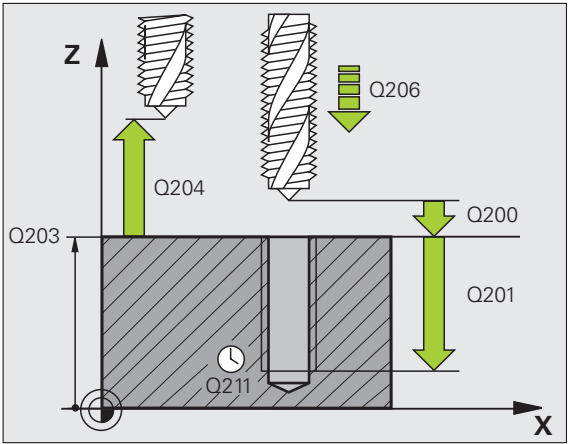
- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip (at starting position) and workpiece surface. Standard value: approx. 4 times the thread pitch. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Total hole depth** Q201 (thread length, incremental): Distance between workpiece surface and end of thread. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate F** Q206: Traversing speed of the tool during tapping. Input range: 0 to 99999.999, alternatively **FAUTO**
- ▶ **Dwell time at bottom** Q211: Enter a value between 0 and 0.5 seconds to avoid wedging of the tool during retraction. Input range 0 to 3600.0000, alternatively **PREDEF**
- ▶ **Workpiece surface coordinate** Q203 (absolute): Coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**

The feed rate is calculated as follows: $F = S \times p$

- F: Feed rate (mm/min)
- S: Spindle speed (rpm)
- p: Thread pitch (mm)

Retracting after a program interruption

If you interrupt program run during tapping with the machine stop button, the TNC will display a soft key with which you can retract the tool.



Example: NC blocks

25 CYCL DEF 206 TAPPING NEW	
Q200=2	;SETUP CLEARANCE
Q201=-20	;DEPTH
Q206=150	;FEED RATE FOR PLNGNG
Q211=0.25	;DWELL TIME AT DEPTH
Q203=+25	;SURFACE COORDINATE
Q204=50	;2ND SETUP CLEARANCE



4.3 RIGID TAPPING without a floating tap holder NEW (Cycle 207, DIN/ISO: G207)

Cycle run

The TNC cuts the thread without a floating tap holder in one or more passes.

- 1 The TNC positions the tool in the spindle axis to the entered setup clearance above the workpiece surface at rapid traverse **FMAX**.
- 2 The tool drills to the total hole depth in one movement.
- 3 Once the tool has reached the total hole depth, the direction of spindle rotation is reversed and the tool is retracted to the setup clearance at the end of the dwell time. If programmed, the tool moves to the 2nd setup clearance at **FMAX**.
- 4 The TNC stops the spindle turning at setup clearance.



Please note while programming:



Machine and TNC must be specially prepared by the machine tool builder for use of this cycle.

This cycle is effective only for machines with servo-controlled spindle.



Program a positioning block for the starting point (hole center) in the working plane with radius compensation **R0**.

The algebraic sign for the total hole depth parameter determines the working direction.

The TNC calculates the feed rate from the spindle speed. If the spindle speed override is used during tapping, the feed rate is automatically adjusted.

The feed-rate override knob is disabled.

At the end of the cycle the spindle comes to a stop. Before the next operation, restart the spindle with **M3** (or **M4**).



Danger of collision!

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!

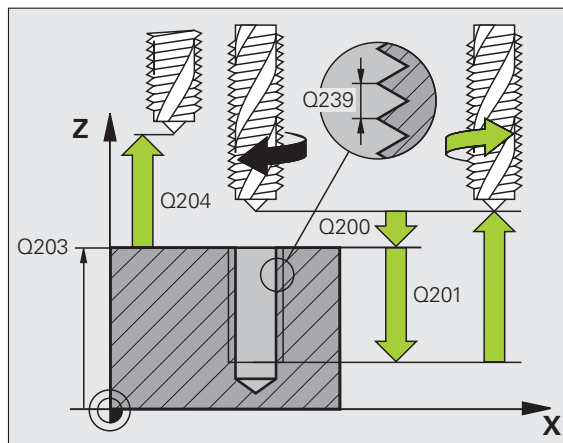
Cycle parameters



- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip (at starting position) and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Total hole depth** Q201 (incremental): Distance between workpiece surface and end of thread. Input range: -99999.9999 to 99999.9999
- ▶ **Pitch** Q239
Pitch of the thread. The algebraic sign differentiates between right-hand and left-hand threads:
 + = right-hand thread
 - = left-hand thread
 Input range -99.9999 to 99.9999
- ▶ **Workpiece surface coordinate** Q203 (absolute): Coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**

Retracting after a program interruption

If you interrupt program run during thread cutting with the machine stop button, the TNC will display the MANUAL OPERATION soft key. If you press the MANUAL OPERATION key, you can retract the tool under program control. Simply press the positive axis direction button of the active spindle axis.



Example: NC blocks

```

26 CYCL DEF 207 RIGID TAPPING NEW
  Q200=2    ;SETUP CLEARANCE
  Q201=-20  ;DEPTH
  Q239=+1   ;PITCH
  Q203=+25  ;SURFACE COORDINATE
  Q204=50   ;2ND SETUP CLEARANCE
  
```



4.4 TAPPING WITH CHIP BREAKING (Cycle 209, DIN/ISO: G209)

Cycle run

The TNC machines the thread in several passes until it reaches the programmed depth. You can define in a parameter whether the tool is to be retracted completely from the hole for chip breaking.

- 1 The TNC positions the tool in the tool axis at rapid traverse **FMAX** to the programmed setup clearance above the workpiece surface. There it carries out an oriented spindle stop.
- 2 The tool moves to the programmed infeed depth, reverses the direction of spindle rotation and retracts by a specific distance or completely for chip breaking, depending on the definition. If you have defined a factor for increasing the spindle speed, the TNC retracts from the hole at the corresponding speed
- 3 It then reverses the direction of spindle rotation again and advances to the next infeed depth.
- 4 The TNC repeats this process (2 to 3) until the programmed thread depth is reached.
- 5 The tool is then retracted to the setup clearance. If programmed, the tool moves to the 2nd setup clearance at **FMAX**.
- 6 The TNC stops the spindle turning at setup clearance.

Please note while programming:

Machine and TNC must be specially prepared by the machine tool builder for use of this cycle.

This cycle is effective only for machines with servo-controlled spindle.



Program a positioning block for the starting point (hole center) in the working plane with radius compensation **R0**.

The algebraic sign for the parameter thread depth determines the working direction.

The TNC calculates the feed rate from the spindle speed. If the spindle speed override is used during tapping, the feed rate is automatically adjusted.

The feed-rate override knob is disabled.

If you defined an rpm factor for fast retraction in cycle parameter **Q403**, the TNC limits the speed to the maximum speed of the active gear range.

At the end of the cycle the spindle comes to a stop. Before the next operation, restart the spindle with **M3** (or **M4**).

**Danger of collision!**

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

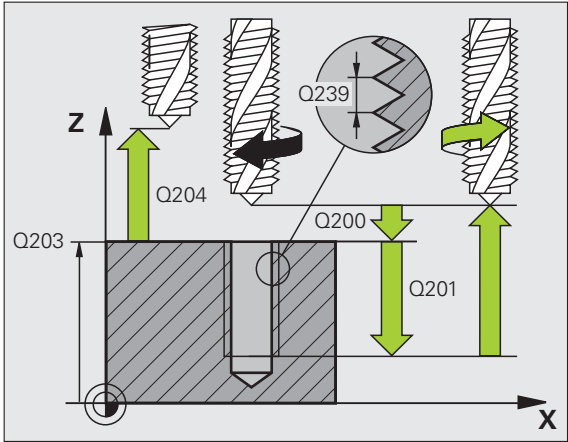
Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!



Cycle parameters



- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip (at starting position) and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Thread depth** Q201 (incremental): Distance between workpiece surface and end of thread. Input range: -99999.9999 to 99999.9999
- ▶ **Pitch** Q239
Pitch of the thread. The algebraic sign differentiates between right-hand and left-hand threads:
 - + = right-hand thread
 - = left-hand threadInput range -99.9999 to 99.9999
- ▶ **Workpiece surface coordinate** Q203 (absolute): Coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Infeed depth for chip breaking** Q257 (incremental): Depth at which TNC carries out chip breaking. Input range: 0 to 99999.9999
- ▶ **Retraction rate for chip breaking** Q256: The TNC multiplies the pitch Q239 by the programmed value and retracts the tool by the calculated value during chip breaking. If you enter Q256 = 0, the TNC retracts the tool completely from the hole (to the setup clearance) for chip breaking. Input range: 0.1000 to 99999.9999
- ▶ **Angle for spindle orientation** Q336 (absolute): Angle at which the TNC positions the tool before machining the thread. This allows you to regroove the thread, if required. Input range -360.0000 to 360.0000.
- ▶ **RPM factor for retraction** Q403: Factor by which the TNC increases the spindle speed—and therefore also the retraction feed rate—when retracting from the drill hole. Input range 0.0001 to 10, rpm is increased at most to the maximum speed of the active gear range.



Example: NC blocks

26 CYCL DEF 209 TAPPING W/ CHIP BRKG	
Q200=2	;SETUP CLEARANCE
Q201=-20	;DEPTH
Q239=+1	;PITCH
Q203=+25	;SURFACE COORDINATE
Q204=50	;2ND SETUP CLEARANCE
Q257=5	;DEPTH FOR CHIP BRKNG
Q256=+25	;DIST. FOR CHIP BRKNG
Q336=50	;ANGLE OF SPINDLE
Q403=1.5	;RPM FACTOR

Retracting after a program interruption

If you interrupt program run during thread cutting with the machine stop button, the TNC will display the MANUAL OPERATION soft key. If you press the MANUAL OPERATION key, you can retract the tool under program control. Simply press the positive axis direction button of the active spindle axis.



4.5 Fundamentals of thread milling

Prerequisites

- Your machine tool should feature internal spindle cooling (cooling lubricant at least 30 bars, compressed air supply at least 6 bars).
- Thread milling usually leads to distortions of the thread profile. To correct this effect, you need tool-specific compensation values which are given in the tool catalog or are available from the tool manufacturer. You program the compensation with the delta value for the tool radius **DR** in the **TOOL CALL**.
- The Cycles 262, 263, 264 and 267 can only be used with rightward rotating tools. For Cycle 265 you can use rightward and leftward rotating tools.
- The working direction is determined by the following input parameters: Algebraic sign Q239 (+ = right-hand thread / - = left-hand thread) and milling method Q351 (+1 = climb / -1 = up-cut). The table below illustrates the interrelation between the individual input parameters for rightward rotating tools.

Internal thread	Pitch	Climb / Up-cut	Work direction
Right-handed	+	+1(RL)	Z+
Left-handed	-	-1(RR)	Z+
Right-handed	+	-1(RR)	Z-
Left-handed	-	+1(RL)	Z-

External thread	Pitch	Climb / Up-cut	Work direction
Right-handed	+	+1(RL)	Z-
Left-handed	-	-1(RR)	Z-
Right-handed	+	-1(RR)	Z+
Left-handed	-	+1(RL)	Z+



The TNC references the programmed feed rate during thread milling to the tool cutting edge. Since the TNC, however, always displays the feed rate relative to the path of the tool tip, the displayed value does not match the programmed value.

The machining direction of the thread changes if you execute a thread milling cycle in connection with Cycle 8 MIRRORING in only one axis.





Danger of collision!

Always program the same algebraic sign for the infeeds: Cycles comprise several sequences of operation that are independent of each other. The order of precedence according to which the work direction is determined is described with the individual cycles. For example, if you only want to repeat the countersinking process of a cycle, enter 0 for the thread depth. The work direction will then be determined from the countersinking depth.

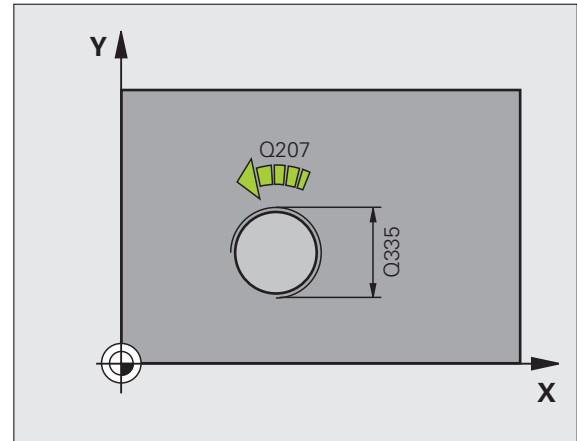
Procedure in case of a tool break

If a tool break occurs during thread cutting, stop the program run, change to the Positioning with MDI operating mode and move the tool in a linear path to the hole center. You can then retract the tool in the infeed axis and replace it.

4.6 THREAD MILLING (Cycle 262, DIN/ISO: G262)

Cycle run

- 1 The TNC positions the tool in the spindle axis to the entered setup clearance above the workpiece surface at rapid traverse **FMAX**.
- 2 The tool moves at the programmed feed rate for pre-positioning to the starting plane. The starting plane is derived from the algebraic sign of the thread pitch, the milling method (climb or up-cut milling) and the number of threads per step.
- 3 The tool then approaches the thread diameter tangentially in a helical movement. Before the helical approach, a compensating motion of the tool axis is carried out in order to begin at the programmed starting plane for the thread path.
- 4 Depending on the setting of the parameter for the number of threads, the tool mills the thread in one helical movement, in several offset movements or in one continuous movement.
- 5 After this, the tool departs the contour tangentially and returns to the starting point in the working plane.
- 6 At the end of the cycle, the TNC retracts the tool at rapid traverse to the setup clearance, or—if programmed—to the 2nd setup clearance.



Please note while programming:

Program a positioning block for the starting point (hole center) in the working plane with radius compensation **R0**.

The algebraic sign for the cycle parameter thread depth determines the working direction. If you program the thread DEPTH = 0, the cycle will not be executed.

The nominal thread diameter is approached in a semi-circle from the center. A pre-positioning movement to the side is carried out if the pitch of the tool diameter is four times smaller than the nominal thread diameter.

Note that the TNC makes a compensation movement in the tool axis before the approach movement. The length of the compensation movement is at most half of the thread pitch. Ensure sufficient space in the hole!

If you change the thread depth, the TNC automatically changes the starting point for the helical movement.

**Danger of collision!**

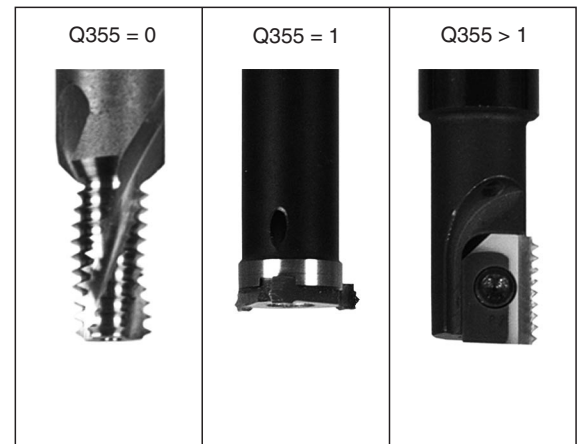
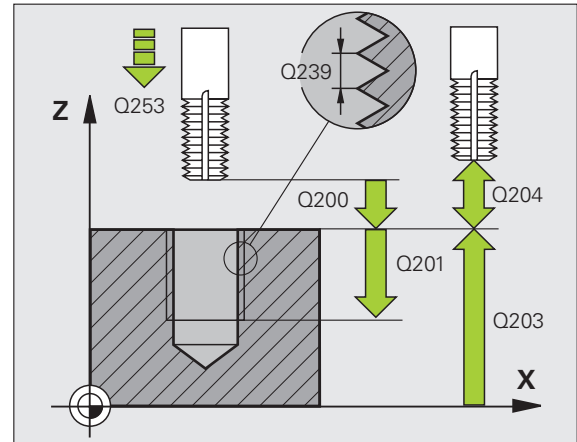
Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!

Cycle parameters



- ▶ **Nominal diameter Q335:** Nominal thread diameter.
Input range: 0 to 99999.9999
- ▶ **Thread pitch Q239:** Pitch of the thread. The algebraic sign differentiates between right-hand and left-hand threads:
 - + = right-hand thread
 - = left-hand thread
 Input range -99.9999 to 99.9999
- ▶ **Thread depth Q201 (incremental):** Distance between workpiece surface and root of thread. Input range: -99999.9999 to 99999.9999
- ▶ **Threads per step Q355:** Number of thread revolutions by which the tool is moved:
 - 0 = one 360° helical line to the thread depth
 - 1 = continuous helical path over the entire length of the thread
 - >1 = several helical paths with approach and departure; between them, the TNC offsets the tool by Q355, multiplied by the pitch. Input range: 0 to 99999
- ▶ **Feed rate for pre-positioning Q253:** Traversing speed of the tool in mm/min when plunging into the workpiece, or when retracting from the workpiece. Input range 0 to 99999.999 alternatively **FMAX**, **FAUTO**, **PREDEF**.
- ▶ **Climb or up-cut Q351:** Type of milling operation with M3
 - +1 = climb milling
 - 1 = up-cut milling
 Alternatively **PREDEF**
- ▶ **Setup clearance Q200 (incremental):** Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Workpiece surface coordinate Q203 (absolute):** Coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance Q204 (incremental):** Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Feed rate for milling Q207:** Traversing speed of the tool during milling in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO**.



Example: NC blocks

```

25 CYCL DEF 262 THREAD MILLING
  Q335=10 ;NOMINAL DIAMETER
  Q239=+1.5 ;PITCH
  Q201=-20 ;DEPTH OF THREAD
  Q355=0 ;THREADS PER STEP
  Q253=750 ;F PRE-POSITIONING
  Q351=+1 ;CLIMB OR UP-CUT
  Q200=2 ;SETUP CLEARANCE
  Q203=+30 ;SURFACE COORDINATE
  Q204=50 ;2ND SETUP CLEARANCE
  Q207=500 ;FEED RATE FOR MILLING
  
```



4.7 THREAD MILLING / COUNTERSINKING (Cycle 263, DIN/ISO: G263)

Cycle run

- 1 The TNC positions the tool in the spindle axis to the entered setup clearance above the workpiece surface at rapid traverse **FMAX**.

Countersinking

- 2 The tool moves at the feed rate for pre-positioning to the countersinking depth minus the setup clearance, and then at the feed rate for countersinking to the countersinking depth.
- 3 If a safety clearance to the side has been entered, the TNC immediately positions the tool at the feed rate for pre-positioning to the countersinking depth.
- 4 Then, depending on the available space, the TNC makes a tangential approach to the core diameter, either tangentially from the center or with a pre-positioning move to the side, and follows a circular path.

Countersinking at front

- 5 The tool moves at the feed rate for pre-positioning to the countersinking depth at front.
- 6 The TNC positions the tool without compensation from the center on a semicircle to the offset at front, and then follows a circular path at the feed rate for countersinking.
- 7 The tool then moves in a semicircle to the hole center.

Thread milling

- 8 The TNC moves the tool at the programmed feed rate for pre-positioning to the starting plane for the thread. The starting plane is determined from the thread pitch and the type of milling (climb or up-cut).
- 9 Then the tool moves tangentially on a helical path to the thread diameter and mills the thread with a 360° helical motion.
- 10 After this, the tool departs the contour tangentially and returns to the starting point in the working plane.
- 11 At the end of the cycle, the TNC retracts the tool at rapid traverse to setup clearance, or—if programmed—to the 2nd setup clearance.

Please note while programming:**Before programming, note the following:**

Program a positioning block for the starting point (hole center) in the working plane with radius compensation **R0**.

The algebraic sign of the cycle parameters depth of thread, countersinking depth or sinking depth at front determines the working direction. The working direction is defined in the following sequence:

1st: Depth of thread

2nd: Countersinking depth

3rd: Depth at front

If you program a depth parameter to be 0, the TNC does not execute that step.

If you want to countersink with the front of the tool, define the countersinking depth as 0.

Program the thread depth as a value smaller than the countersinking depth by at least one-third the thread pitch.

**Danger of collision!**

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

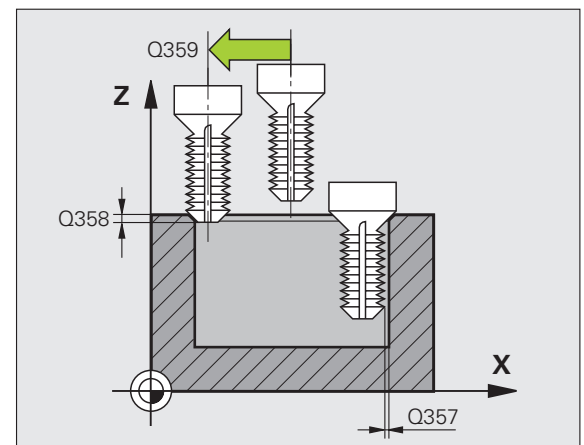
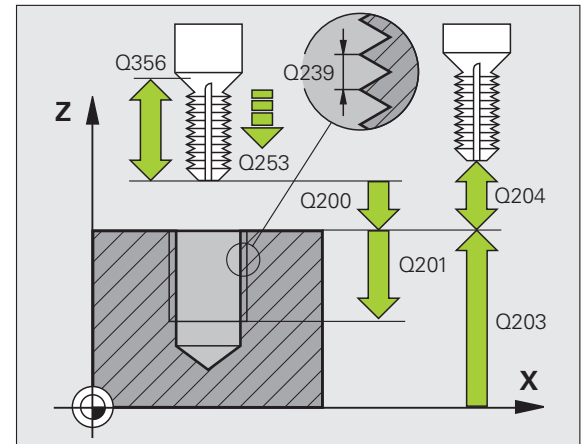
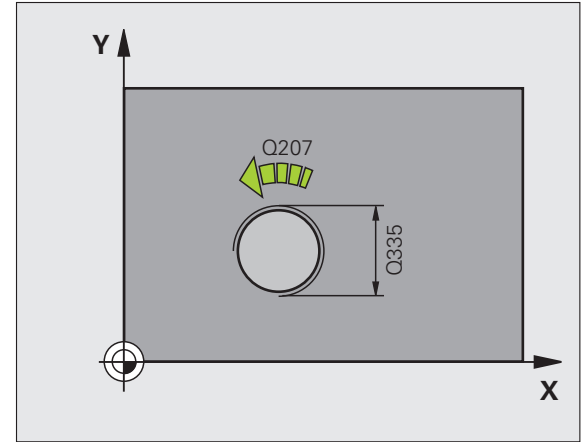
Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!



Cycle parameters



- ▶ **Nominal diameter** Q335: Nominal thread diameter.
Input range: 0 to 99999.9999
- ▶ **Thread pitch** Q239: Pitch of the thread. The algebraic sign differentiates between right-hand and left-hand threads:
+ = right-hand thread
- = left-hand thread
Input range -99.9999 to 99.9999
- ▶ **Thread depth** Q201 (incremental): Distance between workpiece surface and root of thread. Input range: -99999.9999 to 99999.9999
- ▶ **Countersinking depth** Q356 (incremental): Distance between tool point and the top surface of the workpiece. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for pre-positioning** Q253: Traversing speed of the tool in mm/min when plunging into the workpiece, or when retracting from the workpiece. Input range 0 to 99999.999 alternatively **FMAX**, **FAUTO**, **PREDEF**.
- ▶ **Climb or up-cut** Q351: Type of milling operation with M3
+1 = climb milling
-1 = up-cut milling
Alternatively **PREDEF**
- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Setup clearance to the side** Q357 (incremental): Distance between tool tooth and the wall of the hole. Input range: 0 to 99999.9999
- ▶ **Depth at front** Q358 (incremental): Distance between tool tip and the top surface of the workpiece for countersinking at the front of the tool. Input range: -99999.9999 to 99999.9999
- ▶ **Countersinking offset at front** Q359 (incremental): Distance by which the TNC moves the tool center away from the hole center. Input range: 0 to 99999.9999



- ▶ **Workpiece surface coordinate** Q203 (absolute): Coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Feed rate for countersinking** Q254: Traversing speed of the tool during countersinking in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU**.
- ▶ **Feed rate for milling** Q207: Traversing speed of the tool during milling in mm/min. Input range: 0 to 99999.9999; alternatively **FAUTO**.

Example: NC blocks

25	CYCL DEF 263	THREAD MLLNG/CNTSNKG
Q335=10	;NOMINAL DIAMETER	
Q239=+1.5	;PITCH	
Q201=-16	;DEPTH OF THREAD	
Q356=-20	;COUNTERSINKING DEPTH	
Q253=750	;F PRE-POSITIONING	
Q351=+1	;CLIMB OR UP-CUT	
Q200=2	;SETUP CLEARANCE	
Q357=0.2	;CLEARANCE TO SIDE	
Q358=+0	;DEPTH AT FRONT	
Q359=+0	;OFFSET AT FRONT	
Q203=+30	;SURFACE COORDINATE	
Q204=50	;2ND SETUP CLEARANCE	
Q254=150	;F COUNTERSINKING	
Q207=500	;FEED RATE FOR MILLING	



4.8 THREAD DRILLING/MILLING (Cycle 264, DIN/ISO: G264)

Cycle run

- 1 The TNC positions the tool in the spindle axis to the entered setup clearance above the workpiece surface at rapid traverse **FMAX**.

Drilling

- 2 The tool drills to the first plunging depth at the programmed feed rate for plunging.
- 3 If you have programmed chip breaking, the tool then retracts by the entered retraction value. If you are working without chip breaking, the tool is moved at rapid traverse to the setup clearance, and then at **FMAX** to the entered starting position above the first plunging depth.
- 4 The tool then advances with another infeed at the programmed feed rate.
- 5 The TNC repeats this process (2 to 4) until the programmed total hole depth is reached.

Countersinking at front

- 6 The tool moves at the feed rate for pre-positioning to the countersinking depth at front.
- 7 The TNC positions the tool without compensation from the center on a semicircle to the offset at front, and then follows a circular path at the feed rate for countersinking.
- 8 The tool then moves in a semicircle to the hole center.

Thread milling

- 9 The TNC moves the tool at the programmed feed rate for pre-positioning to the starting plane for the thread. The starting plane is determined from the thread pitch and the type of milling (climb or up-cut).
- 10 Then the tool moves tangentially on a helical path to the thread diameter and mills the thread with a 360° helical motion.
- 11 After this, the tool departs the contour tangentially and returns to the starting point in the working plane.
- 12 At the end of the cycle, the TNC retracts the tool at rapid traverse to setup clearance, or—if programmed—to the 2nd setup clearance.

Please note while programming:

Program a positioning block for the starting point (hole center) in the working plane with radius compensation **R0**.

The algebraic sign of the cycle parameters depth of thread, countersinking depth or sinking depth at front determines the working direction. The working direction is defined in the following sequence:

- 1st: Depth of thread
- 2nd: Total hole depth
- 3rd: Depth at front

If you program a depth parameter to be 0, the TNC does not execute that step.

Program the thread depth as a value smaller than the total hole depth by at least one-third the thread pitch.

**Danger of collision!**

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

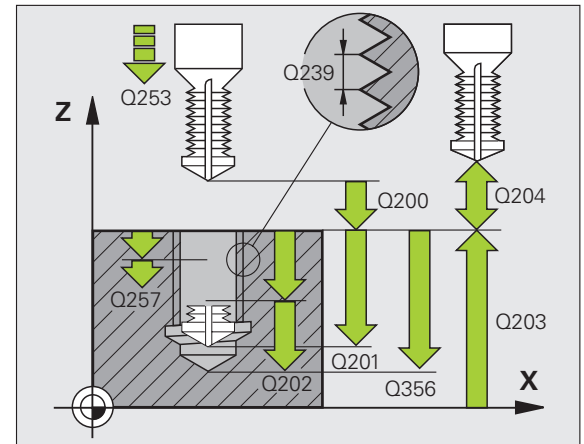
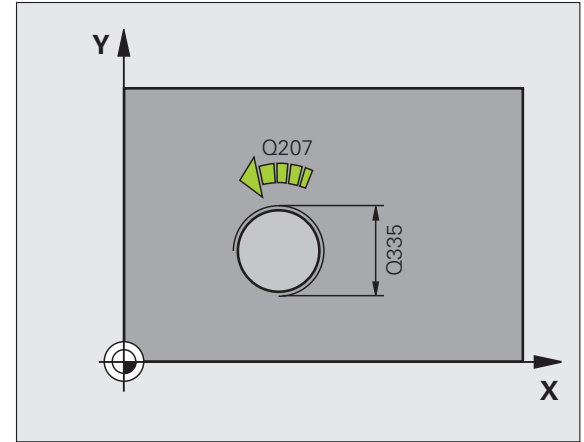
Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!



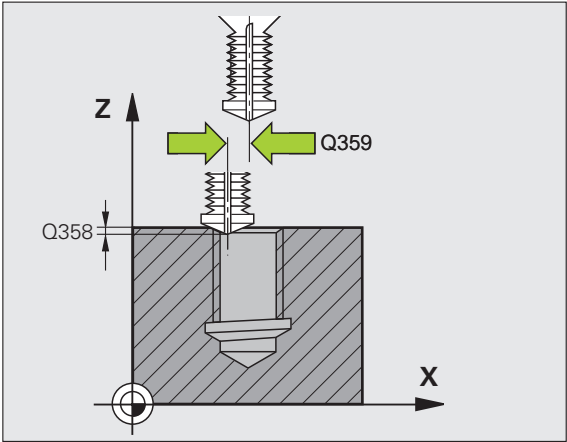
Cycle parameters



- ▶ **Nominal diameter** Q335: Nominal thread diameter.
Input range: 0 to 99999.9999
- ▶ **Thread pitch** Q239: Pitch of the thread. The algebraic sign differentiates between right-hand and left-hand threads:
 + = right-hand thread
 - = left-hand thread
 Input range -99.9999 to 99.9999
- ▶ **Thread depth** Q201 (incremental): Distance between workpiece surface and root of thread. Input range: -99999.9999 to 99999.9999
- ▶ **Total hole depth** Q356 (incremental): Distance between workpiece surface and bottom of hole. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for pre-positioning** Q253: Traversing speed of the tool in mm/min when plunging into the workpiece, or when retracting from the workpiece. Input range 0 to 99999,999 alternatively **FMAX**, **FAUTO**, **PREDEF**.
- ▶ **Climb or up-cut** Q351: Type of milling operation with M3
 +1 = climb milling
 -1 = up-cut milling
 Alternatively **PREDEF**
- ▶ **Plunging depth** Q202 (incremental): Infeed per cut. The depth does not have to be a multiple of the plunging depth. Input range 0 to 99999.9999. The TNC will go to depth in one movement if:
 - the plunging depth is equal to the depth
 - the plunging depth is greater than the depth
- ▶ **Upper advanced stop distance** Q258 (incremental): Setup clearance for rapid traverse positioning when the TNC moves the tool again to the current plunging depth after retraction from the hole. Input range: 0 to 99999.9999
- ▶ **Infeed depth for chip breaking** Q257 (incremental): Depth at which TNC carries out chip breaking. No chip breaking if 0 is entered. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Retraction rate for chip breaking** Q256 (incremental): Value by which the TNC retracts the tool during chip breaking. Input range: 0.1000 to 99999.9999



- ▶ **Depth at front** Q358 (incremental): Distance between tool tip and the top surface of the workpiece for countersinking at the front of the tool. Input range: -99999.9999 to 99999.9999
- ▶ **Countersinking offset at front** Q359 (incremental): Distance by which the TNC moves the tool center away from the hole center. Input range: 0 to 99999.9999
- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Workpiece surface coordinate** Q203 (absolute): Coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Feed rate for plunging** Q206: Traversing speed of the tool during drilling in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU**.
- ▶ **Feed rate for milling** Q207: Traversing speed of the tool during milling in mm/min. Input range: 0 to 99999.9999; alternatively **FAUTO**.



Example: NC blocks

25 CYCL DEF 264 THREAD DRILLNG/MLNG	
Q335=10	;NOMINAL DIAMETER
Q239=+1.5	;PITCH
Q201=-16	;DEPTH OF THREAD
Q356=-20	;TOTAL HOLE DEPTH
Q253=750	;F PRE-POSITIONING
Q351=+1	;CLIMB OR UP-CUT
Q202=5	;PLUNGING DEPTH
Q258=0.2	;ADVANCED STOP DISTANCE
Q257=5	;DEPTH FOR CHIP BRKNG
Q256=0.2	;DIST. FOR CHIP BRKNG
Q358=+0	;DEPTH AT FRONT
Q359=+0	;OFFSET AT FRONT
Q200=2	;SETUP CLEARANCE
Q203=+30	;SURFACE COORDINATE
Q204=50	;2ND SETUP CLEARANCE
Q206=150	;FEED RATE FOR PLNGNG
Q207=500	;FEED RATE FOR MILLING



4.9 HELICAL THREAD DRILLING/MILLING (Cycle 265, DIN/ISO: G265)

Cycle run

- 1 The TNC positions the tool in the spindle axis to the entered setup clearance above the workpiece surface at rapid traverse **FMAX**.

Countersinking at front

- 2 If countersinking is before thread milling, the tool moves at the feed rate for countersinking to the sinking depth at front. If countersinking occurs after thread milling, the TNC moves the tool to the countersinking depth at the feed rate for prepositioning.
- 3 The TNC positions the tool without compensation from the center on a semicircle to the offset at front, and then follows a circular path at the feed rate for countersinking.
- 4 The tool then moves in a semicircle to the hole center.

Thread milling

- 5 The tool moves at the programmed feed rate for pre-positioning to the starting plane for the thread.
- 6 The tool then approaches the thread diameter tangentially in a helical movement.
- 7 The tool moves on a continuous helical downward path until it reaches the thread depth.
- 8 After this, the tool departs the contour tangentially and returns to the starting point in the working plane.
- 9 At the end of the cycle, the TNC retracts the tool at rapid traverse to setup clearance, or—if programmed—to the 2nd setup clearance.

Please note while programming:

Program a positioning block for the starting point (hole center) in the working plane with radius compensation **R0**.

The algebraic sign of the cycle parameters depth of thread or sinking depth at front determines the working direction. The working direction is defined in the following sequence:

- 1st: Depth of thread
- 2nd: Depth at front

If you program a depth parameter to be 0, the TNC does not execute that step.

If you change the thread depth, the TNC automatically changes the starting point for the helical movement.

The type of milling (up-cut/climb) is determined by the thread (right-hand/left-hand) and the direction of tool rotation, since it is only possible to work in the direction of the tool.

**Danger of collision!**

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

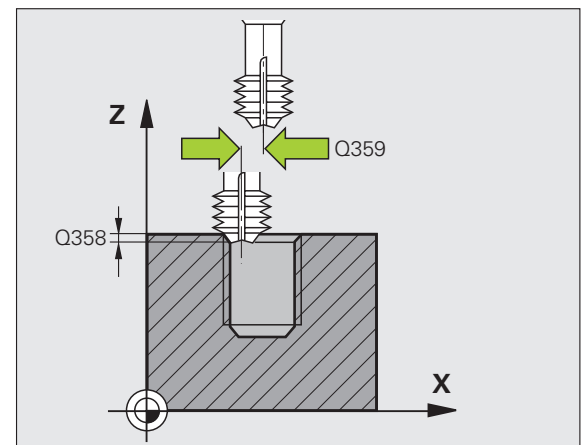
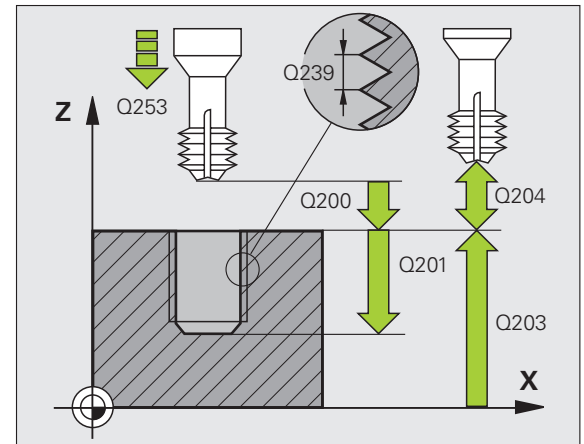
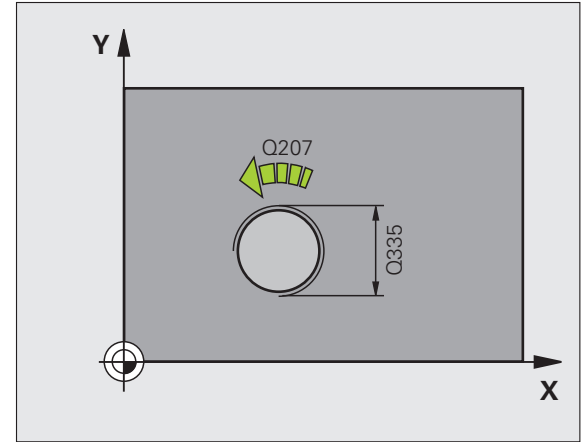
Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!



Cycle parameters



- ▶ **Nominal diameter** Q335: Nominal thread diameter.
Input range: 0 to 99999.9999
- ▶ **Thread pitch** Q239: Pitch of the thread. The algebraic sign differentiates between right-hand and left-hand threads:
+ = right-hand thread
- = left-hand thread
Input range -99.9999 to 99.9999
- ▶ **Thread depth** Q201 (incremental): Distance between workpiece surface and root of thread. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for pre-positioning** Q253: Traversing speed of the tool in mm/min when plunging into the workpiece, or when retracting from the workpiece. Input range 0 to 99999.999 alternatively **FMAX**, **FAUTO**, **PREDEF**.
- ▶ **Depth at front** Q358 (incremental): Distance between tool tip and the top surface of the workpiece for countersinking at the front of the tool. Input range: -99999.9999 to 99999.9999
- ▶ **Countersinking offset at front** Q359 (incremental): Distance by which the TNC moves the tool center away from the hole center. Input range: 0 to 99999.9999
- ▶ **Countersink** Q360: Execution of the chamfer
0 = before thread machining
1 = after thread machining
- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**



- ▶ **Workpiece surface coordinate** Q203 (absolute): Coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Feed rate for countersinking** Q254: Traversing speed of the tool during countersinking in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU**.
- ▶ **Feed rate for milling** Q207: Traversing speed of the tool during milling in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO**.

Example: NC blocks

25 CYCL DEF 265 HEL. THREAD DRLG/MLG
Q335=10 ;NOMINAL DIAMETER
Q239=+1.5 ;PITCH
Q201=-16 ;DEPTH OF THREAD
Q253=750 ;F PRE-POSITIONING
Q358=+0 ;DEPTH AT FRONT
Q359=+0 ;OFFSET AT FRONT
Q360=0 ;COUNTERSINK
Q200=2 ;SETUP CLEARANCE
Q203=+30 ;SURFACE COORDINATE
Q204=50 ;2ND SETUP CLEARANCE
Q254=150 ;F COUNTERSINKING
Q207=500 ;FEED RATE FOR MILLING



4.10 OUTSIDE THREAD MILLING (Cycle 267, DIN/ISO: G267)

Cycle run

- 1 The TNC positions the tool in the spindle axis to the entered setup clearance above the workpiece surface at rapid traverse **FMAX**.

Countersinking at front

- 2 The TNC moves in the reference axis of the working plane from the center of the stud to the starting point for countersinking at front. The position of the starting point is determined by the thread radius, tool radius and pitch.
- 3 The tool moves at the feed rate for pre-positioning to the countersinking depth at front.
- 4 The TNC positions the tool without compensation from the center on a semicircle to the offset at front, and then follows a circular path at the feed rate for countersinking.
- 5 The tool then moves on a semicircle to the starting point.

Thread milling

- 6 The TNC positions the tool to the starting point if there has been no previous countersinking at front. Starting point for thread milling = starting point for countersinking at front.
- 7 The tool moves at the programmed feed rate for pre-positioning to the starting plane. The starting plane is derived from the algebraic sign of the thread pitch, the milling method (climb or up-cut milling) and the number of threads per step.
- 8 The tool then approaches the thread diameter tangentially in a helical movement.
- 9 Depending on the setting of the parameter for the number of threads, the tool mills the thread in one helical movement, in several offset movements or in one continuous movement.
- 10 After this, the tool departs the contour tangentially and returns to the starting point in the working plane.
- 11 At the end of the cycle, the TNC retracts the tool at rapid traverse to the setup clearance, or—if programmed—to the 2nd setup clearance.

Please note while programming:

Program a positioning block for the starting point (stud center) in the working plane with radius compensation **R0**.

The offset required before countersinking at the front should be determined ahead of time. You must enter the value from the center of the stud to the center of the tool (uncorrected value).

The algebraic sign of the cycle parameters depth of thread or sinking depth at front determines the working direction. The working direction is defined in the following sequence:

- 1st: Depth of thread
- 2nd: Depth at front

If you program a depth parameter to be 0, the TNC does not execute that step.

The algebraic sign for the cycle parameter thread depth determines the working direction.

**Danger of collision!**

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

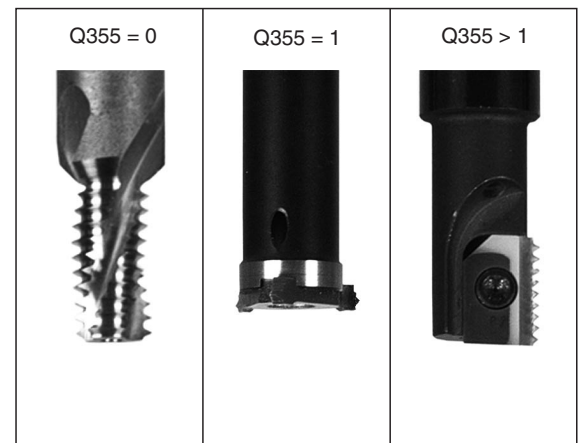
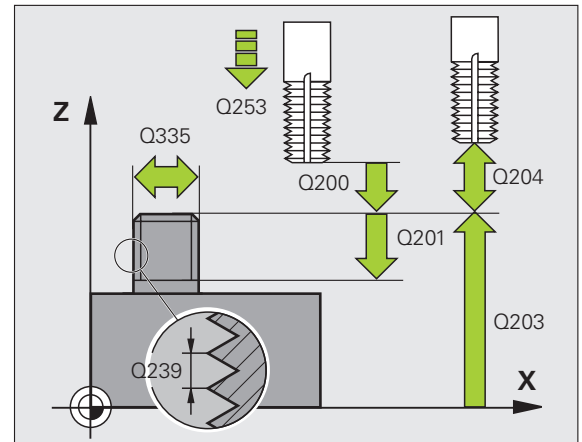
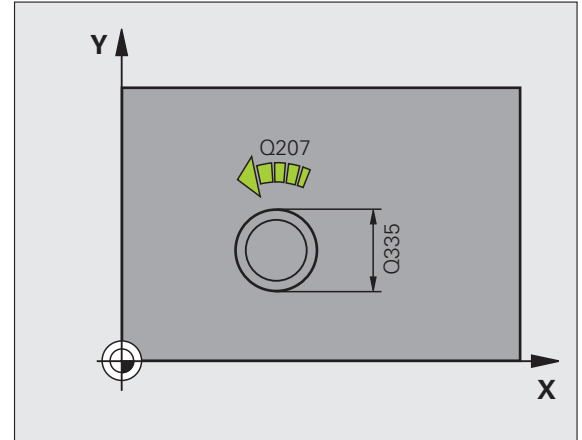
Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!



Cycle parameters



- ▶ **Nominal diameter Q335:** Nominal thread diameter.
Input range: 0 to 99999.9999
- ▶ **Thread pitch Q239:** Pitch of the thread. The algebraic sign differentiates between right-hand and left-hand threads:
 + = right-hand thread
 - = left-hand thread
 Input range -99.9999 to 99.9999
- ▶ **Thread depth Q201 (incremental):** Distance between workpiece surface and root of thread.
- ▶ **Threads per step Q355:** Number of thread revolutions by which the tool is moved:
 0 = one helical line to the thread depth
 1 = continuous helical path over the entire length of the thread
 >1 = several helical paths with approach and departure; between them, the TNC offsets the tool by Q355, multiplied by the pitch. Input range: 0 to 99999
- ▶ **Feed rate for pre-positioning Q253:** Traversing speed of the tool in mm/min when plunging into the workpiece, or when retracting from the workpiece.
Input range 0 to 99999.999 alternatively **FMAX**, **FAUTO**, **PREDEF**.
- ▶ **Climb or up-cut Q351:** Type of milling operation with M3
 +1 = climb milling
 -1 = up-cut milling
 Alternatively **PREDEF**



- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Depth at front** Q358 (incremental): Distance between tool tip and the top surface of the workpiece for countersinking at the front of the tool. Input range: -99999.9999 to 99999.9999
- ▶ **Countersinking offset at front** Q359 (incremental): Distance by which the TNC moves the tool center away from the stud center. Input range: 0 to 99999.9999
- ▶ **Workpiece surface coordinate** Q203 (absolute): Coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Feed rate for countersinking** Q254: Traversing speed of the tool during countersinking in mm/min. Input range: 0 to 99999.999, alternatively **FAUTO, FU**.
- ▶ **Feed rate for milling** Q207: Traversing speed of the tool during milling in mm/min. Input range: 0 to 99999.999, alternatively **FAUTO**.

Example: NC blocks

25 CYCL DEF 267 OUTSIDE THREAD MLLNG
Q335=10 ;NOMINAL DIAMETER
Q239=+1.5 ;PITCH
Q201=-20 ;DEPTH OF THREAD
Q355=0 ;THREADS PER STEP
Q253=750 ;F PRE-POSITIONING
Q351=+1 ;CLIMB OR UP-CUT
Q200=2 ;SETUP CLEARANCE
Q358=+0 ;DEPTH AT FRONT
Q359=+0 ;OFFSET AT FRONT
Q203=+30 ;SURFACE COORDINATE
Q204=50 ;2ND SETUP CLEARANCE
Q254=150 ;F COUNTERSINKING
Q207=500 ;FEED RATE FOR MILLING



4.11 Programming examples

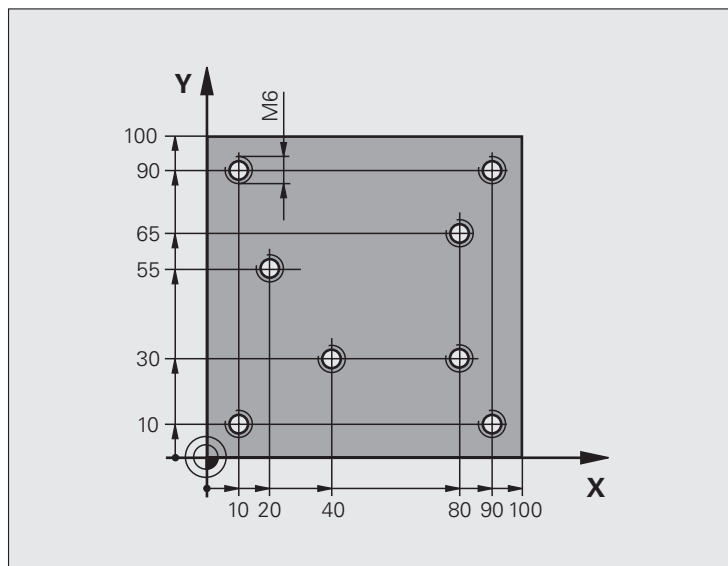
Example: Thread milling

The drill hole coordinates are stored in the point table TAB1.PNT and are called by the TNC with **CYCL CALL PAT.**

The tool radii are selected so that all work steps can be seen in the test graphics.

Program sequence

- Centering
- Drilling
- Tapping



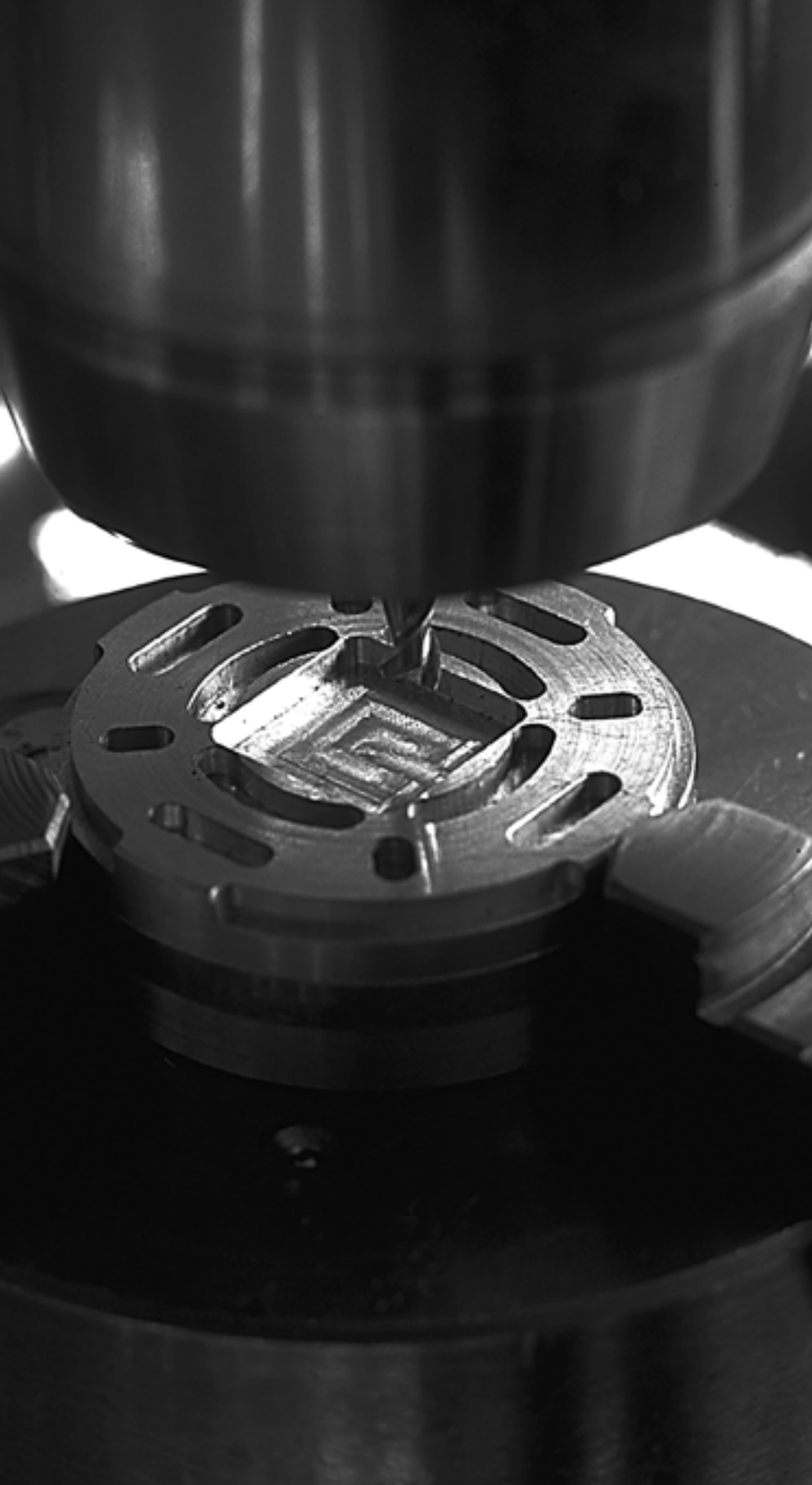
0 BEGIN PGM 1 MM	
1 BLK FORM 0.1 Z X+0 Y+0 Z-20	Definition of workpiece blank
2 BLK FORM 0.2 X+100 Y+100 Y+0	
3 TOOL DEF 1 L+0 R+4	Tool definition of center drill
4 TOOL DEF 2 L+0 2.4	Drill tool definition
5 TOOL DEF 3 L+0 R+3	Tool definition of tap
6 TOOL CALL 1 Z S5000	Tool call of centering drill
7 L Z+10 R0 F5000	Move tool to clearance height (enter a value for F)
	The TNC positions to the clearance height after every cycle
8 SEL PATTERN "TAB1"	Defining point tables
9 CYCL DEF 200 DRILLING	Cycle definition: CENTERING
Q200=2 ;SETUP CLEARANCE	
Q201=-2 ;DEPTH	
Q206=150 ;FEED RATE FOR PLNGN	
Q202=2 ;PLUNGING DEPTH	
Q210=0 ;DWELL TIME AT TOP	
Q203=+0 ;SURFACE COORDINATE	0 must be entered here, effective as defined in point table

Q204=0 ;2ND SETUP CLEARANCE	0 must be entered here, effective as defined in point table
Q211=0.2 ;DWELL TIME AT DEPTH	
10 CYCL CALL PAT F5000 M3	Cycle call in connection with point table TAB1.PNT
	Feed rate between points: 5000 mm/min
11 L Z+100 R0 FMAX M6	Retract the tool, change the tool
12 TOOL CALL 2 Z S5000	Call tool: drill
13 L Z+10 R0 F5000	Move tool to clearance height (enter a value for F)
14 CYCL DEF 200 DRILLING	Cycle definition: drilling
Q200=2 ;SETUP CLEARANCE	
Q201=-25 ;DEPTH	
Q206=150 ;FEED RATE FOR PECKING	
Q202=5 ;PLUNGING DEPTH	
Q210=0 ;DWELL TIME AT TOP	
Q203=+0 ;SURFACE COORDINATE	0 must be entered here, effective as defined in point table
Q204=0 ;2ND SETUP CLEARANCE	0 must be entered here, effective as defined in point table
Q211=0.2 ;DWELL TIME AT DEPTH	
15 CYCL CALL PAT F5000 M3	Cycle call in connection with point table TAB1.PNT
16 L Z+100 R0 FMAX M6	Retract the tool, change the tool
17 TOOL CALL 3 Z S200	Tool call for tap
18 L Z+50 R0 FMAX	Move tool to clearance height
19 CYCL DEF 206 TAPPING NEW	Cycle definition for tapping
Q200=2 ;SETUP CLEARANCE	
Q201=-25 ;DEPTH OF THREAD	
Q206=150 ;FEED RATE FOR PECKING	
Q211=0 ;DWELL TIME AT DEPTH	
Q203=+0 ;SURFACE COORDINATE	0 must be entered here, effective as defined in point table
Q204=0 ;2ND SETUP CLEARANCE	0 must be entered here, effective as defined in point table
20 CYCL CALL PAT F5000 M3	Cycle call in connection with point table TAB1.PNT
21 L Z+100 R0 FMAX M2	Retract in the tool axis, end program
22 END PGM 1 MM	



Point table TAB1.PNT

TAB1.PNTMM
NRXYZ
0+10+10+0
1+40+30+0
2+90+10+0
3+80+30+0
4+80+65+0
5+90+90+0
6+10+90+0
7+20+55+0
[END]



5







**Canned Cycles: Pocket
Milling / Stud Milling /
Slot Milling**



5.1 Fundamentals

Overview

The TNC offers 6 cycles for machining pockets, studs and slots:

Cycle	Soft key	Page
251 RECTANGULAR POCKET Roughing/finishing cycle with selection of machining operation and helical plunging		Page 137
252 CIRCULAR POCKET Roughing/finishing cycle with selection of machining operation and helical plunging		Page 142
253 SLOT MILLING Roughing/finishing cycle with selection of machining operation and reciprocal plunging		Page 146
254 CIRCULAR SLOT Roughing/finishing cycle with selection of machining operation and reciprocal plunging		Page 151
256 RECTANGULAR STUD Roughing/finishing cycle with stepover, if multiple passes are required		Page 156
257 CIRCULAR STUD Roughing/finishing cycle with stepover, if multiple passes are required		Page 160

5.2 RECTANGULAR POCKET (Cycle 251, DIN/ISO: G251)

Cycle run

Use Cycle 251 RECTANGULAR POCKET to completely machine rectangular pockets. Depending on the cycle parameters, the following machining alternatives are available:

- Complete machining: Roughing, floor finishing, side finishing
- Only roughing
- Only floor finishing and side finishing
- Only floor finishing
- Only side finishing

Roughing

- 1 The tool plunges into the workpiece at the pocket center and advances to the first plunging depth. Specify the plunging strategy with Parameter Q366.
- 2 The TNC roughs out the pocket from the inside out, taking the overlap factor (Parameter Q370) and the finishing allowances (parameters Q368 and Q369) into account.
- 3 At the end of the roughing operation, the TNC moves the tool tangentially away from the pocket wall, then moves by the setup clearance above the current pecking depth and returns from there at rapid traverse to the pocket center.
- 4 This process is repeated until the programmed pocket depth is reached.

Finishing

- 5 Inasmuch as finishing allowances are defined, the TNC then finishes the pocket walls, in multiple infeeds if so specified. The pocket wall is approached tangentially.
- 6 Then the TNC finishes the floor of the pocket from the inside out. The pocket floor is approached tangentially.



Please note while programming:

With an inactive tool table you must always plunge vertically (Q366=0) because you cannot define a plunging angle.

Pre-position the tool in the machining plane to the starting position with radius compensation **RO**. Note Parameter Q367 (pocket position).

The TNC runs the cycle in the axes (machining plane) with which you approached the starting position. For example, in X and Y if you programmed **CYCL CALL POS X... Y...** or in U and V if you programmed **CYCL CALL POS U... V...**

The TNC automatically pre-positions the tool in the tool axis. Note Parameter Q204 (2nd setup clearance).

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.

At the end of the cycle, the TNC returns the tool to the starting position.

At the end of a roughing operation, the TNC positions the tool back to the pocket center at rapid traverse. The tool is above the current pecking depth by the setup clearance. Enter the setup clearance so that the tool cannot jam because of chips.

**Danger of collision!**

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

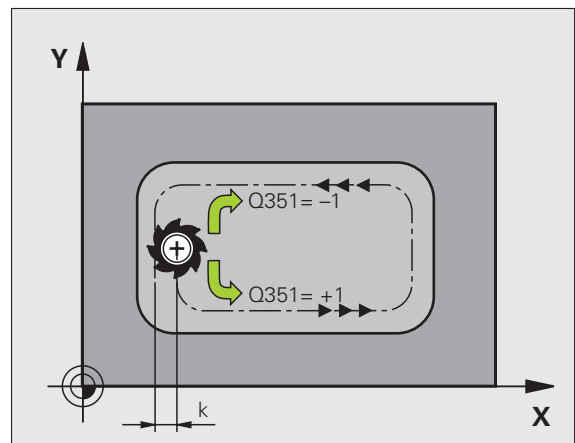
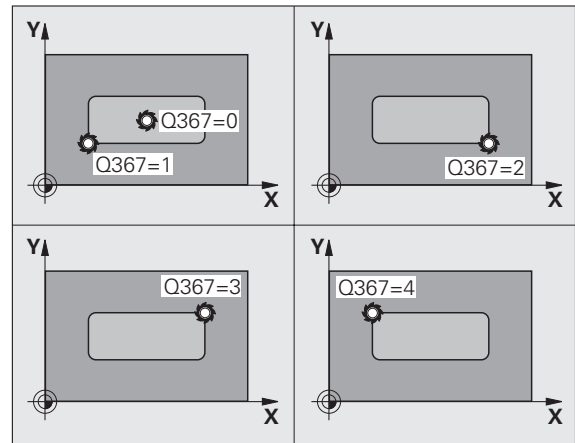
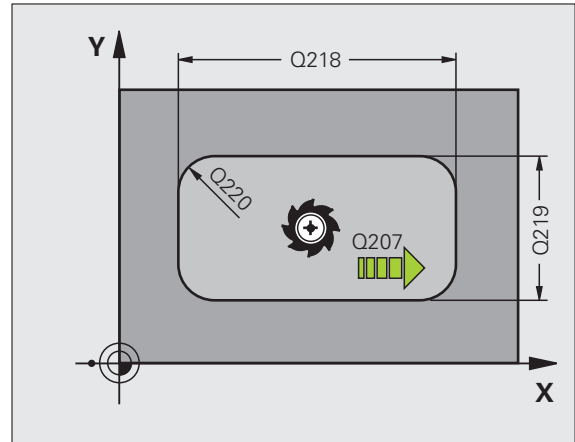
Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!

If you call the cycle with machining operation 2 (only finishing), then the TNC positions the tool in the center of the pocket at rapid traverse to the first plunging depth.

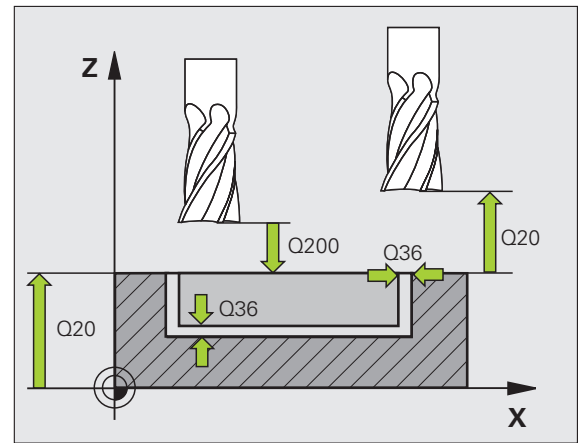
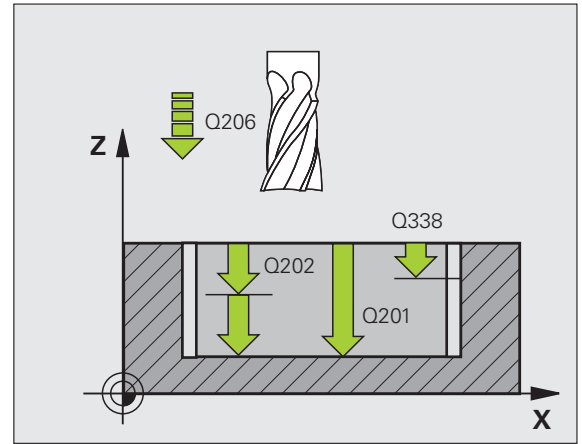
Cycle parameters



- ▶ **Machining operation (0/1/2) Q215:** Define the machining operation:
 - 0:** Roughing and finishing
 - 1:** Only roughing
 - 2:** Only finishing
 Side finishing and floor finishing are only executed if the finishing allowances (Q368, Q369) have been defined.
- ▶ **First side length Q218 (incremental):** Pocket length, parallel to the reference axis of the working plane. Input range: 0 to 99999.9999
- ▶ **2nd side length Q219 (incremental):** Pocket length, parallel to the minor axis of the working plane. Input range: 0 to 99999.9999
- ▶ **Corner radius Q220:** Radius of the pocket corner. If you have entered 0 here, the TNC assumes that the corner radius is equal to the tool radius. Input range: 0 to 99999.9999
- ▶ **Finishing allowance for side Q368 (incremental):** Finishing allowance in the working plane. Input range: 0 to 99999.9999
- ▶ **Angle of rotation Q224 (absolute):** Angle by which the entire pocket is rotated. The center of rotation is the position at which the tool is located when the cycle is called. Input range: -360.0000 to 360.0000
- ▶ **Pocket position Q367:** Position of the pocket in reference to the position of the tool when the cycle is called:
 - 0:** Tool position = Center of pocket
 - 1:** Tool position = Lower left corner
 - 2:** Tool position = Lower right corner
 - 3:** Tool position = Upper right corner
 - 4:** Tool position = Upper left corner
- ▶ **Feed rate for milling Q207:** Traversing speed of the tool during milling in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU, FZ**.
- ▶ **Climb or up-cut Q351:** Type of milling operation with M3:
 - +1** = climb milling
 - 1** = up-cut milling
 Alternatively **PREDEF**



- ▶ **Depth** Q201 (incremental): Distance between workpiece surface and bottom of pocket. Input range: -99999.9999 to 99999.9999
- ▶ **Plunging depth** Q202 (incremental): Infeed per cut. Enter a value greater than 0. Input range: 0 to 99999.9999
- ▶ **Finishing allowance for floor** Q369 (incremental): Finishing allowance in the tool axis. Input range: 0 to 99999.9999
- ▶ **Feed rate for plunging** Q206: Traversing speed of the tool while moving to depth in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU, FZ**.
- ▶ **Infeed for finishing** Q338 (incremental): Infeed per cut. Q338=0: Finishing in one infeed. Input range: 0 to 99999.9999
- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Workpiece surface coordinate** Q203 (absolute): Absolute coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**



- ▶ **Path overlap factor** Q370: $Q370 \times \text{tool radius} = \text{stepover factor } k$. Input range: 0.1 to 1.9999 alternatively **PREDEF**.
- ▶ **Plunging strategy** Q366: Type of plunging strategy.
 - 0 = vertical plunging. The TNC plunges perpendicularly, regardless of the plunging angle **ANGLE** defined in the tool table.
 - 1 = helical plunging. In the tool table, the plunging angle **ANGLE** for the active tool must be defined as not equal to 0. The TNC will otherwise display an error message.
 - 2 = reciprocating plunge. In the tool table, the plunging angle **ANGLE** for the active tool must be defined as not equal to 0. Otherwise, the TNC generates an error message. The reciprocation length depends on the plunging angle. As a minimum value the TNC uses twice the tool diameter.
 - Alternative: **PREDEF**
- ▶ **Feed rate for finishing** Q385: Traversing speed of the tool during side and floor finishing in mm/min. Input range: 0 to 99999.9999; alternatively **FAUTO**, **FU**, **FZ**.

Example: NC blocks

8 CYCL DEF 251 RECTANGULAR POCKET
Q215=0 ;MACHINING OPERATION
Q218=80 ;FIRST SIDE LENGTH
Q219=60 ;2ND SIDE LENGTH
Q220=5 ;CORNER RADIUS
Q368=0.2 ;ALLOWANCE FOR SIDE
Q224=+0 ;ANGLE OF ROTATION
Q367=0 ;POCKET POSITION
Q207=500 ;FEED RATE FOR MILLING
Q351=+1 ;CLIMB OR UP-CUT
Q201=-20 ;DEPTH
Q202=5 ;PLUNGING DEPTH
Q369=0.1 ;ALLOWANCE FOR FLOOR
Q206=150 ;FEED RATE FOR PLUNGING
Q338=5 ;INFEEED FOR FINISHING
Q200=2 ;SETUP CLEARANCE
Q203=+0 ;SURFACE COORDINATE
Q204=50 ;2ND SETUP CLEARANCE
Q370=1 ;TOOL PATH OVERLAP
Q366=1 ;PLUNGE
Q385=500 ;FEED RATE FOR FINISHING
9 CYCL CALL POS X+50 Y+50 Z+0 FMAX M3



5.3 CIRCULAR POCKET (Cycle 252, DIN/ISO: G252)

Cycle run

Use Cycle 252 CIRCULAR POCKET to completely machine circular pockets. Depending on the cycle parameters, the following machining alternatives are available:

- Complete machining: Roughing, floor finishing, side finishing
- Only roughing
- Only floor finishing and side finishing
- Only floor finishing
- Only side finishing

Roughing

- 1 The tool plunges into the workpiece at the pocket center and advances to the first plunging depth. Specify the plunging strategy with Parameter Q366.
- 2 The TNC roughs out the pocket from the inside out, taking the overlap factor (Parameter Q370) and the finishing allowances (parameters Q368 and Q369) into account.
- 3 At the end of the roughing operation, the TNC moves the tool tangentially away from the pocket wall, then moves by the setup clearance above the current pecking depth and returns from there at rapid traverse to the pocket center.
- 4 This process is repeated until the programmed pocket depth is reached.

Finishing

- 5 Inasmuch as finishing allowances are defined, the TNC then finishes the pocket walls, in multiple infeeds if so specified. The pocket wall is approached tangentially.
- 6 Then the TNC finishes the floor of the pocket from the inside out. The pocket floor is approached tangentially.

Please note while programming:

With an inactive tool table you must always plunge vertically (Q366=0) because you cannot define a plunging angle.

Pre-position the tool in the machining plane to the starting position (circle center) with radius compensation **R0**.

The TNC runs the cycle in the axes (machining plane) with which you approached the starting position. For example, in X and Y if you programmed **CYCL CALL POS X... Y...** or in U and V if you programmed **CYCL CALL POS U... V...**

The TNC automatically pre-positions the tool in the tool axis. Note Parameter Q204 (2nd setup clearance).

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.

At the end of the cycle, the TNC returns the tool to the starting position.

At the end of a roughing operation, the TNC positions the tool back to the pocket center at rapid traverse. The tool is above the current pecking depth by the setup clearance. Enter the setup clearance so that the tool cannot jam because of chips.

**Danger of collision!**

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!

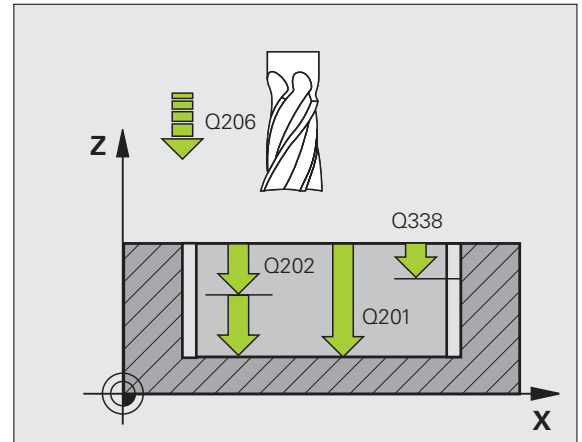
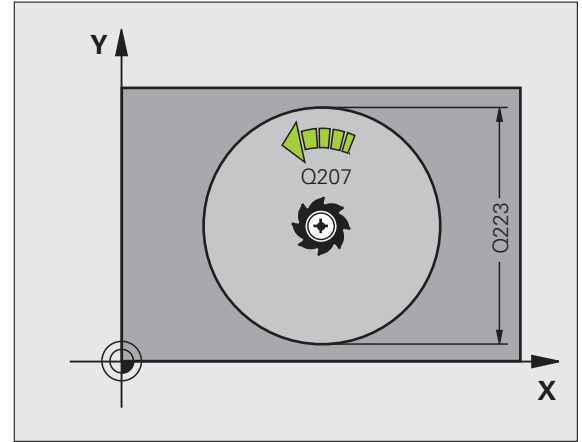
If you call the cycle with machining operation 2 (only finishing), then the TNC positions the tool in the center of the pocket at rapid traverse to the first plunging depth.



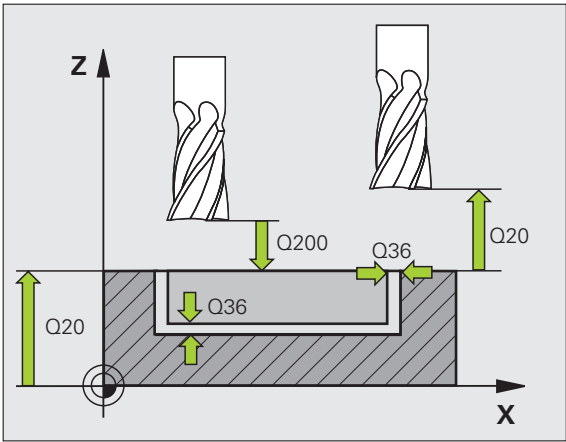
Cycle parameters



- ▶ **Machining operation (0/1/2) Q215:** Define the machining operation:
0: Roughing and finishing
1: Only roughing
2: Only finishing
 Side finishing and floor finishing are only executed if the finishing allowances (Q368, Q369) have been defined.
- ▶ **Circle diameter Q223:** Diameter of the finished pocket. Input range: 0 to 99999.9999
- ▶ **Finishing allowance for side Q368 (incremental):** Finishing allowance in the working plane. Input range: 0 to 99999.9999
- ▶ **Feed rate for milling Q207:** Traversing speed of the tool during milling in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU, FZ**.
- ▶ **Climb or up-cut Q351:** Type of milling operation with M3:
+1 = climb milling
-1 = up-cut milling
 Alternatively **PREDEF**
- ▶ **Depth Q201 (incremental):** Distance between workpiece surface and bottom of pocket. Input range: -99999.9999 to 99999.9999
- ▶ **Plunging depth Q202 (incremental):** Infeed per cut. Enter a value greater than 0. Input range: 0 to 99999.9999
- ▶ **Finishing allowance for floor Q369 (incremental):** Finishing allowance in the tool axis. Input range: 0 to 99999.9999
- ▶ **Feed rate for plunging Q206:** Traversing speed of the tool while moving to depth in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU, FZ**.
- ▶ **Infeed for finishing Q338 (incremental):** Infeed per cut. Q338=0: Finishing in one infeed. Input range: 0 to 99999.9999



- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Workpiece surface coordinate** Q203 (absolute): Absolute coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Path overlap factor** Q370: $Q370 \times \text{tool radius}$ = stepover factor k. Input range: 0.1 to 1.9999 alternatively **PREDEF**.
- ▶ **Plunging strategy** Q366: Type of plunging strategy.
 - 0 = vertical plunging. The TNC plunges perpendicularly, regardless of the plunging angle **ANGLE** defined in the tool table.
 - 1 = helical plunging. In the tool table, the plunging angle **ANGLE** for the active tool must be defined as not equal to 0. The TNC will otherwise display an error message.
 - Alternative: **PREDEF**
- ▶ **Feed rate for finishing** Q385: Traversing speed of the tool during side and floor finishing in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO**, **FU**, **FZ**.



Example: NC blocks

8 CYCL DEF 252 CIRCULAR POCKET	
Q215=0	;MACHINING OPERATION
Q223=60	;CIRCLE DIAMETER
Q368=0.2	;ALLOWANCE FOR SIDE
Q207=500	;FEED RATE FOR MILLING
Q351=+1	;CLIMB OR UP-CUT
Q201=-20	;DEPTH
Q202=5	;PLUNGING DEPTH
Q369=0.1	;ALLOWANCE FOR FLOOR
Q206=150	;FEED RATE FOR PLUNGING
Q338=5	;INFEEED FOR FINISHING
Q200=2	;SETUP CLEARANCE
Q203=+0	;SURFACE COORDINATE
Q204=50	;2ND SETUP CLEARANCE
Q370=1	;TOOL PATH OVERLAP
Q366=1	;PLUNGE
Q385=500	;FEED RATE FOR FINISHING
9 CYCL CALL POS X+50 Y+50 Z+0 FMAX M3	



5.4 SLOT MILLING (Cycle 253, DIN/ISO: G253)

Cycle run

Use Cycle 253 to completely machine a slot. Depending on the cycle parameters, the following machining alternatives are available:

- Complete machining: Roughing, floor finishing, side finishing
- Only roughing
- Only floor finishing and side finishing
- Only floor finishing
- Only side finishing

Roughing

- 1 Starting from the left slot arc center, the tool moves in a reciprocating motion at the plunging angle defined in the tool table to the first infeed depth. Specify the plunging strategy with Parameter Q366.
- 2 The TNC roughs out the slot from the inside out, taking the finishing allowances (parameters Q368 and Q369) into account.
- 3 This process is repeated until the slot depth is reached.

Finishing

- 4 Inasmuch as finishing allowances are defined, the TNC then finishes the slot walls, in multiple infeeds if so specified. The slot side is approached tangentially in the right slot arc.
- 5 Then the TNC finishes the floor of the slot from the inside out. The slot floor is approached tangentially.

Please note while programming:

With an inactive tool table you must always plunge vertically (Q366=0) because you cannot define a plunging angle.

Pre-position the tool in the machining plane to the starting position with radius compensation **R0**. Note Parameter Q367 (slot position).

The TNC runs the cycle in the axes (machining plane) with which you approached the starting position. For example, in X and Y if you programmed **CYCL CALL POS X... Y...** or in U and V if you programmed **CYCL CALL POS U... V...**

The TNC automatically pre-positions the tool in the tool axis. Note Parameter Q204 (2nd setup clearance).

At the end of the cycle the TNC returns the tool to the starting point (slot center) in the working plane. Exception: if you define a slot position not equal to 0, then the TNC only positions the tool in the tool axis to the 2nd setup clearance. In these cases, always program absolute traverse movements after the cycle call.

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.

If the slot width is greater than twice the tool diameter, the TNC roughs the slot correspondingly from inside out. You can therefore mill any slots with small tools, too.

**Danger of collision!**

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!

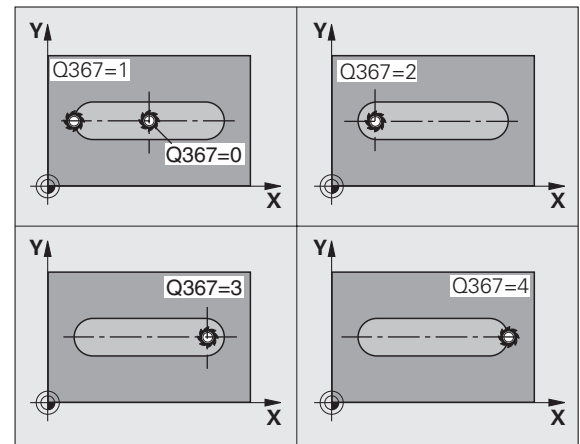
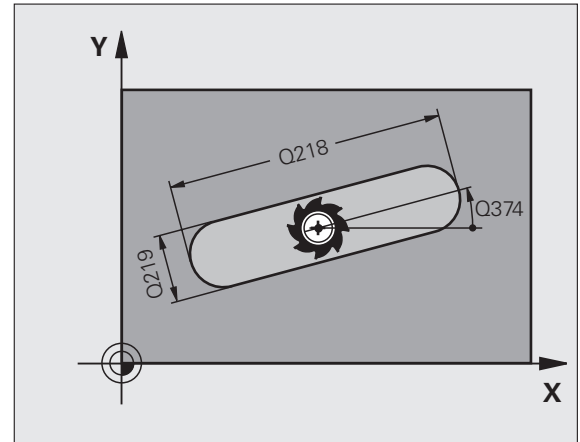
If you call the cycle with machining operation 2 (only finishing), then the TNC positions the tool to the first plunging depth at rapid traverse:



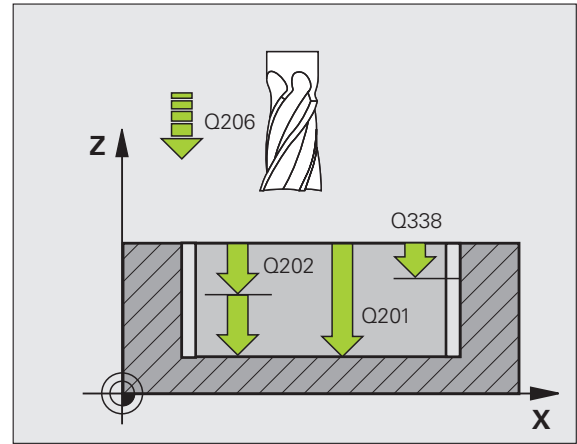
Cycle parameters



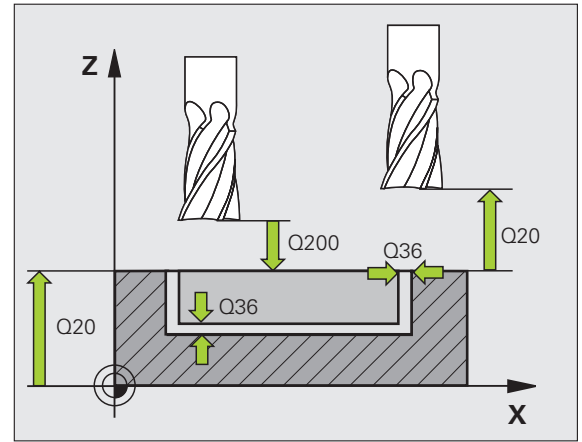
- ▶ **Machining operation (0/1/2)** Q215: Define the machining operation:
0: Roughing and finishing
1: Only roughing
2: Only finishing
 Side finishing and floor finishing are only executed if the finishing allowances (Q368, Q369) have been defined.
- ▶ **Slot length** Q218 (value parallel to the reference axis of the working plane): Enter the length of the slot. Input range: 0 to 99999.9999
- ▶ **Slot width** Q219 (value parallel to the secondary axis of the working plane): Enter the slot width. If you enter a slot width that equals the tool diameter, the TNC will carry out the roughing process only (slot milling). Maximum slot width for roughing: Twice the tool diameter. Input range: 0 to 99999.9999
- ▶ **Finishing allowance for side** Q368 (incremental): Finishing allowance in the working plane.
- ▶ **Angle of rotation** Q374 (absolute): Angle by which the entire slot is rotated. The center of rotation is the position at which the tool is located when the cycle is called. Input range: -360.000 to 360.000
- ▶ **Slot position (0/1/2/3/4)** Q367: Position of the slot in reference to the position of the tool when the cycle is called:
0: Tool position = Center of slot
1: Tool position = Left end of slot
2: Tool position = Center of left slot circle
3: Tool position = Center of right slot circle
4: Tool position = Right end of slot
- ▶ **Feed rate for milling** Q207: Traversing speed of the tool during milling in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU, FZ**.
- ▶ **Climb or up-cut** Q351: Type of milling operation with M3:
+1 = climb milling
-1 = up-cut milling
 Alternatively **PREDEF**



- ▶ **Depth Q201** (incremental): Distance between workpiece surface and bottom of slot. Input range: -99999.9999 to 99999.9999
- ▶ **Plunging depth Q202** (incremental): Infeed per cut. Enter a value greater than 0. Input range: 0 to 99999.9999
- ▶ **Finishing allowance for floor Q369** (incremental): Finishing allowance in the tool axis. Input range: 0 to 99999.9999
- ▶ **Feed rate for plunging Q206**: Traversing speed of the tool while moving to depth in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO**, **FU**, **FZ**.
- ▶ **Infeed for finishing Q338** (incremental): Infeed per cut. Q338=0: Finishing in one infeed. Input range: 0 to 99999.9999



- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Workpiece surface coordinate** Q203 (absolute): Absolute coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Plunging strategy** Q366: Type of plunging strategy.
 - 0 = vertical plunging. The TNC plunges perpendicularly, regardless of the plunging angle **ANGLE** defined in the tool table.
 - 1 = helical plunging. In the tool table, the plunging angle **ANGLE** for the active tool must be defined as not equal to 0. Otherwise, the TNC generates an error message. Plunge on a helical path only if there is enough space.
 - 2 = reciprocating plunge. In the tool table, the plunging angle **ANGLE** for the active tool must be defined as not equal to 0. The TNC will otherwise display an error message.
- Alternative: **PREDEF**
- ▶ **Feed rate for finishing** Q385: Traversing speed of the tool during side and floor finishing in mm/min. Input range: 0 to 99999.9999; alternatively **FAUTO**, **FU**, **FZ**.



Example: NC blocks

8 CYCL DEF 253 SLOT MILLING	
Q215=0	;MACHINING OPERATION
Q218=80	;SLOT LENGTH
Q219=12	;SLOT WIDTH
Q368=0.2	;ALLOWANCE FOR SIDE
Q374=+0	;ANGLE OF ROTATION
Q367=0	;SLOT POSITION
Q207=500	;FEED RATE FOR MILLING
Q351=+1	;CLIMB OR UP-CUT
Q201=-20	;DEPTH
Q202=5	;PLUNGING DEPTH
Q369=0.1	;ALLOWANCE FOR FLOOR
Q206=150	;FEED RATE FOR PLUNGING
Q338=5	;INFEEED FOR FINISHING
Q200=2	;SETUP CLEARANCE
Q203=+0	;SURFACE COORDINATE
Q204=50	;2ND SETUP CLEARANCE
Q366=1	;PLUNGE
Q385=500	;FEED RATE FOR FINISHING
9 CYCL CALL POS X+50 Y+50 Z+0 FMAX M3	

5.5 CIRCULAR SLOT (Cycle 254, DIN/ISO: G254)

Cycle run

Use Cycle 254 to completely machine a circular slot. Depending on the cycle parameters, the following machining alternatives are available:

- Complete machining: Roughing, floor finishing, side finishing
- Only roughing
- Only floor finishing and side finishing
- Only floor finishing
- Only side finishing

Roughing

- 1 The tool moves in a reciprocating motion in the slot center at the plunging angle defined in the tool table to the first infeed depth. Specify the plunging strategy with Parameter Q366.
- 2 The TNC roughs out the slot from the inside out, taking the finishing allowances (parameters Q368 and Q369) into account.
- 3 This process is repeated until the slot depth is reached.

Finishing

- 4 Inasmuch as finishing allowances are defined, the TNC then finishes the slot walls, in multiple infeeds if so specified. The slot side is approached tangentially.
- 5 Then the TNC finishes the floor of the slot from the inside out. The slot floor is approached tangentially.



Please note while programming:

With an inactive tool table you must always plunge vertically (Q366=0) because you cannot define a plunging angle.

Pre-position the tool in the machining plane with radius compensation **R0**. Define Parameter Q367 (**Reference for slot position**) appropriately.

The TNC runs the cycle in the axes (machining plane) with which you approached the starting position. For example, in X and Y if you programmed **CYCL CALL POS X... Y...** or in U and V if you programmed **CYCL CALL POS U... V...**

The TNC automatically pre-positions the tool in the tool axis. Note Parameter Q204 (2nd setup clearance).

At the end of the cycle the TNC returns the tool to the starting point (center of the circular arc) in the working plane. Exception: if you define a slot position not equal to 0, then the TNC only positions the tool in the tool axis to the 2nd setup clearance. In these cases, always program absolute traverse movements after the cycle call.

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.

If the slot width is greater than twice the tool diameter, the TNC roughs the slot correspondingly from inside out. You can therefore mill any slots with small tools, too.

The slot position 0 is not allowed if you use Cycle 254 Circular Slot in combination with Cycle 221.

**Danger of collision!**

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

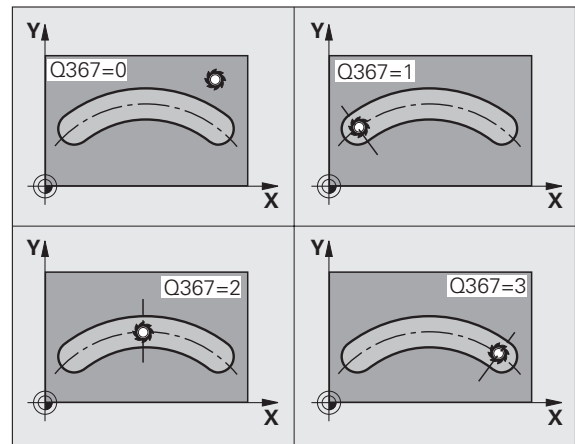
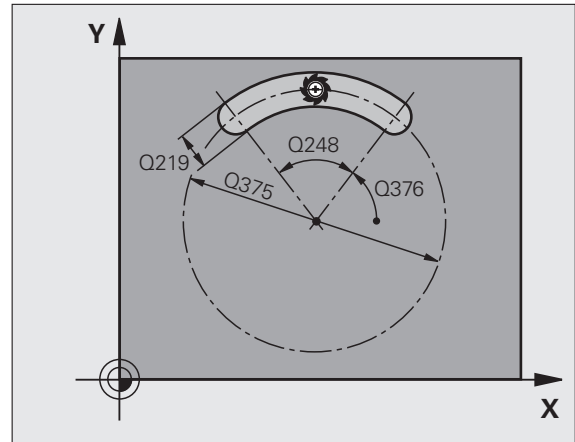
Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!

If you call the cycle with machining operation 2 (only finishing), then the TNC positions the tool to the first plunging depth at rapid traverse:

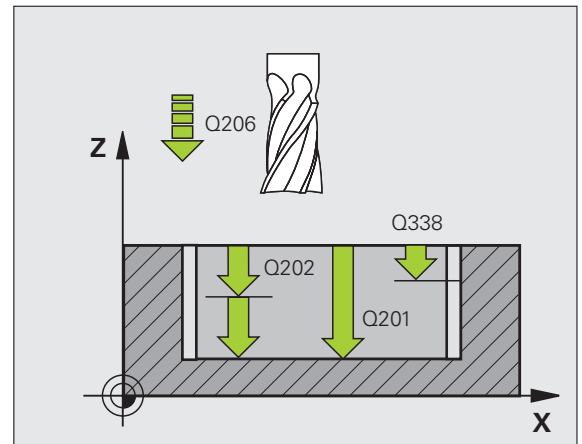
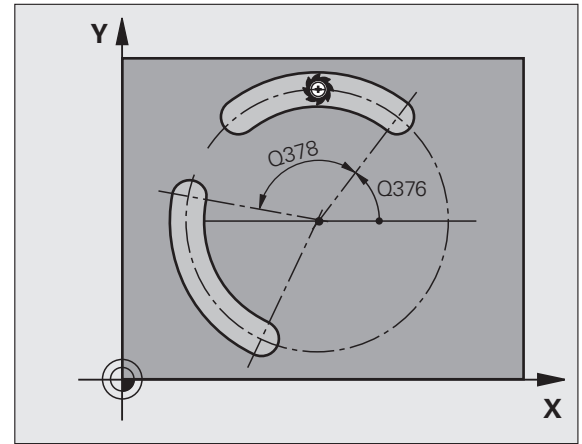
Cycle parameters



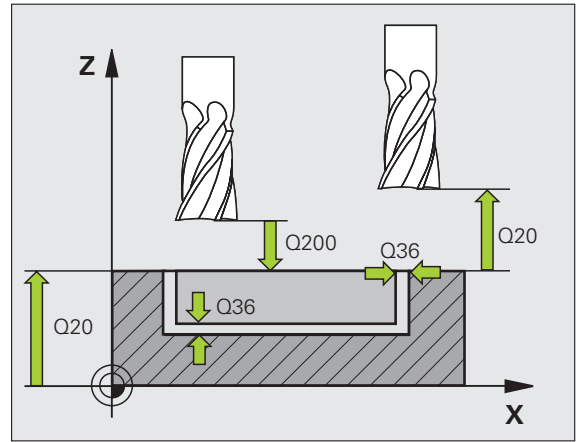
- ▶ **Machining operation (0/1/2)** Q215: Define the machining operation:
 - 0:** Roughing and finishing
 - 1:** Only roughing
 - 2:** Only finishing
 Side finishing and floor finishing are only executed if the finishing allowances (Q368, Q369) have been defined.
- ▶ **Slot width** Q219 (value parallel to the secondary axis of the working plane): Enter the slot width. If you enter a slot width that equals the tool diameter, the TNC will carry out the roughing process only (slot milling). Maximum slot width for roughing: Twice the tool diameter. Input range: 0 to 99999.9999
- ▶ **Finishing allowance for side** Q368 (incremental): Finishing allowance in the working plane. Input range: 0 to 99999.9999
- ▶ **Pitch circle diameter** Q375: Enter the diameter of the pitch circle. Input range: 0 to 99999.9999
- ▶ **Reference for slot position (0/1/2/3)** Q367: Position of the slot in reference to the position of the tool when the cycle is called:
 - 0:** The tool position is not taken into account. The slot position is determined from the entered pitch circle center and the starting angle.
 - 1:** Tool position = Center of left slot circle. Starting angle Q376 refers to this position. The entered pitch circle center is not taken into account.
 - 2:** Tool position = Center of center line. Starting angle Q376 refers to this position. The entered pitch circle center is not taken into account.
 - 3:** Tool position = Center of right slot circle. Starting angle Q376 refers to this position. The entered pitch circle center is not taken into account.
- ▶ **Center in 1st axis** Q216 (absolute): Center of the pitch circle in the reference axis of the working plane.
Only effective if Q367 = 0. Input range: -99999.9999 to 99999.9999
- ▶ **Center in 2nd axis** Q217 (absolute): Center of the pitch circle in the minor axis of the working plane.
Only effective if Q367 = 0. Input range: -99999.9999 to 99999.9999
- ▶ **Starting angle** Q376 (absolute): Enter the polar angle of the starting point. Input range: -360.000 to 360.000
- ▶ **Angular length** Q248 (incremental): Enter the angular length of the slot. Input range: 0 to 360.000



- ▶ **Angle increment** Q378 (incremental): Angle by which the entire slot is rotated. The center of rotation is at the center of the pitch circle. Input range: -360.000 to 360.000
- ▶ **Number of repetitions** Q377: Number of machining operations on a pitch circle. Input range: 1 to 99999
- ▶ **Feed rate for milling** Q207: Traversing speed of the tool during milling in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU, FZ**.
- ▶ **Climb or up-cut** Q351: Type of milling operation with M3:
 +1 = climb milling
 -1 = up-cut milling
 Alternatively **PREDEF**
- ▶ **Depth** Q201 (incremental): Distance between workpiece surface and bottom of slot. Input range: -99999.9999 to 99999.9999
- ▶ **Plunging depth** Q202 (incremental): Infeed per cut. Enter a value greater than 0. Input range: 0 to 99999.9999
- ▶ **Finishing allowance for floor** Q369 (incremental): Finishing allowance in the tool axis. Input range: 0 to 99999.9999
- ▶ **Feed rate for plunging** Q206: Traversing speed of the tool while moving to depth in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU, FZ**.
- ▶ **Infeed for finishing** Q338 (incremental): Infeed per cut. Q338=0: Finishing in one infeed. Input range: 0 to 99999.9999



- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Workpiece surface coordinate** Q203 (absolute): Absolute coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Plunging strategy** Q366: Type of plunging strategy.
 - 0 = vertical plunging. The TNC plunges perpendicularly, regardless of the plunging angle **ANGLE** defined in the tool table.
 - 1 = helical plunging. In the tool table, the plunging angle **ANGLE** for the active tool must be defined as not equal to 0. Otherwise, the TNC generates an error message. Plunge on a helical path only if there is enough space.
 - 2 = reciprocating plunge. In the tool table, the plunging angle **ANGLE** for the active tool must be defined as not equal to 0. Otherwise, the TNC generates an error message. The TNC can only plunge reciprocally once the traversing length on the circular arc is at least three times the tool diameter.
- Alternative: **PREDEF**
- ▶ **Feed rate for finishing** Q385: Traversing speed of the tool during side and floor finishing in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO**, **FU**, **FZ**.



Example: NC blocks

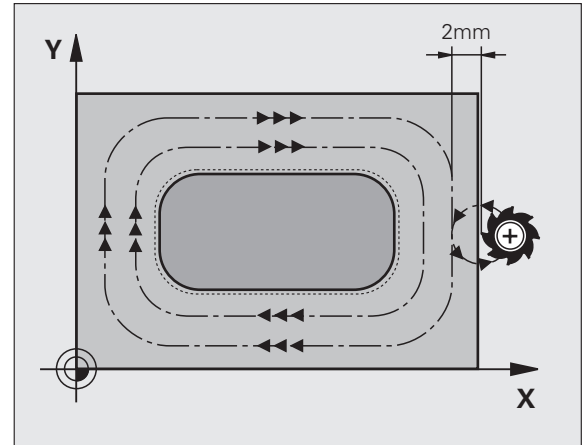
8 CYCL DEF 254 CIRCULAR SLOT	
Q215=0	;MACHINING OPERATION
Q219=12	;SLOT WIDTH
Q368=0.2	;ALLOWANCE FOR SIDE
Q375=80	;PITCH CIRCLE DIA.
Q367=0	;REF. SLOT POSITION
Q216=+50	;CENTER IN 1ST AXIS
Q217=+50	;CENTER IN 2ND AXIS
Q376=+45	;STARTING ANGLE
Q248=90	;ANGULAR LENGTH
Q378=0	;STEPPING ANGLE
Q377=1	;NUMBER OF OPERATIONS
Q207=500	;FEED RATE FOR MILLING
Q351=+1	;CLIMB OR UP-CUT
Q201=-20	;DEPTH
Q202=5	;PLUNGING DEPTH
Q369=0.1	;ALLOWANCE FOR FLOOR
Q206=150	;FEED RATE FOR PLUNGING
Q338=5	;INFEEED FOR FINISHING
Q200=2	;SETUP CLEARANCE
Q203=+0	;SURFACE COORDINATE
Q204=50	;2ND SETUP CLEARANCE
Q366=1	;PLUNGE
Q385=500	;FEED RATE FOR FINISHING
9 CYCL CALL POS X+50 Y+50 Z+0 FMAX M3	

5.6 RECTANGULAR STUD (Cycle 256, DIN/ISO: G256)

Cycle run

Use Cycle 256 to machine a rectangular stud. If a dimension of the workpiece blank is greater than the maximum possible stepover, then the TNC performs multiple stepovers until the finished dimension has been machined.

- 1 The tool moves from the cycle starting position (stud center) in the positive X direction to the starting position for the stud machining. The starting position is 2 mm to the right of the unmachined stud.
- 2 If the tool is at the 2nd setup clearance, it moves at rapid traverse **FMAX** to the setup clearance, and from there it advances to the first plunging depth at the feed rate for plunging.
- 3 The tool then moves tangentially on a semicircle to the stud contour and machines one revolution.
- 4 If the finished dimension cannot be machined with one revolution, the TNC performs a stepover with the current factor, and machines another revolution. The TNC takes the dimensions of the workpiece blank, the finished dimension, and the permitted stepover into account. This process is repeated until the defined finished dimension has been reached.
- 5 The tool then tangentially departs the contour on a semicircle and returns to the starting point for the stud machining.
- 6 The TNC then plunges the tool to the next plunging depth, and machines the stud at this depth.
- 7 This process is repeated until the programmed stud depth is reached.



Please note while programming:

Pre-position the tool in the machining plane to the starting position with radius compensation **R0**. Note Parameter Q367 (stud position).

The TNC automatically pre-positions the tool in the tool axis. Note Parameter Q204 (2nd setup clearance).

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.

At the end, the TNC positions the tool back to the setup clearance, or to the 2nd setup clearance if one was programmed.

**Danger of collision!**

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!

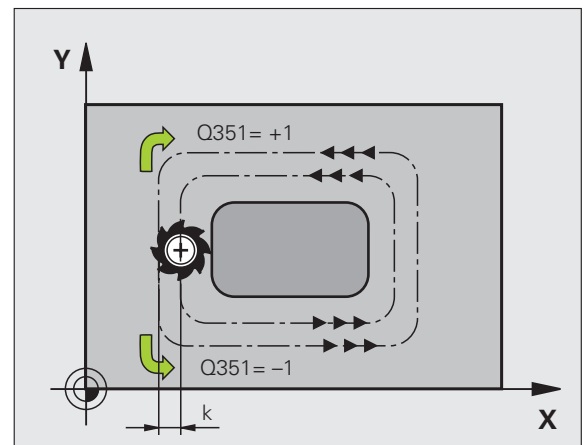
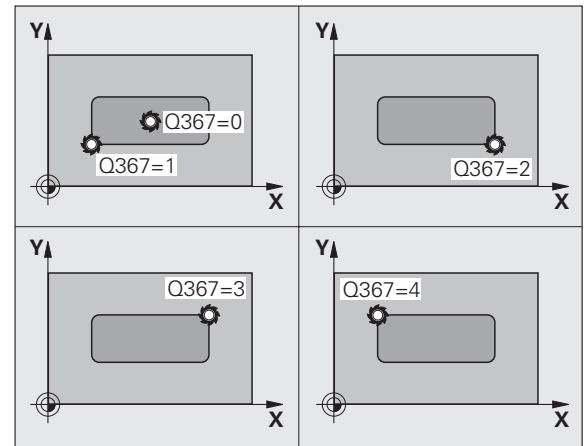
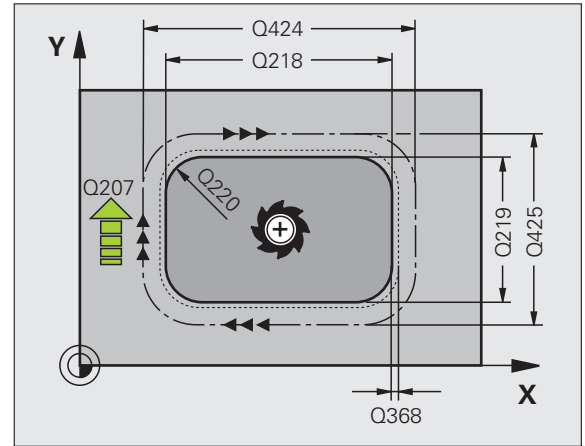
Leave enough room next to the stud for the approach motion. Minimum: tool diameter + 2 mm



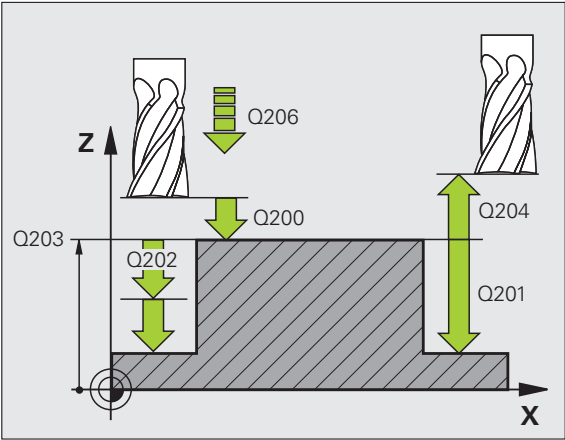
Cycle parameters



- ▶ **First side length** Q218: Stud length, parallel to the reference axis of the working plane. Input range: 0 to 99999.9999
- ▶ **Workpiece blank side length 1** Q424: Length of the stud blank, parallel to the reference axis of the working plane. Enter **Workpiece blank side length 1** greater than **First side length**. The TNC performs multiple stepovers if the difference between blank dimension 1 and finished dimension 1 is greater than the permitted stepover (tool radius multiplied by path overlap **Q370**). The TNC always calculates a constant stepover. Input range: 0 to 99999.9999
- ▶ **Second side length** Q219: Stud length, parallel to the minor axis of the working plane. Enter **Workpiece blank side length 2** greater than **Second side length**. The TNC performs multiple stepovers if the difference between blank dimension 2 and finished dimension 2 is greater than the permitted stepover (tool radius multiplied by path overlap **Q370**). The TNC always calculates a constant stepover. Input range: 0 to 99999.9999
- ▶ **Workpiece blank side length 2** Q425: Length of the stud blank, parallel to the minor axis of the working plane. Input range: 0 to 99999.9999
- ▶ **Corner radius** Q220: Radius of the stud corner. Input range: 0 to 99999.9999
- ▶ **Finishing allowance for side** Q368 (incremental): Finishing allowance in the working plane, is left over after machining. Input range: 0 to 99999.9999
- ▶ **Angle of rotation** Q224 (absolute): Angle by which the entire stud is rotated. The center of rotation is the position at which the tool is located when the cycle is called. Input range: -360.000 to 360.000
- ▶ **Stud position** Q367: Position of the stud in reference to the position of the tool when the cycle is called:
 - 0:** Tool position = Center of stud
 - 1:** Tool position = Lower left corner
 - 2:** Tool position = Lower right corner
 - 3:** Tool position = Upper right corner
 - 4:** Tool position = Upper left corner



- **Feed rate for milling** Q207: Traversing speed of the tool during milling in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU, FZ**.
- **Climb or up-cut** Q351: Type of milling operation with M3:
+1 = climb milling
-1 = up-cut milling
 Alternatively **PREDEF**
- **Depth** Q201 (incremental): Distance between workpiece surface and bottom of stud. Input range: -99999.9999 to 99999.9999
- **Plunging depth** Q202 (incremental): Infeed per cut. Enter a value greater than 0. Input range: 0 to 99999.9999
- **Feed rate for plunging** Q206: Traversing speed of the tool while moving to depth in mm/min. Input range: 0 to 99999.999; alternatively **FMAX, FAUTO, FU, FZ**.
- **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- **Workpiece surface coordinate** Q203 (absolute): Absolute coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- **Path overlap factor** Q370: $Q370 \times \text{tool radius} = \text{stepover factor } k$. Input range: 0.1 to 1.9999 alternatively **PREDEF**.



Example: NC blocks

8 CYCL DEF 256 RECTANGULAR STUD				
Q218=60	;FIRST SIDE LENGTH			
Q424=74	;WORKPC. BLANK SIDE 1			
Q219=40	;2ND SIDE LENGTH			
Q425=60	;WORKPC. BLANK SIDE 2			
Q220=5	;CORNER RADIUS			
Q368=0.2	;ALLOWANCE FOR SIDE			
Q224=+0	;ANGLE OF ROTATION			
Q367=0	;STUD POSITION			
Q207=500	;FEED RATE FOR MILLING			
Q351=+1	;CLIMB OR UP-CUT			
Q201=-20	;DEPTH			
Q202=5	;PLUNGING DEPTH			
Q206=150	;FEED RATE FOR PLUNGING			
Q200=2	;SETUP CLEARANCE			
Q203=+0	;SURFACE COORDINATE			
Q204=50	;2ND SETUP CLEARANCE			
Q370=1	;TOOL PATH OVERLAP			
9 CYCL CALL POS X+50 Y+50 Z+0 FMAX M3				

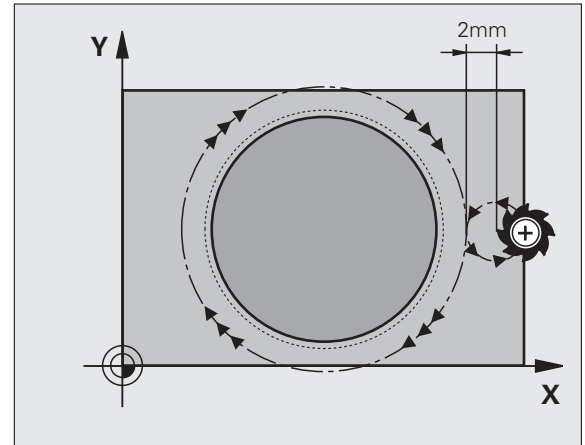


5.7 CIRCULAR STUD (Cycle 257, DIN/ISO: G257)

Cycle run

Use Cycle 257 to machine a circular stud. If a diameter of the workpiece blank is greater than the maximum possible stepover, then the TNC performs multiple stepovers until the finished diameter has been machined.

- 1 The tool moves from the cycle starting position (stud center) in the positive X direction to the starting position for the stud machining. The starting position is 2 mm to the right of the unmachined stud.
- 2 If the tool is at the 2nd setup clearance, it moves at rapid traverse FMAX to the set-up clearance, and from there advances to the first plunging depth at the feed rate for plunging.
- 3 The tool then moves tangentially on a semicircle to the stud contour and machines one revolution.
- 4 If the finished diameter cannot be machined with one revolution, the TNC performs a stepover with the current factor, and machines another revolution. The TNC takes the dimensions of the workpiece blank diameter, the finished diameter, and the permitted stepover into account. This process is repeated until the defined finished diameter has been reached.
- 5 The tool then tangentially departs the contour on a semicircle and returns to the starting point for the stud machining.
- 6 The TNC then plunges the tool to the next plunging depth, and machines the stud at this depth.
- 7 This process is repeated until the programmed stud depth is reached.



Please note while programming:

Pre-position the tool in the machining plane to the starting position (stud center) with radius compensation **R0**.

The TNC automatically pre-positions the tool in the tool axis. Note Parameter Q204 (2nd setup clearance).

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.

At the end of the cycle, the TNC returns the tool to the starting position.

At the end, the TNC positions the tool back to the setup clearance, or to the 2nd setup clearance if one was programmed.

**Danger of collision!**

Enter in MP7441 bit 2 whether the TNC should output an error message (bit 2=1) or not (bit 2=0) if a positive depth is entered.

Keep in mind that the TNC reverses the calculation for pre-positioning when a **positive depth is entered**. This means that the tool moves at rapid traverse in the tool axis to setup clearance **below** the workpiece surface!

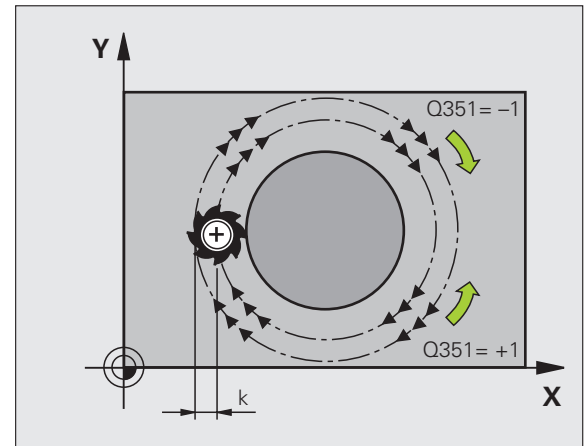
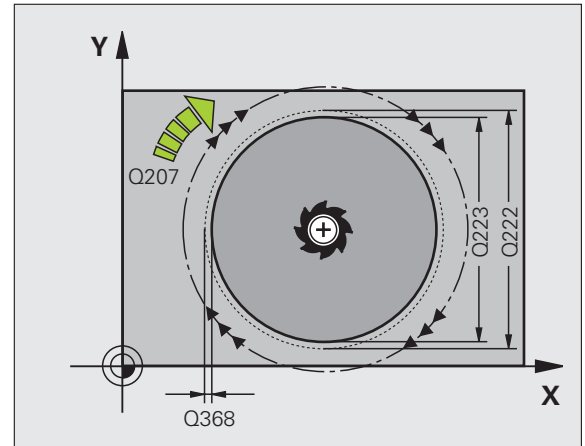
Leave enough room next to the stud for the approach motion. Minimum: tool diameter + 2 mm



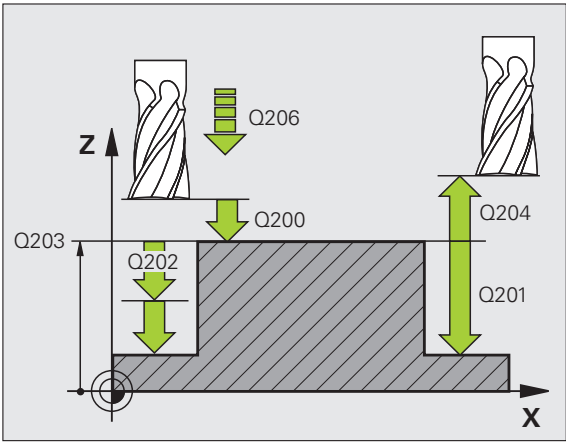
Cycle parameters



- ▶ **Finished part diameter Q223:** Diameter of the completely machined stud. Input range: 0 to 99999.9999
- ▶ **Workpiece blank diameter Q222:** Diameter of the workpiece blank. Enter the workpiece blank diameter greater than the finished diameter. The TNC performs multiple stepovers if the difference between the workpiece blank diameter and finished diameter is greater than the permitted stepover (tool radius multiplied by path overlap **Q370**). The TNC always calculates a constant stepover. Input range: 0 to 99999.9999
- ▶ **Finishing allowance for side Q368 (incremental):** Finishing allowance in the working plane. Input range: 0 to 99999.9999
- ▶ **Feed rate for milling Q207:** Traversing speed of the tool during milling in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO, FU, FZ**.
- ▶ **Climb or up-cut Q351:** Type of milling operation with M3:
 - +1** = climb milling
 - 1** = up-cut milling
 Alternatively **PREDEF**



- **Depth** Q201 (incremental): Distance between workpiece surface and bottom of stud. Input range: -99999.9999 to 99999.9999
- **Plunging depth** Q202 (incremental): Infeed per cut. Enter a value greater than 0. Input range: 0 to 99999.9999
- **Feed rate for plunging** Q206: Traversing speed of the tool while moving to depth in mm/min. Input range: 0 to 99999.999; alternatively **FMAX**, **FAUTO**, **FU**, **FZ**.
- **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- **Workpiece surface coordinate** Q203 (absolute): Absolute coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- **Path overlap factor** Q370: $Q370 \times \text{tool radius} = \text{stepover factor } k$. Input range: 0.1 to 1.9999 alternatively **PREDEF**.



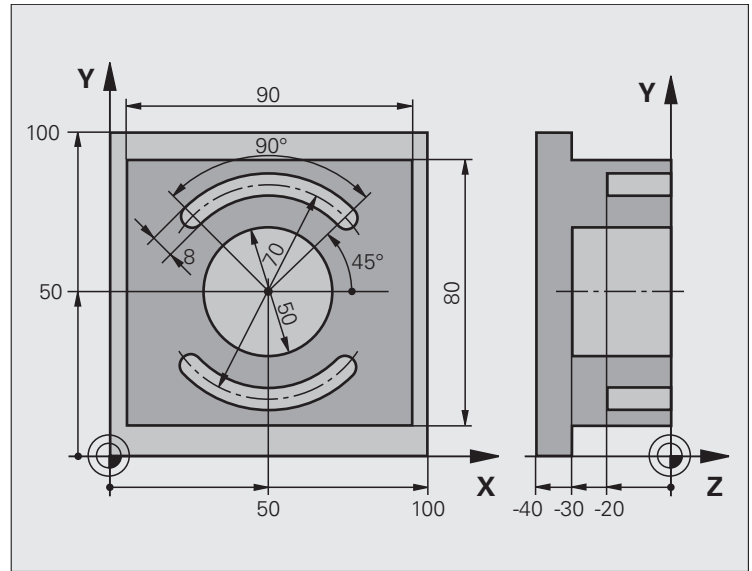
Example: NC blocks

8 CYCL DEF 257 CIRCULAR STUD	
Q223=60	; FINISHED PART DIA.
Q222=60	; WORKPIECE BLANK DIA.
Q368=0.2	; ALLOWANCE FOR SIDE
Q207=500	; FEED RATE FOR MILLING
Q351=+1	; CLIMB OR UP-CUT
Q201=-20	; DEPTH
Q202=5	; PLUNGING DEPTH
Q206=150	; FEED RATE FOR PLUNGING
Q200=2	; SETUP CLEARANCE
Q203=+0	; SURFACE COORDINATE
Q204=50	; 2ND SETUP CLEARANCE
Q370=1	; TOOL PATH OVERLAP
9 CYCL CALL POS X+50 Y+50 Z+0 FMAX M3	



5.8 Programming examples

Example: Milling pockets, studs and slots



```
0 BEGIN PGM C210 MM
```

```
1 BLK FORM 0.1 Z X+0 Y+0 Z-40
```

Definition of workpiece blank

```
2 BLK FORM 0.2 X+100 Y+100 Z+0
```

```
3 TOOL DEF 1 L+0 R+6
```

Define the tool for roughing/finishing

```
4 TOOL DEF 2 L+0 R+3
```

Define slotting mill

```
5 TOOL CALL 1 Z S3500
```

Call the tool for roughing/finishing

```
6 L Z+250 R0 FMAX
```

Retract the tool

7 CYCL DEF 256 RECTANGULAR STUD	Define cycle for machining the contour outside
Q218=90 ;FIRST SIDE LENGTH	
Q424=100 ;WORKPC. BLANK SIDE 1	
Q219=80 ;2ND SIDE LENGTH	
Q425=100 ;WORKPC. BLANK SIDE 2	
Q220=0 ;CORNER RADIUS	
Q368=0 ;ALLOWANCE FOR SIDE	
Q224=0 ;ROTATIONAL POSITION	
Q367=0 ;STUD POSITION	
Q207=250 ;FEED RATE FOR MILLING	
Q351=+1 ;CLIMB OR UP-CUT	
Q201=-30 ;DEPTH	
Q202=5 ;PLUNGING DEPTH	
Q206=250 ;FEED RATE FOR PLNGNG	
Q200=2 ;SETUP CLEARANCE	
Q203=+0 ;SURFACE COORDINATE	
Q204=20 ;2ND SETUP CLEARANCE	
Q370=1 ;TOOL PATH OVERLAP	
8 CYCL CALL POS X+50 Y+50 Z+0 M3	Call cycle for machining the contour outside
9 CYCL DEF 252 CIRCULAR POCKET	Define CIRCULAR POCKET MILLING cycle
Q215=0 ;MACHINING OPERATION	
Q223=50 ;CIRCLE DIAMETER	
Q368=0.2 ;ALLOWANCE FOR SIDE	
Q207=500 ;FEED RATE FOR MILLING	
Q351=+1 ;CLIMB OR UP-CUT	
Q201=-30 ;DEPTH	
Q202=5 ;PLUNGING DEPTH	
Q369=0.1 ;ALLOWANCE FOR FLOOR	
Q206=150 ;FEED RATE FOR PLUNGING	
Q338=5 ;INFEEED FOR FINISHING	
Q200=2 ;SETUP CLEARANCE	
Q203=+0 ;SURFACE COORDINATE	
Q204=50 ;2ND SETUP CLEARANCE	
Q370=1 ;TOOL PATH OVERLAP	
Q366=1 ;PLUNGE	
Q385=750 ;FEED RATE FOR FINISHING	
10 CYCL CALL POS X+50 Y+50 Z+0 FMAX	Call CIRCULAR POCKET MILLING cycle
11 L Z+250 R0 FMAX M6	Tool change



5.8 Programming examples

12 TOLL CALL 2 Z S5000	Call slotting mill
13 CYCL DEF 254 CIRCULAR SLOT	Define SLOT cycle
Q215=0 ;MACHINING OPERATION	
Q219=8 ;SLOT WIDTH	
Q368=0.2 ;ALLOWANCE FOR SIDE	
Q375=70 ;PITCH CIRCLE DIA.	
Q367=0 ;REF. SLOT POSITION	No pre-positioning in X/Y required
Q216=+50 ;CENTER IN 1ST AXIS	
Q217=+50 ;CENTER IN 2ND AXIS	
Q376=+45 ;STARTING ANGLE	
Q248=90 ;ANGULAR LENGTH	
Q378=180 ;STEPPING ANGLE	Starting point for second slot
Q377=2 ;NUMBER OF OPERATIONS	
Q207=500 ;FEED RATE FOR MILLING	
Q351=+1 ;CLIMB OR UP-CUT	
Q201=-20 ;DEPTH	
Q202=5 ;PLUNGING DEPTH	
Q369=0.1 ;ALLOWANCE FOR FLOOR	
Q206=150 ;FEED RATE FOR PLUNGING	
Q338=5 ;INFEEED FOR FINISHING	
Q200=2 ;SETUP CLEARANCE	
Q203=+0 ;SURFACE COORDINATE	
Q204=50 ;2ND SETUP CLEARANCE	
Q366=1 ;PLUNGE	
14 CYCL CALL FMAX M3	Call SLOT cycle
15 L Z+250 R0 FMAX M2	Retract in the tool axis, end program
16 END PGM C210 MM	





6



**Canned Cycles: Pattern
Definitions**



6.1 Fundamentals

Overview

The TNC provides two cycles for machining point patterns directly:

Cycle	Soft key	Page
220 CIRCULAR PATTERN		Page 169
221 LINEAR PATTERN		Page 172

You can combine Cycle 220 and Cycle 221 with the following fixed cycles:



If you have to machine irregular point patterns, use **CYCL CALL PAT** (see “Point Tables” on page 63) to develop point tables.

More regular point patterns are available with the **PATTERN DEF** function (see “Pattern Definition PATTERN DEF” on page 55).

Cycle 200	DRILLING
Cycle 201	REAMING
Cycle 202	BORING
Cycle 203	UNIVERSAL DRILLING
Cycle 204	BACK BORING
Cycle 205	UNIVERSAL PECKING
Cycle 206	TAPPING NEW with a floating tap holder
Cycle 207	RIGID TAPPING without a floating tap holder NEW
Cycle 208	BORE MILLING
Cycle 209	TAPPING WITH CHIP BREAKING
Cycle 240	CENTERING
Cycle 251	RECTANGULAR POCKET
Cycle 252	CIRCULAR POCKET
Cycle 253	SLOT MILLING
Cycle 254	CIRCULAR SLOT (can only be combined with Cycle 221)
Cycle 256	RECTANGULAR STUD
Cycle 257	CIRCULAR STUD
Cycle 262	THREAD MILLING
Cycle 263	THREAD MILLING/COUNTERSINKING
Cycle 264	THREAD DRILLING/MILLING
Cycle 265	HELICAL THREAD DRILLING/MILLING
Cycle 267	OUTSIDE THREAD MILLING



6.2 CIRCULAR PATTERN (Cycle 220, DIN/ISO: G220))

Cycle run

- 1 The TNC moves the tool at rapid traverse from its current position to the starting point for the first machining operation.

Sequence:

- Move to the 2nd setup clearance (spindle axis)
 - Approach the starting point in the spindle axis.
 - Move to the setup clearance above the workpiece surface (spindle axis).
- 2 From this position the TNC executes the last defined fixed cycle.
 - 3 The tool then approaches on a straight line or circular arc the starting point for the next machining operation. The tool stops at the set-up clearance (or the 2nd setup clearance).
 - 4 This process (1 to 3) is repeated until all machining operations have been executed.

Please note while programming:



Cycle 220 is DEF active, which means that Cycle 220 automatically calls the last defined fixed cycle.

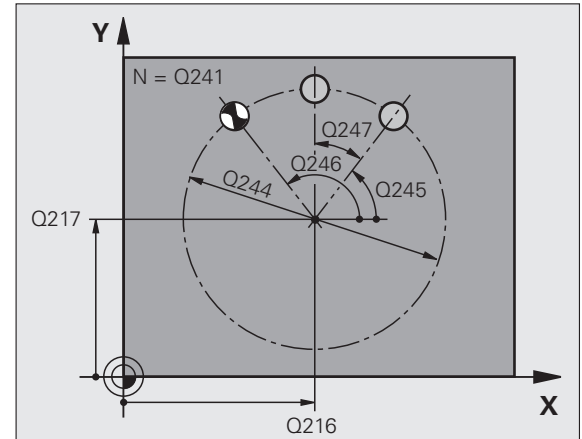
If you combine Cycle 220 with one of the fixed cycles 200 to 209 and 251 to 267, the setup clearance, workpiece surface and 2nd setup clearance that you defined in Cycle 220 will be effective for the selected fixed cycle.



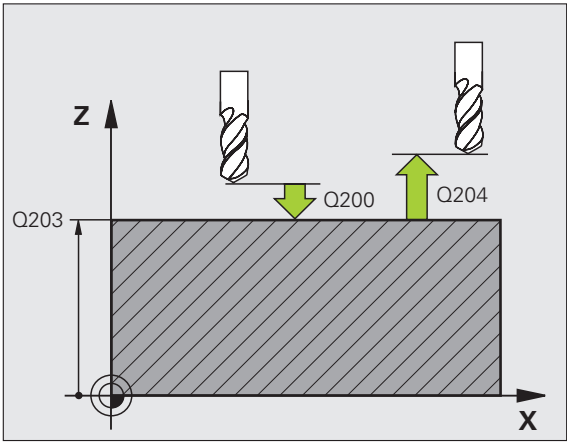
Cycle parameters



- ▶ **Center in 1st axis** Q216 (absolute): Center of the pitch circle in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Center in 2nd axis** Q217 (absolute): Center of the pitch circle in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Pitch circle diameter** Q244: Diameter of the pitch circle. Input range: 0 to 99999.9999
- ▶ **Starting angle** Q245 (absolute): Angle between the reference axis of the working plane and the starting point for the first machining operation on the pitch circle. Input range: -360.000 to 360.000
- ▶ **Stopping angle** Q246 (absolute): Angle between the reference axis of the working plane and the starting point for the last machining operation on the pitch circle (does not apply to full circles). Do not enter the same value for the stopping angle and starting angle. If you enter the stopping angle greater than the starting angle, machining will be carried out counterclockwise; otherwise, machining will be clockwise. Input range: -360.000 to 360.000
- ▶ **Stepping angle** Q247 (incremental): Angle between two machining operations on a pitch circle. If you enter an angle step of 0, the TNC will calculate the angle step from the starting and stopping angles and the number of pattern repetitions. If you enter a value other than 0, the TNC will not take the stopping angle into account. The sign for the angle step determines the working direction (– = clockwise). Input range: -360.000 to 360.000
- ▶ **Number of repetitions** Q241: Number of machining operations on a pitch circle. Input range: 1 to 99999



- **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- **Workpiece surface coordinate** Q203 (absolute): Coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**
- **Moving to clearance height** Q301: Definition of how the tool is to move between machining processes.
0: Move to the setup clearance between operations.
1: Move to the 2nd setup clearance between machining operations.
 Alternatively **PREDEF**
- **Type of traverse?** **Line=0/Arc=1** Q365: Definition of the path function with which the tool is to move between machining operations.
0: Move between operations on a straight line
1: Move between operations on the pitch circle



Example: NC blocks

53	CYCLE DEF 220	POLAR PATTERN
Q216	=+50	;CENTER IN 1ST AXIS
Q217	=+50	;CENTER 2ND AXIS
Q244	=80	;PITCH CIRCLE DIA.
Q245	=+0	;STARTING ANGLE
Q246	=+360	;STOPPING ANGLE
Q247	=+0	;STEPPING ANGLE
Q241	=8	;NUMBER OF OPERATIONS
Q200	=2	;SETUP CLEARANCE
Q203	=+30	;SURFACE COORDINATE
Q204	=50	;2ND SETUP CLEARANCE
Q301	=1	;MOVE TO CLEARANCE
Q365	=0	;TYPE OF TRAVERSE



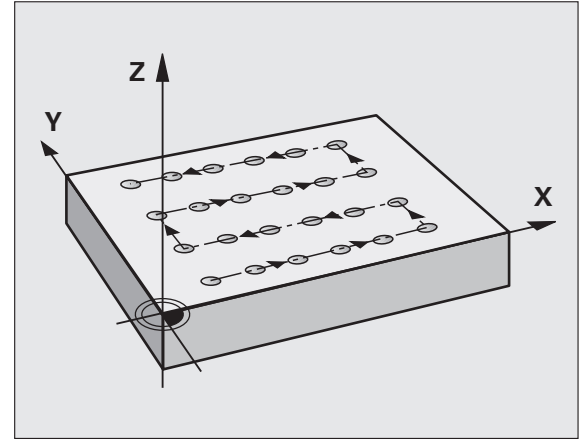
6.3 LINEAR PATTERN (Cycle 221, DIN/ISO: G221)

Cycle run

- 1 The TNC automatically moves the tool from its current position to the starting point for the first machining operation.

Sequence:

- Move to the 2nd setup clearance (spindle axis)
 - Approach the starting point in the spindle axis.
 - Move to the setup clearance above the workpiece surface (spindle axis).
- 2 From this position the TNC executes the last defined fixed cycle.
 - 3 The tool then approaches the starting point for the next machining operation in the positive reference axis direction at the setup clearance (or the 2nd setup clearance).
 - 4 This process (1 to 3) is repeated until all machining operations on the first line have been executed. The tool is located above the last point on the first line.
 - 5 The tool subsequently moves to the last point on the second line where it carries out the machining operation.
 - 6 From this position the tool approaches the starting point for the next machining operation in the negative reference axis direction.
 - 7 This process (6) is repeated until all machining operations in the second line have been executed.
 - 8 The tool then moves to the starting point of the next line.
 - 9 All subsequent lines are processed in a reciprocating movement.



Please note while programming:



Cycle 221 is DEF active, which means that Cycle 221 automatically calls the last defined fixed cycle.

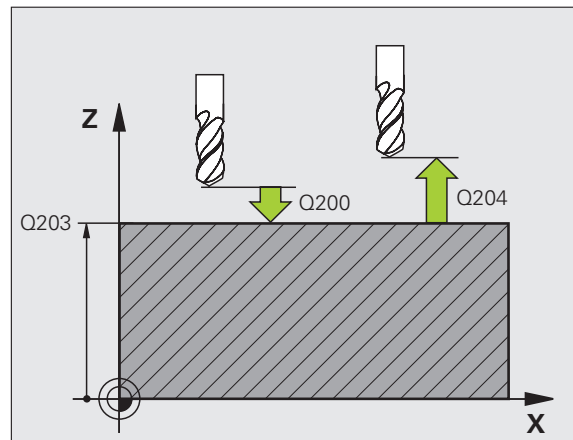
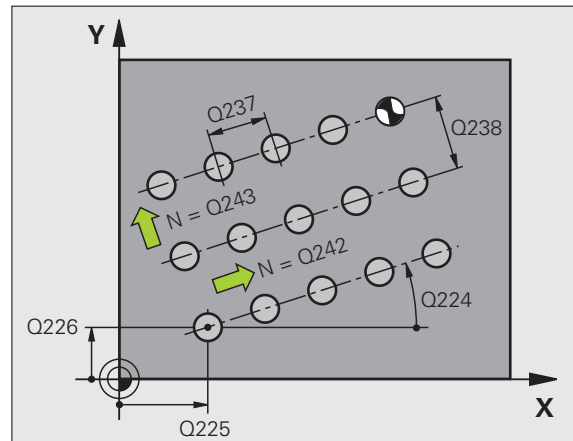
If you combine Cycle 221 with one of the canned cycles 200 to 209 and 251 to 267, the setup clearance, workpiece surface, 2nd setup clearance and the rotational position that you defined in Cycle 221 will be effective for the selected canned cycle.

The slot position 0 is not allowed if you use Cycle 254 Circular Slot in combination with Cycle 221.

Cycle parameters



- ▶ **Starting point 1st axis** Q225 (absolute): Coordinate of the starting point in the reference axis of the working plane.
- ▶ **Starting point 2nd axis** Q226 (absolute): Coordinate of the starting point in the minor axis of the working plane.
- ▶ **Spacing in 1st axis** Q237 (incremental): Spacing between each point on a line.
- ▶ **Spacing in 2nd axis** Q238 (incremental): Spacing between each line.
- ▶ **Number of columns** Q242: Number of machining operations on a line.
- ▶ **Number of lines** Q243: Number of passes.
- ▶ **Rotational position** Q224 (absolute): Angle by which the entire pattern is rotated. The center of rotation lies in the starting point.
- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip and workpiece surface, alternatively **PREDEF**.
- ▶ **Workpiece surface coordinate** Q203 (absolute): Coordinate of the workpiece surface.
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur, alternatively **PREDEF**.
- ▶ **Moving to clearance height** Q301: Definition of how the tool is to move between machining processes.
0: Move to the setup clearance between operations.
1: Move to the 2nd setup clearance between machining operations.
Alternatively **PREDEF**



Example: NC blocks

54 CYCL DEF 221 CARTESIAN PATTERN

Q225=+15 ;STARTING POINT 1ST AXIS

Q226=+15 ;STARTING POINT 2ND AXIS

Q237=+10 ;SPACING IN 1ST AXIS

Q238=+8 ;SPACING IN 2ND AXIS

Q242=6 ;NUMBER OF COLUMNS

Q243=4 ;NUMBER OF LINES

Q224=+15 ;ROTATIONAL POSITION

Q200=2 ;SETUP CLEARANCE

Q203=+30 ;SURFACE COORDINATE

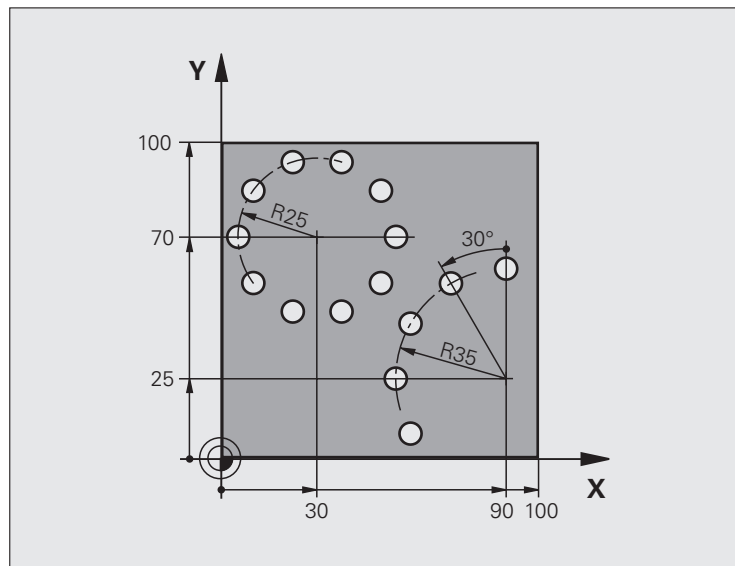
Q204=50 ;2ND SETUP CLEARANCE

Q301=1 ;MOVE TO CLEARANCE



6.4 Programming examples

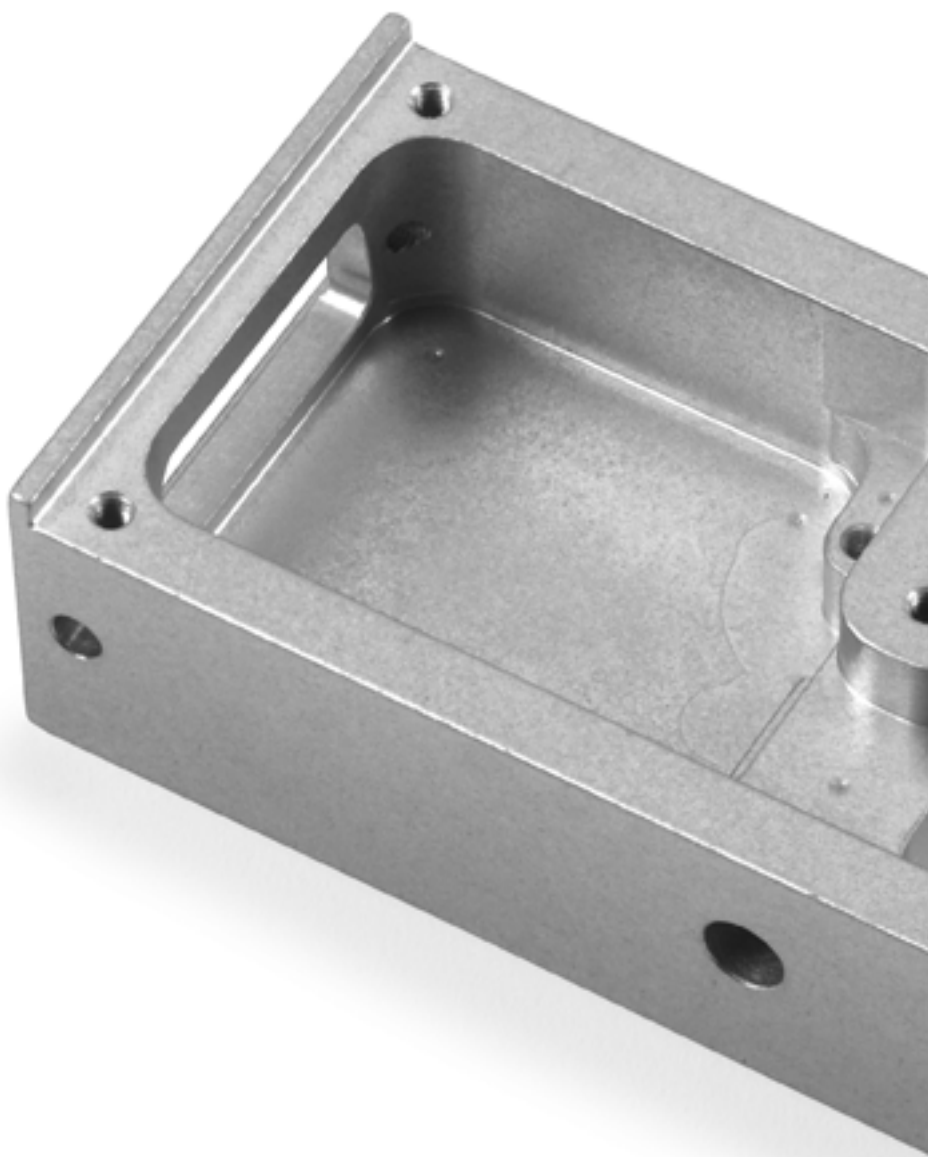
Example: Circular hole patterns



0 BEGIN PGM PATTERN MM	
1 BLK FORM 0.1 Z X+0 Y+0 Z-40	Definition of workpiece blank
2 BLK FORM 0.2 Y+100 Y+100 Z+0	
3 TOOL DEF 1 L+0 R+3	Tool definition
4 TOOL CALL 1 Z S3500	Tool call
5 L Z+250 R0 FMAX M3	Retract the tool
6 CYCL DEF 200 DRILLING	Cycle definition: drilling
Q200=2 ;SETUP CLEARANCE	
Q201=-15 ;DEPTH	
Q206=250 ;FEED RATE FOR PLNGN	
Q202=4 ;PLUNGING DEPTH	
Q210=0 ;DWELL TIME	
Q203=+0 ;SURFACE COORDINATE	
Q204=0 ;2ND SETUP CLEARANCE	
Q211=0.25 ;DWELL TIME AT DEPTH	

7 CYCLE DEF 220 POLAR PATTERN	Define cycle for circular pattern 1, CYCL 200 is called automatically,
Q216=+30 ;CENTER IN 1ST AXIS	Q200, Q203 and Q204 are effective as defined in Cycle 220.
Q217=+70 ;CENTER IN 2ND AXIS	
Q244=50 ;PITCH CIRCLE DIA.	
Q245=+0 ;STARTING ANGLE	
Q246=+360 ;STOPPING ANGLE	
Q247=+0 ;STEPPING ANGLE	
Q241=10 ;QUANTITY	
Q200=2 ;SETUP CLEARANCE	
Q203=+0 ;SURFACE COORDINATE	
Q204=100 ;2ND SETUP CLEARANCE	
Q301=1 ;MOVE TO CLEARANCE	
Q365=0 ;TYPE OF TRAVERSE	
8 CYCLE DEF 220 POLAR PATTERN	Define cycle for circular pattern 2, CYCL 200 is called automatically,
Q216=+90 ;CENTER IN 1ST AXIS	Q200, Q203 and Q204 are effective as defined in Cycle 220.
Q217=+25 ;CENTER IN 2ND AXIS	
Q244=70 ;PITCH CIRCLE DIA.	
Q245=+90 ;STARTING ANGLE	
Q246=+360 ;STOPPING ANGLE	
Q247=30 ;STEPPING ANGLE	
Q241=5 ;QUANTITY	
Q200=2 ;SETUP CLEARANCE	
Q203=+0 ;SURFACE COORDINATE	
Q204=100 ;2ND SETUP CLEARANCE	
Q301=1 ;MOVE TO CLEARANCE	
Q365=0 ;TYPE OF TRAVERSE	
9 L Z+250 R0 FMAX M2	Retract in the tool axis, end program
10 END PGM PATTERN MM	





7

**Canned Cycles:
Contour Pocket**



7.1 SL Cycles

Fundamentals

SL cycles enable you to form complex contours by combining up to 12 subcontours (pockets or islands). You define the individual subcontours in subprograms. The TNC calculates the total contour from the subcontours (subprogram numbers) that you enter in Cycle 14 CONTOUR GEOMETRY.



The memory capacity for programming an SL cycle (all contour subprograms) is limited. The number of possible contour elements depends on the type of contour (inside or outside contour) and the number of subcontours. You can program up to 8192 contour elements.

SL cycles conduct comprehensive and complex internal calculations as well as the resulting machining operations. For safety reasons, always run a graphical program test before machining! This is a simple way of finding out whether the TNC-calculated program will provide the desired results.

Characteristics of the Subprograms

- Coordinate transformations are allowed. If they are programmed within the subcontour they are also effective in the following subprograms, but they need not be reset after the cycle call.
- The TNC ignores feed rates F and miscellaneous functions M.
- The TNC recognizes a pocket if the tool path lies inside the contour, for example if you machine the contour clockwise with radius compensation RR.
- The TNC recognizes an island if the tool path lies outside the contour, for example if you machine the contour clockwise with radius compensation RL.
- The subprograms must not contain spindle axis coordinates.
- The working plane is defined in the first coordinate block of the subprogram. The secondary axes U,V,W are permitted in useful combinations. Always define both axes of the machining plane in the first block.
- If you use Q parameters, then only perform the calculations and assignments within the affected contour subprograms.

Example: Program structure: Machining with SL cycles

```

0 BEGIN PGM SL2 MM
...
12 CYCL DEF 14 CONTOUR GEOMETRY ...
13 CYCL DEF 20 CONTOUR DATA ...
...
16 CYCL DEF 21 PILOT DRILLING ...
17 CYCL CALL
...
18 CYCL DEF 22 ROUGH OUT ...
19 CYCL CALL
...
22 CYCLE DEF 23 FLOOR FINISHING ...
23 CYCL CALL
...
26 CYCL DEF 24 SIDE FINISHING ...
27 CYCL CALL
...
50 L Z+250 R0 FMAX M2
51 LBL 1
...
55 LBL 0
56 LBL 2
...
60 LBL 0
...
99 END PGM SL2 MM

```

Characteristics of the canned cycles

- The TNC automatically positions the tool to the setup clearance before a cycle.
- Each level of infeed depth is milled without interruptions since the cutter traverses around islands instead of over them.
- In order to avoid leaving dwell marks, the TNC inserts a globally definable rounding radius at non-tangential inside corners. The rounding radius, which is entered in Cycle 20, affects the tool center point path, meaning that it would increase a rounding defined by the tool radius (applies to rough-out and side finishing).
- The contour is approached in a tangential arc for side finishing.
- For floor finishing, the tool again approaches the workpiece on a tangential arc (for tool axis Z, for example, the arc may be in the Z/X plane).
- The contour is machined throughout in either climb or up-cut milling.



With bit 4 in MP7420 you can determine where the tool is positioned at the end of Cycles 21 to 24.

■ **Bit 4 = 0:**

At the end of the cycle, the TNC first positions the tool in the tool axis at the clearance height (**Q7**) defined in the cycle, and then to the position in the working plane at which the tool was located when the cycle was called.







■ **Bit 4 = 1:**

At the end of the cycle, the TNC always positions the tool in the tool axis at the clearance height (**Q7**) defined in the cycle. Ensure that no collisions can occur during the following positioning movements!



The machining data (such as milling depth, finishing allowance and setup clearance) are entered as CONTOUR DATA in Cycle 20.



Overview

Cycle	Soft key	Page
14 CONTOUR GEOMETRY (essential)		Page 181
20 CONTOUR DATA (essential)		Page 186
21 PILOT DRILLING (optional)		Page 188
22 ROUGH OUT (essential)		Page 190
23 FLOOR FINISHING (optional)		Page 194
24 SIDE FINISHING (optional)		Page 195

Enhanced cycles:

Cycle	Soft key	Page
25 CONTOUR TRAIN		Page 197
270 CONTOUR TRAIN DATA		Page 199



7.2 CONTOUR GEOMETRY (Cycle 14, DIN/ISO: G37)

Please note while programming:

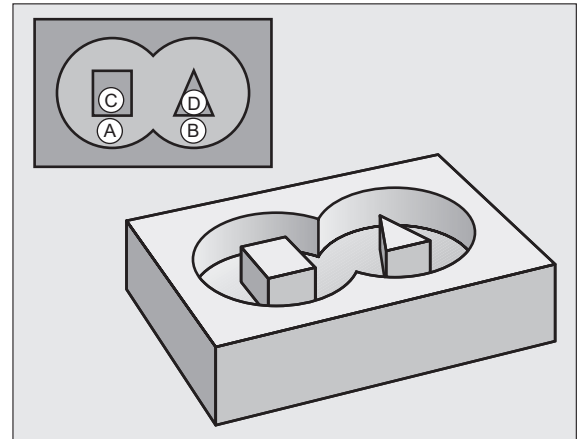
All subprograms that are superimposed to define the contour are listed in Cycle 14 CONTOUR GEOMETRY.



Before programming, note the following

Cycle 14 is DEF active which means that it becomes effective as soon as it is defined in the part program.

You can list up to 12 subprograms (subcontours) in Cycle 14.



Cycle parameters

14
LBL 1...N

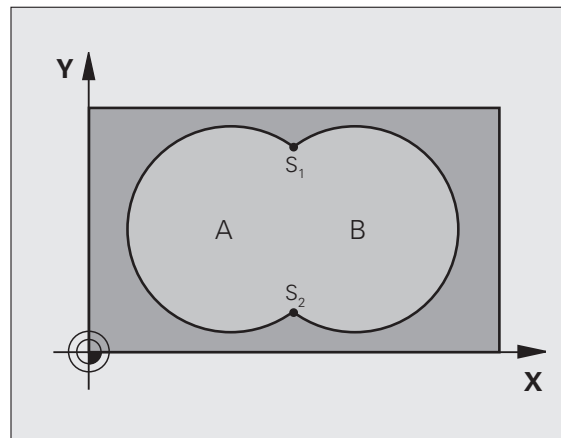
- **Label numbers for the contour:** Enter all label numbers for the individual subprograms that are to be superimposed to define the contour. Confirm every label number with the ENT key. When you have entered all numbers, conclude entry with the END key. Entry of up to 12 subprogram numbers 1 to 254



7.3 Overlapping contours

Fundamentals

Pockets and islands can be overlapped to form a new contour. You can thus enlarge the area of a pocket by another pocket or reduce it by an island.



Example: NC blocks

```
12 CYCL DEF 14.0 CONTOUR GEOMETRY
```

```
13 CYCL DEF 14.1 CONTOUR LABEL1/2/3/4
```

Subprograms: overlapping pockets



The subsequent programming examples are contour subprograms that are called by Cycle 14 CONTOUR GEOMETRY in a main program.

Pockets A and B overlap.

The TNC calculates the points of intersection S_1 and S_2 . They do not have to be programmed.

The pockets are programmed as full circles.

Subprogram 1: Pocket A

```
51 LBL 1
52 L X+10 Y+50 RR
53 CC X+35 Y+50
54 C X+10 Y+50 DR-
55 LBL 0
```

```
51 LBL 1
52 L X+10 Y+50 RR
53 CC X+35 Y+50
54 C X+10 Y+50 DR-
55 LBL 0
```

Subprogram 2: Pocket B

```
56 LBL 2
57 L X+90 Y+50 RR
58 CC X+65 Y+50
59 C X+90 Y+50 DR-
60 LBL 0
```



Area of inclusion

Both surfaces A and B are to be machined, including the overlapping area:

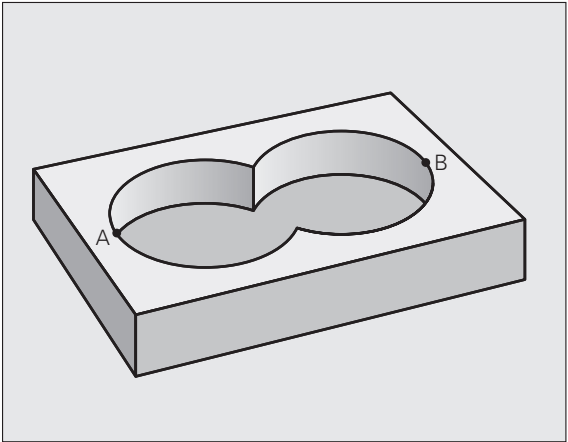
- The surfaces A and B must be pockets.
- The first pocket (in Cycle 14) must start outside the second pocket.

Surface A:

51	LBL	1
52	L	X+10 Y+50 RR
53	CC	X+35 Y+50
54	C	X+10 Y+50 DR-
55	LBL	0

Surface B:

56	LBL	2
57	L	X+90 Y+50 RR
58	CC	X+65 Y+50
59	C	X+90 Y+50 DR-
60	LBL	0



Area of exclusion

Surface A is to be machined without the portion overlapped by B:

- Surface A must be a pocket and B an island.
- A must start outside of B.
- B must start inside of A.

Surface A:

51 LBL 1

52 L X+10 Y+50 RR

53 CC X+35 Y+50

54 C X+10 Y+50 DR-

55 LBL 0

Surface B:

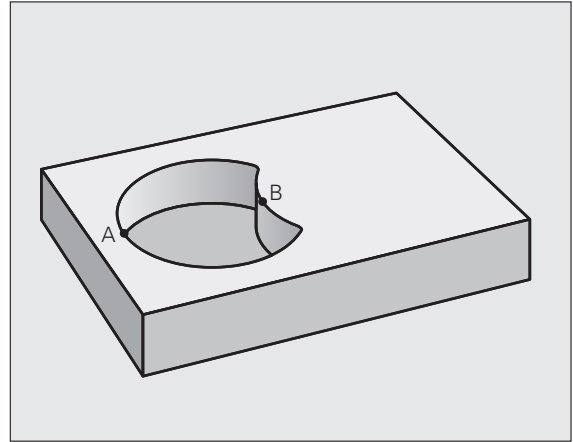
56 LBL 2

57 L X+90 Y+50 RL

58 CC X+65 Y+50

59 C X+90 Y+50 DR-

60 LBL 0



Area of intersection

Only the area where A and B overlap is to be machined. (The areas covered by A or B alone are to be left unmachined.)

- A and B must be pockets.
- A must start inside of B.

Surface A:

51 LBL 1

52 L X+60 Y+50 RR

53 CC X+35 Y+50

54 C X+60 Y+50 DR-

55 LBL 0

Surface B:

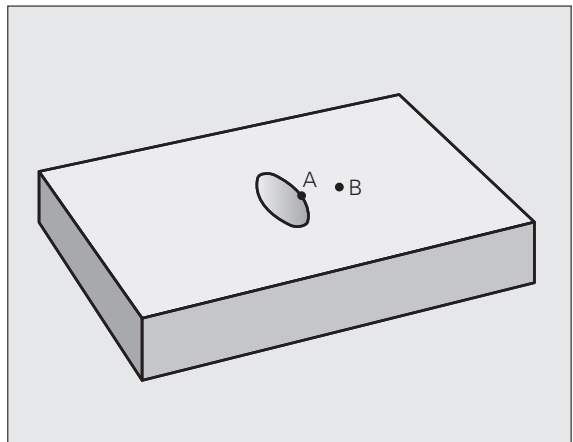
56 LBL 2

57 L X+90 Y+50 RR

58 CC X+65 Y+50

59 C X+90 Y+50 DR-

60 LBL 0



7.4 CONTOUR DATA (Cycle 20, DIN/ISO: G120)

Please note while programming:

Machining data for the subprograms describing the subcontours are entered in Cycle 20.



Cycle 20 is DEF active, which means that it becomes effective as soon as it is defined in the part program.

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the TNC performs the cycle at the depth 0.

The machining data entered in Cycle 20 are valid for Cycles 21 to 24.

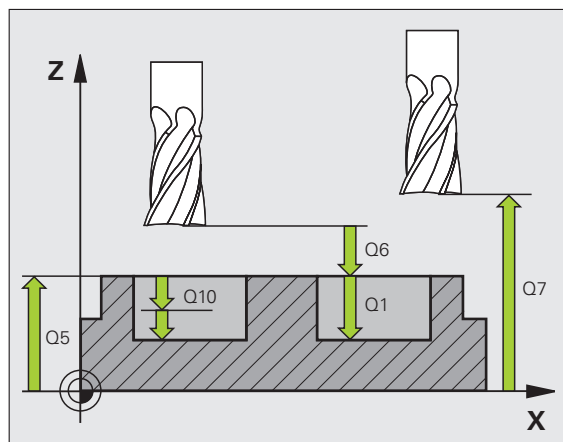
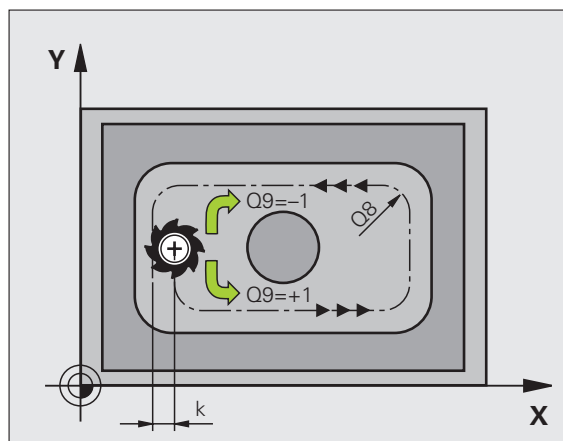
If you are using the SL cycles in Q parameter programs, the cycle parameters Q1 to Q20 cannot be used as program parameters.

Cycle parameters

20
CONTOUR
DATA

- ▶ **Milling depth Q1** (incremental): Distance between workpiece surface and bottom of pocket. Input range: -99999.9999 to 99999.9999
- ▶ **Path overlap factor Q2**: $Q2 \times \text{tool radius} = \text{stepover factor } k$. Input range -0.0001 to 1.9999.
- ▶ **Finishing allowance for side Q3** (incremental): Finishing allowance in the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Finishing allowance for floor Q4** (incremental): Finishing allowance in the tool axis. Input range: -99999.9999 to 99999.9999
- ▶ **Workpiece surface coordinate Q5** (absolute): Absolute coordinate of the workpiece surface. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance Q6** (incremental): Distance between tool tip and workpiece surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height Q7** (absolute): Absolute height at which the tool cannot collide with the workpiece (for intermediate positioning and retraction at the end of the cycle). Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Inside corner radius Q8**: Inside "corner" rounding radius; entered value is referenced to the path of the tool center. **Q8 is not a radius that is inserted as a separate contour element between programmed elements!** Input range 0 to 99999.9999
- ▶ **Direction of rotation ? Q9**: Machining direction for pockets.
 - Q9 = -1 up-cut milling for pocket and island
 - Q9 = +1 climb milling for pocket and island
 - Alternative: **PREDEF**

You can check the machining parameters during a program interruption and overwrite them if required.



Example: NC blocks

57 CYCL DEF 20 CONTOUR DATA	
Q1=-20	;MILLING DEPTH
Q2=1	;TOOL PATH OVERLAP
Q3=+0.2	;ALLOWANCE FOR SIDE
Q4=+0.1	;ALLOWANCE FOR FLOOR
Q5=+30	;SURFACE COORDINATE
Q6=2	;SETUP CLEARANCE
Q7=+80	;CLEARANCE HEIGHT
Q8=0.5	;ROUNDING RADIUS
Q9=+1	;DIRECTION



7.5 PILOT DRILLING (Cycle 21, DIN/ISO: G121)

Cycle run

- 1 The tool drills from the current position to the first plunging depth at the programmed feed rate **F**.
- 2 Then the tool retracts at rapid traverse **FMAX** to the starting position and advances again to the first plunging depth minus the advanced stop distance **t**.
- 3 The advanced stop distance is automatically calculated by the control:
 - At a total hole depth up to 30 mm: $t = 0.6 \text{ mm}$
 - At a total hole depth exceeding 30 mm: $t = \text{hole depth} / 50$
 - Maximum advanced stop distance: 7 mm
- 4 The tool then advances with another infeed at the programmed feed rate **F**.
- 5 The TNC repeats this process (1 to 4) until the programmed depth is reached.
- 6 After a dwell time at the hole bottom, the tool is returned to the starting position at rapid traverse **FMAX** for chip breaking.

Application

Cycle 21 is for PILOT DRILLING of the cutter infeed points. It accounts for the allowance for side and the allowance for floor as well as the radius of the rough-out tool. The cutter infeed points also serve as starting points for roughing.

Please note while programming:



Before programming, note the following

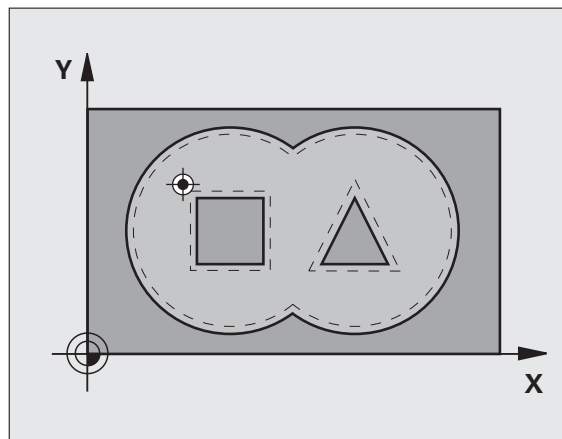
When calculating the infeed points, the TNC does not account for the delta value **DR** programmed in a **TOOL CALL** block.

In narrow areas, the TNC may not be able to carry out pilot drilling with a tool that is larger than the rough-out tool.

Cycle parameters



- ▶ **Plunging depth** Q10 (incremental): Dimension by which the tool drills in each infeed (negative sign for negative working direction). Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging** Q11: Drilling feed rate in mm/min. Input range: 0 to 99999.9999; alternatively **FAUTO, FU, FZ**.
- ▶ **Rough-out tool number/name** Q13 or QS13: Number or name of rough-out tool. Input range 0 to 32767.9 if a number is entered; maximum 16 characters if a name is entered.



Example: NC blocks

```

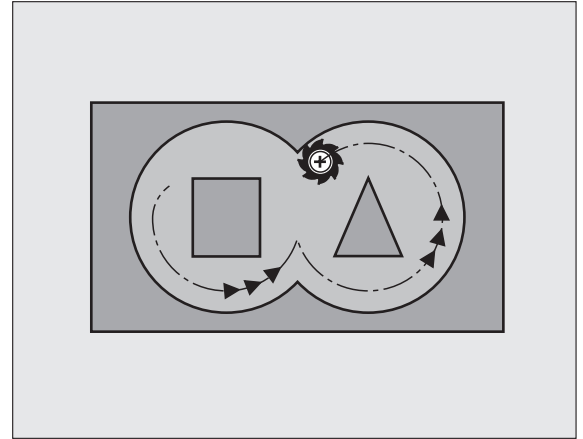
58 CYCL DEF 21 PILOT DRILLING
      Q10=+5      ;PLUNGING DEPTH
      Q11=100     ;FEED RATE FOR PLNGNG
      Q13=1       ;ROUGH-OUT TOOL
    
```



7.6 ROUGH-OUT (Cycle 22, DIN/ISO: G122)

Cycle run

- 1 The TNC positions the tool over the cutter infeed point, taking the allowance for side into account.
- 2 In the first plunging depth, the tool mills the contour from the inside outward at the milling feed rate Q12.
- 3 The island contours (here: C/D) are cleared out with an approach toward the pocket contour (here: A/B).
- 4 In the next step the TNC moves the tool to the next plunging depth and repeats the roughing procedure until the program depth is reached.
- 5 Finally the TNC retracts the tool to the clearance height.



Please note while programming:

This cycle requires a center-cut end mill (ISO 1641) or pilot drilling with Cycle 21.

You define the plunging behavior of Cycle 22 with parameter Q19 and with the tool table in the **ANGLE** and **LCUTS** columns:

- If Q19=0 is defined, the TNC always plunges perpendicularly, even if a plunge angle (**ANGLE**) is defined for the active tool.
- If you define the **ANGLE**=90°, the TNC plunges perpendicularly. The reciprocation feed rate Q19 is used as plunging feed rate.
- If the reciprocation feed rate Q19 is defined in Cycle 22 and **ANGLE** is defined between 0.1 and 89.999 in the tool table, the TNC plunges helically at the defined **ANGLE**.
- If the reciprocation feed is defined in Cycle 22 and no **ANGLE** is in the tool table, the TNC displays an error message.
- If geometrical conditions do not allow helical plunging (slot geometry), the TNC tries a reciprocating plunge. The reciprocation length is calculated from **LCUTS** and **ANGLE** (reciprocation length = **LCUTS** / tan **ANGLE**).

If you clear out an acute inside corner and use an overlap factor greater than 1, some material might be left over. Check especially the innermost path in the test run graphic and, if necessary, change the overlap factor slightly. This allows another distribution of cuts, which often provides the desired results.

During fine roughing the TNC does not take a defined wear value **DR** of the coarse roughing tool into account.

Feed rate reduction through parameter **Q401** is an FCL3 function and is not automatically available after a software update (see "Feature content level (upgrade functions)" on page 6).



Cycle parameters



- ▶ **Plunging depth** Q10 (incremental): Infeed per cut. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging** Q11: Plunging feed rate in mm/min. Input range: 0 to 99999.9999; alternatively **FAUTO**, **FU**, **FZ**.
- ▶ **Feed rate for roughing** Q12: Milling feed rate in mm/min. Input range: 0 to 99999.9999; alternatively **FAUTO**, **FU**, **FZ**.
- ▶ **Coarse roughing tool** Q18 or QS18: Number or name of the tool with which the TNC has already coarse-roughed the contour. Switch to name input: Press the **TOOL NAME** soft key. The TNC automatically inserts the closing quotation mark when you exit the input field. If there was no coarse roughing, enter "0"; if you enter a number or a name, the TNC will only rough-out the portion that could not be machined with the coarse roughing tool. If the portion that is to be roughed cannot be approached from the side, the TNC will mill in a reciprocating plunge-cut; For this purpose you must enter the tool length **LCUTS** in the tool table **TOOL.T** and define the maximum plunging **ANGLE** of the tool. The TNC will otherwise generate an error message. Input range 0 to 32767.9 if a number is entered; maximum 16 characters if a name is entered.
- ▶ **Reciprocation feed rate** Q19: Traversing speed of the tool in mm/min during reciprocating plung-cut. Input range: 0 to 99999.9999; alternatively **FAUTO**, **FU**, **FZ**.
- ▶ **Retraction feed rate** Q208: Traversing speed of the tool in mm/min when retracting after machining. If you enter Q208 = 0, the TNC retracts the tool at the feed rate in Q12. Input range 0 to 99999.9999, alternatively **FMAX**, **FAUTO**, **PREDEF**.

Example: NC blocks

59 CYCL DEF 22 ROUGH-OUT	
Q10=+5	;PLUNGING DEPTH
Q11=100	;FEED RATE FOR PLNGNG
Q12=750	;FEED RATE FOR ROUGHING
Q18=1	;COARSE ROUGHING TOOL
Q19=150	;RECIPROCATION FEED RATE
Q208=99999	;RETRACTION FEED RATE
Q401=80	;FEED RATE REDUCTION
Q404=0	;FINE ROUGH STRATEGY



- ▶ **Feed rate factor in %:** Q401: Percentage factor by which the TNC reduces the machining feed rate (**Q12**) as soon as the tool moves within the material over its entire circumference during roughing. If you use the feed rate reduction, then you can define the feed rate for roughing so large that there are optimum cutting conditions with the path overlap (**Q2**) specified in Cycle 20. The TNC then reduces the feed rate as per your definition at transitions and narrow places, so the machining time should be reduced in total. Input range: 0.0001 to 100.0000
- ▶ **Fine-roughing strategy** Q404: Specify how the TNC should move the tool during fine roughing when the radius of the fine-roughing tool is larger than half the coarse roughing tool.
 - Q404 = 0
Move the tool along the contour at the current depth between areas that need to be fine-roughed.
 - Q404 = 1
Between areas that need to be fine-roughed, retract the tool to safety clearance and move to the starting point of the next area to be rough-milled.



7.7 FLOOR FINISHING (Cycle 23, DIN/ISO: G123)

Cycle run

The tool approaches the machining plane smoothly (on a vertically tangential arc) if there is sufficient room. If there is not enough room, the TNC moves the tool to depth vertically. The tool then clears the finishing allowance remaining from rough-out.

Please note while programming:



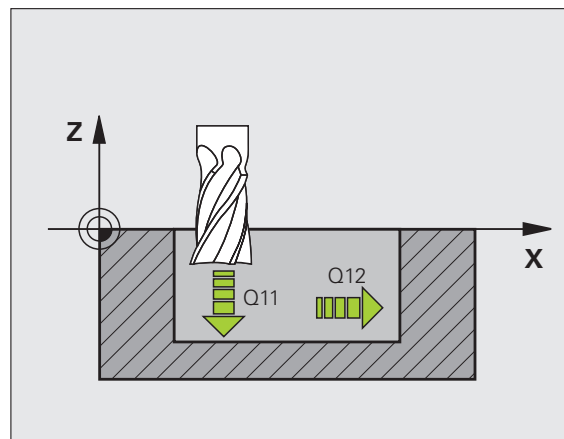
The TNC automatically calculates the starting point for finishing. The starting point depends on the available space in the pocket.

The approaching radius for pre-positioning to the final depth is permanently defined and independent of the plunging angle of the tool.

Cycle parameters



- ▶ **Feed rate for plunging** Q11: Traversing speed of the tool during plunging. Input range 0 to 99999.9999, alternatively **FAUTO, FU, FZ**.
- ▶ **Feed rate for roughing** Q12: Milling feed rate. Input range 0 to 99999.9999, alternatively **FAUTO, FU, FZ**.
- ▶ **Retraction feed rate** Q208: Traversing speed of the tool in mm/min when retracting after machining. If you enter Q208 = 0, the TNC retracts the tool at the feed rate in Q12. Input range 0 to 99999.9999, alternatively **FMAX, FAUTO, PREDEF**.



Example: NC blocks

```
60 CYCL DEF 23 FLOOR FINISHING
```

```
Q11=100 ;FEED RATE FOR PLNGNG
```

```
Q12=350 ;FEED RATE FOR ROUGHING
```

```
Q208=99999 ;RETRACTION FEED RATE
```

7.8 SIDE FINISHING (Cycle 24, DIN/ISO: G124)

Cycle run

The subcontours are approached and departed on a tangential arc. Each subcontour is finished separately.

Please note while programming:



The sum of allowance for side (Q14) and the radius of the finish mill must be smaller than the sum of allowance for side (Q3, Cycle 20) and the radius of the rough mill.

This calculation also holds if you run Cycle 24 without having roughed out with Cycle 22; in this case, enter "0" for the radius of the rough mill.

You can use Cycle 24 also for contour milling. Then you must:

- define the contour to be milled as a single island (without pocket limit), and
- enter the finishing allowance (Q3) in Cycle 20 to be greater than the sum of the finishing allowance Q14 + radius of the tool being used.

The TNC automatically calculates the starting point for finishing. The starting point depends on the available space in the pocket and the allowance programmed in Cycle 20.

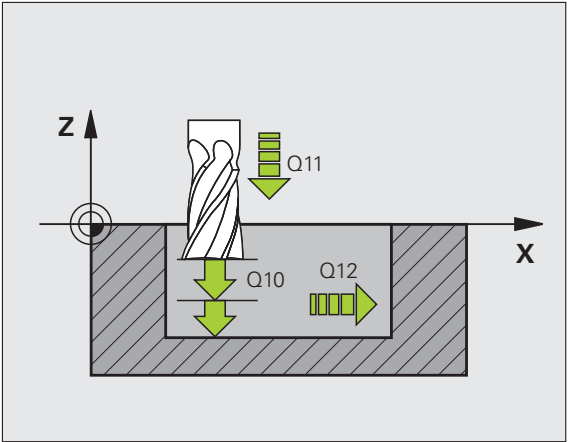
The starting point calculated by the TNC also depends on the machining sequence. If you select the finishing cycle with the GOTO key and then start the program, the starting point can be at a different location from where it would be if you execute the program in the defined sequence.



Cycle parameters



- ▶ **Direction of rotation ? Clockwise = -1 Q9:**
Machining direction:
+1:Counterclockwise
-1:Clockwise
Alternatively **PREDEF**
- ▶ **Plunging depth Q10 (incremental):** Infeed per cut.
Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging Q11:** Traversing speed of the tool during plunging. Input range 0 to 99999.9999, alternatively **FAUTO, FU, FZ.**
- ▶ **Feed rate for roughing Q12:** Milling feed rate. Input range 0 to 99999.9999, alternatively **FAUTO, FU, FZ.**
- ▶ **Finishing allowance for side Q14 (incremental):**
Enter the allowed material for several finish-milling operations. If you enter Q14 = 0, the remaining finishing allowance will be cleared. Input range: -99999.9999 to 99999.9999



Example: NC blocks

61 CYCLE DEF 24 SIDE FINISHING	
Q9=+1	;DIRECTION
Q10=+5	;PLUNGING DEPTH
Q11=100	;FEED RATE FOR PLNGNG
Q12=350	;FEED RATE FOR ROUGHING
Q14=+0	;ALLOWANCE FOR SIDE



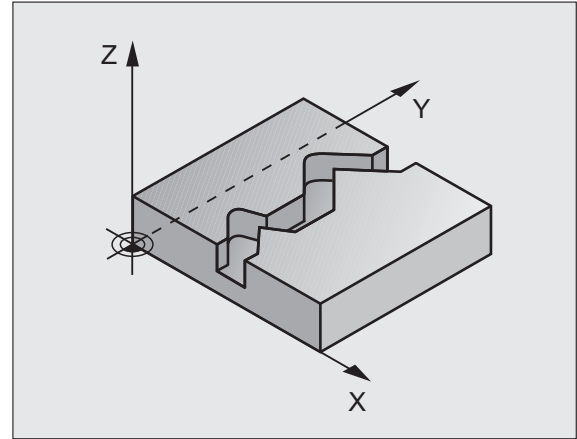
7.9 CONTOUR TRAIN (Cycle 25, DIN/ISO: G125)

Cycle run

In conjunction with Cycle 14 CONTOUR GEOMETRY, this cycle facilitates the machining of open and closed contours.

Cycle 25 CONTOUR TRAIN offers considerable advantages over machining a contour using positioning blocks:

- The TNC monitors the operation to prevent undercuts and surface blemishes. It is recommended that you run a graphic simulation of the contour before execution.
- If the radius of the selected tool is too large, the corners of the contour may have to be reworked.
- The contour can be machined throughout by up-cut or by climb milling. The type of milling even remains effective when the contours are mirrored.
- The tool can traverse back and forth for milling in several infeeds: This results in faster machining.
- Allowance values can be entered in order to perform repeated rough-milling and finish-milling operations.



Please note while programming:



The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.

The TNC takes only the first label of Cycle 14 CONTOUR GEOMETRY into account.

The memory capacity for programming an SL cycle is limited. You can program up to 8192 contour elements in one SL cycle.

Cycle 20 **CONTOUR DATA** is not required.

The miscellaneous functions **M109** and **M110** are not effective when machining a contour with Cycle 25.



Danger of collision!

To avoid collisions,

- Do not program positions in incremental dimensions immediately after Cycle 25 since they are referenced to the position of the tool at the end of the cycle.
- Move the tool to defined (absolute) positions in all main axes, since the position of the tool at the end of the cycle is not identical to the position of the tool at the start of the cycle.



Cycle parameters



- ▶ **Milling depth Q1** (incremental): Distance between workpiece surface and contour floor. Input range: -99999.9999 to 99999.9999
- ▶ **Finishing allowance for side Q3** (incremental): Finishing allowance in the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Workpiece surface coordinate Q5** (absolute): Absolute coordinate of the workpiece surface referenced to the workpiece datum. Input range: -99999.9999 to 99999.9999
- ▶ **Clearance height Q7** (absolute): Absolute height at which the tool cannot collide with the workpiece. Position for tool retraction at the end of the cycle. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Plunging depth Q10** (incremental): Infeed per cut. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging Q11**: Traversing speed of the tool in the spindle axis. Input range 0 to 99999.9999, alternatively **FAUTO, FU, FZ**.
- ▶ **Feed rate for milling Q12**: Traversing speed of the tool in the working plane. Input range 0 to 99999.9999, alternatively **FAUTO, FU, FZ**.
- ▶ **Climb or up-cut ? Up-cut = -1 Q15**:
Climb milling: Input value = +1
Up-cut milling: Input value = -1
To enable climb milling and up-cut milling alternately in several infeeds: Input value = 0

Example: NC blocks

62 CYCL DEF 25 CONTOUR TRAIN	
Q1=-20	;MILLING DEPTH
Q3=+0	;ALLOWANCE FOR SIDE
Q5=+0	;SURFACE COORDINATE
Q7=+50	;CLEARANCE HEIGHT
Q10=+5	;PLUNGING DEPTH
Q11=100	;FEED RATE FOR PLNGNG
Q12=350	;FEED RATE FOR MILLING
Q15=-1	;CLIMB OR UP-CUT



7.10 CONTOUR TRAIN DATA (Cycle 270, DIN/ISO: G270)

Please note while programming:

If desired, you can use this cycle to specify various properties of Cycle 25, **CONTOUR TRAIN**.



Before programming, note the following

Cycle 270 is DEF active which means that it becomes effective as soon as it is defined in the part program.

If Cycle 270 is used, do not define any radius compensation in the contour subprogram.

Approach and departure properties are always performed identically (symmetrically) by the TNC.

Define Cycle 270 before Cycle 25.



Cycle parameters



- ▶ **Type of approach/departure** Q390: Definition of the type of approach or departure.
 - Q390 = 0:
Approach the contour tangentially on a circular arc.
 - Q390 = 1:
Approach the contour tangentially on a straight line.
 - Q390 = 2:
Approach the contour at a right angle.
- ▶ **Radius compensation (0=R0/1=RL/2=RR)** Q391: Definition of the radius compensation:
 - Q391 = 0:
Machine the defined contour without radius compensation
 - Q391 = 1:
Machine the defined contour with compensation to the left
 - Q391 = 2:
Machine the defined contour with compensation to the right
- ▶ **Approach/departure radius** Q392: Only in effect if tangential approach on a circular path was selected. Radius of the approach/departure arc. Input range: 0 to 99999.9999
- ▶ **Center angle** Q393: Only in effect if tangential approach on a circular path was selected. Angular length of the approach arc. Input range: 0 to 99999.9999
- ▶ **Distance to auxiliary point** Q394: Only in effect if tangential approach on a straight line or right-angle approach was selected. Distance to the auxiliary point from which the TNC is to approach the contour. Input range: 0 to 99999.9999

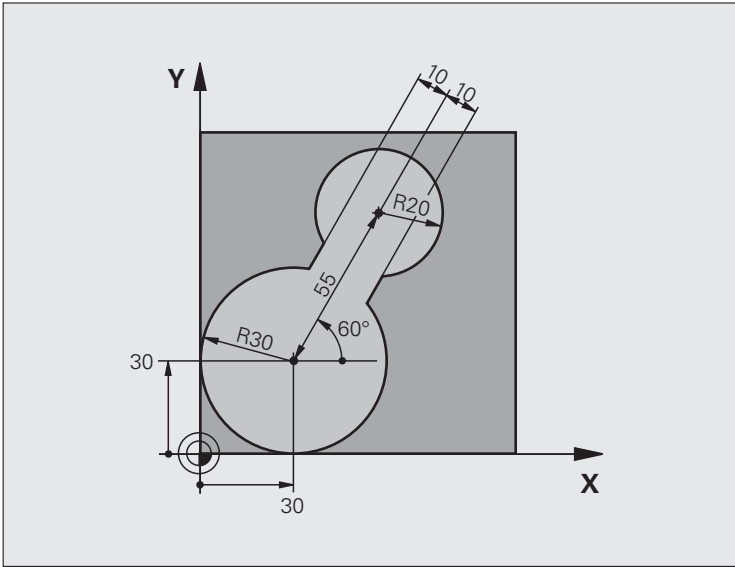
Example: NC blocks

62	CYCL	DEF	270	CONTOUR	TRAIN	DATA
	Q390=0				;TYPE OF APPROACH	
	Q391=1				;RADIUS COMPENSATION	
	Q392=3				;RADIUS	
	Q393=+45				;CENTER ANGLE	
	Q394=+2				;DISTANCE	



7.11 Programming examples

Example: Roughing-out and fine-roughing a pocket



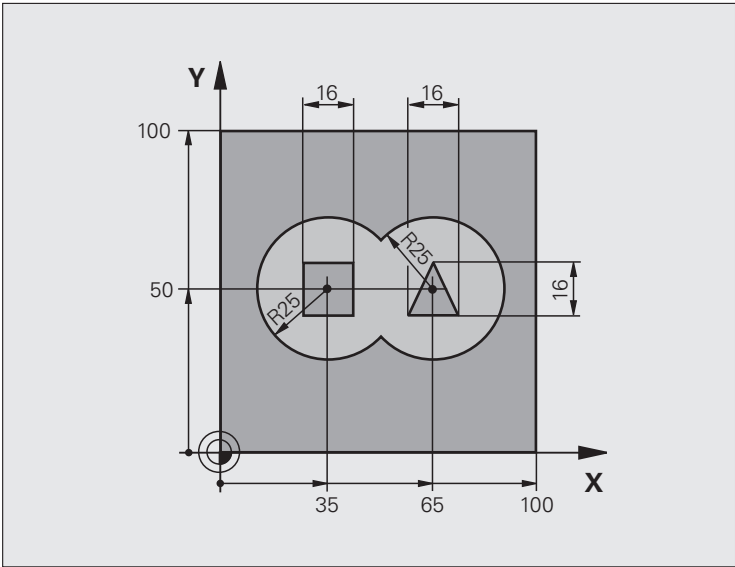
0 BEGIN PGM C20 MM	
1 BLK FORM 0.1 Z X-10 Y-10 Z-40	
2 BLK FORM 0.2 X+100 Y+100 Z+0	Definition of workpiece blank
3 TOOL CALL 1 Z S2500	Tool call: coarse roughing tool, diameter 30
4 L Z+250 R0 FMAX	Retract the tool
5 CYCL DEF 14.0 CONTOUR GEOMETRY	Define contour subprogram
6 CYCL DEF 14 .1 CONTOUR LABEL 1	
7 CYCL DEF 20 CONTOUR DATA	Define general machining parameters
Q1=-20 ;MILLING DEPTH	
Q2=1 ;TOOL PATH OVERLAP	
Q3=+0 ;ALLOWANCE FOR SIDE	
Q4=+0 ;ALLOWANCE FOR FLOOR	
Q5=+0 ;SURFACE COORDINATE	
Q6=2 ;SETUP CLEARANCE	
Q7=+100 ;CLEARANCE HEIGHT	
Q8=0.1 ;ROUNDING RADIUS	
Q9=-1 ;DIRECTION	



8 CYCL DEF 22 ROUGH-OUT	Cycle definition: Coarse roughing
Q10=5 ;PLUNGING DEPTH	
Q11=100 ;FEED RATE FOR PLNGNG	
Q12=350 ;FEED RATE FOR ROUGHING	
Q18=0 ;COARSE ROUGHING TOOL	
Q19=150 ;RECIPROCATION FEED RATE	
Q208=30000 ;RETRACTION FEED RATE	
Q401=100 ;FEED RATE FACTOR	
Q404=0 ;FINE ROUGH STRATEGY	
9 CYCL CALL M3	Cycle call: Coarse roughing
10 L Z+250 R0 FMAX M6	Tool change
11 TOOL CALL 2 Z S3000	Tool call: fine roughing tool, diameter 15
12 CYCL DEF 22 ROUGH-OUT	Define the fine roughing cycle
Q10=5 ;PLUNGING DEPTH	
Q11=100 ;FEED RATE FOR PLNGNG	
Q12=350 ;FEED RATE FOR ROUGHING	
Q18=1 ;COARSE ROUGHING TOOL	
Q19=150 ;RECIPROCATION FEED RATE	
Q208=30000 ;RETRACTION FEED RATE	
Q401=100 ;FEED RATE FACTOR	
Q404=0 ;FINE ROUGH STRATEGY	
13 CYCL CALL M3	Cycle call: Fine roughing
14 L Z+250 R0 FMAX M2	Retract in the tool axis, end program
15 LBL 1	Contour subprogram
16 L X+0 Y+30 RR	
17 FC DR- R30 CCX+30 CCY+30	
18 FL AN+60 PDX+30 PDY+30 D10	
19 FSELECT 3	
20 FPOL X+30 Y+30	
21 FC DR- R20 CCPR+55 CCPA+60	
22 FSELECT 2	
23 FL AN-120 PDX+30 PDY+30 D10	
24 FSELECT 3	
25 FC X+0 DR- R30 CCX+30 CCY+30	
26 FSELECT 2	
27 LBL 0	
28 END PGM C20 MM	



Example: Pilot drilling, roughing-out and finishing overlapping contours



0 BEGIN PGM C21 MM	
1 BLK FORM 0.1 Z X+0 Y+0 Z-40	Definition of workpiece blank
2 BLK FORM 0.2 X+100 Y+100 Z+0	
3 TOOL CALL 1 Z S2500	Tool call: Drill, diameter 12
4 L Z+250 R0 FMAX	Retract the tool
5 CYCL DEF 14.0 CONTOUR GEOMETRY	Define contour subprogram
6 CYCL DEF 14.1 CONTOUR LABEL1/2/3/4	
7 CYCL DEF 20 CONTOUR DATA	Define general machining parameters
Q1=-20 ;MILLING DEPTH	
Q2=1 ;TOOL PATH OVERLAP	
Q3=+0.5 ;ALLOWANCE FOR SIDE	
Q4=+0.5 ;ALLOWANCE FOR FLOOR	
Q5=+0 ;SURFACE COORDINATE	
Q6=2 ;SETUP CLEARANCE	
Q7=+100 ;CLEARANCE HEIGHT	
Q8=0.1 ;ROUNDING RADIUS	
Q9=-1 ;DIRECTION	



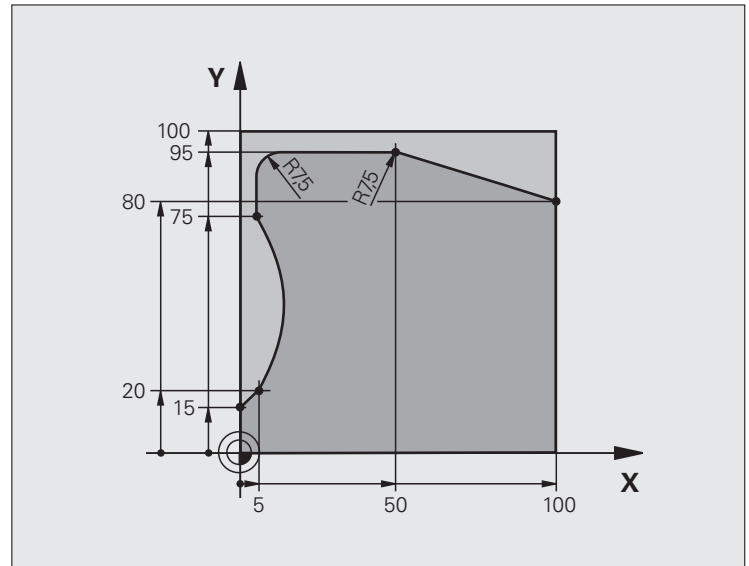
8 CYCL DEF 21 PILOT DRILLING	Cycle definition: Pilot drilling
Q10=5 ;PLUNGING DEPTH	
Q11=250 ;FEED RATE FOR PLNGNG	
Q13=2 ;ROUGH-OUT TOOL	
9 CYCL CALL M3	Cycle call: Pilot drilling
10 L +250 R0 FMAX M6	Tool change
11 TOOL CALL 2 Z S3000	Call the tool for roughing/finishing, diameter 12
12 CYCL DEF 22 ROUGH-OUT	Cycle definition: Rough-out
Q10=5 ;PLUNGING DEPTH	
Q11=100 ;FEED RATE FOR PLNGNG	
Q12=350 ;FEED RATE FOR ROUGHING	
Q18=0 ;COARSE ROUGHING TOOL	
Q19=150 ;RECIPROCATION FEED RATE	
Q208=30000 ;RETRACTION FEED RATE	
Q401=100 ;FEED RATE FACTOR	
Q404=0 ;FINE ROUGH STRATEGY	
13 CYCL CALL M3	Cycle call: Rough-out
14 CYCL DEF 23 FLOOR FINISHING	Cycle definition: Floor finishing
Q11=100 ;FEED RATE FOR PLNGNG	
Q12=200 ;FEED RATE FOR ROUGHING	
Q208=30000 ;RETRACTION FEED RATE	
15 CYCL CALL	Cycle call: Floor finishing
16 CYCLE DEF 24 SIDE FINISHING	Cycle definition: Side finishing
Q9=+1 ;DIRECTION	
Q10=5 ;PLUNGING DEPTH	
Q11=100 ;FEED RATE FOR PLNGNG	
Q12=400 ;FEED RATE FOR ROUGHING	
Q14=+0 ;ALLOWANCE FOR SIDE	
17 CYCL CALL	Cycle call: Side finishing
18 L Z+250 R0 FMAX M2	Retract in the tool axis, end program



19 LBL 1	Contour subprogram 1: left pocket
20 CC X+35 Y+50	
21 L X+10 Y+50 RR	
22 C X+10 DR-	
23 LBL 0	
24 LBL 2	Contour subprogram 2: right pocket
25 CC X+65 Y+50	
26 L X+90 Y+50 RR	
27 C X+90 DR-	
28 LBL 0	
29 LBL 3	Contour subprogram 3: square left island
30 L X+27 Y+50 RL	
31 L Y+58	
32 L X+43	
33 L Y+42	
34 L X+27	
35 LBL 0	
36 LBL 4	Contour subprogram 4: triangular right island
39 L X+65 Y+42 RL	
37 L X+57	
38 L X+65 Y+58	
39 L X+73 Y+42	
40 LBL 0	
41 END PGM C21 MM	



Example: Contour train



0 BEGIN PGM C25 MM	
1 BLK FORM 0.1 Z X+0 Y+0 Z-40	Definition of workpiece blank
2 BLK FORM 0.2 X+100 Y+100 Z+0	
3 TOOL CALL 1 Z S2000	Tool call: Diameter 20
4 L Z+250 R0 FMAX	Retract the tool
5 CYCL DEF 14.0 CONTOUR GEOMETRY	Define contour subprogram
6 CYCL DEF 14.1 CONTOUR LABEL 1	
7 CYCL DEF 25 CONTOUR TRAIN	Define machining parameters
Q1=-20 ;MILLING DEPTH	
Q3=+0 ;ALLOWANCE FOR SIDE	
Q5=+0 ;SURFACE COORDINATE	
Q7=+250 ;CLEARANCE HEIGHT	
Q10=5 ;PLUNGING DEPTH	
Q11=100 ;FEED RATE FOR PLNGNG	
Q12=200 ;FEED RATE FOR MILLING	
Q15=+1 ;CLIMB OR UP-CUT	
8 CYCL CALL M3	Cycle call
9 L Z+250 R0 FMAX M2	Retract in the tool axis, end program

10 LBL 1	Contour subprogram
11 L X+0 Y+15 RL	
12 L X+5 Y+20	
13 CT X+5 Y+75	
14 L Y+95	
15 RND R7.5	
16 L X+50	
17 RND R7.5	
18 L X+100 Y+80	
19 LBL 0	
20 END PGM C25 MM	









8

**Canned Cycles:
Cylindrical Surface**



8.1 Fundamentals

Overview of cylindrical surface cycles

Cycle	Soft key	Page
27 CYLINDER SURFACE		Page 211
28 CYLINDER SURFACE slot milling		Page 214
29 CYLINDER SURFACE ridge milling		Page 217
39 CYLINDER SURFACE outside contour milling		Page 220



8.2 CYLINDER SURFACE (Cycle 27, DIN/ISO: G127, software option 1)

Execution of cycle

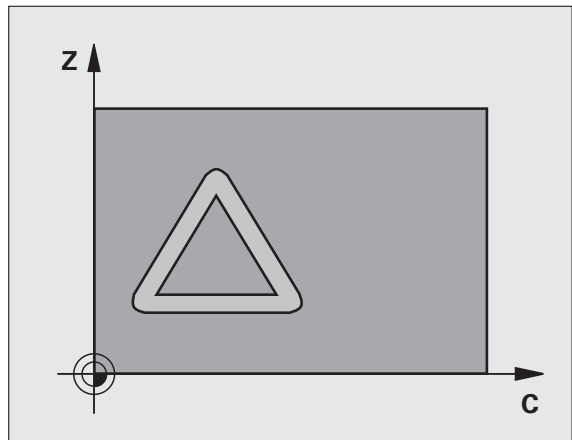
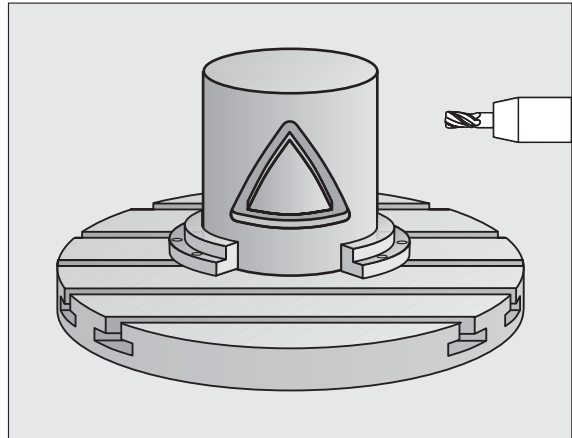
This cycle enables you to program a contour in two dimensions and then roll it onto a cylindrical surface for 3-D machining. Use Cycle 28 if you want to mill guideways on the cylinder.

The contour is described in a subprogram identified in Cycle 14 CONTOUR GEOMETRY.

The subprogram contains coordinates in a rotary axis and in its parallel axis. The rotary axis C, for example, is parallel to the Z axis. The path functions **L**, **CHF**, **CR**, **RND**, **APPR** (except for **APPR LCT**) and **DEP** are available.

The dimensions in the rotary axis can be entered as desired either in degrees or in mm (or inches). You can select the desired dimension type in the cycle definition.

- 1 The TNC positions the tool over the cutter infeed point, taking the allowance for side into account.
- 2 At the first plunging depth, the tool mills along the programmed contour at the milling feed rate Q12.
- 3 At the end of the contour, the TNC returns the tool to the setup clearance and returns to the point of penetration.
- 4 Steps 1 to 3 are repeated until the programmed milling depth Q1 is reached.
- 5 Then the tool moves to the setup clearance.



Please note while programming:



The machine and TNC must be prepared for cylinder surface interpolation by the machine manufacturer. Refer to your machine manual.



In the first NC block of the contour program, always program both cylinder surface coordinates.

The memory capacity for programming an SL cycle is limited. You can program up to 8192 contour elements in one SL cycle.

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.

This cycle requires a center-cut end mill (ISO 1641).

The cylinder must be set up centered on the rotary table.

The tool axis must be perpendicular to the rotary table. If this is not the case, the TNC will generate an error message.

This cycle can also be used in a tilted working plane.

Cycle parameters



- ▶ **Milling depth** Q1 (incremental): Distance between the cylindrical surface and the floor of the contour. Input range: -99999.9999 to 99999.9999
- ▶ **Finishing allowance for side** Q3 (incremental): Finishing allowance in the plane of the unrolled cylindrical surface. This allowance is effective in the direction of the radius compensation. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q6 (incremental): Distance between the tool tip and the cylinder surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Plunging depth** Q10 (incremental): Infeed per cut. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging** Q11: Traversing speed of the tool in the spindle axis. Input range 0 to 99999.9999, alternatively **FAUTO, FU, FZ**.
- ▶ **Feed rate for milling** Q12: Traversing speed of the tool in the working plane. Input range 0 to 99999.9999, alternatively **FAUTO, FU, FZ**.
- ▶ **Cylinder radius** Q16: Radius of the cylinder on which the contour is to be machined. Input range: 0 to 99999.9999
- ▶ **Dimension type ? ang./lin.** Q17: The dimensions for the rotary axis of the subprogram are given either in degrees (0) or in mm/inches (1).

Example: NC blocks

63 CYCL DEF 27 CYLINDER SURFACE	
Q1=-8	;MILLING DEPTH
Q3=+0	;ALLOWANCE FOR SIDE
Q6=+0	;SETUP CLEARANCE
Q10=+3	;PLUNGING DEPTH
Q11=100	;FEED RATE FOR PLNGNG
Q12=350	;FEED RATE FOR MILLING
Q16=25	;RADIUS
Q17=0	;TYPE OF DIMENSION



8.3 CYLINDER SURFACE slot milling (Cycle 28, DIN/ISO: G128, software option 1)

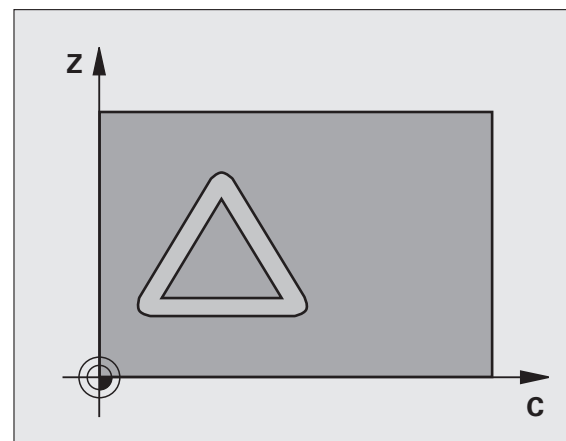
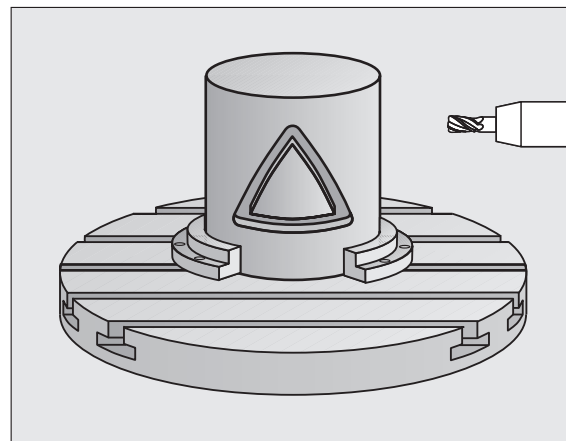
Cycle run

This cycle enables you to program a guide notch in two dimensions and then transfer it onto a cylindrical surface. Unlike Cycle 27, with this cycle the TNC adjusts the tool so that, with radius compensation active, the walls of the slot are nearly parallel. You can machine exactly parallel walls by using a tool that is exactly as wide as the slot.

The smaller the tool is with respect to the slot width, the larger the distortion in circular arcs and oblique line segments. To minimize this process-related distortion, you can define in parameter Q21 a tolerance with which the TNC machines a slot as similar as possible to a slot machined with a tool of the same width as the slot.

Program the midpoint path of the contour together with the tool radius compensation. With the radius compensation you specify whether the TNC cuts the slot with climb milling or up-cut milling.

- 1 The TNC positions the tool over the cutter infeed point.
- 2 At the first plunging depth, the tool mills along the programmed slot wall at the milling feed rate Q12 while respecting the finishing allowance for the side.
- 3 At the end of the contour, the TNC moves the tool to the opposite wall and returns to the infeed point.
- 4 Steps 2 and 3 are repeated until the programmed milling depth Q1 is reached.
- 5 If you have defined the tolerance in Q21, the TNC then remachines the slot walls to be as parallel as possible.
- 6 Finally, the tool retracts in the tool axis to the clearance height or to the position last programmed before the cycle (depending on machine parameter 7420).



Please note while programming:



The machine and TNC must be prepared for cylinder surface interpolation by the machine manufacturer. Refer to your machine manual.



In the first NC block of the contour program, always program both cylinder surface coordinates.

The memory capacity for programming an SL cycle is limited. You can program up to 8192 contour elements in one SL cycle.

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.

This cycle requires a center-cut end mill (ISO 1641).

The cylinder must be set up centered on the rotary table.

The tool axis must be perpendicular to the rotary table. If this is not the case, the TNC will generate an error message.

This cycle can also be used in a tilted working plane.



Cycle parameters



- ▶ **Milling depth** Q1 (incremental): Distance between the cylindrical surface and the floor of the contour. Input range: -99999.9999 to 99999.9999
- ▶ **Finishing allowance for side** Q3 (incremental): Finishing allowance on the slot wall. The finishing allowance reduces the slot width by twice the entered value. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q6 (incremental): Distance between the tool tip and the cylinder surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Plunging depth** Q10 (incremental): Infeed per cut. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging** Q11: Traversing speed of the tool in the spindle axis. Input range 0 to 99999.9999, alternatively **FAUTO, FU, FZ**.
- ▶ **Feed rate for milling** Q12: Traversing speed of the tool in the working plane. Input range 0 to 99999.9999, alternatively **FAUTO, FU, FZ**.
- ▶ **Cylinder radius** Q16: Radius of the cylinder on which the contour is to be machined. Input range: 0 to 99999.9999
- ▶ **Dimension type ? ang./lin.** Q17: The dimensions for the rotary axis of the subprogram are given either in degrees (0) or in mm/inches (1).
- ▶ **Slot width** Q20: Width of the slot to be machined. Input range: -99999.9999 to 99999.9999
- ▶ **Tolerance?** Q21: If you use a tool smaller than the programmed slot width Q20, process-related distortion occurs on the slot wall wherever the slot follows the path of an arc or oblique line. If you define the tolerance Q21, the TNC adds a subsequent milling operation to ensure that the slot dimensions are as close as possible to those of a slot that has been milled with a tool exactly as wide as the slot. With Q21 you define the permitted deviation from this ideal slot. The number of subsequent milling operations depends on the cylinder radius, the tool used, and the slot depth. The smaller the tolerance is defined, the more exact the slot is and the longer the remachining takes. **Recommendation:** Use a tolerance of 0.02 mm. **Function inactive:** Enter 0 (default setting) Input range: 0 to 9.9999

Example: NC blocks

63 CYCL DEF 28 CYLINDER SURFACE	
Q1=-8	;MILLING DEPTH
Q3=+0	;ALLOWANCE FOR SIDE
Q6=+0	;SETUP CLEARANCE
Q10=+3	;PLUNGING DEPTH
Q11=100	;FEED RATE FOR PLNGNG
Q12=350	;FEED RATE FOR MILLING
Q16=25	;RADIUS
Q17=0	;TYPE OF DIMENSION
Q20=12	;SLOT WIDTH
Q21=0	;TOLERANCE

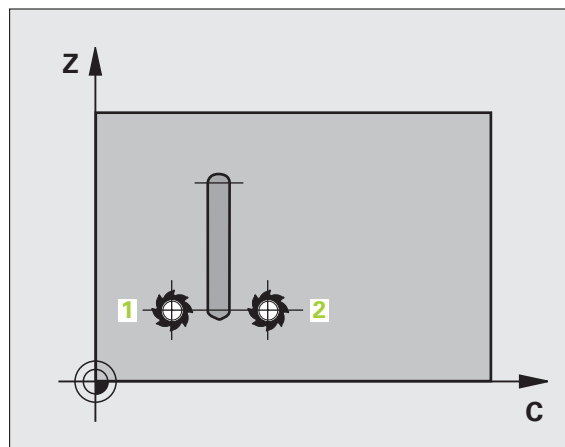
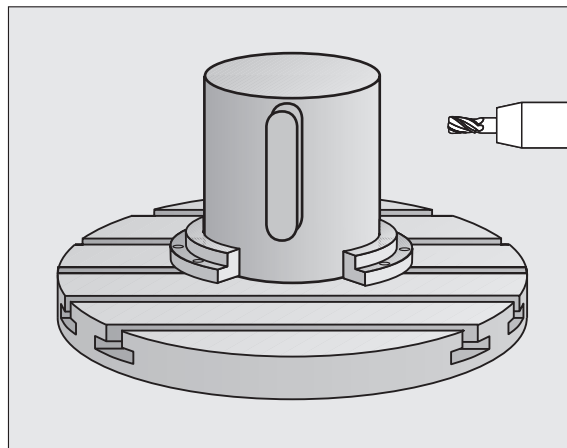
8.4 CYLINDER SURFACE ridge milling (Cycle 29, DIN/ISO: G129, software option 1)

Cycle run

This cycle enables you to program a ridge in two dimensions and then transfer it onto a cylindrical surface. With this cycle the TNC adjusts the tool so that, with radius compensation active, the walls of the slot are always parallel. Program the midpoint path of the ridge together with the tool radius compensation. With the radius compensation you specify whether the TNC cuts the ridge with climb milling or up-cut milling.

At the ends of the ridge the TNC always adds a semicircle whose radius is half the ridge width.

- 1 The TNC positions the tool over the starting point of machining. The TNC calculates the starting point from the ridge width and the tool diameter. It is located next to the first point defined in the contour subprogram, offset by half the ridge width and the tool diameter. The radius compensation determines whether machining begins from the left (**1**, RL = climb milling) or the right (**2**, RR = up-cut milling).
- 2 After the TNC has positioned to the first plunging depth, the tool moves on a circular arc at the milling feed rate Q12 tangentially to the ridge wall. If so programmed, it will leave metal for the finishing allowance.
- 3 At the first plunging depth, the tool mills along the programmed ridge wall at the milling feed rate Q12 until the stud is completed.
- 4 The tool then departs the ridge wall on a tangential path and returns to the starting point of machining.
- 5 Steps 2 to 4 are repeated until the programmed milling depth Q1 is reached.
- 6 Finally, the tool retracts in the tool axis to the clearance height or to the position last programmed before the cycle (depending on machine parameter 7420).



Please note while programming:



The machine and TNC must be prepared for cylinder surface interpolation by the machine manufacturer. Refer to your machine manual.



In the first NC block of the contour program, always program both cylinder surface coordinates.

Ensure that the tool has enough space laterally for contour approach and departure.

The memory capacity for programming an SL cycle is limited. You can program up to 8192 contour elements in one SL cycle.

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program DEPTH = 0, the cycle will not be executed.

The cylinder must be set up centered on the rotary table.

The tool axis must be perpendicular to the rotary table. If this is not the case, the TNC will generate an error message.

This cycle can also be used in a tilted working plane.



Cycle parameters



- ▶ **Milling depth** Q1 (incremental): Distance between the cylindrical surface and the floor of the contour. Input range: -99999.9999 to 99999.9999
- ▶ **Finishing allowance for side** Q3 (incremental): Finishing allowance on the ridge wall. The finishing allowance increases the ridge width by twice the entered value. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q6 (incremental): Distance between the tool tip and the cylinder surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Plunging depth** Q10 (incremental): Infeed per cut. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging** Q11: Traversing speed of the tool in the spindle axis. Input range 0 to 99999.9999, alternatively **FAUTO, FU, FZ**.
- ▶ **Feed rate for milling** Q12: Traversing speed of the tool in the working plane. Input range 0 to 99999.9999, alternatively **FAUTO, FU, FZ**.
- ▶ **Cylinder radius** Q16: Radius of the cylinder on which the contour is to be machined. Input range: 0 to 99999.9999
- ▶ **Dimension type ? ang./lin.** Q17: The dimensions for the rotary axis of the subprogram are given either in degrees (0) or in mm/inches (1).
- ▶ **Ridge width** Q20: Width of the ridge to be machined. Input range: -99999.9999 to 99999.9999

Example: NC blocks

63 CYCL DEF 29 CYLINDER SURFACE RIDGE	
Q1=-8	;MILLING DEPTH
Q3=+0	;ALLOWANCE FOR SIDE
Q6=+0	;SETUP CLEARANCE
Q10=+3	;PLUNGING DEPTH
Q11=100	;FEED RATE FOR PLNGNG
Q12=350	;FEED RATE FOR MILLING
Q16=25	;RADIUS
Q17=0	;TYPE OF DIMENSION
Q20=12	;RIDGE WIDTH



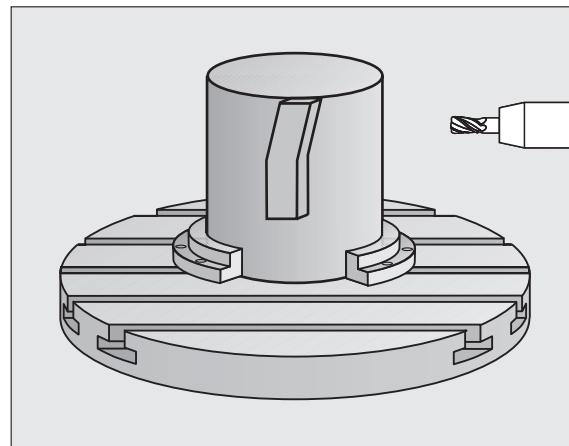
8.5 CYLINDER SURFACE outside contour milling (Cycle 39, DIN/ISO: G139, software option 1)

Cycle run

This cycle enables you to program an open contour in two dimensions and then roll it onto a cylindrical surface for 3-D machining. With this cycle the TNC adjusts the tool so that, with radius compensation active, the wall of the open contour is always parallel to the cylinder axis.

Unlike Cycles 28 and 29, in the contour subprogram you define the actual contour to be machined.

- 1 The TNC positions the tool over the starting point of machining. The TNC locates the starting point next to the first point defined in the contour subprogram, offset by the tool diameter.
- 2 After the TNC has positioned to the first plunging depth, the tool moves on a circular arc at the milling feed rate Q12 tangentially to the contour. If so programmed, it will leave metal for the finishing allowance.
- 3 At the first plunging depth, the tool mills along the programmed contour at the milling feed rate Q12 until the contour train is completed.
- 4 The tool then departs the ridge wall on a tangential path and returns to the starting point of machining.
- 5 Steps 2 to 4 are repeated until the programmed milling depth Q1 is reached.
- 6 Finally, the tool retracts in the tool axis to the clearance height or to the position last programmed before the cycle (depending on machine parameter 7420).



Please note while programming:



The machine and TNC must be prepared for cylinder surface interpolation by the machine manufacturer. Refer to your machine manual.



In the first NC block of the contour program, always program both cylinder surface coordinates.

Ensure that the tool has enough space laterally for contour approach and departure.

The memory capacity for programming an SL cycle is limited. You can program up to 8192 contour elements in one SL cycle.

The algebraic sign for the cycle parameter DEPTH determines the working direction. If you program $\text{DEPTH} = 0$, the cycle will not be executed.

The cylinder must be set up centered on the rotary table.

The tool axis must be perpendicular to the rotary table. If this is not the case, the TNC will generate an error message.

This cycle can also be used in a tilted working plane.



Cycle parameters



- ▶ **Milling depth** Q1 (incremental): Distance between the cylindrical surface and the floor of the contour. Input range: -99999.9999 to 99999.9999
- ▶ **Finishing allowance for side** Q3 (incremental): Finishing allowance on the contour wall. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q6 (incremental): Distance between the tool tip and the cylinder surface. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Plunging depth** Q10 (incremental): Infeed per cut. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging** Q11: Traversing speed of the tool in the spindle axis. Input range 0 to 99999.9999, alternatively **FAUTO, FU, FZ**.
- ▶ **Feed rate for milling** Q12: Traversing speed of the tool in the working plane. Input range 0 to 99999.9999, alternatively **FAUTO, FU, FZ**.
- ▶ **Cylinder radius** Q16: Radius of the cylinder on which the contour is to be machined. Input range: 0 to 99999.9999
- ▶ **Dimension type ? ang./lin.** Q17: The dimensions for the rotary axis of the subprogram are given either in degrees (0) or in mm/inches (1).

Example: NC blocks

63 CYCL DEF 39 CYL. SURFACE CONTOUR	
Q1=-8	;MILLING DEPTH
Q3=+0	;ALLOWANCE FOR SIDE
Q6=+0	;SETUP CLEARANCE
Q10=+3	;PLUNGING DEPTH
Q11=100	;FEED RATE FOR PLNGNG
Q12=350	;FEED RATE FOR MILLING
Q16=25	;RADIUS
Q17=0	;TYPE OF DIMENSION

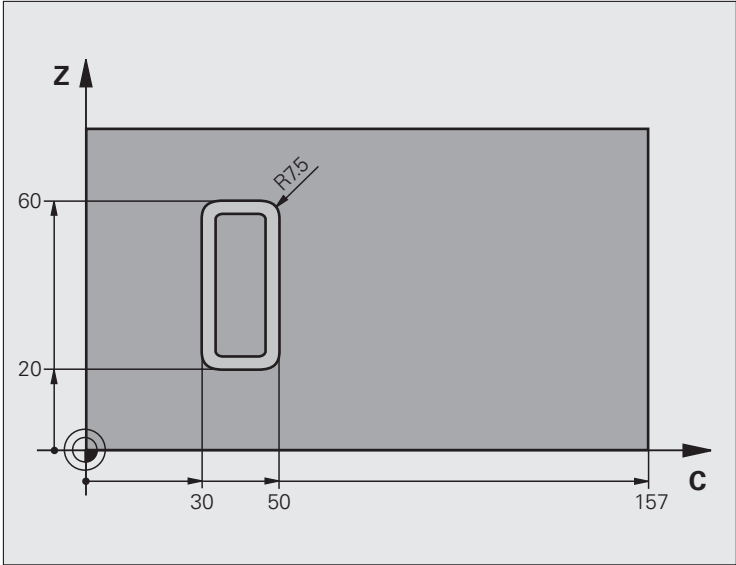


8.6 Programming Examples

Example: Cylinder surface with Cycle 27

Note:

- Machine with B head and C table
- Cylinder centered on rotary table
- Datum at center of rotary table



0 BEGIN PGM C27 MM	
1 TOOL CALL 1 Z S2000	Tool call: Diameter 7
2 L Z+250 R0 FMAX	Retract the tool
3 L X+50 Y0 R0 FMAX	Pre-position tool on rotary table center
4 PLANE SPATIAL SPA+0 SPB+90 SPC+0 TURN FMAX	Positioning
5 CYCL DEF 14.0 CONTOUR GEOMETRY	Define contour subprogram
6 CYCL DEF 14 .1 CONTOUR LABEL 1	
7 CYCL DEF 27 CYLINDER SURFACE	Define machining parameters
Q1=-7 ;MILLING DEPTH	
Q3=+0 ;ALLOWANCE FOR SIDE	
Q6=2 ;SETUP CLEARANCE	
Q10=4 ;PLUNGING DEPTH	
Q11=100 ;FEED RATE FOR PLNGNG	
Q12=250 ;FEED RATE FOR MILLING	
Q16=25 ;RADIUS	
Q17=1 ;TYPE OF DIMENSION	



8.6 Programming Examples

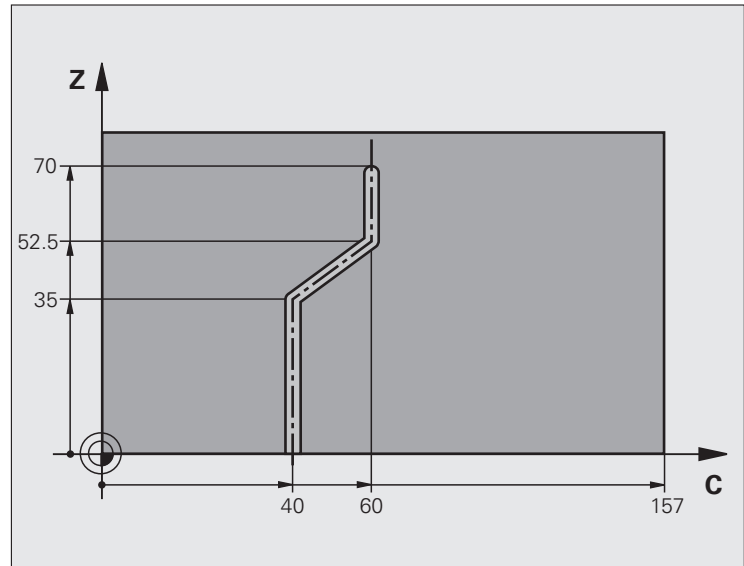
8 L C+0 R0 FMAX M13 M99	Pre-position rotary table, spindle ON, call the cycle
9 L Z+250 R0 FMAX	Retract the tool
10 PLANE RESET TURN FMAX	Tilt back, cancel the PLANE function
11 M2	End of program
12 LBL 1	Contour subprogram
13 L C+40 Z+20 RL	Data for the rotary axis are entered in mm (Q17=1)
14 L C+50	
15 RND R7.5	
16 L Z+60	
17 RND R7.5	
18 L IC-20	
19 RND R7.5	
20 L Z+20	
21 RND R7.5	
22 L C+40	
23 LBL 0	
24 END PGM C27 MM	



Example: Cylinder surface with Cycle 28

Notes:

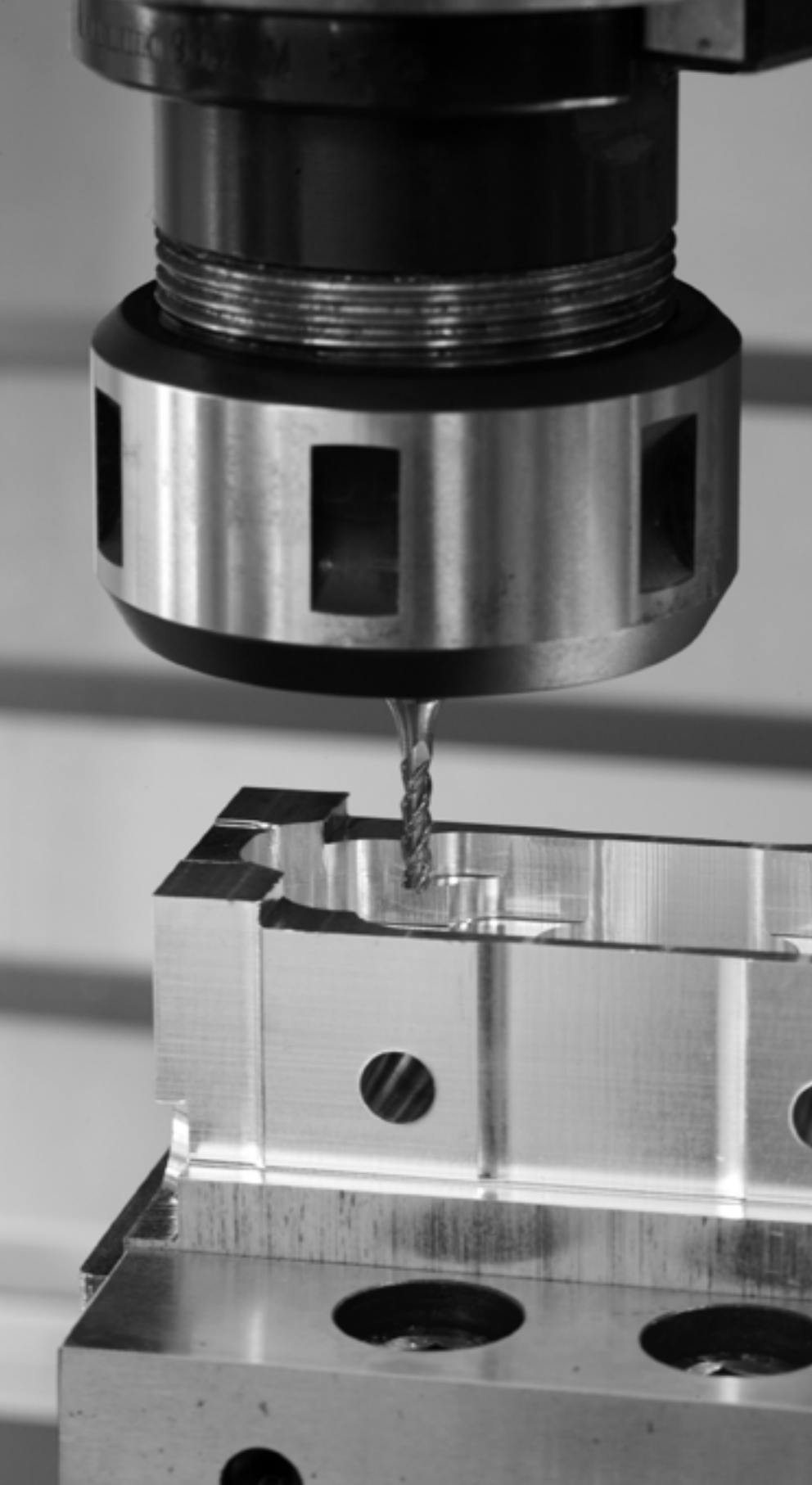
- Cylinder centered on rotary table.
- Machine with B head and C table
- Datum at center of rotary table
- Description of the midpoint path in the contour subprogram



0 BEGIN PGM C28 MM	
1 TOOL CALL 1 Z S2000	Tool call, tool axis Y, diameter 7
2 L Z+250 R0 FMAX	Retract the tool
3 I X+50 Y+0 R0 FMAX	Position tool on rotary table center
4 PLANE SPATIAL SPA+0 SPB+90 SPC+0 TURN FMAX	Positioning
5 CYCL DEF 14.0 CONTOUR GEOMETRY	Define contour subprogram
6 CYCL DEF 14 .1 CONTOUR LABEL 1	
7 CYCL DEF 28 CYLINDER SURFACE	Define machining parameters
Q1=-7 ;MILLING DEPTH	
Q3=+0 ;ALLOWANCE FOR SIDE	
Q6=2 ;SETUP CLEARANCE	
Q10=-4 ;PLUNGING DEPTH	
Q11=100 ;FEED RATE FOR PLNGNG	
Q12=250 ;FEED RATE FOR MILLING	
Q16=25 ;RADIUS	
Q17=1 ;TYPE OF DIMENSION	
Q20=10 ;SLOT WIDTH	
Q21=0.02 ;TOLERANCE	Remachining active

8 L C+0 R0 FMAX M3 M99	Pre-position rotary table, spindle ON, call the cycle
9 L Z+250 R0 FMAX	Retract the tool
10 PLANE RESET TURN FMAX	Tilt back, cancel the PLANE function
11 M2	End of program
12 LBL 1	Contour subprogram, description of the midpoint path
13 L C+40 Z+0 RL	Data for the rotary axis are entered in mm (Q17=1)
14 L Z+35	
15 L C+60 Z+52.5	
16 L Z+70	
17 LBL 0	
18 END PGM C28 MM	





9

**Canned Cycles: Contour
Pocket with Contour
Formula**



9.1 SL Cycles with Complex Contour Formula

Fundamentals

SL cycles and the complex contour formula enable you to form complex contours by combining subcontours (pockets or islands). You define the individual subcontours (geometry data) as separate programs. In this way, any subcontour can be used any number of times. The TNC calculates the complete contour from the selected subcontours, which you link together through a contour formula.



The memory capacity for programming an SL cycle (all contour description programs) is limited to **128 contours**. The number of possible contour elements depends on the type of contour (inside or outside contour) and the number of contour descriptions. You can program up to **16384** contour elements.

The SL cycles with contour formula presuppose a structured program layout and enable you to save frequently used contours in individual programs. Using the contour formula, you can connect the subcontours to a complete contour and define whether it applies to a pocket or island.

In its present form, the "SL cycles with contour formula" function requires input from several areas in the TNC's user interface. This function is to serve as a basis for further development.

Example: Program structure: Machining with SL cycles and complex contour formula

```
0 BEGIN PGM CONTOUR MM
...
5 SEL CONTOUR "MODEL"
6 CYCL DEF 20 CONTOUR DATA ...
8 CYCL DEF 22 ROUGH-OUT...
9 CYCL CALL
...
12 CYCL DEF 23 FLOOR FINISHING ...
13 CYCL CALL
...
16 CYCL DEF 24 SIDE FINISHING ...
17 CYCL CALL
63 L Z+250 R0 FMAX M2
64 END PGM CONTOUR MM
```



Properties of the subcontours

- By default, the TNC assumes that the contour is a pocket. Do not program a radius compensation. In the contour formula you can convert a pocket to an island by making it negative.
- The TNC ignores feed rates F and miscellaneous functions M.
- Coordinate transformations are allowed. If they are programmed within the subcontour they are also effective in the following subprograms, but they need not be reset after the cycle call.
- Although the subprograms can contain coordinates in the spindle axis, such coordinates are ignored.
- The working plane is defined in the first coordinate block of the subprogram. The secondary axes U,V,W are permitted.

Characteristics of the canned cycles

- The TNC automatically positions the tool to the setup clearance before a cycle.
- Each level of infeed depth is milled without interruptions since the cutter traverses around islands instead of over them.
- The radius of “inside corners” can be programmed—the tool keeps moving to prevent surface blemishes at inside corners (this applies for the outermost pass in the Rough-out and Side Finishing cycles).
- The contour is approached on a tangential arc for side finishing.
- For floor finishing, the tool again approaches the workpiece on a tangential arc (for tool axis Z, for example, the arc may be in the Z/X plane).
- The contour is machined throughout in either climb or up-cut milling.



With Machine Parameter 7420 you can determine where the tool is positioned at the end of Cycles 21 to 24.

The machining data (such as milling depth, finishing allowance and setup clearance) are entered as CONTOUR DATA in Cycle 20.

Example: Program structure: Calculation of the subcontours with contour formula

```

0 BEGIN PGM MODEL MM
1 DECLARE CONTOUR QC1 = "CIRCLE1"
2 DECLARE CONTOUR QC2 = "CIRCLE31XY"
3 DECLARE CONTOUR QC3 = "TRIANGLE"
4 DECLARE CONTOUR QC4 = "SQUARE"
5 QC10 = ( QC1 | QC3 | QC4 ) \ QC2
6 END PGM MODEL MM

0 BEGIN PGM CIRCLE1 MM
1 CC X+75 Y+50
2 LP PR+45 PA+0
3 CP IPA+360 DR+
4 END PGM CIRCLE1 MM

0 BEGIN PGM CIRCLE31XY MM
...

```



Selecting a program with contour definitions

With the **SEL CONTOUR** function you select a program with contour definitions, from which the TNC takes the contour descriptions:



- ▶ Show the soft-key row with special functions



- ▶ Select the menu for functions for contour and point machining.



- ▶ Press the SEL CONTOUR soft key.
- ▶ Enter the full name of the program with the contour definition and confirm with the END key.



Program a **SEL CONTOUR** block before the SL cycles. Cycle **14 CONTOUR GEOMETRY** is no longer necessary if you use **SEL CONTOUR**.

Defining contour descriptions

With the **DECLARE CONTOUR** function you enter in a program the path for programs from which the TNC draws the contour descriptions. In addition, you can select a separate depth for this contour description (FCL 2 function):



- ▶ Show the soft-key row with special functions



- ▶ Select the menu for functions for contour and point machining.



- ▶ Press the DECLARE CONTOUR soft key.
- ▶ Enter the number for the contour designator **QC**, and confirm with the ENT key.
- ▶ Enter the full name of the program with the contour description and confirm with the END key, or if desired,
- ▶ Define a separate depth for the selected contour.





With the given contour designators **QC** you can include the various contours in the contour formula.


If you program separate depths for contours, then you must assign a depth to all subcontours (assign the depth 0 if necessary).

Entering a complex contour formula








You can use soft keys to interlink various contours in a mathematical formula.

- 

▶ Show the soft-key row with special functions
- 

▶ Select the menu for functions for contour and point machining.
- 

▶ Press the CONTOUR FORMULA soft key. The TNC then displays the following soft keys:

Mathematical function	Soft key
Intersected with e.g. QC10 = QC1 & QC5	
Joined with e.g. QC25 = QC7 QC18	
Joined, but w/o intersection e.g. QC12 = QC5 ^ QC25	
Intersected with complement of e.g. QC25 = QC1 \ QC2	
Complement of the contour area e.g. Q12 = #Q11	
Opening parenthesis e.g. QC12 = QC1 * (QC2 + QC3)	
Closing parenthesis e.g. QC12 = QC1 * (QC2 + QC3)	
Defining a single contour e.g. QC12 = QC1	



Overlapping contours

By default, the TNC considers a programmed contour to be a pocket. With the functions of the contour formula, you can convert a contour from a pocket to an island.

Pockets and islands can be overlapped to form a new contour. You can thus enlarge the area of a pocket by another pocket or reduce it by an island.

Subprograms: overlapping pockets

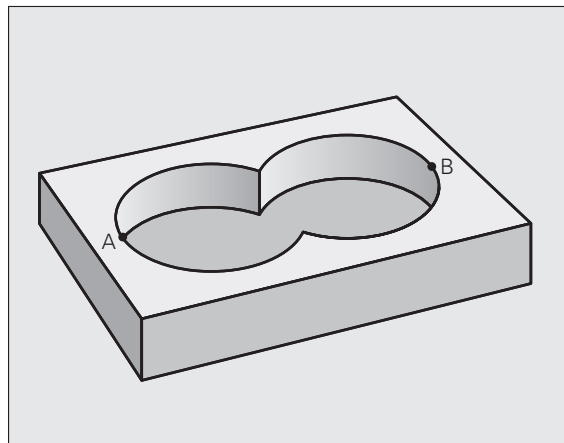


The following programming examples are contour description programs that are defined in a contour definition program. The contour definition program is called through the **SEL CONTOUR** function in the actual main program.

Pockets A and B overlap.

The TNC calculates the points of intersection S1 and S2 (they do not have to be programmed).

The pockets are programmed as full circles.



Contour description program 1: pocket A

```
0 BEGIN PGM POCKET_A MM
1 L X+10 Y+50 R0
2 CC X+35 Y+50
3 C X+10 Y+50 DR-
4 END PGM POCKET_A MM
```

Contour description program 2: pocket B

```
0 BEGIN PGM POCKET_B MM
1 L X+90 Y+50 R0
2 CC X+65 Y+50
3 C X+90 Y+50 DR-
4 END PGM POCKET_B MM
```

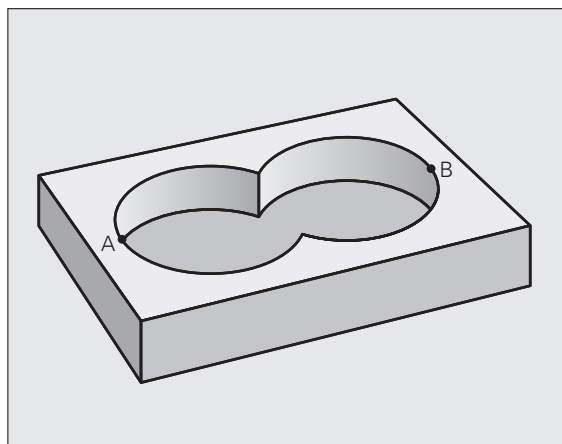
Area of inclusion

Both surfaces A and B are to be machined, including the overlapping area:

- The surfaces A and B must be programmed in separate programs without radius compensation.
- In the contour formula, the surfaces A and B are processed with the "joined with" function.

Contour definition program:

```
50 ...
51 ...
52 DECLARE CONTOUR QC1 = "POCKET_A.H"
53 DECLARE CONTOUR QC2 = "POCKET_B.H"
54 QC10 = QC1 | QC2
55 ...
56 ...
```



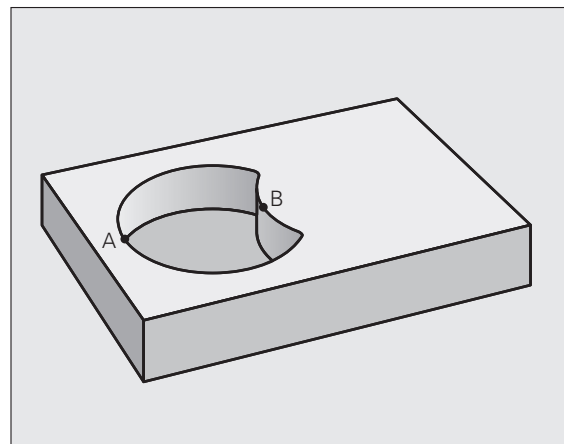
Area of exclusion

Surface A is to be machined without the portion overlapped by B:

- The surfaces A and B must be entered in separate programs without radius compensation.
- In the contour formula, the surface B is subtracted from the surface A with the "joined with complement of" function.

Contour definition program:

```
50 ...
51 ...
52 DECLARE CONTOUR QC1 = "POCKET_A.H"
53 DECLARE CONTOUR QC2 = "POCKET_B.H"
54 QC10 = QC1 \ QC2
55 ...
56 ...
```



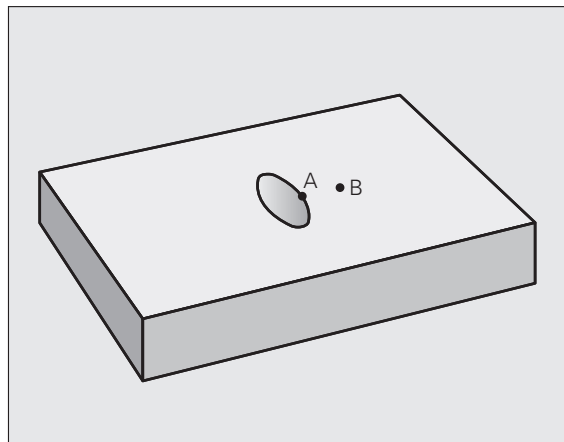
Area of intersection

Only the area where A and B overlap is to be machined. (The areas covered by A or B alone are to be left unmachined.)

- The surfaces A and B must be entered in separate programs without radius compensation.
- In the contour formula, the surfaces A and B are processed with the "intersection with" function.

Contour definition program:

```
50 ...
51 ...
52 DECLARE CONTOUR QC1 = "POCKET_A.H"
53 DECLARE CONTOUR QC2 = "POCKET_B.H"
54 QC10 = QC1 & QC2
55 ...
56 ...
```



Contour machining with SL Cycles



The complete contour is machined with the SL Cycles 20 to 24 (see "Overview" on page 180).

9.1 SL Cycles with Complex Contour Formula

with

Q11=100 ;FEED RATE FOR PLNGNG	
Q12=350 ;FEED RATE FOR ROUGHING	
Q18=0 ;COARSE ROUGHING TOOL	
Q19=150 ;RECIPROCATION FEED RATE	
Q401=100 ;FEED RATE FACTOR	
Q404=0 ;FINE ROUGH STRATEGY	
10 CYCL CALL M3	Cycle call: Rough-out
11 TOOL CALL 2 Z S5000	Tool call of finishing cutter
12 CYCL DEF 23 FLOOR FINISHING	Cycle definition: Floor finishing
Q11=100 ;FEED RATE FOR PLNGNG	
Q12=200 ;FEED RATE FOR ROUGHING	
13 CYCL CALL M3	Cycle call: Floor finishing
14 CYCLE DEF 24 SIDE FINISHING	Cycle definition: Side finishing
Q9=+1 ;DIRECTION	
Q10=5 ;PLUNGING DEPTH	
Q11=100 ;FEED RATE FOR PLNGNG	
Q12=400 ;FEED RATE FOR ROUGHING	
Q14=+0 ;ALLOWANCE FOR SIDE	
15 CYCL CALL M3	Cycle call: Side finishing
16 L Z+250 R0 FMAX M2	Retract in the tool axis, end program
17 END PGM CONTOUR MM	

Contour definition program with contour formula:

0 BEGIN PGM MODEL MM	Contour Definition Program
1 DECLARE CONTOUR QC1 = "CIRCLE1"	Definition of the contour designator for the program "CIRCLE1"
2 FN 0: Q1 =+35	Assignment of values for parameters used in PGM "CIRCLE31XY"
3 FN 0: Q2 = +50	
4 FN 0: Q3 =+25	
5 DECLARE CONTOUR QC2 = "CIRCLE31XY"	Definition of the contour designator for the program "CIRCLE31XY"
6 DECLARE CONTOUR QC3 = "TRIANGLE"	Definition of the contour designator for the program "TRIANGLE"
7 DECLARE CONTOUR QC4 = "SQUARE"	Definition of the contour designator for the program "SQUARE"
8 QC10 = (QC 1 QC 2) \ QC 3 \ QC 4	Contour formula
9 END PGM MODEL MM	

Contour description programs:

0 BEGIN PGM CIRCLE1 MM	Contour description program: circle at right
1 CC X+65 Y+50	
2 L PR+25 PA+0 R0	
3 CP IPA+360 DR+	
4 END PGM CIRCLE1 MM	
0 BEGIN PGM CIRCLE31XY MM	Contour description program: circle at left
1 CC X+Q1 Y+Q2	
2 LP PR+Q3 PA+0 R0	
3 CP IPA+360 DR+	
4 END PGM CIRCLE31XY MM	
0 BEGIN PGM TRIANGLE MM	Contour description program: triangle at right
1 L X+73 Y+42 R0	
2 L X+65 Y+58	
3 L X+58 Y+42	
4 L X+73	
5 END PGM TRIANGLE MM	
0 BEGIN PGM SQUARE MM	Contour description program: square at left
1 L X+27 Y+58 R0	
2 L X+43	
3 L Y+42	
4 L X+27	
5 L Y+58	
6 END PGM SQUARE MM	



9.2 SL Cycles with Simple Contour Formula

Fundamentals

SL cycles and the simple contour formula enable you to form contours by combining up to 9 subcontours (pockets or islands) in a simple manner. You define the individual subcontours (geometry data) as separate programs. In this way, any subcontour can be used any number of times. The TNC calculates the contour from the selected subcontours.



The memory capacity for programming an SL cycle (all contour description programs) is limited to **128 contours**. The number of possible contour elements depends on the type of contour (inside or outside contour) and the number of contour descriptions. You can program up to **16384** contour elements.

Properties of the subcontours

- By default, the TNC assumes that the contour is a pocket. Do not program a radius compensation.
- The TNC ignores feed rates F and miscellaneous functions M.
- Coordinate transformations are allowed. If they are programmed within the subcontour they are also effective in the following subprograms, but they need not be reset after the cycle call.
- Although the subprograms can contain coordinates in the spindle axis, such coordinates are ignored.
- The working plane is defined in the first coordinate block of the subprogram. The secondary axes U,V,W are permitted.

Example: Program structure: Machining with SL cycles and complex contour formula

```

0 BEGIN PGM CONTDEF MM
...
5 CONTOUR DEF
P1= "POCK1.H"
I2 = "ISLE2.H" DEPTH5
I3 "ISLE3.H" DEPTH7.5
6 CYCL DEF 20 CONTOUR DATA ...
8 CYCL DEF 22 ROUGH-OUT...
9 CYCL CALL
...
12 CYCL DEF 23 FLOOR FINISHING ...
13 CYCL CALL
...
16 CYCL DEF 24 SIDE FINISHING ...
17 CYCL CALL
63 L Z+250 R0 FMAX M2
64 END PGM CONTDEF MM

```

Characteristics of the canned cycles

- The TNC automatically positions the tool to the setup clearance before a cycle.
- Each level of infeed depth is milled without interruptions since the cutter traverses around islands instead of over them.
- The radius of “inside corners” can be programmed—the tool keeps moving to prevent surface blemishes at inside corners (this applies for the outermost pass in the Rough-out and Side Finishing cycles).
- The contour is approached on a tangential arc for side finishing.
- For floor finishing, the tool again approaches the workpiece on a tangential arc (for tool axis Z, for example, the arc may be in the Z/X plane).
- The contour is machined throughout in either climb or up-cut milling.



With Machine Parameter 7420 you can determine where the tool is positioned at the end of Cycles 21 to 24.

The machining data (such as milling depth, finishing allowance and setup clearance) are entered as CONTOUR DATA in Cycle 20.



Entering a simple contour formula

You can use soft keys to interlink various contours in a mathematical formula.



- ▶ Show the soft-key row with special functions



- ▶ Select the menu for functions for contour and point machining.



- ▶ Press the CONTOUR DEF soft key. The TNC opens the dialog for entering the contour formula.

- ▶ Enter the name of the first subcontour. The first subcontour must always be the deepest pocket. Confirm with the ENT key.



- ▶ Specify via soft key whether the next subcontour is a pocket or an island. Confirm with the ENT key.

- ▶ Enter the name of the second subcontour. Confirm with the ENT key.

- ▶ If needed, enter the depth of the second subcontour. Confirm with the ENT key.

- ▶ Carry on with the dialog as described above until you have entered all subcontours.



- As a rule, always start the list of subcontours with the deepest pocket!
- If the contour is defined as an island, the TNC interprets the entered depth as the island height. The entered value (without an algebraic sign) then refers to the workpiece top surface!
- If the depth is entered as 0, then for pockets the depth defined in the Cycle 20 is effective. Islands then rise up to the workpiece top surface!

Contour machining with SL Cycles



The complete contour is machined with the SL Cycles 20 to 24 (see "Overview" on page 180).



10

**Canned Cycles:
Multipass Milling**







10.1 Fundamentals

Overview

The TNC offers four cycles for machining surfaces with the following characteristics:

- Created with a CAD/CAM system
- Flat, rectangular surfaces
- Flat, oblique-angled surfaces
- Surfaces that are inclined in any way
- Twisted surfaces

Cycle	Soft key	Page
60 RUN 3-D DATA For multipass milling of 3-D data in several infeeds		Page 243
230 MULTIPASS MILLING For flat rectangular surfaces		Page 245
231 RULED SURFACE For oblique, inclined or twisted surfaces		Page 247
232 FACE MILLING For level rectangular surfaces, with indicated oversizes and multiple infeeds		Page 251



10.2 RUN 3-D DATA (Cycle 30, DIN/ISO: G60)

Cycle run

- 1 From the current position, the TNC positions the tool at rapid traverse **FMAX** in the tool axis to the setup clearance above the MAX point that you have programmed in the cycle.
- 2 The tool then moves at **FMAX** in the working plane to the MIN point you have programmed in the cycle.
- 3 From this point, the tool advances to the first contour point at the feed rate for plunging.
- 4 The TNC subsequently processes all points that are stored in the digitizing data file at the **feed rate for milling**. If necessary, the TNC retracts the tool between machining operations to the **setup clearance** if specific areas are to be left unmachined.
- 5 At the end of the cycle, the tool is retracted at **FMAX** to the setup clearance.

Please note while programming:



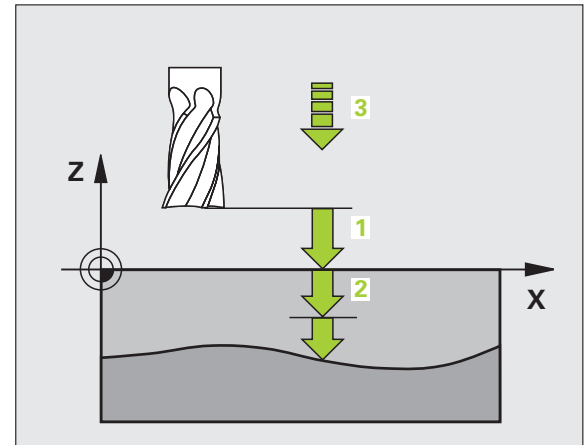
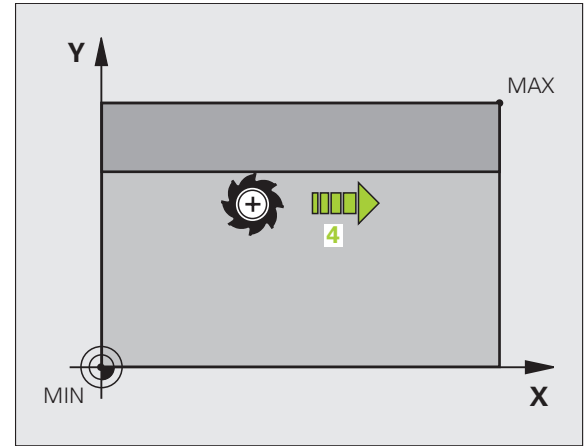
You can particularly use Cycle 30 to run conversational programs created offline in multiple infeeds.



Cycle parameters

98
MILL 3-D
DATA

- ▶ **PGM name 3-D data:** Enter the name of the program in which the contour data is stored. If the file is not stored in the current directory, enter the complete path. A maximum of 254 characters can be entered.
- ▶ **Min. point of range:** Lowest coordinates (X, Y and Z coordinates) in the range to be milled. Input range: -99999.9999 to 99999.9999
- ▶ **Max. point of range:** Largest coordinates (X, Y and Z coordinates) in the range to be milled. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance 1** (incremental): Distance between tool tip and workpiece surface for tool movements at rapid traverse. Input range: 0 to 99999.9999
- ▶ **Plunging depth 2** (incremental value): Infeed per cut. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for plunging 3:** Traversing speed of the tool during plunging in mm/min. Input range: 0 to 99999.999; alternatively **FAUTO**.
- ▶ **Feed rate for plunging 4:** Traversing speed of the tool during milling in mm/min. Input range: 0 to 99999.9999; alternatively **FAUTO**.
- ▶ **Miscellaneous function M:** Optional entry of one to two miscellaneous functions, for example M13. Input range: 0 to 999



Example: NC blocks

```

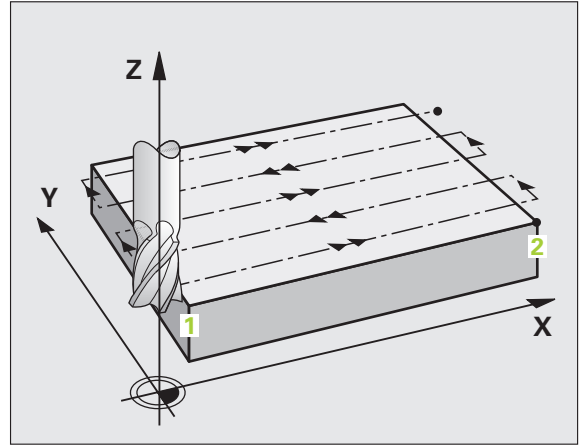
64 CYCL DEF 30.0 RUN 3-D DATA
65 CYCL DEF 30.1 PGM DIGIT.: BSP.H
66 CYCL DEF 30.2 X+0 Y+0 Z-20
67 CYCL DEF 30.3 X+100 Y+100 Z+0
68 CYCL DEF 30.4 SETUP 2
69 CYCL DEF 30.5 PECKG +5 F100
70 CYCL DEF 30.6 F350 M8

```


10.3 MULTIPASS MILLING (Cycle 230, DIN/ISO: G230)

Cycle run

- 1 From the current position in the working plane, the TNC positions the tool at rapid traverse **FMAX** to the starting point **1**; the TNC moves the tool by its radius to the left and upward.
- 2 The tool then moves at **FMAX** in the tool axis to the setup clearance. From there it approaches the programmed starting position in the tool axis at the feed rate for plunging.
- 3 The tool then moves at the programmed feed rate for milling to the end point **2**. The TNC calculates the end point from the programmed starting point, the program length, and the tool radius.
- 4 The TNC offsets the tool to the starting point in the next pass at the stepover feed rate. The offset is calculated from the programmed width and the number of cuts.
- 5 The tool then returns in the negative direction of the first axis.
- 6 Multipass milling is repeated until the programmed surface has been completed.
- 7 At the end of the cycle, the tool is retracted at **FMAX** to the setup clearance.



Please note while programming:



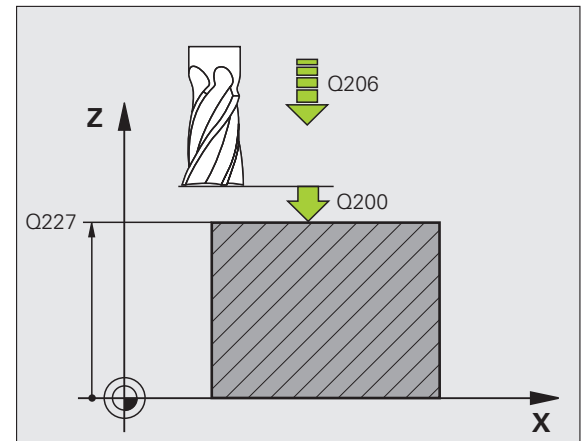
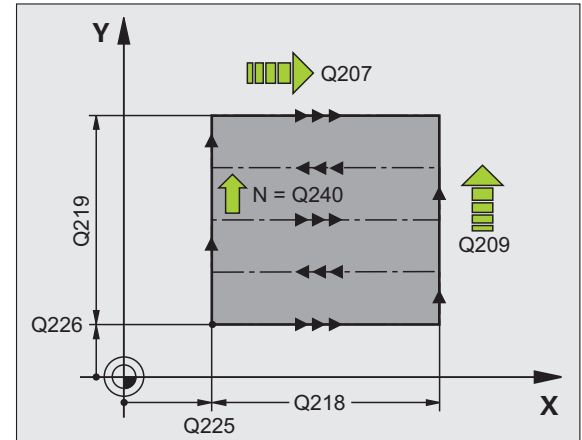
From the current position, the TNC positions the tool at the starting point, first in the working plane and then in the spindle axis.

Pre-position the tool in such a way that no collision between tool and clamping devices can occur.

Cycle parameters



- ▶ **Starting point in 1st axis** Q225 (absolute): Minimum point coordinate of the surface to be multipass-milled in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Starting point in 2nd axis** Q226 (absolute): Minimum-point coordinate of the surface to be multipass-milled in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Starting point in 3rd axis** Q227 (absolute): Height in the spindle axis at which multipass-milling is carried out. Input range: -99999.9999 to 99999.9999
- ▶ **First side length** Q218 (incremental): Length of the surface to be multipass-milled in the reference axis of the working plane, referenced to the starting point in the 1st axis. Input range: 0 to 99999.9999
- ▶ **Second side length** Q219 (incremental): Length of the surface to be multipass-milled in the minor axis of the working plane, referenced to the starting point in the 2nd axis. Input range: 0 to 99999.9999
- ▶ **Number of cuts** Q240: Number of passes to be made over the width. Input range: 0 to 99999
- ▶ **Feed rate for plunging** Q206: Traversing speed of the tool while moving from setup clearance to the milling depth in mm/min. Input range: 0 to 99999.9999; alternatively **FAUTO, FU, FZ**.
- ▶ **Feed rate for milling** Q207: Traversing speed of the tool during milling in mm/min. Input range: 0 to 99999.9999; alternatively **FAUTO, FU, FZ**.
- ▶ **Stepover feed rate** Q209: Traversing speed of the tool in mm/min when moving to the next pass. If you are moving the tool transversely in the material, enter Q209 to be smaller than Q207. If you are moving it transversely in the open, Q209 may be greater than Q207. Input range 0 to 99999.9999, alternatively **FAUTO, FU, FZ**.
- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip and milling depth for positioning at the start and end of the cycle. Input range 0 to 99999.9999, alternatively **PREDEF**



Example: NC blocks

```
71 CYCL DEF 230 MULTIPASS MILLING
```

```
Q225=+10 ;STARTING POINT 1ST AXIS
```

```
Q226=+12 ;STARTING POINT 2ND AXIS
```

```
Q227=+2.5 ;STARTING PNT 3RD AXIS
```

```
Q218=150 ;FIRST SIDE LENGTH
```

```
Q219=75 ;SECOND SIDE LENGTH
```

```
Q240=25 ;NUMBER OF CUTS
```

```
Q206=150 ;FEED RATE FOR PLNGNG
```

```
Q207=500 ;FEED RATE FOR MILLING
```

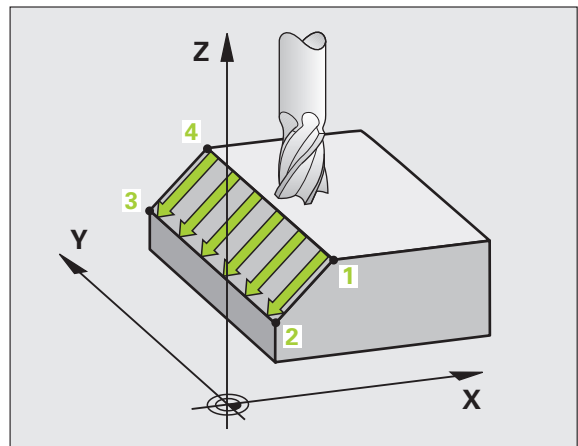
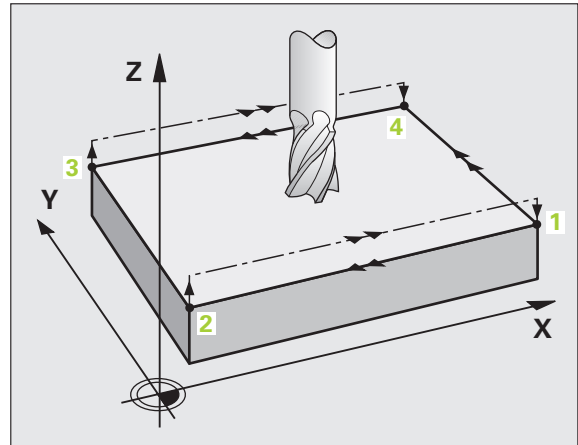
```
Q209=200 ;STEPOVER FEED RATE
```

```
Q200=2 ;SETUP CLEARANCE
```

10.4 RULED SURFACE (Cycle 231, DIN/ISO: G231)

Cycle run

- 1 From the current position, the TNC positions the tool in a linear 3-D movement to the starting point **1**.
- 2 The tool subsequently advances to the stopping point **2** at the feed rate for milling.
- 3 From this point, the tool moves at rapid traverse **FMAX** by the tool diameter in the positive tool axis direction, and then back to starting point **1**.
- 4 At the starting point **1** the TNC moves the tool back to the last traversed Z value.
- 5 Then the TNC moves the tool in all three axes from point **1** in the direction of point **4** to the next line.
- 6 From this point, the tool moves to the stopping point on this pass. The TNC calculates the end point from point **2** and a movement in the direction of point **3**.
- 7 Multipass milling is repeated until the programmed surface has been completed.
- 8 At the end of the cycle, the tool is positioned above the highest programmed point in the spindle axis, offset by the tool diameter.



Cutting motion

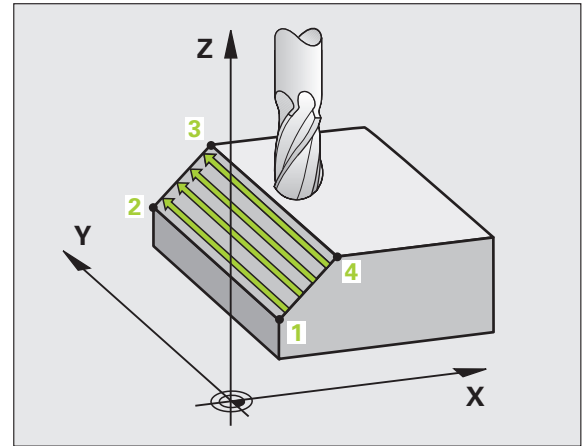
The starting point, and therefore the milling direction, is selectable because the TNC always moves from point **1** to point **2** and in the total movement from point **1 / 2** to point **3 / 4**. You can program point **1** at any corner of the surface to be machined.

If you are using an end mill for the machining operation, you can optimize the surface finish in the following ways:

- A shaping cut (spindle axis coordinate of point **1** greater than spindle-axis coordinate of point **2**) for slightly inclined surfaces.
- A drawing cut (spindle axis coordinate of point **1** smaller than spindle-axis coordinate of point **2**) for steep surfaces.
- When milling twisted surfaces, program the main cutting direction (from point **1** to point **2**) parallel to the direction of the steeper inclination.

If you are using a spherical cutter for the machining operation, you can optimize the surface finish in the following way:

- When milling twisted surfaces, program the main cutting direction (from point **1** to point **2**) perpendicular to the direction of the steepest inclination.

**Please note while programming:**

From the current position, the TNC positions the tool in a linear 3-D movement to the starting point **1**. Pre-position the tool in such a way that no collision between tool and fixtures can occur.

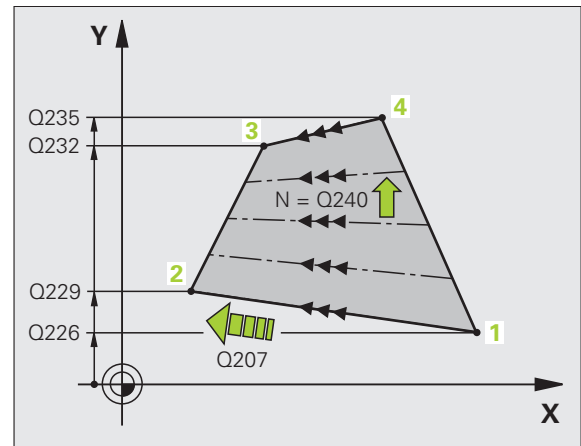
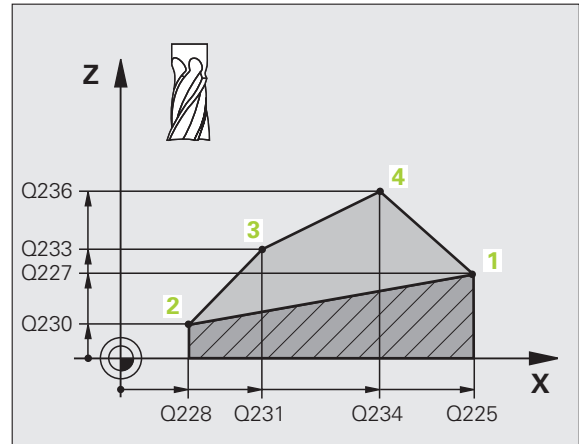
The TNC moves the tool with radius compensation R0 to the programmed positions.

If required, use a center-cut end mill (ISO 1641).

Cycle parameters



- ▶ **Starting point in 1st axis Q225 (absolute):** Starting point coordinate of the surface to be multipass-milled in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Starting point in 2nd axis Q226 (absolute):** Starting point coordinate of the surface to be multipass-milled in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Starting point in 3rd axis Q227 (absolute):** Starting point coordinate of the surface to be multipass-milled in the tool axis. Input range: -99999.9999 to 99999.9999
- ▶ **2nd point in 1st axis Q228 (absolute):** End point coordinate of the surface to be multipass milled in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **2nd point in 2nd axis Q229 (absolute):** End point coordinate of the surface to be multipass milled in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **2nd point in 3rd axis Q230 (absolute):** End point coordinate of the surface to be multipass milled in the spindle axis. Input range: -99999.9999 to 99999.9999
- ▶ **3rd point in 1st axis Q231 (absolute):** Coordinate of point **3** in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **3rd point in 2nd axis Q232 (absolute):** Coordinate of point **3** in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **3rd point in 3rd axis Q233 (absolute):** Coordinate of point **3** in the spindle axis. Input range: -99999.9999 to 99999.9999



- **4th point in 1st axis** Q234 (absolute): Coordinate of point **4** in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- **4th point in 2nd axis** Q235 (absolute): Coordinate of point **4** in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- **4th point in 3rd axis** Q236 (absolute): Coordinate of point **4** in the spindle axis. Input range: -99999.9999 to 99999.9999
- **Number of cuts** Q240: Number of passes to be made between points **1** and **4**, **2** and **3**. Input range: 0 to 99999
- **Feed rate for milling** Q207: Traversing speed of the tool in mm/min while milling. The TNC performs the first step at half the programmed feed rate. Input range 0 to 99999,999, alternatively **FAUTO**, **FU**, **FZ**.

Example: NC blocks

72 CYCL DEF 231 RULED SURFACE	
Q225=+0	;STARTING POINT 1ST AXIS
Q226=+5	;STARTING POINT 2ND AXIS
Q227=-2	;STARTING PNT 3RD AXIS
Q228=+100	;2ND POINT 1ST AXIS
Q229=+15	;2ND POINT 2ND AXIS
Q230=+5	;2ND POINT 3RD AXIS
Q231=+15	;3RD POINT 1ST AXIS
Q232=+125	;3RD POINT 2ND AXIS
Q233=+25	;3RD POINT 3RD AXIS
Q234=+15	;4TH POINT 1ST AXIS
Q235=+125	;4TH POINT 2ND AXIS
Q236=+25	;4TH POINT 3RD AXIS
Q240=40	;NUMBER OF CUTS
Q207=500	;FEED RATE FOR MILLING

10.5 FACE MILLING (Cycle 232, DIN/ISO: G232)

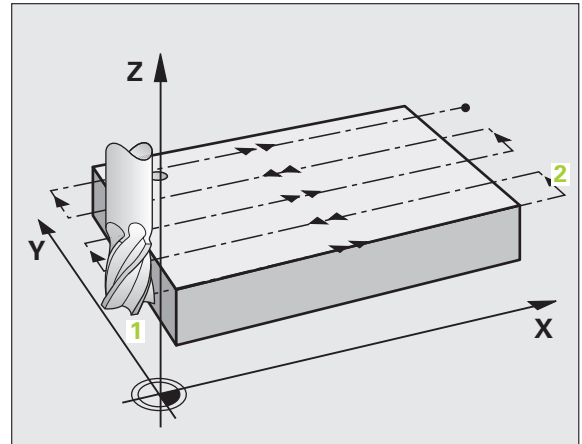
Cycle run

Cycle 232 is used to face mill a level surface in multiple infeeds while taking the finishing allowance into account. Three machining strategies are available:

- **Strategy Q389=0:** Meander machining, stepover outside the surface being machined
 - **Strategy Q389=1:** Meander machining, stepover within the surface being machined
 - **Strategy Q389=2:** Line-by-line machining, retraction and stepover at the positioning feed rate
- 1 From the current position, the TNC positions the tool at rapid traverse **FMAX** to the starting position **1** using positioning logic: If the current position in the spindle axis is greater than the 2nd setup clearance, the TNC positions the tool first in the machining plane and then in the spindle axis. Otherwise it first moves to the 2nd setup clearance and then in the machining plane. The starting point in the machining plane is offset from the edge of the workpiece by the tool radius and the safety clearance to the side.
 - 2 The tool then moves in the spindle axis at the positioning feed rate to the first plunging depth calculated by the control.

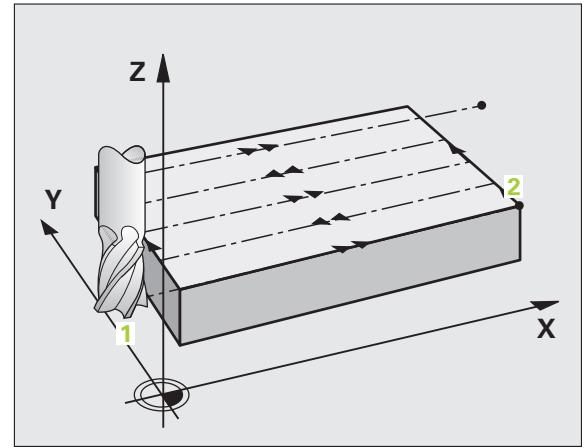
Strategy Q389=0

- 3 The tool then advances to the stopping point **2** at the feed rate for milling. The end point lies **outside** the surface. The control calculates the end point from the programmed starting point, the programmed length, the programmed safety clearance to the side and the tool radius.
- 4 The TNC offsets the tool to the starting point in the next pass at the pre-positioning feed rate. The offset is calculated from the programmed width, the tool radius and the maximum path overlap factor.
- 5 The tool then moves back in the direction of the starting point **1**.
- 6 The process is repeated until the programmed surface has been completed. At the end of the last pass, the next machining depth is plunged to.
- 7 In order to avoid non-productive motions, the surface is then machined in reverse direction.
- 8 The process is repeated until all infeeds have been machined. In the last infeed, simply the finishing allowance entered is milled at the finishing feed rate.
- 9 At the end of the cycle, the TNC retracts the tool at **FMAX** to the 2nd setup clearance.



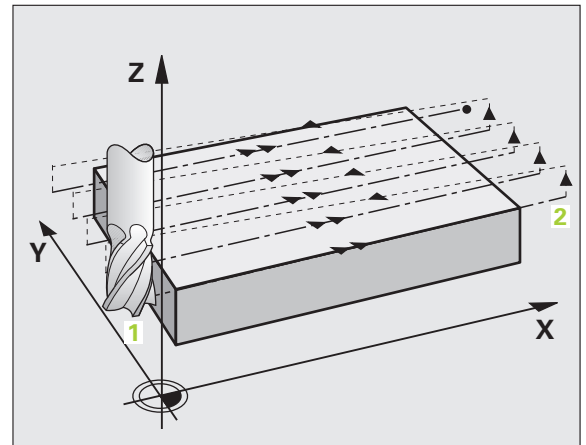
Strategy Q389=1

- 3 The tool then advances to the stopping point **2** at the feed rate for milling. The end point lies **within** the surface. The control calculates the end point from the programmed starting point, the programmed length and the tool radius.
- 4 The TNC offsets the tool to the starting point in the next pass at the pre-positioning feed rate. The offset is calculated from the programmed width, the tool radius and the maximum path overlap factor.
- 5 The tool then moves back in the direction of the starting point **1**. The motion to the next line occurs within the workpiece borders.
- 6 The process is repeated until the programmed surface has been completed. At the end of the last pass, the next machining depth is plunged to.
- 7 In order to avoid non-productive motions, the surface is then machined in reverse direction.
- 8 The process is repeated until all infeeds have been machined. In the last infeed, simply the finishing allowance entered is milled at the finishing feed rate.
- 9 At the end of the cycle, the TNC retracts the tool at **FMAX** to the 2nd setup clearance.



Strategy Q389=2

- 3 The tool then advances to the stopping point **2** at the feed rate for milling. The end point lies **outside** the surface. The control calculates the end point from the programmed starting point, the programmed length, the programmed safety clearance to the side and the tool radius.
- 4 The TNC positions the tool in the spindle axis to the setup clearance over the current infeed depth, and then moves at the pre-positioning feed rate directly back to the starting point in the next line. The TNC calculates the offset from the programmed width, the tool radius and the maximum path overlap factor.
- 5 The tool then returns to the current infeed depth and moves in the direction of the next end point **2**.
- 6 The milling process is repeated until the programmed surface has been completed. At the end of the last pass, the next machining depth is plunged to.
- 7 In order to avoid non-productive motions, the surface is then machined in reverse direction.
- 8 The process is repeated until all infeeds have been machined. In the last infeed, simply the finishing allowance entered is milled at the finishing feed rate.
- 9 At the end of the cycle, the TNC retracts the tool at **FMAX** to the 2nd setup clearance.



Please note while programming:

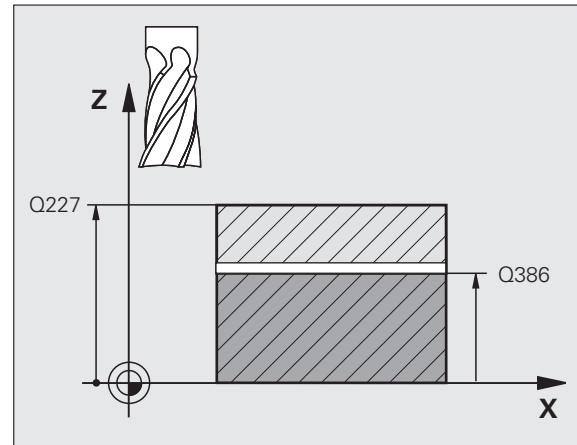
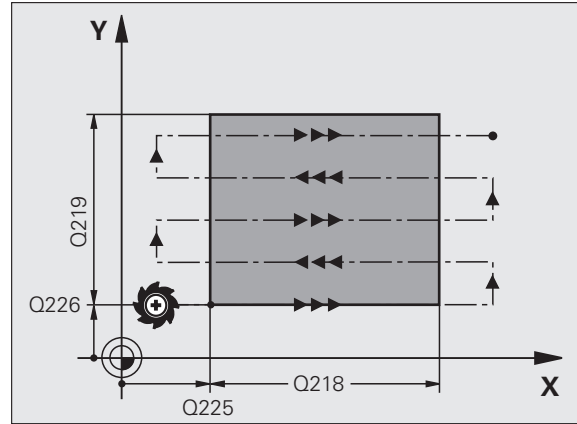


Enter the 2nd setup clearance in Q204 so that no collision between tool and clamping devices can occur.

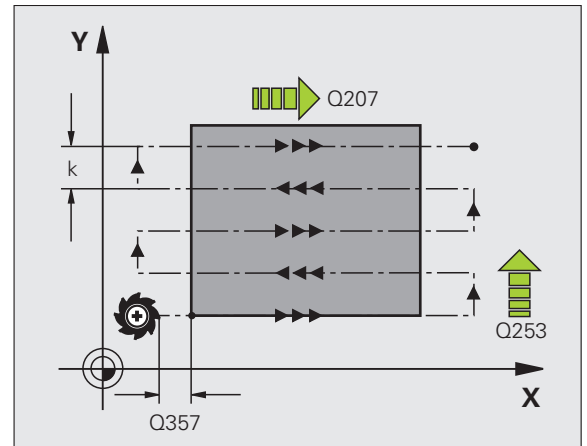
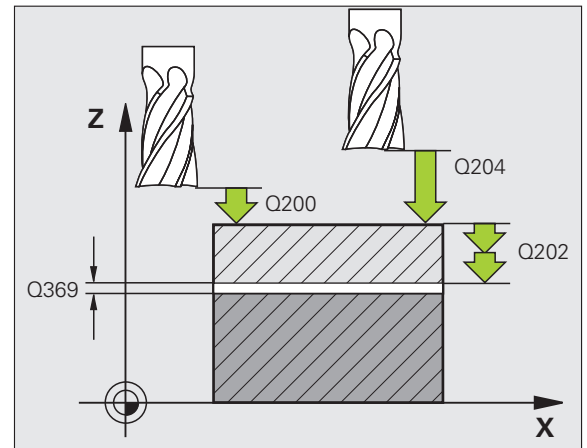
Cycle parameters



- ▶ **Machining strategy (0/1/2)** Q389: Specify how the TNC is to machine the surface:
0: Meander machining, stepover at positioning feed rate outside the surface to be machined
1: Meander machining, stepover at feed rate for milling within the surface to be machined
2: Line-by-line machining, retraction and stepover at the positioning feed rate
- ▶ **Starting point in 1st axis** Q225 (absolute): Starting point coordinate of the surface to be machined in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Starting point in 2nd axis** Q226 (absolute): Starting point coordinate of the surface to be multipass-milled in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Starting point in 3rd axis** Q227 (absolute): Coordinate of the workpiece surface used to calculate the infeeds. Input range: -99999.9999 to 99999.9999
- ▶ **End point in 3rd axis** Q386 (absolute): Coordinate in the spindle axis to which the surface is to be face milled. Input range: -99999.9999 to 99999.9999
- ▶ **First side length** Q218 (incremental value): Length of the surface to be machined in the reference axis of the working plane. Use the algebraic sign to specify the direction of the first milling path in reference to the **starting point in the 1st axis**. Input range: -99999.9999 to 99999.9999
- ▶ **Second side length** Q219 (incremental value): Length of the surface to be machined in the minor axis of the working plane. Use the algebraic sign to specify the direction of the first stepover in reference to the **starting point in the 2nd axis**. Input range: -99999.9999 to 99999.9999



- ▶ **Maximum plunging depth** Q202 (incremental value): **Maximum** amount that the tool is advanced each time. The TNC calculates the actual plunging depth from the difference between the end point and starting point of the tool axis (taking the finishing allowance into account), so that uniform plunging depths are used each time. Input range: 0 to 99999.9999
- ▶ **Allowance for floor** Q369 (incremental): Distance used for the last infeed. Input range: 0 to 99999.9999
- ▶ **Max. path overlap factor** Q370: **Maximum** stepover factor k. The TNC calculates the actual stepover from the second side length (Q219) and the tool radius so that a constant stepover is used for machining. If you have entered a radius R2 in the tool table (e.g. tooth radius when using a face-milling cutter), the TNC reduces the stepover accordingly. Input range 0.1 to 1.9999, alternatively **PREDEF**
- ▶ **Feed rate for milling** Q207: Traversing speed of the tool during milling in mm/min. Input range: 0 to 99999.9999; alternatively **FAUTO, FU, FZ**.
- ▶ **Feed rate for finishing** Q385: Traversing speed of the tool in mm/min, while milling the last infeed. Input range: 0 to 99999.9999; alternatively **FAUTO, FU, FZ**.
- ▶ **Feed rate for pre-positioning** Q253: Traversing speed of the tool in mm/min when approaching the starting position and when moving to the next pass. If you are moving the tool transversely to the material (Q389=1), the TNC moves the tool at the feed rate for milling Q207. Input range 0 to 99999.9999, alternatively **FMAX, FAUTO, PREDEF**.



- ▶ **Setup clearance** Q200 (incremental): Distance between tool tip and the starting position in the tool axis. If you are milling with machining strategy Q389=2, the TNC moves the tool at the setup clearance over the current plunging depth to the starting point of the next pass. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance to side** Q357 (incremental): Safety clearance to the side of the workpiece when the tool approaches the first plunging depth, and distance at which the stepover occurs if the machining strategy Q389=0 or Q389=2 is used. Input range: 0 to 99999.9999
- ▶ **2nd setup clearance** Q204 (incremental): Coordinate in the spindle axis at which no collision between tool and workpiece (fixtures) can occur. Input range 0 to 99999.9999, alternatively **PREDEF**

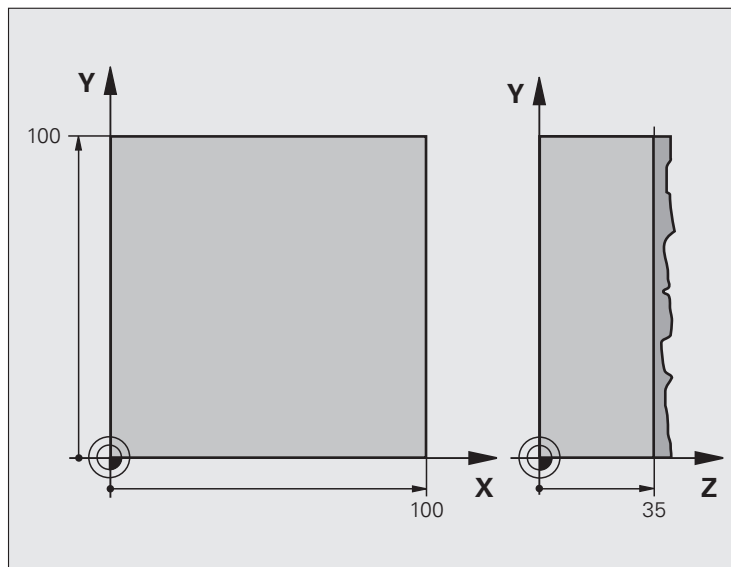
Example: NC blocks

71 CYCL DEF 232 FACE MILLING
Q389=2 ;STRATEGY
Q225=+10 ;STARTING POINT 1ST AXIS
Q226=+12 ;STARTING POINT 2ND AXIS
Q227=+2.5 ;STARTING PNT 3RD AXIS
Q386=-3 ;END POINT IN 3RD AXIS
Q218=150 ;FIRST SIDE LENGTH
Q219=75 ;SECOND SIDE LENGTH
Q202=2 ;MAX. PLUNGING DEPTH
Q369=0.5 ;ALLOWANCE FOR FLOOR
Q370=1 ;MAX. OVERLAP
Q207=500 ;FEED RATE FOR MILLING
Q385=800 ;FEED RATE FOR FINISHING
Q253=2000 ;F PRE-POSITIONING
Q200=2 ;SETUP CLEARANCE
Q357=2 ;CLEARANCE TO SIDE
Q204=2 ;2ND SETUP CLEARANCE



10.6 Programming examples

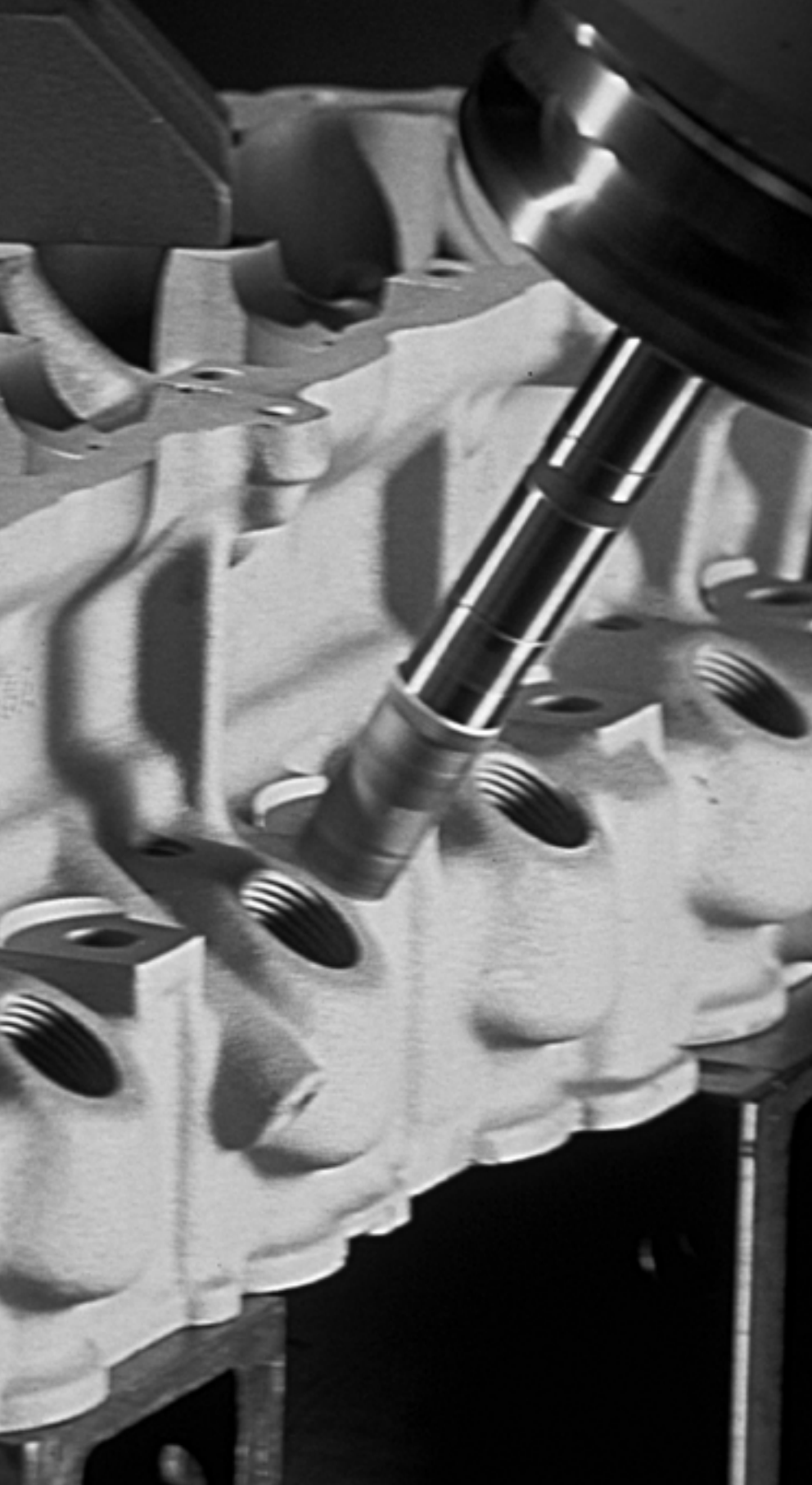
Example: Multipass milling



0 BEGIN PGM C230 MM	
1 BLK FORM 0.1 Z X+0 Y+0 Z+0	Definition of workpiece blank
2 BLK FORM 0.2 X+100 Y+100 Z+40	
3 TOOL DEF 1 L+0 R+5	Tool definition
4 TOOL CALL 1 Z S3500	Tool call
5 L Z+250 R0 FMAX	Retract the tool
6 CYCL DEF 230 MULTIPASS MILLING	Cycle definition: MULTIPASS MILLING
Q225=+0 ;STARTNG PNT 1ST AXIS	
Q226=+0 ;STARTNG PNT 2ND AXIS	
Q227=+35 ;STARTNG PNT 3RD AXIS	
Q218=100 ;FIRST SIDE LENGTH	
Q219=100 ;2ND SIDE LENGTH	
Q240=25 ;NUMBER OF CUTS	
Q206=250 ;FEED RATE FOR PLNGN	
Q207=400 ;FEED RATE FOR MILLING	
Q209=150 ;STEPOVER FEED RATE	
Q200=2 ;SETUP CLEARANCE	

7 L X+-25 Y+0 R0 FMAX M3	Pre-position near the starting point
8 CYCL CALL	Cycle call
9 L Z+250 R0 FMAX M2	Retract in the tool axis, end program
10 END PGM C230 MM	





11








**Cycles: Coordinate
Transformations**



11.1 Fundamentals

Overview

Once a contour has been programmed, you can position it on the workpiece at various locations and in different sizes through the use of coordinate transformations. The TNC provides the following coordinate transformation cycles:

Cycle	Soft key	Page
7 DATUM SHIFT For shifting contours directly within the program or from datum tables		Page 262
247 DATUM SETTING Datum setting during program run		Page 269
8 MIRROR IMAGE Mirroring contours		Page 270
10 ROTATION For rotating contours in the working plane		Page 272
11 SCALING FACTOR For increasing or reducing the size of contours		Page 274
26 AXIS-SPECIFIC SCALING FACTOR For increasing or reducing the size of contours with scaling factors for each axis		Page 276
19 WORKING PLANE Machining in tilted coordinate system on machines with swivel heads and/or rotary tables		Page 278

Effect of coordinate transformations

Beginning of effect: A coordinate transformation becomes effective as soon as it is defined—it is not called. It remains in effect until it is changed or canceled.

To cancel coordinate transformations:

- Define cycles for basic behavior with a new value, such as scaling factor 1.0
- Execute a miscellaneous function M2, M30, or an END PGM block (depending on MP7300).
- Select a new program
- Program miscellaneous function M142 Erasing modal program information.



11.2 DATUM SHIFT (Cycle 7, DIN/ISO: G54)

Effect

A DATUM SHIFT allows machining operations to be repeated at various locations on the workpiece.

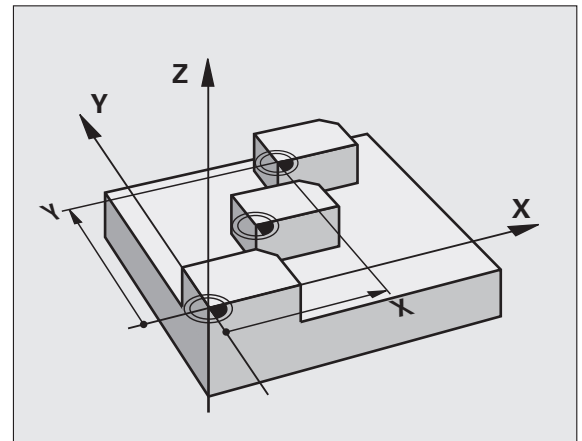
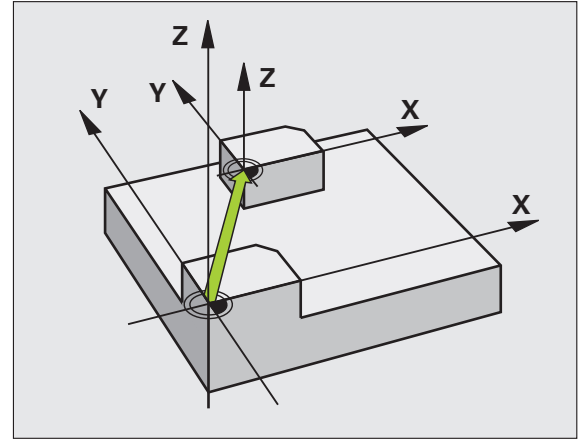
When the DATUM SHIFT cycle is defined, all coordinate data is based on the new datum. The TNC displays the datum shift in each axis in the additional status display. Input of rotary axes is also permitted.

Resetting

- Program a datum shift to the coordinates X=0, Y=0 etc. directly with a cycle definition.
- Use the **TRANS DATUM RESET** function.
- Call a datum shift to the coordinates X=0; Y=0 etc. from the datum table.

Graphics

If you program a new **BLK FORM** after a datum shift, you can use MP 7310 to determine whether the **BLK FORM** is referenced to the current datum or to the original datum. Referencing a new BLK FORM to the current datum enables you to display each part in a program in which several pallets are machined.



Cycle parameters



- **Datum shift:** Enter the coordinates of the new datum. Absolute values are referenced to the manually set workpiece datum. Incremental values are always referenced to the datum which was last valid—this can be a datum which has already been shifted. Input range: Up to 6 NC axes, each from -99999.9999 to 99999.9999

Example: NC blocks

```
13 CYCL DEF 7.0 DATUM SHIFT
```

```
14 CYCL DEF 7.1 X+60
```

```
16 CYCL DEF 7.3 Z-5
```

```
15 CYCL DEF 7.2 Y+40
```

11.3 DATUM shift with datum tables (Cycle 7, DIN/ISO: G53)

Effect

Datum tables are used for

- frequently recurring machining sequences at various locations on the workpiece
- frequent use of the same datum shift

Within a program, you can either program datum points directly in the cycle definition or call them from a datum table.

Resetting

- Call a datum shift to the coordinates $X=0$; $Y=0$ etc. from the datum table.
- Execute a datum shift to the coordinates $X=0$, $Y=0$ etc. directly with a cycle definition.
- Use the **TRANS DATUM RESET** function.

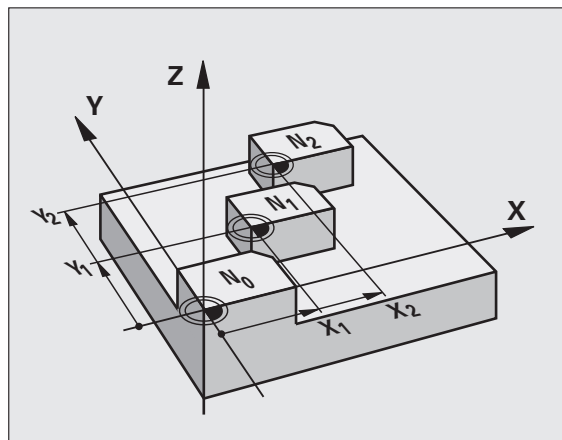
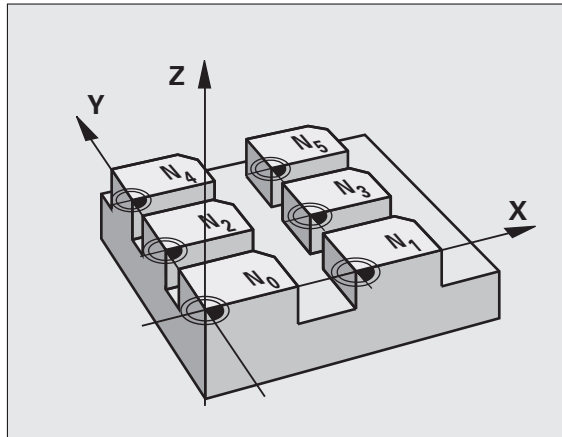
Graphics

If you program a new **BLK FORM** after a datum shift, you can use MP 7310 to determine whether the **BLK FORM** is referenced to the current datum or to the original datum. Referencing a new BLK FORM to the current datum enables you to display each part in a program in which several pallets are machined.

Status displays

In the additional status display, the following data from the datum table are shown :

- Name and path of the active datum table
- Active datum number
- Comment from the DOC column of the active datum number



Please note while programming:**Danger of collision!**

Datums from a datum table are **always and exclusively** referenced to the current datum (preset).

MP7475, which earlier defined whether datums are referenced to the machine datum or the workpiece datum, now serves only as a safety measure. If MP7475 = 1, the TNC outputs an error message if a datum shift is called from a datum table.

Datum tables from the TNC 4xx whose coordinates are referenced to the machine datum (MP7475 = 1) cannot be used in the iTNC 530.



If you are using datum shifts with datum tables, then use the **SEL TABLE** function to activate the desired datum table from the NC program.

If you work without **SEL TABLE**, then you must activate the desired datum table before the test run or the program run. (This applies also to the programming graphics).

- Use the file management to select the desired table for a test run in the **Test Run** operating mode: The table receives the status S.
- Use the file management in a program run mode to select the desired table for a program run: The table receives the status M.

The coordinate values from datum tables are only effective with absolute coordinate values.

New lines can only be inserted at the end of the table.

Cycle parameters



- **Datum shift:** Enter the number of the datum from the datum table or a Q parameter. If you enter a Q parameter, the TNC activates the datum number entered in the Q parameter. Input range:0 to 9999

Example: NC blocks

```
77 CYCL DEF 7.0 DATUM SHIFT
```

```
78 CYCL DEF 7.1 #5
```

Selecting a datum table in the part program

With the **SEL TABLE** function you select the table from which the TNC takes the datums:



- To select the functions for program call, press the PGM CALL key.



- Press the DATUM TABLE soft key.
- Enter the complete path name of the datum table and confirm your entry with the END key.



Program a **SEL TABLE** block before Cycle 7 Datum Shift.

A datum table selected with **SEL TABLE** remains active until you select another datum table with **SEL TABLE** or through PGM MGT.

You can define datum tables and datum numbers in an NC block with the **TRANS DATUM TABLE** function.



Editing the datum table in the Programming and Editing mode of operation



After you have changed a value in a datum table, you must save the change with the ENT key. Otherwise the change may not be included during program run.

Select the datum table in the **Programming and Editing** mode of operation.



- ▶ Press the PGM MGT key to call the file manager.
- ▶ Display the datum tables: Press the soft keys SELECT TYPE and SHOW .D.
- ▶ Select the desired table or enter a new file name.
- ▶ Edit the file. The soft-key row comprises the following functions for editing:

Function	Soft key
Select beginning of table	
Select end of table	
Go to previous page	
Go to next page	
Insert line (only possible at end of table)	
Delete line	
Confirm the entered line and go to the beginning of the next line	
Add the entered number of lines (reference points) to the end of the table	

Editing a pocket table in a Program Run operating mode

In a program run mode you can select the active datum table. Press the DATUM TABLE soft key. You can then use the same editing functions as in the **Programming and Editing** mode of operation.



Transferring the actual values into the datum table

You can enter the current tool position or the last probed position in the datum table by pressing the "actual-position-capture" key:

- Place the text box on the line of the column in which you want to enter the position.



- Select the actual-position-capture function: The TNC opens a pop-up window that asks whether you want to enter the current tool position or the last probed values.

- Select the desired function with the arrow keys and confirm your selection with the ENT key.



- To enter the values in all axes, press the ALL VALUES soft key.



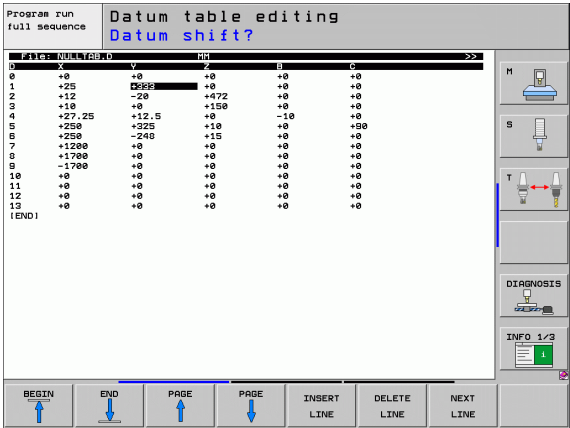
- To enter the value in the axis where the text box is located, press the CURRENT VALUE soft key.



Configuring the datum table

In the second and third soft-key rows you can define for each datum table the axes for which you wish to set the datums. In the standard setting all of the axes are active. If you wish to exclude an axis, set the corresponding soft key to OFF. The TNC then deletes that column from the datum table.

If you do not wish to define a datum table for an active axis, press the NO ENT key. The TNC then enters a dash in that column.



To leave a datum table

Select a different type of file in file management and choose the desired file.



11.4 DATUM SETTING (Cycle 247, DIN/ISO: G247)

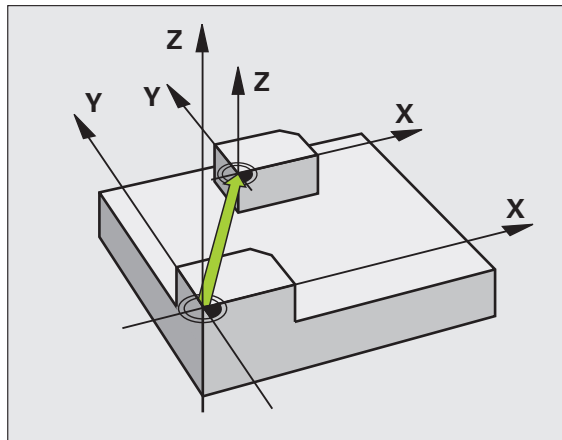
Effect

With the Cycle DATUM SETTING, you can activate as the new datum a preset defined in a preset table.

After a DATUM SETTING cycle definition, all of the coordinate inputs and datum shifts (absolute and incremental) are referenced to the new preset.

Status display

In the status display the TNC shows the active preset number behind the datum symbol.



Please note before programming:



When activating a datum from the preset table, the TNC resets the active datum shift.

The TNC sets the preset only in the axes that are defined with values in the preset table. The datums of axes marked with – remain unchanged.

If you activate preset number 0 (line 0), then you activate the datum that you last set in a manual operating mode.

Cycle 247 is not functional in Test Run mode.

Cycle parameters



- **Number for datum?:** Enter the number of the datum to be activated from the preset table. Input range: 0 to 65535

Example: NC blocks

```
13 CYCL DEF 247 DATUM SETTING
```

```
Q339=4 ;DATUM NUMBER
```



11.5 MIRROR IMAGE (Cycle 8, DIN/ISO: G28)

Effect

The TNC can machine the mirror image of a contour in the working plane.

The mirror image cycle becomes effective as soon as it is defined in the program. It is also effective in the Positioning with MDI mode of operation. The active mirrored axes are shown in the additional status display.

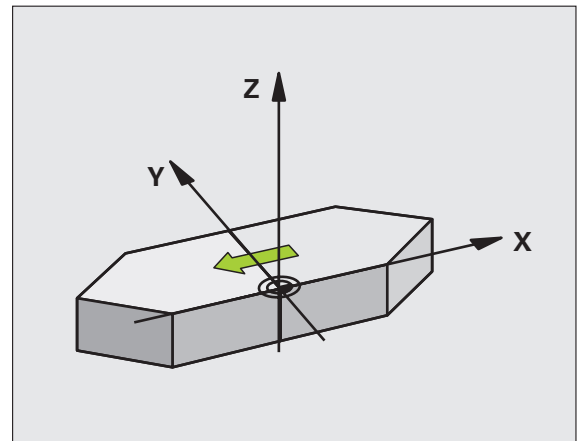
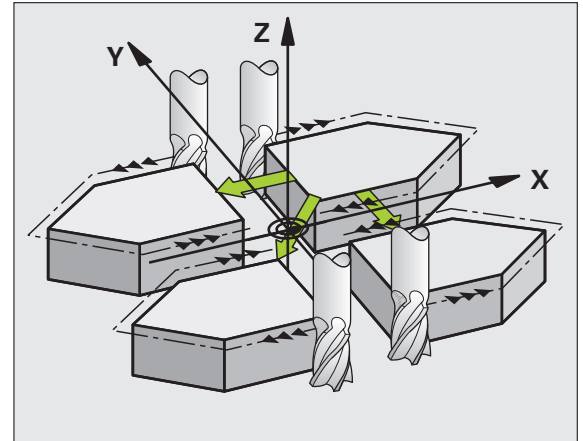
- If you mirror only one axis, the machining direction of the tool is reversed (except in canned cycles).
- If you mirror two axes, the machining direction remains the same.

The result of the mirror image depends on the location of the datum:

- If the datum lies on the contour to be mirrored, the element simply flips over.
- If the datum lies outside the contour to be mirrored, the element also “jumps” to another location.

Resetting

Program the MIRROR IMAGE cycle once again with NO ENT.



Please note while programming:



If you mirror only one axis, the machining direction is reversed for the milling cycles (Cycles 2xx). Exception: Cycle 208, in which the direction defined in the cycle applies.

Cycle parameters



- **Mirrored axis?:** Enter the axis to be mirrored. You can mirror all axes, including rotary axes, except for the spindle axis and its auxiliary axes. You can enter up to three axes. Input range: Up to three NC axes **X, Y, Z, U, V, W, A, B, C**

Example: NC blocks

```
79 CYCL DEF 8.0 MIRROR IMAGE
```

```
80 CYCL DEF 8.1 X Y U
```



11.6 ROTATION (Cycle 10, DIN/ISO: G73)

Effect

The TNC can rotate the coordinate system about the active datum in the working plane within a program.

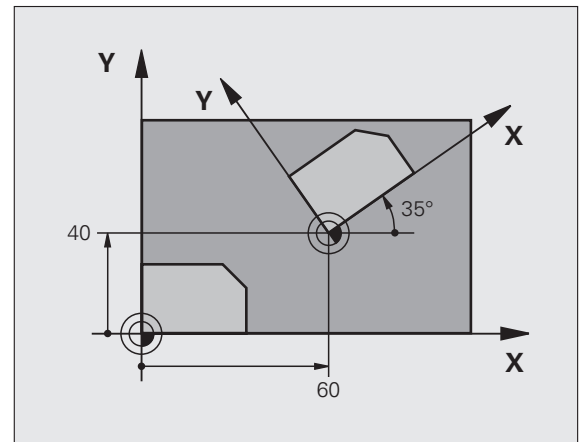
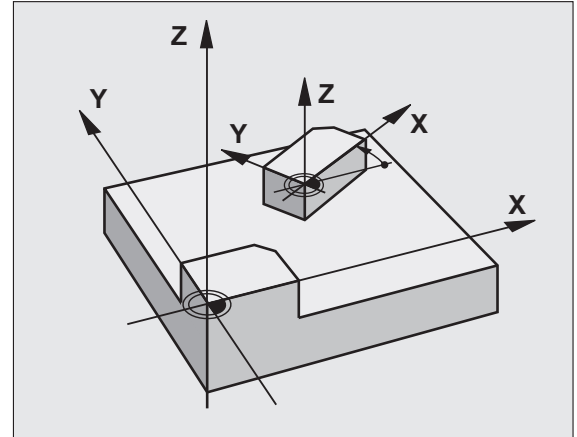
The ROTATION cycle becomes effective as soon as it is defined in the program. It is also effective in the Positioning with MDI mode of operation. The active rotation angle is shown in the additional status display.

Reference axis for the rotation angle:

- X/Y plane X axis
- Y/Z plane Y axis
- Z/X plane Z axis

Resetting

Program the ROTATION cycle once again with a rotation angle of 0°.



Please note while programming:



An active radius compensation is canceled by defining Cycle 10 and must therefore be reprogrammed, if necessary.

After defining Cycle 10, you must move both axes of the working plane to activate rotation for all axes.

Cycle parameters



- **Rotation:** Enter the rotation angle in degrees (°). Input range -360.000° to $+360.000^{\circ}$ (absolute or incremental)

Example: NC blocks

```
12 CALL LBL 1
13 CYCL DEF 7.0 DATUM SHIFT
14 CYCL DEF 7.1 X+60
15 CYCL DEF 7.2 Y+40
16 CYCL DEF 10.0 ROTATION
17 CYCL DEF 10.1 ROT+35
18 CALL LBL 1
```



11.7 SCALING (Cycle 11, DIN/ISO: G72)

Effect

The TNC can increase or reduce the size of contours within a program, enabling you to program shrinkage and oversize allowances.

The SCALING FACTOR becomes effective as soon as it is defined in the program. It is also effective in the Positioning with MDI mode of operation. The active scaling factor is shown in the additional status display.

The scaling factor has an effect on

- the working plane, or on all three coordinate axes at the same time (depending on MP 7410)
- dimensions in cycles
- the parallel axes U,V,W

Prerequisite

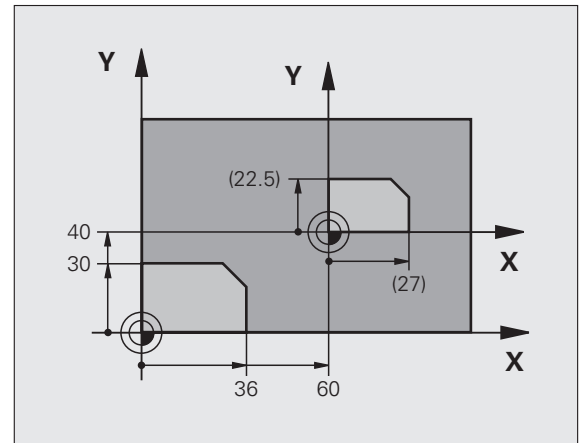
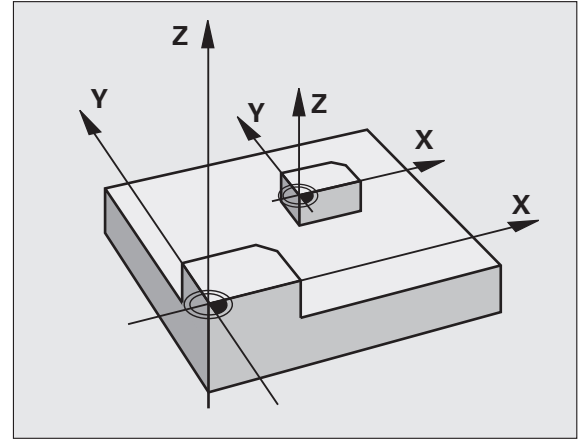
It is advisable to set the datum to an edge or a corner of the contour before enlarging or reducing the contour.

Enlargement: SCL greater than 1 (up to 99.999 999)

Reduction: SCL less than 1 (down to 0.000 001)

Resetting

Program the SCALING FACTOR cycle once again with a scaling factor of 1.



Cycle parameters



- **Scaling factor?:** Enter the scaling factor SCL. The TNC multiplies the coordinates and radii by the SCL factor (as described under “Effect” above). Input range: 0.000000 to 99.999999

Example: NC blocks

```
11 CALL LBL 1
12 CYCL DEF 7.0 DATUM SHIFT
13 CYCL DEF 7.1 X+60
14 CYCL DEF 7.2 Y+40
15 CYCL DEF 11.0 SCALING
16 CYCL DEF 11.1 SCL 0.75
17 CALL LBL 1
```



11.8 AXIS-SPECIFIC SCALING (Cycle 26)

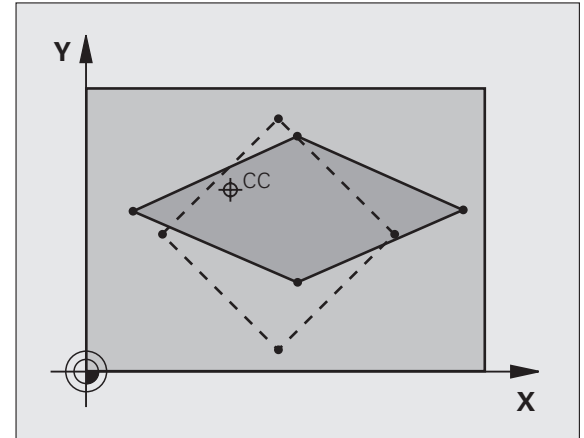
Effect

With Cycle 26 you can account for shrinkage and oversize factors for each axis.

The SCALING FACTOR becomes effective as soon as it is defined in the program. It is also effective in the Positioning with MDI mode of operation. The active scaling factor is shown in the additional status display.

Resetting

Program the SCALING FACTOR cycle once again with a scaling factor of 1 for the same axis.



Please note while programming:



Coordinate axes sharing coordinates for arcs must be enlarged or reduced by the same factor.

You can program each coordinate axis with its own axis-specific scaling factor.

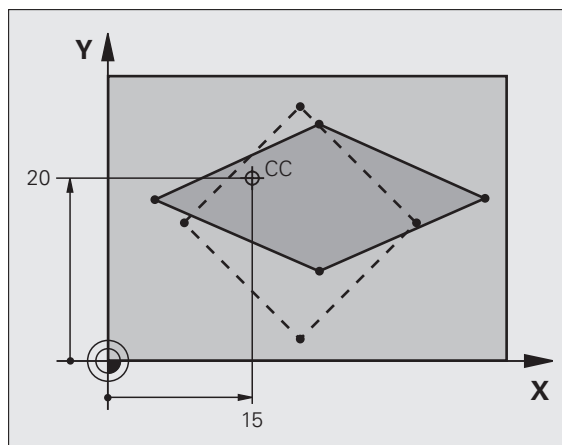
In addition, you can enter the coordinates of a center for all scaling factors.

The size of the contour is enlarged or reduced with reference to the center, and not necessarily (as in Cycle 11 SCALING) with reference to the active datum.

Cycle parameters



- **Axis and scaling factor:** Select the coordinate axis/axes by soft key and enter the factor(s) involved in enlarging or reducing. Input range: 0.000000 to 99.999999
- **Center coordinates:** Enter the center of the axis-specific enlargement or reduction. Input range: -99999.9999 to 99999.9999



Example: NC blocks

```

25 CALL LBL 1
26 CYCL DEF 26.0 AXIS-SPECIFIC SCALING
27 CYCL DEF 26.1 X 1.4 Y 0.6 CCX+15 CCY+20
28 CALL LBL 1
    
```



11.9 WORKING PLANE (Cycle 19, DIN/ISO: G80, software option 1)

Effect

In Cycle 19 you define the position of the working plane—i.e. the position of the tool axis referenced to the machine coordinate system—by entering tilt angles. There are two ways to determine the position of the working plane:

- Enter the position of the rotary axes directly.
- Describe the position of the working plane using up to 3 rotations (spatial angle) of the **fixed machine** coordinate system. The required spatial angle can be calculated by cutting a perpendicular line through the tilted working plane and considering it from the axis around which you wish to tilt. With two spatial angles, every tool position in space can be defined exactly.



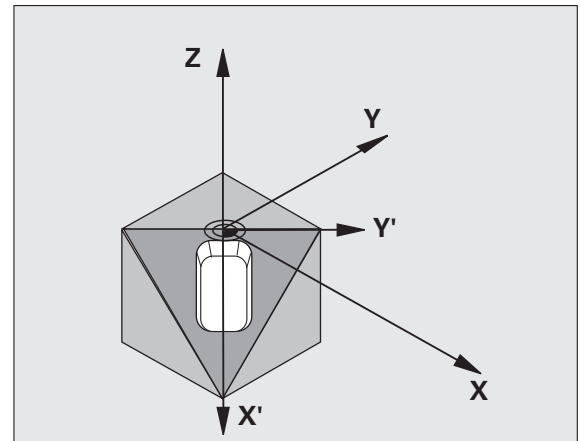
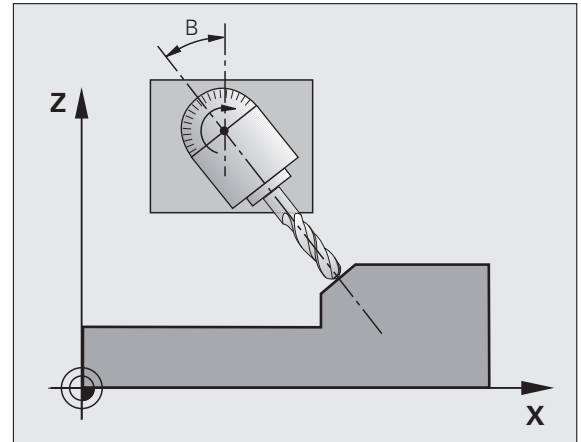
Note that the position of the tilted coordinate system, and therefore also all movements in the tilted system, are dependent on your description of the tilted plane.

If you program the position of the working plane via spatial angles, the TNC will calculate the required angle positions of the tilted axes automatically and will store these in the parameters Q120 (A axis) to Q122 (C axis). If two solutions are possible, the TNC will choose the shorter path from the zero position of the rotary axes.

The axes are always rotated in the same sequence for calculating the tilt of the plane: The TNC first rotates the A axis, then the B axis, and finally the C axis.

Cycle 19 becomes effective as soon as it is defined in the program. As soon as you move an axis in the tilted system, the compensation for this specific axis is activated. You must move all axes to activate compensation for all axes.

If you set the function **Tilting program run** to **Active** in the Manual Operation mode, the angular value entered in this menu is overwritten by Cycle 19 WORKING PLANE.



Please note while programming:



The functions for tilting the working plane are interfaced to the TNC and the machine tool by the machine tool builder. With some swivel heads and tilting tables, the machine tool builder determines whether the entered angles are interpreted as coordinates of the rotary axes or as mathematical angles of a tilted plane. Refer to your machine manual.



Because nonprogrammed rotary axis values are interpreted as unchanged, you should always define all three spatial angles, even if one or more angles are at zero.

The working plane is always tilted around the active datum.

If you use Cycle 19 when M120 is active, the TNC automatically rescinds the radius compensation, which also rescinds the M120 function.

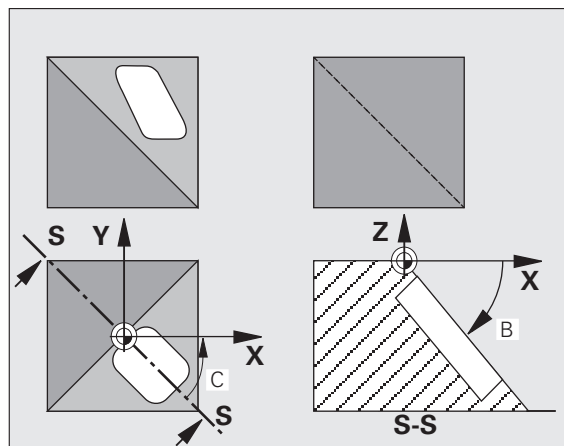
Cycle parameters



- **Rotary axis and tilt angle?:** Enter the axes of rotation together with the associated tilt angles. The rotary axes A, B and C are programmed using soft keys. Input range: -360.000 to 360.000

If the TNC automatically positions the rotary axes, you can enter the following parameters:

- **Feed rate ? F=:** Traverse speed of the rotary axis during automatic positioning. Input range: 0 to 99999.999
- **Setup clearance?** (incremental): The TNC positions the tilting head so that the position that results from the extension of the tool by the setup clearance does not change relative to the workpiece. Input range: 0 to 99999.9999



Resetting

To cancel the tilt angle, redefine the WORKING PLANE cycle and enter an angular value of 0° for all axes of rotation. You must then program the WORKING PLANE cycle once again by answering the dialog question with the NO ENT key to disable the function.



Position the axis of rotation



The machine tool builder determines whether Cycle 19 positions the axes of rotation automatically or whether they must be positioned manually in the program. Refer to your machine manual.

Manual positioning of rotary axes

If the rotary axes are not positioned automatically in Cycle 19, you must position them in a separate L block after the cycle definition.

If you use axis angles, you can define the axis values right in the L block. If you use spatial angles, then use the Q parameters **Q120** (A-axis value), **Q121** (B-axis value) and **Q122** (C-axis value), which are described by Cycle 19.

Example NC blocks:

10 L Z+100 R0 FMAX	
11 L X+25 Y+10 R0 FMAX	
12 CYCL DEF 19.0 WORKING PLANE	Define the spatial angle for calculation of the compensation
13 CYCL DEF 19.1 A+0 B+45 C+0	
14 L A+Q120 C+Q122 R0 F1000	Position the rotary axes by using values calculated by Cycle 19
15 L Z+80 R0 FMAX	Activate compensation for the spindle axis
16 L X-8.5 Y-10 R0 FMAX	Activate compensation for the working plane



For manual positioning, always use the rotary axis positions stored in Q parameters Q120 to Q122.

Avoid using functions, such as M94 (modulo rotary axes), in order to avoid discrepancies between the actual and nominal positions of rotary axes in multiple definitions.



Automatic positioning of rotary axes

If the rotary axes are positioned automatically in Cycle 19:

- The TNC can position only controlled axes
- In order for the tilted axes to be positioned, you must enter a feed rate and a setup clearance in addition to the tilting angles, during cycle definition.
- Use only preset tools (the full tool length must be defined).
- The position of the tool tip as referenced to the workpiece surface remains nearly unchanged after tilting
- The TNC performs the tilt at the last programmed feed rate. The maximum feed rate that can be reached depends on the complexity of the swivel head or tilting table.

Example NC blocks:

10 L Z+100 R0 FMAX	
11 L X+25 Y+10 R0 FMAX	
12 CYCL DEF 19.0 WORKING PLANE	Define the angle for calculation of the compensation
13 CYCL DEF 19.1 A+0 B+45 C+0 F5000 SETUP50	Also define the feed rate and the clearance
14 L Z+80 R0 FMAX	Activate compensation for the spindle axis
15 L X-8.5 Y-10 R0 FMAX	Activate compensation for the working plane



Position display in the tilted system

On activation of Cycle 19, the displayed positions (**ACTL** and **NOML**) and the datum indicated in the additional status display are referenced to the tilted coordinate system. The positions displayed immediately after cycle definition might not be the same as the coordinates of the last programmed position before Cycle 19.

Workspace monitoring

The TNC monitors only those axes in the tilted coordinate system that are moved. If necessary, the TNC outputs an error message.

Positioning in a tilted coordinate system

With the miscellaneous function M130 you can move the tool, while the coordinate system is tilted, to positions that are referenced to the non-tilted coordinate system.

Positioning movements with straight lines that are referenced to the machine coordinate system (blocks with M91 or M92) can also be executed in a tilted working plane. Constraints:

- Positioning is without length compensation.
- Positioning is without machine geometry compensation.
- Tool radius compensation is not permitted.

Combining coordinate transformation cycles

When combining coordinate transformation cycles, always make sure the working plane is swiveled around the active datum. You can program a datum shift before activating Cycle 19. In this case, you are shifting the machine-based coordinate system.

If you program a datum shift after having activated Cycle 19, you are shifting the tilted coordinate system.

Important: When resetting the cycles, use the reverse sequence used for defining them:

- 1st: Activate the datum shift
- 2nd: Activate tilting function
- 3rd: Activate rotation
- ...
- Machining
- ...
- 1st: Reset the rotation
- 2nd: Reset the tilting function
- 3rd: Reset the datum shift

Automatic workpiece measurement in the tilted system

The TNC measuring cycles enable you to have the TNC measure a workpiece in a tilted system automatically. The TNC stores the measured data in Q parameters for further processing (for example, for printout).



Procedure for working with Cycle 19 WORKING PLANE

1 Write the program

- ▶ Define the tool (not required if TOOL.T is active), and enter the full tool length.
- ▶ Call the tool.
- ▶ Retract the tool in the tool axis to a position where there is no danger of collision with the workpiece (clamping devices) during tilting.
- ▶ If required, position the rotary axis or axes with an L block to the appropriate angular value(s) (depending on a machine parameter).
- ▶ Activate datum shift if required.
- ▶ Define Cycle 19 WORKING PLANE; enter the angular values for the rotary axes.
- ▶ Traverse all principal axes (X, Y, Z) to activate compensation.
- ▶ Write the program as if the machining process were to be executed in a non-tilted plane.
- ▶ If required, define Cycle 19 WORKING PLANE with other angular values to execute machining in a different axis position. In this case, it is not necessary to reset Cycle 19. You can define the new angular values directly.
- ▶ Reset Cycle 19 WORKING PLANE; program 0° for all rotary axes.
- ▶ Disable the WORKING PLANE function; redefine Cycle 19 and answer the dialog question with NO ENT.
- ▶ Reset datum shift if required.
- ▶ Position the rotary axes to the 0° position, if required.

2 Clamp the workpiece

3 Preparations in the operating mode Positioning with Manual Data Input (MDI)

Pre-position the rotary axis/axes to the corresponding angular value(s) for setting the datum. The angular value depends on the selected reference plane on the workpiece.

4 Preparations in the operating mode Manual Operation

Use the 3D-ROT soft key to set the function TILT WORKING PLANE to ACTIVE in the Manual Operating mode. For open loop axes, enter the angular values for the rotary axes into the menu.

If the axes are not controlled, the angular values entered in the menu must correspond to the actual position(s) of the rotary axis or axes, respectively. The TNC will otherwise calculate a wrong datum.

5 Datum setting

- Manually by touching the workpiece with the tool in the untilted coordinate system.
- Controlled with a HEIDENHAIN 3-D touch probe (see the Touch Probe Cycles User's Manual, chapter 2).
- Automatically with a HEIDENHAIN 3-D touch probe (see the Touch Probe Cycles User's Manual, chapter 3).

6 Start the part program in the operating mode Program Run, Full Sequence

7 Manual Operation mode

Use the 3-D ROT soft key to set the TILT WORKING PLANE function to INACTIVE. Enter an angular value of 0° for each rotary axis in the menu.

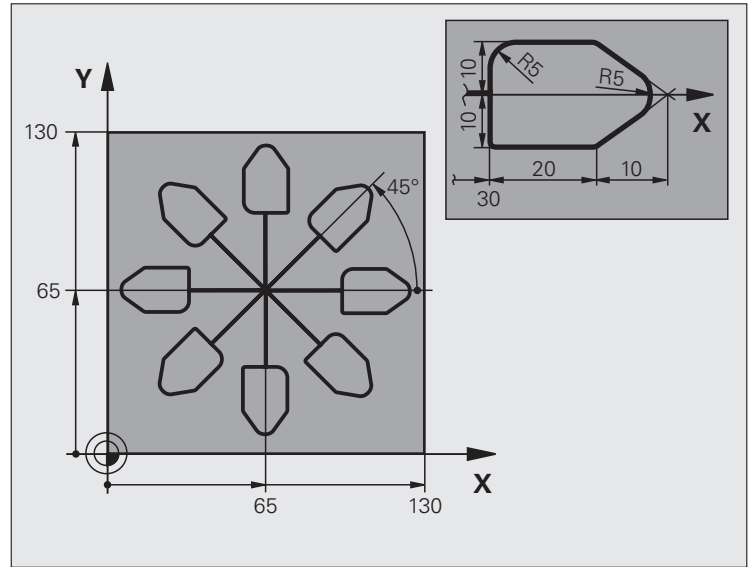


11.10 Programming examples

Example: Coordinate transformation cycles

Program sequence

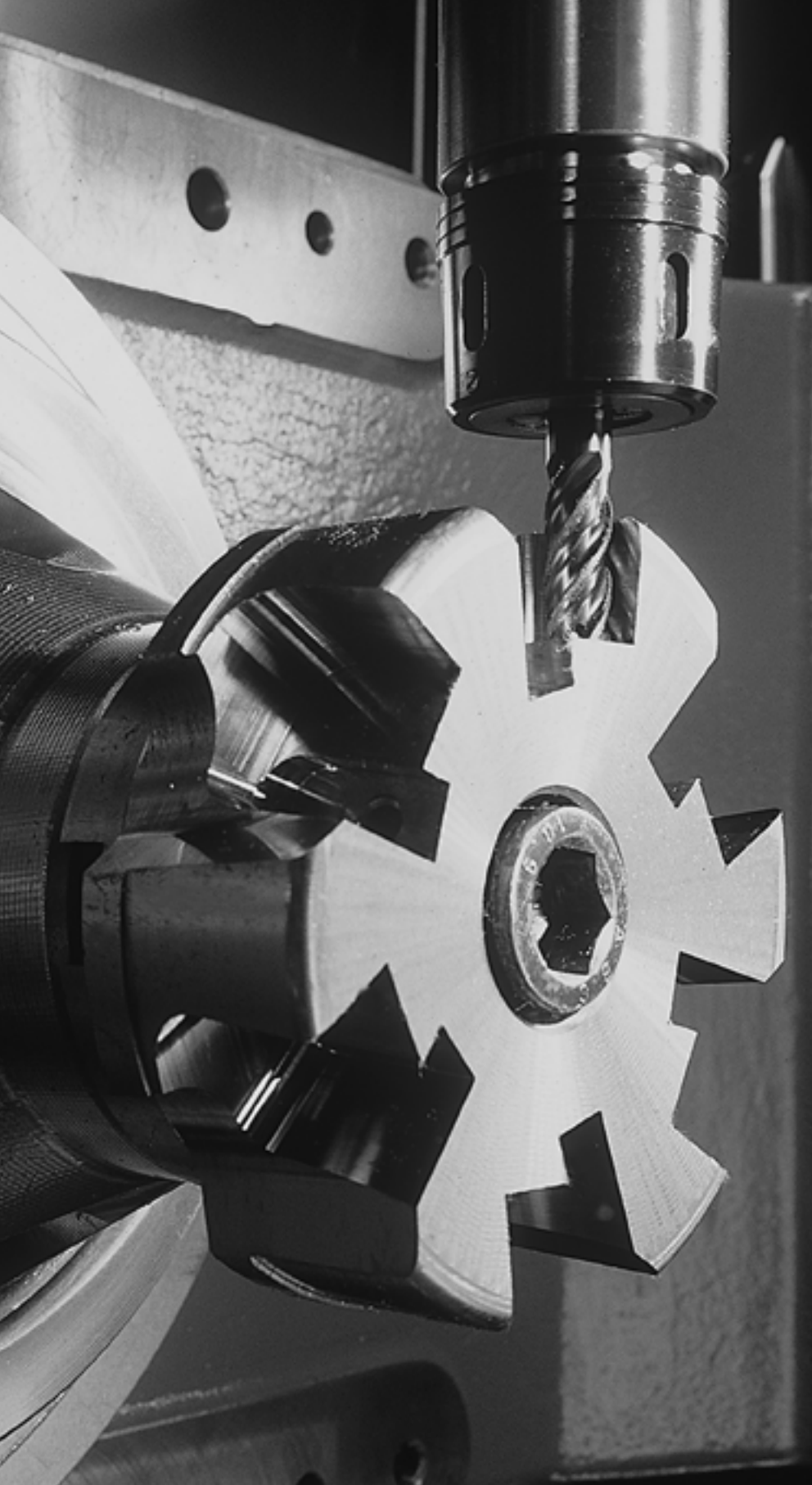
- Program the coordinate transformations in the main program
- Machining within a subprogram



0 BEGIN PGM COTRANS MM	
1 BLK FORM 0.1 Z X+0 Y+0 Z-20	Definition of workpiece blank
2 BLK FORM 0.2 X+130 Y+130 Z+0	
3 TOOL DEF 1 L+0 R+1	Tool definition
4 TOOL CALL 1 Z S4500	Tool call
5 L Z+250 R0 FMAX	Retract the tool
6 CYCL DEF 7.0 DATUM SHIFT	Shift datum to center
7 CYCL DEF 7.1 X+65	
8 CYCL DEF 7.2 Y+65	
9 CALL LBL 1	Call milling operation
10 LBL 10	Set label for program section repeat
11 CYCL DEF 10.0 ROTATION	Rotate by 45° (incremental)
12 CYCL DEF 10.1 IROT+45	
13 CALL LBL 1	Call milling operation
14 CALL LBL 10 REP 6/6	Return jump to LBL 10; repeat the milling operation six times
15 CYCL DEF 10.0 ROTATION	Reset the rotation
16 CYCL DEF 10.1 ROT+0	
17 TRANS DATUM RESET	Reset the datum shift

18 L Z+250 R0 FMAX M2	Retract in the tool axis, end program
19 LBL 1	Subprogram 1
20 L X+0 Y+0 R0 FMAX	Define milling operation
21 L Z+2 R0 FMAX M3	
22 L Z-5 R0 F200	
23 L X+30 RL	
24 L IY+10	
25 RND R5	
26 L IX+20	
27 L IX+10 IY-10	
28 RND R5	
29 L IX-10 IY-10	
30 L IX-20	
31 L IY+10	
32 L X+0 Y+0 R0 F5000	
33 L Z+20 R0 FMAX	
34 LBL 0	
35 END PGM COTRANS MM	





12





**Cycles: Special
Functions**



12.1 Fundamentals

Overview

The TNC provides four cycles for the following special purposes:

Cycle	Soft key	Page
9 DWELL TIME		Page 291
12 PROGRAM CALL		Page 292
13 ORIENTED SPINDLE STOP		Page 294
32 TOLERANCE		Page 295

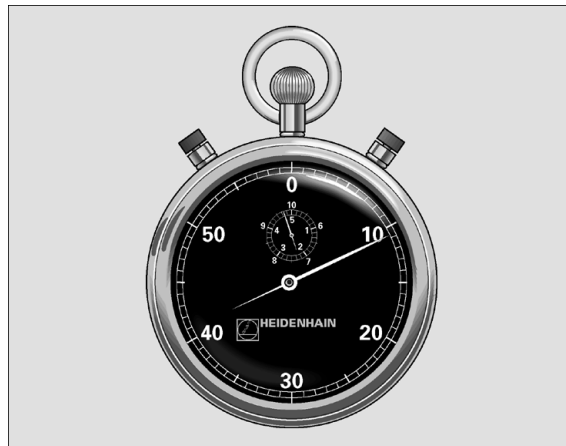


12.2 DWELL TIME (Cycle 9, DIN/ISO: G04)

Function

This causes the execution of the next block within a running program to be delayed by the programmed DWELL TIME. A dwell time can be used for such purposes as chip breaking.

The cycle becomes effective as soon as it is defined in the program. Modal conditions such as spindle rotation are not affected.



Example: NC blocks

```
89 CYCL DEF 9.0 DWELL TIME
```

```
90 CYCL DEF 9.1 DWELL 1.5
```

Cycle parameters

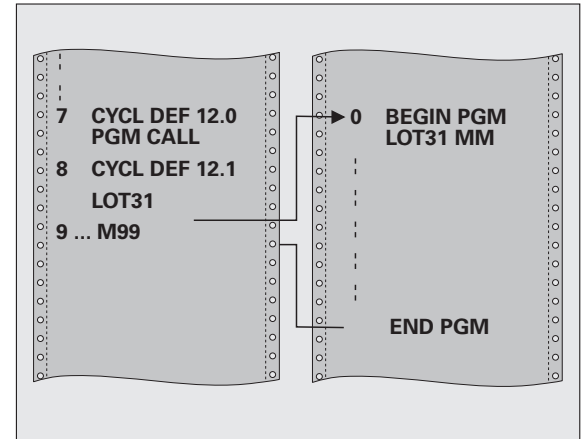


- **Dwell time in seconds:** Enter the dwell time in seconds. Input range: 0 to 3600 s (1 hour) in steps of 0.001 seconds

12.3 PROGRAM CALL (Cycle 12, DIN/ISO: G39)

Cycle function

Routines that you have programmed (such as special drilling cycles or geometrical modules) can be written as main programs and then called like fixed cycles.



Please note while programming:



The program you are calling must be stored on the hard disk of your TNC.

If the program you are defining to be a cycle is located in the same directory as the program you are calling it from, you need only to enter the program name.

If the program you are defining to be a cycle is not located in the same directory as the program you are calling it from, you must enter the complete path (for example **TNC:\KLAR35\FK1\50.H**).

If you want to define an ISO program to be a cycle, enter the file type .I behind the program name.

As a rule, Q parameters are globally effective when called with Cycle 12. So please note that changes to Q parameters in the called program can also influence the calling program.

Cycle parameters

12
PGM
CALL

- **Program name:** Enter the name of the program you want to call and, if necessary, the directory it is located in. A maximum of 254 characters can be entered.

The following functions can be used to call the defined program:

- **CYCL CALL** (separate block), or
- **CYCL CALL POS** (separate block), or
- **M99** (blockwise) or
- **M89** (executed after every positioning block)

Example: Designate program 50 as a cycle and call it with M99

```
55 CYCL DEF 12.0 PGM CALL
```

```
56 CYCL DEF 12.1 PGM TNC:\KLAR35\FK1\50.H
```

```
57 L X+20 Y+50 FMAX M99
```

12.4 ORIENTED SPINDLE STOP (Cycle 13, DIN/ISO: G36)

Cycle function



Machine and TNC must be specially prepared by the machine tool builder for use of this cycle.

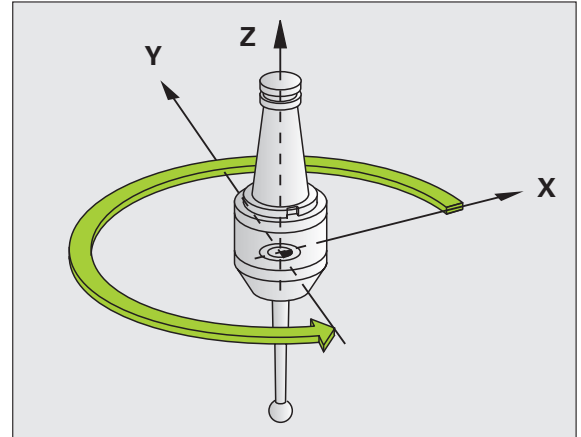
The TNC can control the machine tool spindle and rotate it to a given angular position.

Oriented spindle stops are required for

- Tool changing systems with a defined tool change position
- Orientation of the transmitter/receiver window of HEIDENHAIN 3-D touch probes with infrared transmission

The angle of orientation defined in the cycle is positioned to by entering M19 or M20 (depending on the machine).

If you program M19 or M20 without having defined Cycle 13, the TNC positions the machine tool spindle to an angle that has been set by the machine manufacturer (see your machine manual).



Example: NC blocks

```
93 CYL DEF13.0 ORIENTATION
```

```
94 CYCL DEF 13.1 ANGLE 180
```

Please note while programming:



Cycle 13 is used internally for machining cycles 202, 204 and 209. Please note that, if required, you must program Cycle 13 again in your NC program after one of the machining cycles mentioned above.

Cycle parameters



- **Angle of orientation:** Enter the angle referenced to the reference axis of the working plane. Input range: 0.0000° to 360.0000°

12.5 TOLERANCE (Cycle 32, DIN/ISO: G62)

Cycle function



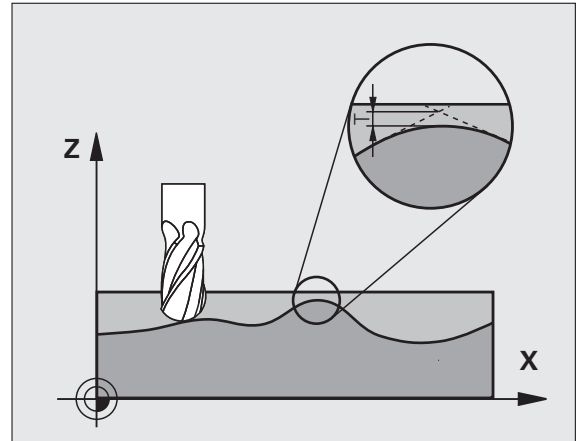
Machine and TNC must be specially prepared by the machine tool builder for use of this cycle.

With the entries in Cycle 32 you can influence the result of HSC machining with respect to accuracy, surface definition and speed, inasmuch as the TNC has been adapted to the machine's characteristics.

The TNC automatically smoothens the contour between two path elements (whether compensated or not). The tool has constant contact with the workpiece surface and therefore reduces wear on the machine tool. The tolerance defined in the cycle also affects the traverse paths on circular arcs.

If necessary, the TNC automatically reduces the programmed feed rate so that the program can be machined at the fastest possible speed without short pauses for computing time. **Even if the TNC does not move with reduced speed, it will always comply with the tolerance that you have defined.** The larger you define the tolerance, the faster the TNC can move the axes.

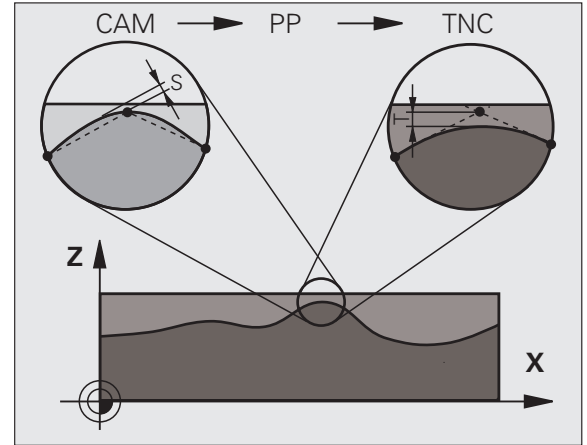
Smoothing the contour results in a certain amount of deviation from the contour. The size of this contour error **tolerance value** is set in a machine parameter by the machine manufacturer. With **CYCLE 32**, you can change the pre-set tolerance value and select different filter settings, provided that your machine manufacturer implements these features.



Influences of the geometry definition in the CAM system

The most important factor of influence in offline NC program creation is the chord error S defined in the CAM system. The maximum point spacing of NC programs generated in a postprocessor (PP) is defined through the chord error. If the chord error is less than or equal to the tolerance value T defined in Cycle 32, then the TNC can smooth the contour points unless any special machine settings limit the programmed feed rate.

You will achieve optimal smoothing if in Cycle 32 you choose a tolerance value between 110% and 200% of the CAM chord error.



Please note while programming:

With very small tolerance values the machine cannot cut the contour without jerking. These jerking movements are not caused by poor processing power in the TNC, but by the fact that, in order to machine the contour element transitions very exactly, the TNC might have to drastically reduce the speed.

Cycle 32 is DEF active which means that it becomes effective as soon as it is defined in the part program.

The TNC resets Cycle 32 if you

- Redefine it and confirm the dialog question for the **tolerance value** with NO ENT.
- Select a new program with the PGM MGT key.

After you have reset Cycle 32, the TNC reactivates the tolerance that was predefined by machine parameter.

In a program with millimeters set as unit of measure, the TNC interprets the entered tolerance value in millimeters. In an inch program it interprets it as inches.

If you transfer a program with Cycle 32 that contains only the cycle parameter **Tolerance value T**, the TNC inserts the two remaining parameters with the value 0 if required.

As the tolerance value increases, the diameter of circular movements usually decreases. If the HSC filter is active on your machine (ask your machine manufacturer, if necessary), the circle can also become larger.

If Cycle 32 is active, the TNC shows the parameters defined for Cycle 32 on the **CYC** tab of the additional status display.



Cycle parameters



- ▶ **Tolerance value T:** Permissible contour deviation in mm (or inches with inch programming) Input range: 0 to 99999.9999
- ▶ **HSC MODE, Finishing=0, Roughing=1:** Activate filter:
 - Input value 0:
Milling with increased contour accuracy. The TNC uses the filter settings that your machine tool builder has defined for finishing operations.
 - Input value 1:
Milling at an increased feed rate. The TNC uses the filter settings that your machine tool builder has defined for roughing operations. The TNC works with optimal smoothing of the contour points, which results in a reduction of the machining time
- ▶ **Tolerance for rotary axes TA:** Permissible position error of rotary axes in degrees when M128 is active. The TNC always reduces the feed rate in such a way that—if more than one axis is traversed—the slowest axis moves at its maximum feed rate. Rotary axes are usually much slower than linear axes. You can significantly reduce the machining time for programs for more than one axis by entering a large tolerance value (e.g. 10°), since the TNC does not always have to move the rotary axis to the given nominal position. The contour will not be damaged by entering a rotary axis tolerance value. Only the position of the rotary axis with respect to the workpiece surface will change. Input range: 0 to 179.9999



The **HSC MODE** and **TA** parameters are only available if on your machine you have software option 2 active (HSC machining).

Example: NC blocks

```
95 CYCL DEF 32.0 TOLERANCE
96 CYCL DEF 32.1 T0.05
97 CYC DEF 32.2 HSC MODE:1 TA5
```





13

**Using Touch Probe
Cycles**



13.1 General Information about Touch Probe Cycles



The TNC must be specially prepared by the machine tool builder for the use of a 3-D touch probe. The machine tool manual provides further information.



If you are carrying out measurements during program run, be sure that the tool data (length, radius) can be used from the calibrated data or from the last **TOOL CALL** block (selected with MP7411).

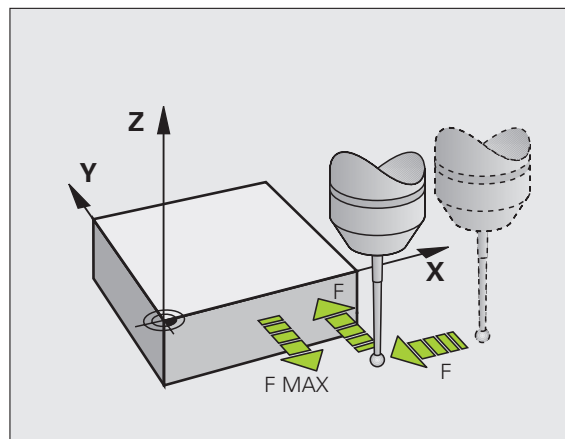
Method of function

Whenever the TNC runs a touch probe cycle, the 3-D touch probe approaches the workpiece in one linear axis. This is also true during an active basic rotation or with a tilted working plane. The machine tool builder determines the probing feed rate in a machine parameter (see "Before You Start Working with Touch Probe Cycles" later in this chapter).

When the probe stylus contacts the workpiece,

- the 3-D touch probe transmits a signal to the TNC: the coordinates of the probed position are stored,
- the touch probe stops moving, and
- returns to its starting position at rapid traverse.

If the stylus is not deflected within a distance defined in MP 6130, the TNC displays an error message.



Cycles in the Manual and El. Handwheel Modes

In the Manual Operation and El. Handwheel modes, the TNC provides touch probe cycles that allow you to:

- Calibrate the touch probe
- Compensate workpiece misalignment
- Set reference points

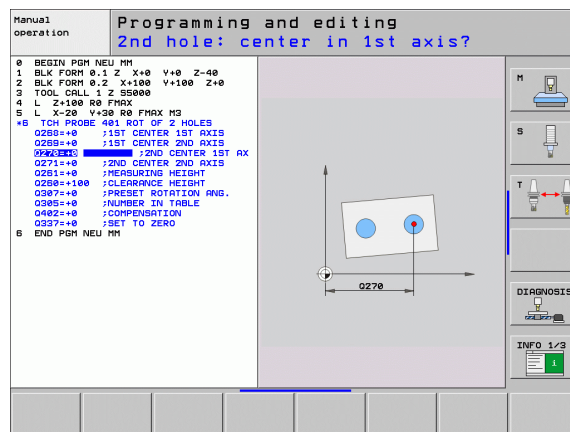
Touch probe cycles for automatic operation

Besides the touch probe cycles, which you can use in the Manual and El. Handwheel modes, the TNC provides numerous cycles for a wide variety of applications in automatic mode:

- Calibrating the touch probe (Chapter 3)
- Compensating workpiece misalignment (Chapter 3)
- Setting reference points (Chapter 3)
- Automatic workpiece inspection (Chapter 3)
- Automatic workpiece measurement (Chapter 4)

You can program the touch probe cycles in the Programming and Editing operating mode via the TOUCH PROBE key. Like the most recent canned cycles, touch probe cycles with numbers greater than 400 use Q parameters as transfer parameters. Parameters with specific functions that are required in several cycles always have the same number: For example, Q260 is always assigned the clearance height, Q261 the measuring height, etc.

To simplify programming, the TNC shows a graphic during cycle definition. In the graphic, the parameter that needs to be entered is highlighted (see figure at right).



Defining the touch probe cycle in the Programming and Editing mode of operation



- ▶ The soft-key row shows all available touch probe functions divided into groups.
- ▶ Select the desired probe cycle, for example datum setting. Cycles for automatic tool measurement are available only if your machine has been prepared for them.
- ▶ Select a cycle, e.g. datum setting at pocket. The TNC initiates the programming dialog and asks for all required input values. At the same time a graphic of the input parameters is displayed in the right screen window. The parameter that is asked for in the dialog prompt is highlighted.
- ▶ Enter all parameters requested by the TNC and conclude each entry with the ENT key.
- ▶ The TNC ends the dialog when all required data has been entered.

Group of measuring cycles	Soft key	Page
Cycles for automatic measurement and compensation of workpiece misalignment		Page 308
Cycles for automatic workpiece presetting		Page 330
Cycles for automatic workpiece inspection		Page 384
Calibration cycles, special cycles		Page 434
Cycles for automatic kinematics measurement		Page 448
Cycles for automatic tool measurement (enabled by the machine tool builder)		Page 478

Example: NC blocks

5 TCH PROBE 410 DATUM INSIDE RECTAN.
Q321=+50 ;CENTER IN 1ST AXIS
Q322=+50 ;CENTER IN 2ND AXIS
Q323=60 ;FIRST SIDE LENGTH
Q324=20 ;2ND SIDE LENGTH
Q261=-5 ;MEASURING HEIGHT
Q320=0 ;SETUP CLEARANCE
Q260=+20 ;CLEARANCE HEIGHT
Q301=0 ;MOVE TO CLEARANCE
Q305=10 ;NO. IN TABLE
Q331=+0 ;DATUM
Q332=+0 ;DATUM
Q303=+1 ;MEAS. VALUE TRANSFER
Q381=1 ;PROBE IN TS AXIS
Q382=+85 ;1ST CO. FOR TS AXIS
Q383=+50 ;2ND CO. FOR TS AXIS
Q384=+0 ;3RD CO. FOR TS AXIS
Q333=+0 ;DATUM



13.2 Before You Start Working with Touch Probe Cycles

To make it possible to cover the widest possible range of applications, machine parameters enable you to determine the behavior common to all touch probe cycles:

Maximum traverse to touch point: MP6130

If the stylus is not deflected within the path defined in MP6130, the TNC outputs an error message.

Safety clearance to touch point: MP6140

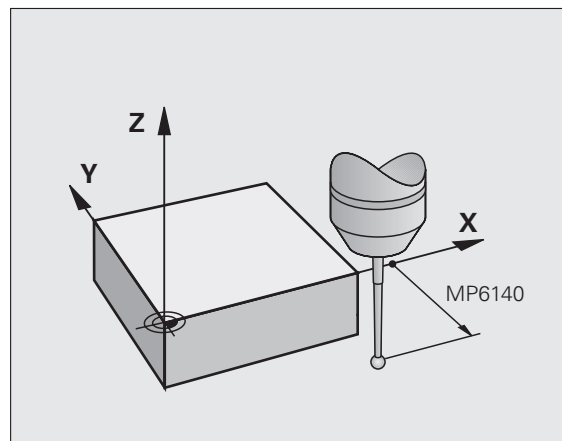
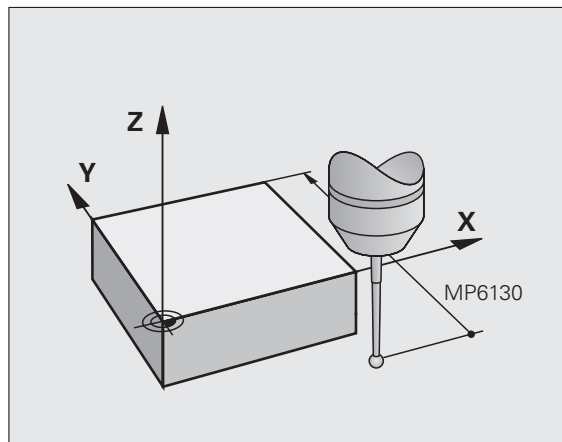
In MP6140 you define how far from the defined (or calculated) touch point the TNC is to pre-position the touch probe. The smaller the value you enter, the more exactly must you define the touch point position. In many touch probe cycles you can also define a setup clearance in addition that is added to Machine Parameter 6140.

Orient the infrared touch probe to the programmed probe direction: MP6165

To increase measuring accuracy, you can use $MP\ 6165 = 1$ to have an infrared touch probe oriented in the programmed probe direction before every probe process. In this way the stylus is always deflected in the same direction.



If you change MP6165, you must recalibrate the touch probe, because its deflection behavior changes.



Consider a basic rotation in the Manual Operation mode: MP6166

Set MP 6166 = 1 for the TNC to consider an active basic rotation during the probing process (the workpiece is approached along an angular path if required) to ensure that the measuring accuracy for probing individual positions is also increased in Setup mode.



This feature is not active during the following functions in the Manual Operation mode:

- Calibrate length
- Calibrate radius
- Measure basic rotation

Multiple measurement: MP6170

To increase measuring certainty, the TNC can run each probing process up to three times in sequence. If the measured position values differ too greatly, the TNC outputs an error message (the limit value is defined in MP6171). With multiple measurement it is possible to detect random errors, e.g., from contamination.

If the measured values lie within the confidence interval, the TNC saves the mean value of the measured positions.

Confidence interval for multiple measurement: MP6171

In MP6171 you store the value by which the results may differ when you make multiple measurements. If the difference in the measured values exceeds the value in MP6171, the TNC outputs an error message.

Touch trigger probe, probing feed rate: MP6120

In MP6120 you define the feed rate at which the TNC is to probe the workpiece.

Touch trigger probe, rapid traverse for positioning: MP6150

In MP6150 you define the feed rate at which the TNC pre-positions the touch probe, or positions it between measuring points.

Touch trigger probe, rapid traverse for positioning: MP6151

In MP6151 you define whether the TNC is to position the touch probe at the feed rate defined in MP6150 or at rapid traverse.

- Input value = 0: Position at feed rate from MP6150
- Input value = 1: Pre-position at rapid traverse

KinematicsOpt: Tolerance limit in Optimization mode: MP6600

In **MP6600** you define the tolerance limit starting from which the TNC displays a note in the Optimizing mode when the measured kinematic data is greater than this limit value. The default value is 0.05. The larger the machine, the greater these values should be.

- Input range: 0.001 to 0.999

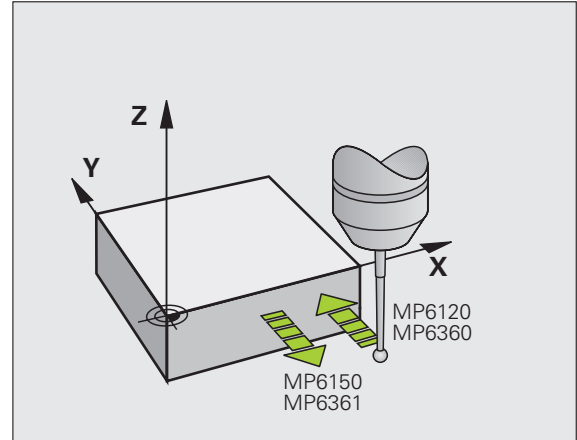
KinematicsOpt, permissible deviation of the calibration ball radius: MP6601

In **MP6601** you define the maximum permissible deviation from the entered cycle parameter by the calibration ball radius measured in the cycles.

- Input range: 0.01 to 0.1

The TNC calculates the calibration ball radius twice at every measuring point for all 5 touch points. If the radius is greater than $Q407 + MP6601$ an error message appears because it could be contamination.

If the radius found by the TNC is less than $5 * (Q407 - MP6601)$, the TNC also issues an error message.



Executing touch probe cycles

All touch probe cycles are DEF active. This means that the TNC runs the cycle automatically as soon as the TNC executes the cycle definition in the program run.



Make sure that at the beginning of the cycle the compensation data (length, radius) from the calibrated data or from the last TOOL CALL block are active (selection via MP7411, see the User's Manual of the iTNC530, "General User Parameters").

You can also run the Touch Probe Cycles 408 to 419 during an active basic rotation. Make sure, however, that the basic rotation angle does not change when you use Cycle 7 DATUM SHIFT with datum tables after the measuring cycle.

Touch probe cycles with a number greater than 400 position the touch probe according to a positioning logic:

- If the current coordinate of the south pole of the stylus is less than the coordinate of the clearance height (defined in the cycle), the TNC retracts the touch probe in the probe axis to the clearance height and then positions it in the working plane to the first starting position.
- If the current coordinate of the south pole of the stylus is greater than the coordinate of the clearance height, the TNC first positions the probe in the working plane to the first starting position and then moves it immediately to the measuring height in the touch probe axis.



14







**Touch Probe Cycles:
Automatic Measurement
of Workpiece
Misalignment**



14.1 Fundamentals

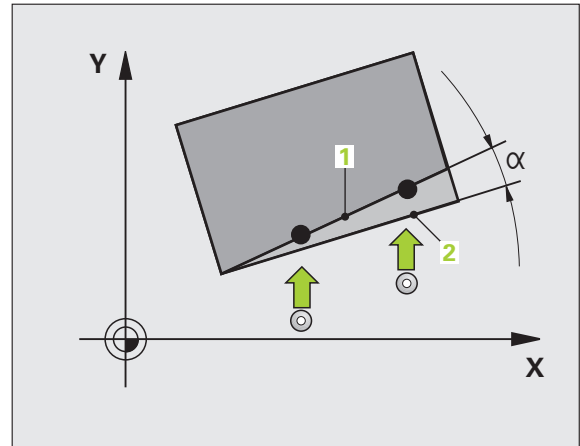
Overview

The TNC provides five cycles that enable you to measure and compensate workpiece misalignment. In addition, you can reset a basic rotation with Cycle 404:

Cycle	Soft key	Page
400 BASIC ROTATION Automatic measurement using two points. Compensation via basic rotation.		Page 310
401 ROT OF 2 HOLES Automatic measurement using two holes. Compensation via basic rotation.		Page 313
402 ROT OF 2 STUDS Automatic measurement using two studs. Compensation via basic rotation.		Page 316
403 ROT IN ROTARY AXIS Automatic measurement using two points. Compensation by turning the table.		Page 319
405 ROT IN C AXIS Automatic alignment of an angular offset between a hole center and the positive Y axis. Compensation via table rotation.		Page 323
404 SET BASIC ROTATION Setting any basic rotation.		Page 322

Characteristics common to all touch probe cycles for measuring workpiece misalignment

For Cycles 400, 401 and 402 you can define through parameter Q307 **Default setting for basic rotation** whether the measurement result is to be corrected by a known angle α (see figure at right). This enables you to measure the basic rotation against any straight line **1** of the workpiece and to establish the reference to the actual 0° direction **2**.

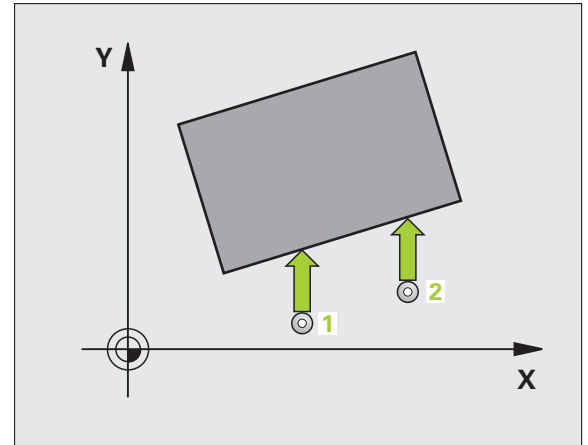


14.2 BASIC ROTATION (Cycle 400, DIN/ISO: G400)

Cycle run

Touch probe cycle 400 determines a workpiece misalignment by measuring two points, which must lie on a straight surface. With the basic rotation function the TNC compensates the measured value.

- 1 Following the positioning logic (see "Executing touch probe cycles" on page 306), the TNC positions the touch probe to the programmed starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC offsets the touch probe by the safety clearance in the direction opposite the defined traverse direction.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360).
- 3 Then the touch probe moves to the next starting position **2** and probes the second position.
- 4 The TNC returns the touch probe to the clearance height and performs the basic rotation.



Please note while programming:



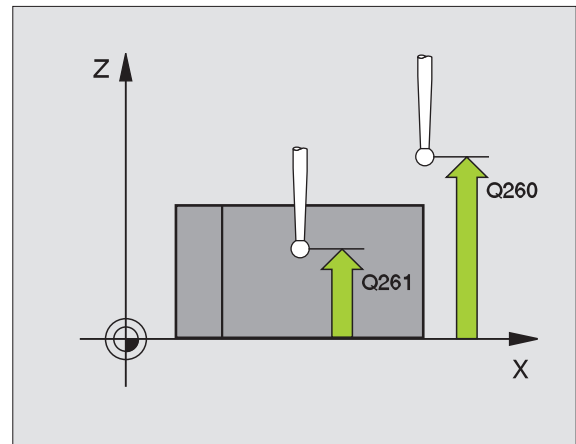
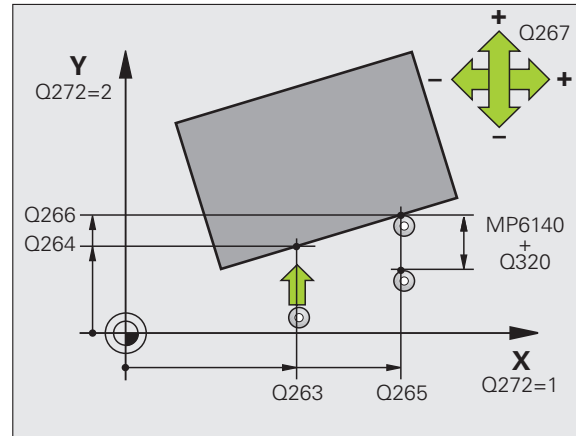
Before a cycle definition you must have programmed a tool call to define the touch probe axis.

The TNC will reset an active basic rotation at the beginning of the cycle.

Cycle parameters



- ▶ **1st meas. point 1st axis** Q263 (absolute):
Coordinate of the first touch point in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **1st meas. point 2nd axis** Q264 (absolute):
Coordinate of the first touch point in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **2nd meas. point 1st axis** Q265 (absolute):
Coordinate of the second touch point in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **2nd meas. point 2nd axis** Q266 (absolute):
Coordinate of the second touch point in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Measuring axis** Q272: Axis in the working plane in which the measurement is to be made:
 - 1:**Reference axis = measuring axis
 - 2:**Minor axis = measuring axis
- ▶ **Traverse direction 1** Q267: Direction in which the probe is to approach the workpiece:
 - 1:**Negative traverse direction
 - +1:**Positive traverse direction
- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**



- ▶ **Traversing to clearance height** Q301: Definition of how the touch probe is to move between the measuring points:
0: Move at measuring height between measuring points
1: Move at clearance height between measuring points
Alternatively **PREDEF**
- ▶ **Default setting for basic rotation** Q307
(absolute): If the misalignment is to be measured against a straight line other than the reference axis, enter the angle of this reference line. The TNC will then calculate the difference between the value measured and the angle of the reference line for the basic rotation. Input range: -360.000 to 360.000
- ▶ **Preset number in table** Q305: Enter the preset number in the table in which the TNC is to save the determined basic rotation. If you enter Q305=0, the TNC automatically places the determined basic rotation in the ROT menu of the Manual Operation mode. Input range: 0 to 2999

Example: NC blocks

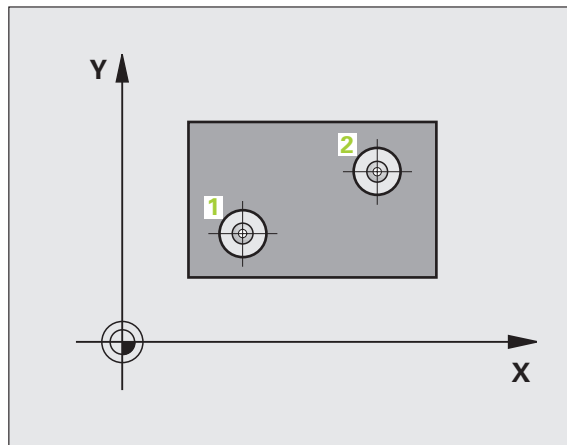
5 TCH PROBE 400 BASIC ROTATION	
Q263=+10	;1ST POINT 1ST AXIS
Q264=+3,5	;1ST POINT 2ND AXIS
Q265=+25	;2ND POINT 1ST AXIS
Q266=+2	;2ND POINT 2ND AXIS
Q272=2	;MEASURING AXIS
Q267=+1	;TRAVERSE DIRECTION
Q261=-5	;MEASURING HEIGHT
Q320=0	;SETUP CLEARANCE
Q260=+20	;CLEARANCE HEIGHT
Q301=0	;MOVE TO CLEARANCE
Q307=0	;PRESET BASIC ROTATION
Q305=0	;NO. IN TABLE

14.3 BASIC ROTATION from two holes (Cycle 401, DIN/ISO: G401)

Cycle run

The Touch Probe Cycle 401 measures the centers of two holes. Then the TNC calculates the angle between the reference axis in the working plane and the line connecting the two hole centers. With the basic rotation function, the TNC compensates the calculated value. As an alternative, you can also compensate the determined misalignment by rotating the rotary table.

- 1 Following the positioning logic (see "Executing touch probe cycles" on page 306), the TNC positions the touch probe at rapid traverse (value from MP6150 or MP6361) to the point entered as center of the first hole **1**.
- 2 Then the probe moves to the entered measuring height and probes four points to find the first hole center.
- 3 The touch probe returns to the clearance height and then to the position entered as center of the second hole **2**.
- 4 The TNC moves the touch probe to the entered measuring height and probes four points to find the second hole center.
- 5 Then the TNC returns the touch probe to the clearance height and performs the basic rotation.



Please note while programming:



Before a cycle definition you must have programmed a tool call to define the touch probe axis.

The TNC will reset an active basic rotation at the beginning of the cycle.

This touch probe cycle is not allowed when the tilted working plane function is active.

If you want to compensate the misalignment by rotating the rotary table, the TNC will automatically use the following rotary axes:

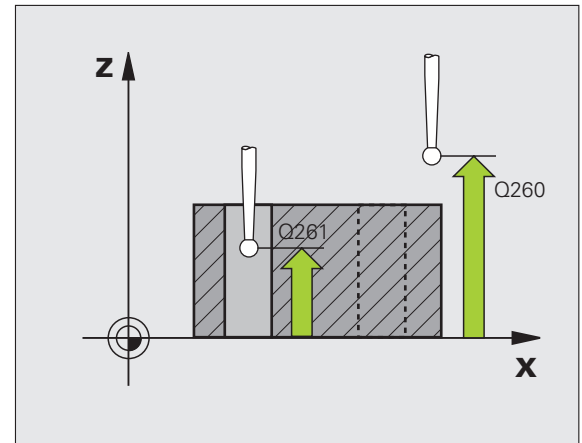
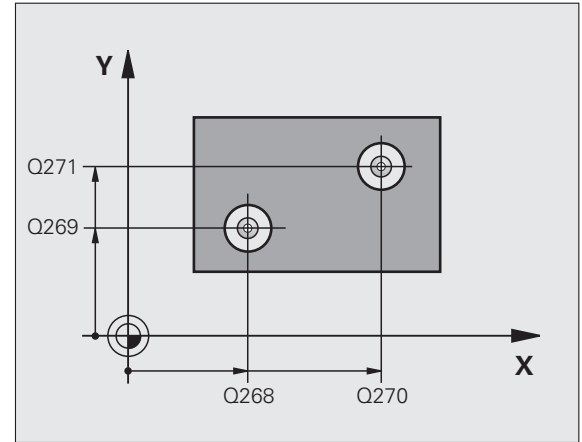
- C for tool axis Z
- B for tool axis Y
- A for tool axis X



Cycle parameters



- ▶ **1st hole: Center in 1st axis Q268** (absolute):
Center of the first hole in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **1st hole: Center in 2nd axis Q269** (absolute):
Center of the first hole in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **2nd hole: Center in 1st axis Q270** (absolute):
Center of the second hole in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **2nd hole: Center in 2nd axis Q271** (absolute):
Center of the second hole in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Measuring height in the touch probe axis Q261** (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Clearance height Q260** (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Default setting for basic rotation Q307** (absolute): If the misalignment is to be measured against a straight line other than the reference axis, enter the angle of this reference line. The TNC will then calculate the difference between the value measured and the angle of the reference line for the basic rotation. Input range: -360.000 to 360.000



- **Preset number in table Q305:** Enter the preset number in the table in which the TNC is to save the determined basic rotation. If you enter Q305=0, the TNC automatically places the determined basic rotation in the ROT menu of the Manual Operation mode. The parameter has no effect if the misalignment is to be compensated by a rotation of the rotary table (**Q402=1**). In this case the misalignment is not saved as an angular value. Input range: 0 to 2999
- **Basic rotation / alignment Q402:** Specify whether the TNC should compensate misalignment with a basic rotation, or by rotating the rotary table:
 - 0:** Set basic rotation
 - 1:** Rotate the rotary table
 When you select rotary table, the TNC does not save the measured misalignment, not even when you have defined a table line in parameter **Q305**.
- **Set to zero after alignment Q337:** Definition of whether the TNC should set the display of the aligned rotary axis to zero:
 - 0:** Do not reset the display of the rotary axis to 0 after alignment
 - 1:** Reset the display of the rotary axis to 0 after alignment
 The TNC sets the display to 0 only if you have defined **Q402=1**.

Example: NC blocks

5 TCH PROBE 401 ROT OF 2 HOLES	
Q268=-37	;1ST CENTER IN 1ST AXIS
Q269=+12	;1ST CENTER IN 2ND AXIS
Q270=+75	;2ND CENTER IN 1ST AXIS
Q271=+20	;2ND CENTER IN 2ND AXIS
Q261=-5	;MEASURING HEIGHT
Q260=+20	;CLEARANCE HEIGHT
Q307=0	;PRESET BASIC ROTATION
Q305=0	;NO. IN TABLE
Q402=0	;ALIGNMENT
Q337=0	;SET TO ZERO

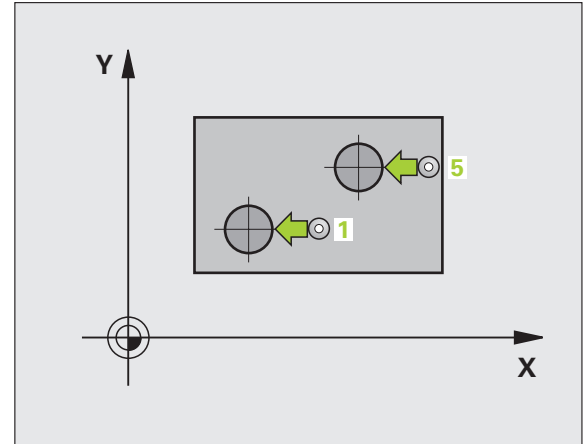


14.4 BASIC ROTATION over two studs (Cycle 402, DIN/ISO: G402)

Cycle run

The Touch Probe Cycle 402 measures the centers of two studs. Then the TNC calculates the angle between the reference axis in the working plane and the line connecting the two stud centers. With the basic rotation function, the TNC compensates the calculated value. As an alternative, you can also compensate the determined misalignment by rotating the rotary table.

- 1 Following the positioning logic (see "Executing touch probe cycles" on page 306), the TNC positions the touch probe in rapid traverse (value from MP6150 or MP6361) to the starting point for probing the first stud **1**.
- 2 Then the probe moves to the entered **measuring height 1** and probes four points to find the center of the first stud. The touch probe moves on a circular arc between the touch points, each of which is offset by 90°.
- 3 The touch probe returns to the clearance height and then to the starting point for probing **5** the second stud.
- 4 The TNC moves the touch probe to the entered **measuring height 2** and probes four points to find the center of the second stud.
- 5 Then the TNC returns the touch probe to the clearance height and performs the basic rotation.



Please note while programming:



Before a cycle definition you must have programmed a tool call to define the touch probe axis.

The TNC will reset an active basic rotation at the beginning of the cycle.

This touch probe cycle is not allowed when the tilted working plane function is active.

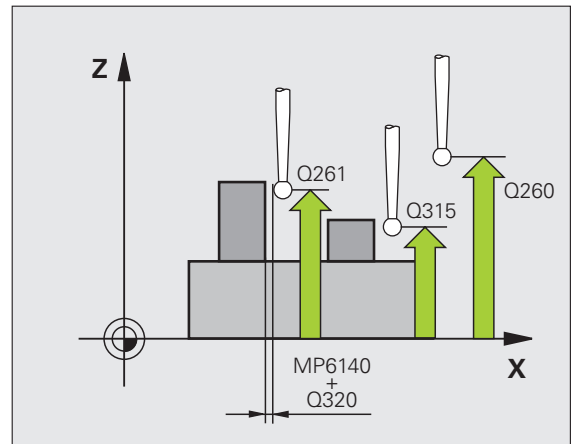
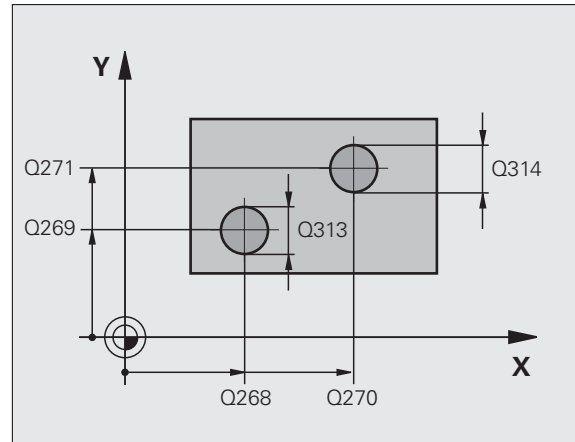
If you want to compensate the misalignment by rotating the rotary table, the TNC will automatically use the following rotary axes:

- C for tool axis Z
- B for tool axis Y
- A for tool axis X

Cycle parameters



- ▶ **1st stud: Center in 1st axis** (absolute): Center of the first stud in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **1st stud: Center in 2nd axis** Q269 (absolute): Center of the first stud in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Diameter of stud 1** Q313: Approximate diameter of the 1st stud. Enter a value that is more likely to be too large than too small. Input range: 0 to 99999.9999
- ▶ **Measuring height 1 in the probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point in the touch probe axis) at which stud 1 is to be measured. Input range: -99999.9999 to 99999.9999
- ▶ **2nd stud: Center in 1st axis** Q270 (absolute): Center of the second stud in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **2nd stud: Center in 2nd axis** Q271 (absolute): Center of the second stud in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Diameter of stud 2** Q314: Approximate diameter of the 2nd stud. Enter a value that is more likely to be too large than too small. Input range: 0 to 99999.9999
- ▶ **Measuring height 2 in the probe axis** Q315 (absolute): Coordinate of the ball tip center (= touch point in the touch probe axis) at which stud 2 is to be measured. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**



- ▶ **Traversing to clearance height** Q301: Definition of how the touch probe is to move between the measuring points:
0: Move at measuring height between measuring points
1: Move at clearance height between measuring points
Alternatively **PREDEF**
- ▶ **Default setting for basic rotation** Q307 (absolute): If the misalignment is to be measured against a straight line other than the reference axis, enter the angle of this reference line. The TNC will then calculate the difference between the value measured and the angle of the reference line for the basic rotation. Input range: -360.000 to 360.000
- ▶ **Preset number in table** Q305: Enter the preset number in the table in which the TNC is to save the determined basic rotation. If you enter Q305=0, the TNC automatically places the determined basic rotation in the ROT menu of the Manual Operation mode. The parameter has no effect if the misalignment is to be compensated by a rotation of the rotary table (**Q402=1**). In this case the misalignment is not saved as an angular value. Input range: 0 to 2999
- ▶ **Basic rotation / alignment** Q402: Specify whether the TNC should compensate misalignment with a basic rotation, or by rotating the rotary table:
0: Set basic rotation
1: Rotate the rotary table
When you select rotary table, the TNC does not save the measured misalignment, not even when you have defined a table line in parameter **Q305**.
- ▶ **Set to zero after alignment** Q337: Definition of whether the TNC should set the display of the aligned rotary axis to zero:
0: Do not reset the display of the rotary axis to 0 after alignment
1: Reset the display of the rotary axis to 0 after alignment
The TNC sets the display to 0 only if you have defined **Q402=1**.

Example: NC blocks

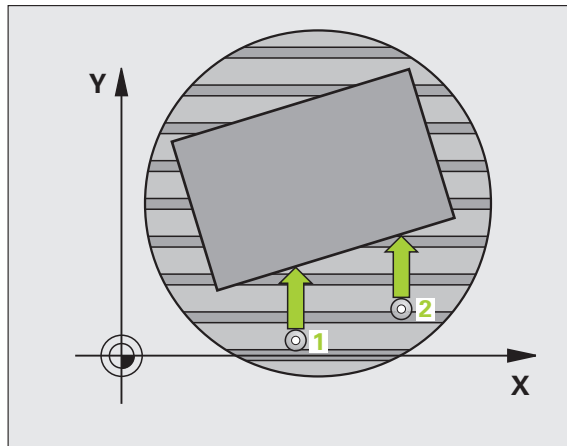
5 TCH PROBE 402 ROT OF 2 STUDS	
Q268=-37	;1ST CENTER IN 1ST AXIS
Q269=+12	;1ST CENTER IN 2ND AXIS
Q313=60	;DIAMETER OF STUD 1
Q261=-5	;MEASURING HEIGHT 1
Q270=+75	;2ND CENTER IN 1ST AXIS
Q271=+20	;2ND CENTER IN 2ND AXIS
Q314=60	;DIAMETER OF STUD 2
Q315=-5	;MEASURING HEIGHT 2
Q320=0	;SETUP CLEARANCE
Q260=+20	;CLEARANCE HEIGHT
Q301=0	;MOVE TO CLEARANCE
Q307=0	;PRESET BASIC ROTATION
Q305=0	;NO. IN TABLE
Q402=0	;ALIGNMENT
Q337=0	;SET TO ZERO

14.5 BASIC ROTATION compensation via rotary axis (Cycle 403, DIN/ISO: G403)

Cycle run

Touch Probe Cycle 403 determines a workpiece misalignment by measuring two points, which must lie on a straight surface. The TNC compensates the determined misalignment by rotating the A, B or C axis. The workpiece can be clamped in any position on the rotary table.

- 1 Following the positioning logic (see "Executing touch probe cycles" on page 306), the TNC positions the touch probe to the programmed starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC offsets the touch probe by the safety clearance in the direction opposite the defined traverse direction.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360).
- 3 Then the touch probe moves to the next starting position **2** and probes the second position.
- 4 The TNC returns the touch probe to the clearance height and moves the rotary axis, which was defined in the cycle, by the measured value. Optionally you can have the display set to 0 after alignment.



Please note while programming:



Danger of collision!

You can now also use Cycle 403 when the "Tilt the working plane" function is active. Ensure that the **clearance height** is sufficiently large so that no collisions can occur during the final positioning of the rotary axis.

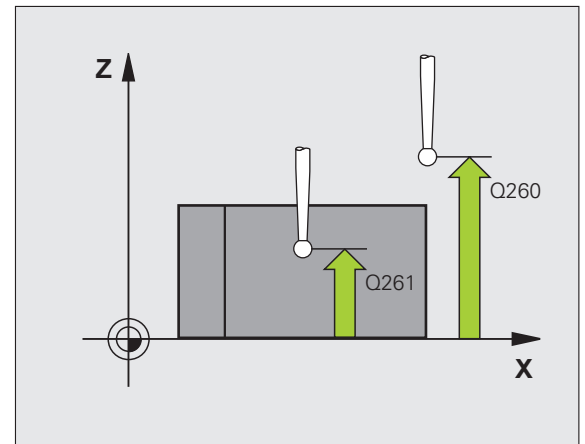
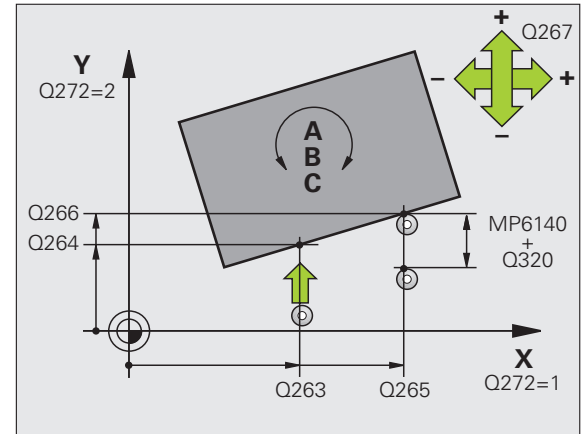
The TNC does not check whether touch points and compensation axis match. This can result in compensation movements offset by 180°.



Before a cycle definition you must have programmed a tool call to define the touch probe axis.

The TNC stores the measured angle in parameter **Q150**.

Cycle parameters



- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Traversing to clearance height** Q301: Definition of how the touch probe is to move between the measuring points:
 - 0:** Move at measuring height between measuring points
 - 1:** Move at clearance height between measuring points
- ▶ **Axis for compensation motion** Q312: assignment of the rotary axis in which the TNC is to compensate the measured misalignment:
 - 4:** Compensate misalignment with rotary axis A
 - 5:** Compensate misalignment with rotary axis B
 - 6:** Compensate misalignment with rotary axis C
- ▶ **Set to zero after alignment** Q337: Definition of whether the TNC should set the display of the aligned rotary axis to zero:
 - 0:** Do not reset the display of the rotary axis to 0 after alignment
 - 1:** Reset the display of the rotary axis to 0 after alignment
- ▶ **Number in table** Q305: Enter the number in the preset table/datum table in which the TNC is to set the rotary axis to zero. Only effective if Q337 is set to 1. Input range: 0 to 2999
- ▶ **Measured-value transfer (0, 1)** Q303: Specify if the determined basic rotation is to be saved in the datum table or in the preset table:
 - 0:** Write the measured basic rotation as a datum shift in the active datum table. The reference system is the active workpiece coordinate system.
 - 1:** Write the measured basic rotation into the preset table. The reference system is the machine coordinate system (REF system).
- ▶ **Reference angle? (0=ref. axis)** Q380: Angle with which the TNC is to align the probed straight line. Only effective if the rotary axis C is selected (Q312=6). Input range: -360.000 to 360.000

Example: NC blocks

5	TCH	PROBE	403	ROT	IN	C-AXIS
Q263	=+0					;1ST POINT 1ST AXIS
Q264	=+0					;1ST POINT 2ND AXIS
Q265	=+20					;2ND POINT 1ST AXIS
Q266	=+30					;2ND POINT 2ND AXIS
Q272	=1					;MEASURING AXIS
Q267	=-1					;TRAVERSE DIRECTION
Q261	=-5					;MEASURING HEIGHT
Q320	=0					;SETUP CLEARANCE
Q260	=+20					;CLEARANCE HEIGHT
Q301	=0					;MOVE TO CLEARANCE
Q312	=6					;COMPENSATION AXIS
Q337	=0					;SET TO ZERO
Q305	=1					;NO. IN TABLE
Q303	=+1					;MEAS. VALUE TRANSFER
Q380	=+90					;REFERENCE ANGLE



14.6 SET BASIC ROTATION (Cycle 404, DIN/ISO: G404)

Cycle run

With Touch Probe Cycle 404, you can set any basic rotation automatically during program run. This cycle is intended primarily for resetting a previous basic rotation.

Example: NC blocks

5 TCH PROBE 404 BASIC ROTATION		
Q307=+0	;PRESET BASIC ROTATION	
Q305=1	;NO. IN TABLE	

Cycle parameters



- ▶ **Preset value for basic rotation:** Angular value at which the basic rotation is to be set. Input range: -360.000 to 360.000
- ▶ **Number in table Q305:** Enter the number in the preset/datum table in which the TNC is to save the defined basic rotation. Input range: 0 to 2999



14.7 Compensating workpiece misalignment by rotating the C axis (Cycle 405, DIN/ISO: G405)

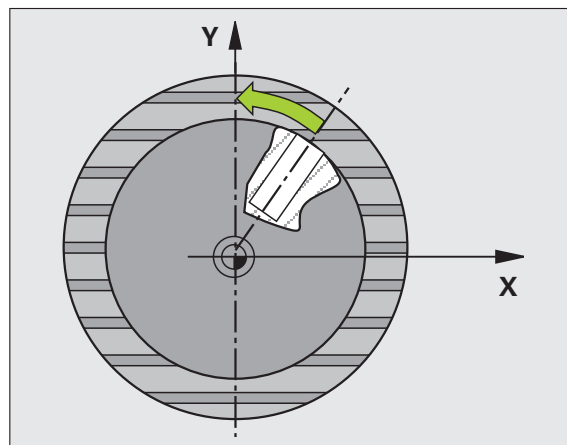
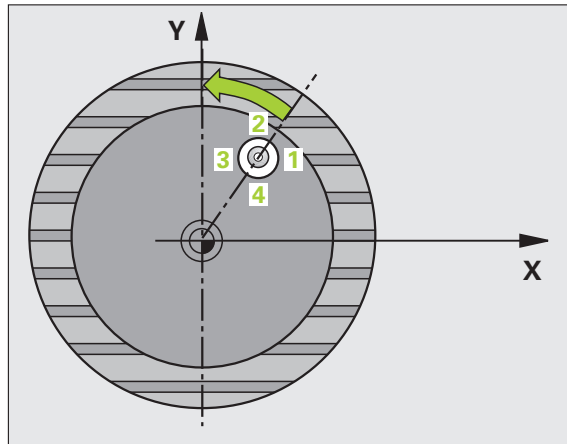
Cycle run

With Touch Probe Cycle 405, you can measure

- the angular offset between the positive Y axis of the active coordinate system and the center of a hole, or
- the angular offset between the nominal position and the actual position of a hole center.

The TNC compensates the determined angular offset by rotating the C axis. The workpiece can be clamped in any position on the rotary table, but the Y coordinate of the hole must be positive. If you measure the angular misalignment of the hole with touch probe axis Y (horizontal position of the hole), it may be necessary to execute the cycle more than once because the measuring strategy causes an inaccuracy of approx. 1% of the misalignment.

- 1 Following the positioning logic (see "Executing touch probe cycles" on page 306), the TNC positions the touch probe to the starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC calculates the probe starting points from the data in the cycle and the safety clearance from MP6140.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360). The TNC derives the probing direction automatically from the programmed starting angle.
- 3 Then the touch probe moves in a circular arc either at measuring height or at clearance height to the next starting point **2** and probes the second touch point.
- 4 The TNC positions the probe to starting point **3** and then to starting point **4** to probe the third and fourth touch points and positions the touch probe on the hole centers measured.
- 5 Finally the TNC returns the touch probe to the clearance height and aligns the workpiece by rotating the table. The TNC rotates the rotary table so that the hole center after compensation lies in the direction of the positive Y axis, or on the nominal position of the hole center—both with a vertical and horizontal touch probe axis. The measured angular misalignment is also available in parameter Q150.



Please note while programming:



Danger of collision!

To prevent a collision between the touch probe and the workpiece, enter a **low** estimate for the nominal diameter of the pocket (or hole).

If the dimensions of the pocket and the safety clearance do not permit pre-positioning in the proximity of the touch points, the TNC always starts probing from the center of the pocket. In this case the touch probe does not return to the clearance height between the four measuring points.

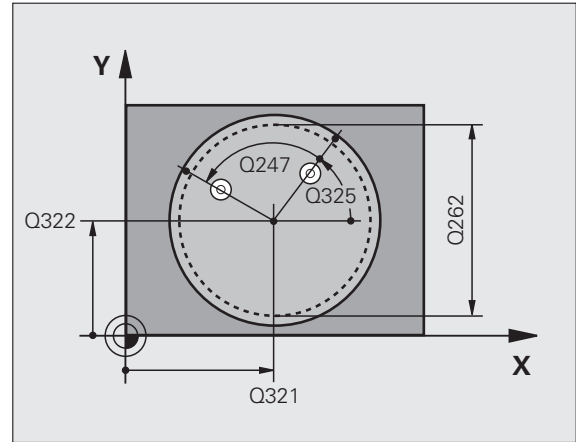
Before a cycle definition you must have programmed a tool call to define the touch probe axis.

The smaller the angle, the less accurately the TNC can calculate the circle center. Minimum input value: 5°.

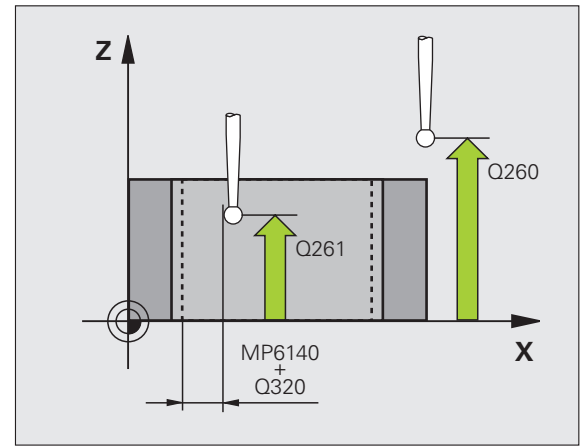
Cycle parameters



- ▶ **Center in 1st axis** Q321 (absolute): Center of the hole in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Center in 2nd axis** Q322 (absolute value): Center of the hole in the minor axis of the working plane. If you program Q322 = 0, the TNC aligns the hole center to the positive Y axis. If you program Q322 not equal to 0, then the TNC aligns the hole center to the nominal position (angle of the hole center). Input range: -99999.9999 to 99999.9999
- ▶ **Nominal diameter** Q262: Approximate diameter of the circular pocket (or hole). Enter a value that is more likely to be too small than too large. Input range: 0 to 99999.9999
- ▶ **Starting angle** Q325 (absolute): Angle between the reference axis of the working plane and the first touch point. Input range: -360.000 to 360.000
- ▶ **Stepping angle** Q247 (incremental): Angle between two measuring points. The algebraic sign of the stepping angle determines the direction of rotation (negative = clockwise) in which the touch probe moves to the next measuring point. If you wish to probe a circular arc instead of a complete circle, then program the stepping angle to be less than 90°. Input range: -120.000 to 120.000



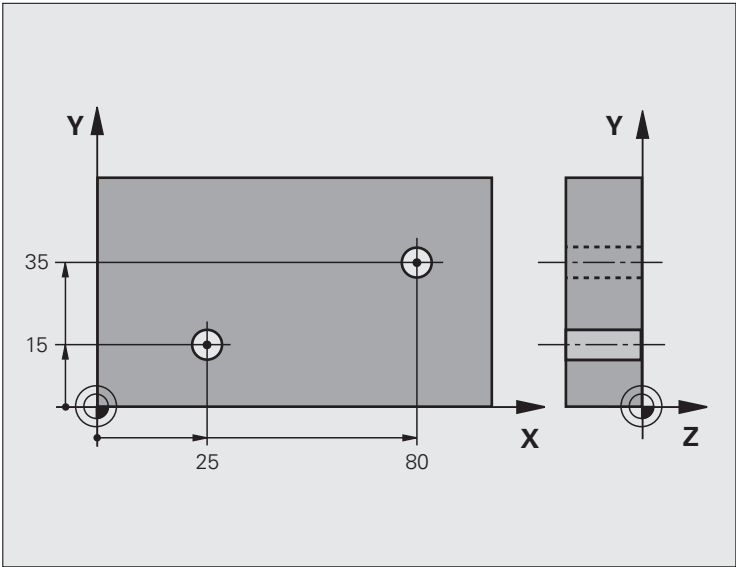
- ▶ **Measuring height in the touch probe axis Q261** (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance Q320** (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height Q260** (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Traversing to clearance height Q301**: Definition of how the touch probe is to move between the measuring points:
 - 0**: Move at measuring height between measuring points
 - 1**: Move at clearance height between measuring points
 Alternatively **PREDEF**
- ▶ **Set to zero after alignment Q337**: Definition of whether the TNC should set the display of the C axis to zero, or write the angular offset in column C of the datum table:
 - 0**: Set display of C to 0
 - >0**: Write the angular misalignment, including algebraic sign, in the datum table. Line number = value of Q337. If a C-axis shift is registered in the datum table, the TNC adds the measured angular misalignment.



Example: NC blocks

5 TCH PROBE 405 ROT IN C AXIS	
Q321=+50	;CENTER IN 1ST AXIS
Q322=+50	;CENTER IN 2ND AXIS
Q262=10	;NOMINAL DIAMETER
Q325=+0	;STARTING ANGLE
Q247=90	;STEPPING ANGLE
Q261=-5	;MEASURING HEIGHT
Q320=0	;SETUP CLEARANCE
Q260=+20	;CLEARANCE HEIGHT
Q301=0	;MOVE TO CLEARANCE
Q337=0	;SET TO ZERO

Example: Determining a basic rotation from two holes



0 BEGIN PGM CYC401 MM	
1 TOOL CALL 69 Z	
2 TCH PROBE 401 ROT 2 HOLES	
Q268=+25 ;1ST CENTER IN 1ST AXIS	Center of the 1st hole: X coordinate
Q269=+15 ;1ST CENTER IN 2ND AXIS	Center of the 1st hole: Y coordinate
Q270=+80 ;2ND CENTER IN 1ST AXIS	Center of the 2nd hole: X coordinate
Q271=+35 ;2ND CENTER IN 2ND AXIS	Center of the 2nd hole: Y coordinate
Q261=-5 ;MEASURING HEIGHT	Coordinate in the touch probe axis in which the measurement is made
Q260=+20 ;CLEARANCE HEIGHT	Height in the touch probe axis at which the probe can traverse without collision
Q307=+0 ;PRESET BASIC ROTATION	Angle of the reference line
Q402=1 ;ALIGNMENT	Compensate misalignment by rotating the rotary table
Q337=1 ;SET TO ZERO	Set the display to zero after the alignment
3 CALL PGM 35K47	Part program call
4 END PGM CYC401 MM	





15

**Touch Probe Cycles:
Automatic Datum
Setting**















15.1 Fundamentals

Overview


The TNC offers twelve cycles for automatically finding reference points and handling them as follows:

- Setting the determined values directly as display values
- Entering the determined values in the preset table
- Entering the determined values in a datum table

Cycle	Soft key	Page
408 SLOT CENTER REF PT. Measuring the inside width of a slot, and defining the slot center as datum		Page 333
409 RIDGE CENTER REF PT. Measuring the outside width of a ridge, and defining the ridge center as datum		Page 337
410 DATUM INSIDE RECTAN. Measuring the inside length and width of a rectangle, and defining the center as datum		Page 340
411 DATUM OUTSIDE RECTAN. Measuring the outside length and width of a rectangle, and defining the center as datum		Page 344
412 DATUM INSIDE CIRCLE Measuring any four points on the inside of a circle, and defining the center as datum		Page 348
413 DATUM OUTSIDE CIRCLE Measuring any four points on the outside of a circle, and defining the center as datum		Page 352
414 DATUM OUTSIDE CORNER Measuring two lines from the outside of the angle, and defining the intersection as datum		Page 356
415 DATUM INSIDE CORNER Measuring two lines from within the angle, and defining the intersection as datum		Page 361
416 DATUM CIRCLE CENTER (2nd soft-key row) Measuring any three holes on a bolt hole circle, and defining the bolt-hole center as datum		Page 365

Cycle	Soft key	Page
417 DATUM IN TS AXIS (2nd soft-key row) Measuring any position in the touch probe axis and defining it as datum		Page 369
418 DATUM FROM 4 HOLES (2nd soft-key row) Measuring 4 holes crosswise and defining the intersection of the lines between them as datum		Page 371
419 DATUM IN ONE AXIS (2nd soft-key row) Measuring any position in any axis and defining it as datum		Page 375

Characteristics common to all touch probe cycles for datum setting



You can also run the Touch Probe Cycles 408 to 419 during an active rotation (basic rotation or Cycle 10).

Datum point and touch probe axis

From the touch probe axis that you have defined in the measuring program the TNC determines the working plane for the datum:

Active touch probe axis	Datum setting in
Z or W	X and Y
Y or V	Z and X
X or U	Y and Z



Saving the calculated datum

In all cycles for datum setting you can use the input parameters Q303 and Q305 to define how the TNC is to save the calculated datum:

■ **Q305 = 0, Q303 = any value**

The TNC sets the calculated datum in the display. The new datum is active immediately. At the same time, the TNC saves the datum set in the display by the cycle in line 0 of the preset table.

■ **Q305 not equal to 0, Q303 = -1**



This combination can only occur if you

- read in programs containing Cycles 410 to 418 created on a TNC 4xx
- read in programs containing Cycles 410 to 418 created with an older software version on an iTNC 530
- did not specifically define the measured-value transfer with parameter Q303 when defining the cycle.

In these cases the TNC outputs an error message, since the complete handling of REF-referenced datum tables has changed. You must define a measured-value transfer yourself with parameter Q303.

■ **Q305 not equal to 0, Q303 = 0**

The TNC writes the calculated reference point in the active datum table. The reference system is the active workpiece coordinate system. The value of parameter Q305 determines the datum number. **Activate datum with Cycle 7 in the part program.**

■ **Q305 not equal to 0, Q303 = 1**

The TNC writes the calculated reference point in the preset table. The reference system is the machine coordinate system (REF coordinates). The value of parameter Q305 determines the preset number. **Activate preset with Cycle 247 in the part program.**

Measurement results in Q parameters

The TNC saves the measurement results of the respective touch probe cycle in the globally effective Q parameters Q150 to Q160. You can use these parameters in your program. Note the table of result parameters that are listed with every cycle description.



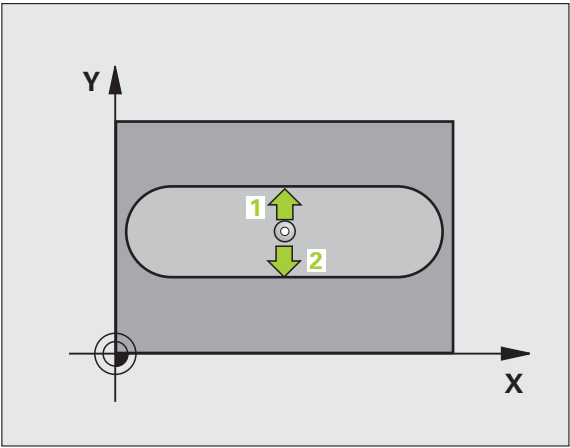
15.2 SLOT CENTER REF PT (Cycle 408, DIN/ISO: G408, FCL 3 function)

Cycle run

Touch Probe Cycle 408 finds the center of a slot and defines its center as datum. If desired, the TNC can also enter the coordinates into a datum table or the preset table.

- 1 Following the positioning logic (see "Executing touch probe cycles" on page 306), the TNC positions the touch probe to the starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC calculates the probe starting points from the data in the cycle and the safety clearance from MP6140.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360).
- 3 Then the touch probe moves either paraxially at the measuring height or linearly at the clearance height to the next starting point **2** and probes the second touch point.
- 4 Finally the TNC returns the touch probe to the clearance height and processes the determined datum depending on the cycle parameters Q303 and Q305 (see "Saving the calculated datum" on page 332) and saves the actual values in the Q parameters listed below
- 5 If desired, the TNC subsequently measures the datum in the touch probe axis in a separate probing.

Parameter number	Meaning
Q166	Actual value of measured slot width
Q157	Actual value of the centerline



Please note while programming:

**Danger of collision!**

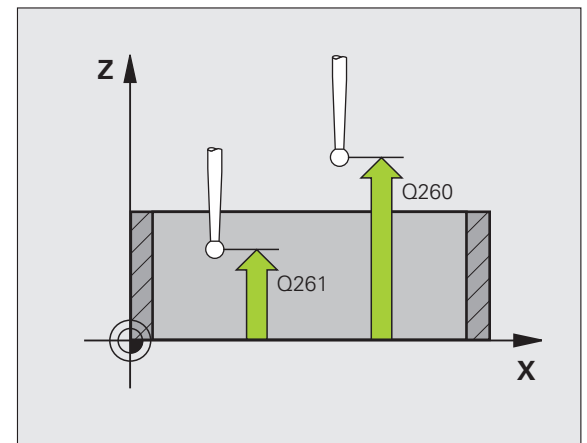
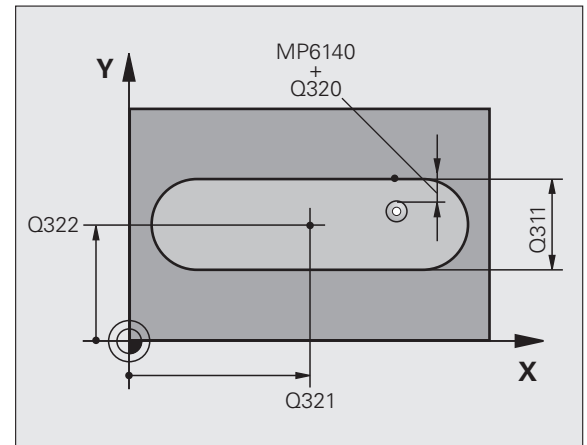
To prevent a collision between touch probe and workpiece, enter a **low** estimate for the slot width.

If the slot width and the safety clearance do not permit pre-positioning in the proximity of the touch points, the TNC always starts probing from the center of the slot. In this case the touch probe does not return to the clearance height between the two measuring points.

Before a cycle definition you must have programmed a tool call to define the touch probe axis.

Cycle parameters

- ▶ **Center in 1st axis** Q321 (absolute): Center of the slot in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Center in 2nd axis** Q322 (absolute): Center of the slot in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Width of slot** Q311 (incremental): Width of the slot, regardless of its position in the working plane. Input range: 0 to 99999.9999
- ▶ **Measuring axis (1=1st axis / 2=2nd axis)** Q272:
Axis in which the measurement is to be made:
1: Reference axis = measuring axis
2: Minor axis = measuring axis
- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**



- ▶ **Traversing to clearance height** Q301: Definition of how the touch probe is to move between the measuring points:
 - 0:** Move at measuring height between measuring points
 - 1:** Move at clearance height between measuring points
 Alternatively **PREDEF**
- ▶ **Number in table** Q305: Enter the number in the datum/preset table in which the TNC is to save the coordinates of the slot center. If you enter Q305=0, the TNC automatically sets the display so that the new datum is on the slot center. Input range: 0 to 2999
- ▶ **New datum** Q405 (absolute): Coordinate in the measuring axis at which the TNC should set the calculated slot center. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **Measured-value transfer (0, 1)** Q303: Specify whether the determined datum is to be saved in the datum table or in the preset table:
 - 0:** Write determined datum in the active datum table. The reference system is the active workpiece coordinate system.
 - 1:** Write determined datum in the preset table. The reference system is the machine coordinate system (REF system).



- ▶ **Probe in TS axis** Q381: Specify whether the TNC should also set the datum in the touch probe axis:
0: Do not set datum in the touch probe axis
1: Set datum in the touch probe axis
- ▶ **Probe TS axis: Coord. 1st axis** Q382 (absolute):
Coordinate of the probe point in the reference axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 2nd axis** Q383 (absolute):
Coordinate of the probe point in the minor axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 3rd axis** Q384 (absolute):
Coordinate of the probe point in the touch probe axis at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **New datum in TS axis** Q333 (absolute): Coordinate in the touch probe axis at which the TNC should set the datum. Default setting = 0. Input range: -99999.9999 to 99999.9999

Example: NC blocks

5	TCH	PROBE	408	SLOT	CENTER	REF	PT
Q321	=+50						;CENTER IN 1ST AXIS
Q322	=+50						;CENTER IN 2ND AXIS
Q311	=25						;SLOT WIDTH
Q272	=1						;MEASURING AXIS
Q261	=-5						;MEASURING HEIGHT
Q320	=0						;SETUP CLEARANCE
Q260	=+20						;CLEARANCE HEIGHT
Q301	=0						;MOVE TO CLEARANCE
Q305	=10						;NO. IN TABLE
Q405	=+0						;DATUM
Q303	=+1						;MEAS. VALUE TRANSFER
Q381	=1						;PROBE IN TS AXIS
Q382	=+85						;1ST CO. FOR TS AXIS
Q383	=+50						;2ND CO. FOR TS AXIS
Q384	=+0						;3RD CO. FOR TS AXIS
Q333	=+1						;DATUM

15.3 RIDGE CENTER REF PT (Cycle 409, DIN/ISO: G409, FCL 3 function)

Cycle run

Touch Probe Cycle 409 finds the center of a ridge and defines its center as datum. If desired, the TNC can also enter the coordinates into a datum table or the preset table.

- 1 Following the positioning logic (see “Executing touch probe cycles” on page 306), the TNC positions the touch probe to the starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC calculates the probe starting points from the data in the cycle and the safety clearance from MP6140.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360).
- 3 Then the touch probe moves at clearance height to the next touch point **2** and probes the second touch point.
- 4 Finally the TNC returns the touch probe to the clearance height and processes the determined datum depending on the cycle parameters Q303 and Q305 (see “Saving the calculated datum” on page 332) and saves the actual values in the Q parameters listed below.
- 5 If desired, the TNC subsequently measures the datum in the touch probe axis in a separate probing.

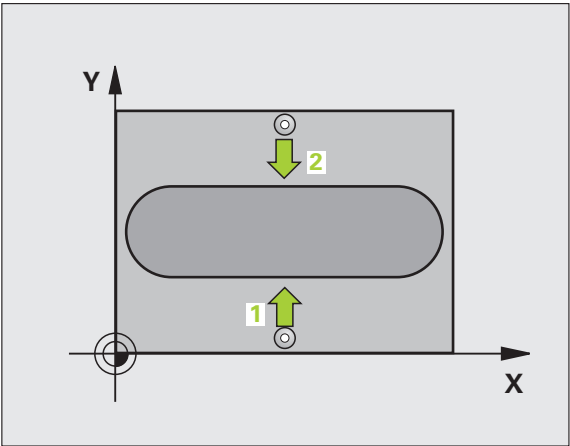
Parameter number	Meaning
Q166	Actual value of measured ridge width
Q157	Actual value of the centerline

Please note while programming:



Danger of collision!

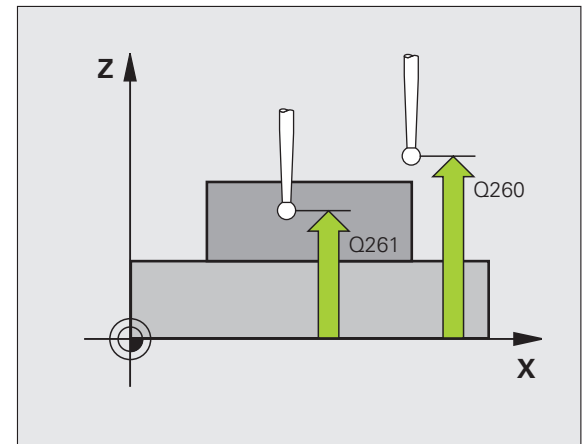
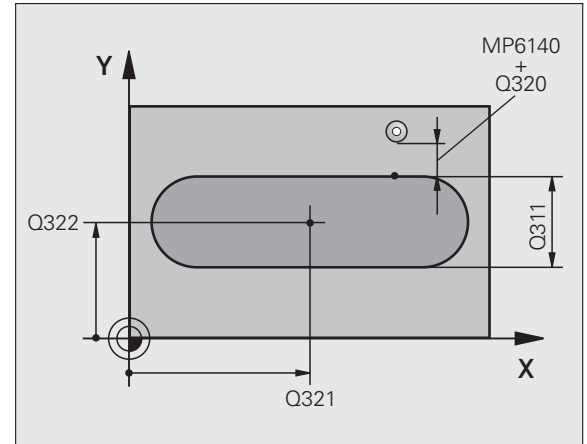
To prevent a collision between touch probe and workpiece, enter a **high** estimate for the ridge width.
Before a cycle definition you must have programmed a tool call to define the touch probe axis.



Cycle parameters



- ▶ **Center in 1st axis** Q321 (absolute): Center of the ridge in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Center in 2nd axis** Q322 (absolute): Center of the ridge in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Width of ridge** Q311 (incremental): Width of the ridge, regardless of its position in the working plane. Input range: 0 to 99999.9999
- ▶ **Measuring axis (1=1st axis / 2=2nd axis)** Q272:
Axis in which the measurement is to be made:
1: Reference axis = measuring axis
2: Minor axis = measuring axis
- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Number in table** Q305: Enter the number in the datum/preset table in which the TNC is to save the coordinates of the ridge center. If you enter Q305=0, the TNC automatically sets the display so that the new datum is on the slot center. Input range: 0 to 2999
- ▶ **New datum** Q405 (absolute): Coordinate in the measuring axis at which the TNC should set the calculated ridge center. Default setting = 0. Input range: -99999.9999 to 99999.9999



- ▶ **Measured-value transfer (0, 1) Q303:** Specify whether the determined datum is to be saved in the datum table or in the preset table:
0: Write determined datum in the active datum table. The reference system is the active workpiece coordinate system.
1: Write determined datum in the preset table. The reference system is the machine coordinate system (REF system).
- ▶ **Probe in TS axis Q381:** Specify whether the TNC should also set the datum in the touch probe axis:
0: Do not set datum in the touch probe axis
1: Set datum in the touch probe axis
- ▶ **Probe TS axis: Coord. 1st axis Q382 (absolute):** Coordinate of the probe point in the reference axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 2nd axis Q383 (absolute):** Coordinate of the probe point in the minor axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 3rd axis Q384 (absolute):** Coordinate of the probe point in the touch probe axis at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **New datum in TS axis Q333 (absolute):** Coordinate in the touch probe axis at which the TNC should set the datum. Default setting = 0. Input range: -99999.9999 to 99999.9999

Example: NC blocks

5 TCH PROBE 409 SLOT CENTER RIDGE
Q321=+50 ;CENTER IN 1ST AXIS
Q322=+50 ;CENTER IN 2ND AXIS
Q311=25 ;RIDGE WIDTH
Q272=1 ;MEASURING AXIS
Q261=-5 ;MEASURING HEIGHT
Q320=0 ;SETUP CLEARANCE
Q260=+20 ;CLEARANCE HEIGHT
Q305=10 ;NO. IN TABLE
Q405=+0 ;DATUM
Q303=+1 ;MEAS. VALUE TRANSFER
Q381=1 ;PROBE IN TS AXIS
Q382=+85 ;1ST CO. FOR TS AXIS
Q383=+50 ;2ND CO. FOR TS AXIS
Q384=+0 ;3RD CO. FOR TS AXIS
Q333=+1 ;DATUM



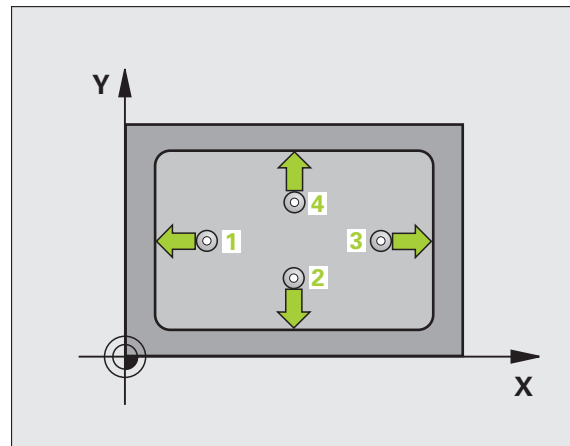
15.4 DATUM FROM INSIDE OF RECTANGLE (Cycle 410, DIN/ISO: G410)

Cycle run

Touch Probe Cycle 410 finds the center of a rectangular pocket and defines its center as datum. If desired, the TNC can also enter the coordinates into a datum table or the preset table.

- 1 Following the positioning logic (see “Executing touch probe cycles” on page 306), the TNC positions the touch probe to the starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC calculates the probe starting points from the data in the cycle and the safety clearance from MP6140.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360).
- 3 Then the touch probe moves either paraxially at the measuring height or linearly at the clearance height to the next starting point **2** and probes the second touch point.
- 4 The TNC positions the probe to starting point **3** and then to starting point **4** to probe the third and fourth touch points.
- 5 Finally the TNC returns the touch probe to the clearance height and processes the determined datum depending on the cycle parameters Q303 and Q305. (see “Saving the calculated datum” on page 332)
- 6 If desired, the TNC subsequently measures the datum in the touch probe axis in a separate probing and saves the actual values in the following Q parameters.

Parameter number	Meaning
Q151	Actual value of center in reference axis
Q152	Actual value of center in minor axis
Q154	Actual value of length in the reference axis
Q155	Actual value of length in the minor axis



Please note while programming:



Danger of collision!

To prevent a collision between touch probe and workpiece, enter **low** estimates for the lengths of the 1st and 2nd sides.

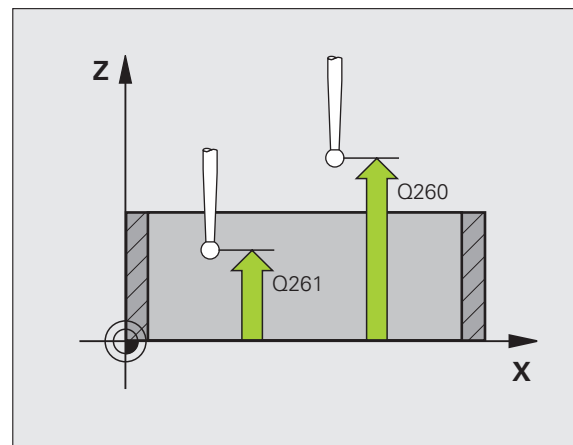
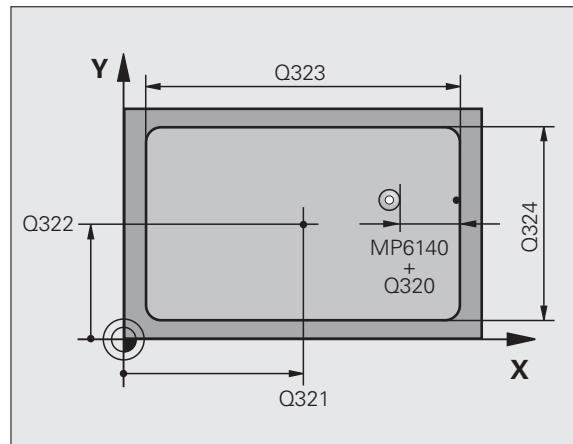
If the dimensions of the pocket and the safety clearance do not permit pre-positioning in the proximity of the touch points, the TNC always starts probing from the center of the pocket. In this case the touch probe does not return to the clearance height between the four measuring points.

Before a cycle definition you must have programmed a tool call to define the touch probe axis.

Cycle parameters



- ▶ **Center in 1st axis** Q321 (absolute): Center of the pocket in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Center in 2nd axis** Q322 (absolute): Center of the pocket in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **First side length** Q323 (incremental): Pocket length, parallel to the reference axis of the working plane. Input range: 0 to 99999.9999
- ▶ **2nd side length** Q324 (incremental): Pocket length, parallel to the minor axis of the working plane. Input range: 0 to 99999.9999
- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**



- ▶ **Traversing to clearance height** Q301: Definition of how the touch probe is to move between the measuring points:
0: Move at measuring height between measuring points
1: Move at clearance height between measuring points
 Alternatively **PREDEF**
- ▶ **Datum number in table** Q305: Enter the number in the datum/preset table in which the TNC is to save the coordinates of the pocket center. If you enter Q305=0, the TNC automatically sets the display so that the new datum is at the center of the pocket.
 Input range: 0 to 2999
- ▶ **New datum for reference axis** Q331 (absolute):
 Coordinate in the reference axis at which the TNC should set the pocket center. Default setting = 0.
 Input range: -99999.9999 to 99999.9999
- ▶ **New datum for minor axis** Q332 (absolute):
 Coordinate in the minor axis at which the TNC should set the pocket center. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **Measured-value transfer (0, 1)** Q303: Specify whether the determined datum is to be saved in the datum table or in the preset table:
-1: Do not use. Is entered by the TNC when old programs are read in (see "Saving the calculated datum" on page 332).
0: Write determined datum in the active datum table. The reference system is the active workpiece coordinate system.
1: Write determined datum in the preset table. The reference system is the machine coordinate system (REF system).

- ▶ **Probe in TS axis** Q381: Specify whether the TNC should also set the datum in the touch probe axis:
0: Do not set datum in the touch probe axis
1: Set datum in the touch probe axis
- ▶ **Probe TS axis: Coord. 1st axis** Q382 (absolute):
 Coordinate of the probe point in the reference axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 2nd axis** Q383 (absolute):
 Coordinate of the probe point in the minor axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 3rd axis** Q384 (absolute):
 Coordinate of the probe point in the touch probe axis at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **New datum in TS axis** Q333 (absolute): Coordinate in the touch probe axis at which the TNC should set the datum. Default setting = 0. Input range: -99999.9999 to 99999.9999

Example: NC blocks

5 TCH PROBE 410 DATUM INSIDE RECTAN.
Q321=+50 ;CENTER IN 1ST AXIS
Q322=+50 ;CENTER IN 2ND AXIS
Q323=60 ;FIRST SIDE LENGTH
Q324=20 ;2ND SIDE LENGTH
Q261=-5 ;MEASURING HEIGHT
Q320=0 ;SETUP CLEARANCE
Q260=+20 ;CLEARANCE HEIGHT
Q301=0 ;MOVE TO CLEARANCE
Q305=10 ;NO. IN TABLE
Q331=+0 ;DATUM
Q332=+0 ;DATUM
Q303=+1 ;MEAS. VALUE TRANSFER
Q381=1 ;PROBE IN TS AXIS
Q382=+85 ;1ST CO. FOR TS AXIS
Q383=+50 ;2ND CO. FOR TS AXIS
Q384=+0 ;3RD CO. FOR TS AXIS
Q333=+1 ;DATUM



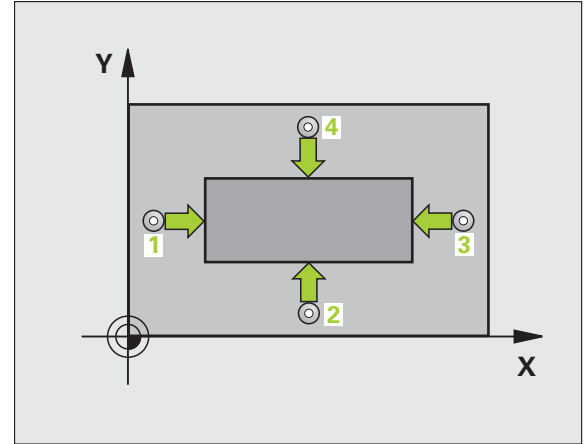
15.5 DATUM FROM OUTSIDE OF RECTANGLE (Cycle 411, DIN/ISO: G411)

Cycle run

Touch Probe Cycle 411 finds the center of a rectangular stud and defines its center as datum. If desired, the TNC can also enter the coordinates into a datum table or the preset table.

- 1 Following the positioning logic (see “Executing touch probe cycles” on page 306), the TNC positions the touch probe to the starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC calculates the probe starting points from the data in the cycle and the safety clearance from MP6140.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360).
- 3 Then the touch probe moves either paraxially at the measuring height or linearly at the clearance height to the next starting point **2** and probes the second touch point.
- 4 The TNC positions the probe to starting point **3** and then to starting point **4** to probe the third and fourth touch points.
- 5 Finally the TNC returns the touch probe to the clearance height and processes the determined datum depending on the cycle parameters Q303 and Q305. (see “Saving the calculated datum” on page 332)
- 6 If desired, the TNC subsequently measures the datum in the touch probe axis in a separate probing and saves the actual values in the following Q parameters.

Parameter number	Meaning
Q151	Actual value of center in reference axis
Q152	Actual value of center in minor axis
Q154	Actual value of length in the reference axis
Q155	Actual value of length in the minor axis



Please note while programming:



Danger of collision!

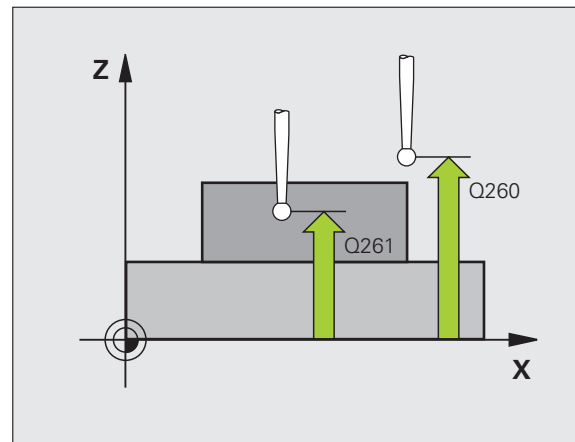
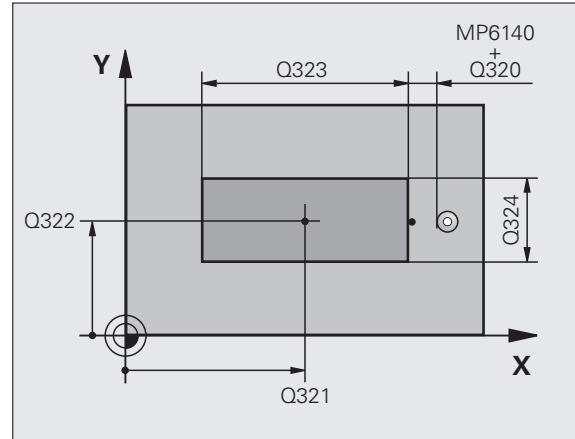
To prevent a collision between the touch probe and workpiece, enter **high** estimates for the lengths of the 1st and 2nd sides.

Before a cycle definition you must have programmed a tool call to define the touch probe axis.

Cycle parameters



- ▶ **Center in 1st axis** Q321 (absolute): Center of the stud in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Center in 2nd axis** Q322 (absolute): Center of the stud in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **First side length** Q323 (incremental): Stud length, parallel to the reference axis of the working plane. Input range: 0 to 99999.9999
- ▶ **2nd side length** Q324 (incremental): Stud length, parallel to the minor axis of the working plane. Input range: 0 to 99999.9999
- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**



- ▶ **Traversing to clearance height** Q301: Definition of how the touch probe is to move between the measuring points:
0: Move at measuring height between measuring points
1: Move at clearance height between measuring points
 Alternatively **PREDEF**
- ▶ **Datum number in table** Q305: Enter the datum number in the table in which the TNC is to save the coordinates of the pocket center. If you enter Q305=0, the TNC automatically sets the display so that the new datum is on the stud center. Input range: 0 to 2999
- ▶ **New datum for reference axis** Q331 (absolute):
 Coordinate in the reference axis at which the TNC should set the stud center. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **New datum for minor axis** Q332 (absolute):
 Coordinate in the minor axis at which the TNC should set the stud center. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **Measured-value transfer (0, 1)** Q303: Specify whether the determined datum is to be saved in the datum table or in the preset table:
-1: Do not use. Is entered by the TNC when old programs are read in (see "Saving the calculated datum" on page 332).
0: Write determined datum in the active datum table. The reference system is the active workpiece coordinate system.
1: Write determined datum in the preset table. The reference system is the machine coordinate system (REF system).

- ▶ **Probe in TS axis** Q381: Specify whether the TNC should also set the datum in the touch probe axis:
0: Do not set datum in the touch probe axis
1: Set datum in the touch probe axis
- ▶ **Probe TS axis: Coord. 1st axis** Q382 (absolute):
 Coordinate of the probe point in the reference axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 2nd axis** Q383 (absolute):
 Coordinate of the probe point in the minor axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 3rd axis** Q384 (absolute):
 Coordinate of the probe point in the touch probe axis at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **New datum in TS axis** Q333 (absolute): Coordinate in the touch probe axis at which the TNC should set the datum. Default setting = 0. Input range: -99999.9999 to 99999.9999

Example: NC blocks

5 TCH PROBE 411 DATUM OUTS. RECTAN.
Q321=+50 ;CENTER IN 1ST AXIS
Q322=+50 ;CENTER IN 2ND AXIS
Q323=60 ;FIRST SIDE LENGTH
Q324=20 ;2ND SIDE LENGTH
Q261=-5 ;MEASURING HEIGHT
Q320=0 ;SETUP CLEARANCE
Q260=+20 ;CLEARANCE HEIGHT
Q301=0 ;MOVE TO CLEARANCE
Q305=0 ;NO. IN TABLE
Q331=+0 ;DATUM
Q332=+0 ;DATUM
Q303=+1 ;MEAS. VALUE TRANSFER
Q381=1 ;PROBE IN TS AXIS
Q382=+85 ;1ST CO. FOR TS AXIS
Q383=+50 ;2ND CO. FOR TS AXIS
Q384=+0 ;3RD CO. FOR TS AXIS
Q333=+1 ;DATUM



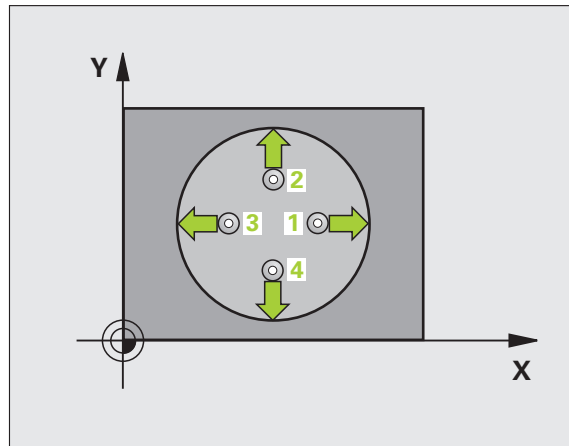
15.6 DATUM FROM INSIDE OF CIRCLE (Cycle 412, DIN/ISO: G412)

Cycle run

Touch Probe Cycle 412 finds the center of a circular pocket (or of a hole) and defines its center as datum. If desired, the TNC can also enter the coordinates into a datum table or the preset table.

- 1 Following the positioning logic (see “Executing touch probe cycles” on page 306), the TNC positions the touch probe to the starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC calculates the probe starting points from the data in the cycle and the safety clearance from MP6140.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360). The TNC derives the probing direction automatically from the programmed starting angle.
- 3 Then the touch probe moves in a circular arc either at measuring height or at clearance height to the next starting point **2** and probes the second touch point.
- 4 The TNC positions the probe to starting point **3** and then to starting point **4** to probe the third and fourth touch points.
- 5 Finally the TNC returns the touch probe to the clearance height and processes the determined datum depending on the cycle parameters Q303 and Q305 (see “Saving the calculated datum” on page 332) and saves the actual values in the Q parameters listed below.
- 6 If desired, the TNC subsequently measures the datum in the touch probe axis in a separate probing.

Parameter number	Meaning
Q151	Actual value of center in reference axis
Q152	Actual value of center in minor axis
Q153	Actual value of diameter



Please note while programming:



Danger of collision!

To prevent a collision between the touch probe and the workpiece, enter a **low** estimate for the nominal diameter of the pocket (or hole).

If the dimensions of the pocket and the safety clearance do not permit pre-positioning in the proximity of the touch points, the TNC always starts probing from the center of the pocket. In this case the touch probe does not return to the clearance height between the four measuring points.

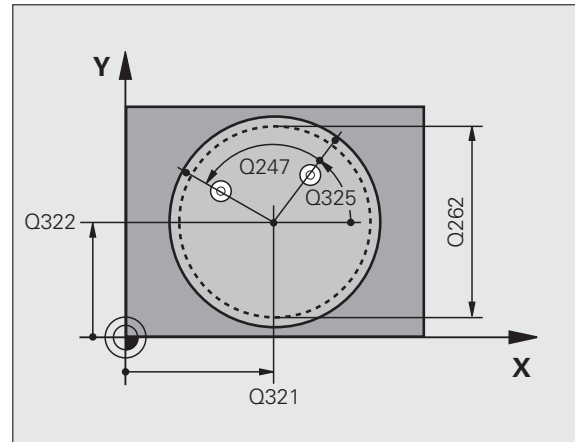
The smaller the angle increment Q247, the less accurately the TNC can calculate the datum. Minimum input value: 5°

Before a cycle definition you must have programmed a tool call to define the touch probe axis.

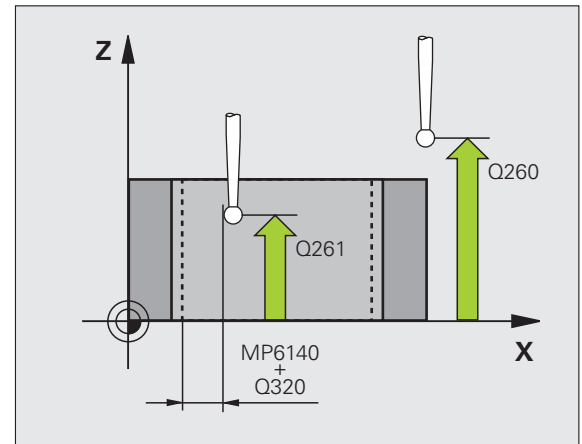
Cycle parameters



- ▶ **Center in 1st axis** Q321 (absolute): Center of the pocket in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Center in 2nd axis** Q322 (absolute): Center of the pocket in the minor axis of the working plane. If you program $Q322 = 0$, the TNC aligns the hole center to the positive Y axis. If you program Q322 not equal to 0, then the TNC aligns the hole center to the nominal position. Input range: -99999.9999 to 99999.9999
- ▶ **Nominal diameter** Q262: Approximate diameter of the circular pocket (or hole). Enter a value that is more likely to be too small than too large. Input range: 0 to 99999.9999
- ▶ **Starting angle** Q325 (absolute): Angle between the reference axis of the working plane and the first touch point. Input range: -360.0000 to 360.0000
- ▶ **Stepping angle** Q247 (incremental): Angle between two measuring points. The algebraic sign of the stepping angle determines the direction of rotation (negative = clockwise) in which the touch probe moves to the next measuring point. If you wish to probe a circular arc instead of a complete circle, then program the stepping angle to be less than 90° . Input range: -120.0000 to 120.0000



- ▶ **Measuring height in the touch probe axis Q261** (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance Q320** (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height Q260** (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Traversing to clearance height Q301**: Definition of how the touch probe is to move between the measuring points:
0: Move at measuring height between measuring points
1: Move at clearance height between measuring points
Alternatively **PREDEF**
- ▶ **Datum number in table Q305**: Enter the number in the datum/preset table in which the TNC is to save the coordinates of the pocket center. If you enter $Q305=0$, the TNC automatically sets the display so that the new datum is at the center of the pocket. Input range: 0 to 2999
- ▶ **New datum for reference axis Q331** (absolute): Coordinate in the reference axis at which the TNC should set the pocket center. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **New datum for minor axis Q332** (absolute): Coordinate in the minor axis at which the TNC should set the pocket center. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **Measured-value transfer (0, 1) Q303**: Specify whether the determined datum is to be saved in the datum table or in the preset table:
-1: Do not use. Is entered by the TNC when old programs are read in (see "Saving the calculated datum" on page 332).
0: Write determined datum in the active datum table. The reference system is the active workpiece coordinate system.
1: Write determined datum in the preset table. The reference system is the machine coordinate system (REF system).



- ▶ **Probe in TS axis** Q381: Specify whether the TNC should also set the datum in the touch probe axis:
0: Do not set datum in the touch probe axis
1: Set datum in the touch probe axis
- ▶ **Probe TS axis: Coord. 1st axis** Q382 (absolute):
 Coordinate of the probe point in the reference axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 2nd axis** Q383 (absolute):
 Coordinate of the probe point in the minor axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 3rd axis** Q384 (absolute):
 Coordinate of the probe point in the touch probe axis at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **New datum in TS axis** Q333 (absolute): Coordinate in the touch probe axis at which the TNC should set the datum. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **No. of measuring points (4/3)** Q423: Specify whether the TNC should measure the hole with 4 or 3 probing points:
4: Use 4 measuring points (standard setting)
3: Use 3 measuring points
- ▶ **Type of traverse? Line=0/Arc=1** Q365: Definition of the path function with which the tool is to move between the measuring points if "traverse to clearance height" (Q301=1) is active.
0: Move between operations on a straight line
1: Move between operations on the pitch circle

Example: NC blocks

5 TCH PROBE 412 DATUM INSIDE CIRCLE
Q321=+50 ;CENTER IN 1ST AXIS
Q322=+50 ;CENTER IN 2ND AXIS
Q262=75 ;NOMINAL DIAMETER
Q325=+0 ;STARTING ANGLE
Q247=+60 ;STEPPING ANGLE
Q261=-5 ;MEASURING HEIGHT
Q320=0 ;SETUP CLEARANCE
Q260=+20 ;CLEARANCE HEIGHT
Q301=0 ;MOVE TO CLEARANCE
Q305=12 ;NO. IN TABLE
Q331=+0 ;DATUM
Q332=+0 ;DATUM
Q303=+1 ;MEAS. VALUE TRANSFER
Q381=1 ;PROBE IN TS AXIS
Q382=+85 ;1ST CO. FOR TS AXIS
Q383=+50 ;2ND CO. FOR TS AXIS
Q384=+0 ;3RD CO. FOR TS AXIS
Q333=+1 ;DATUM
Q423=4 ;NO. OF MEAS. POINTS
Q365=1 ;TYPE OF TRAVERSE



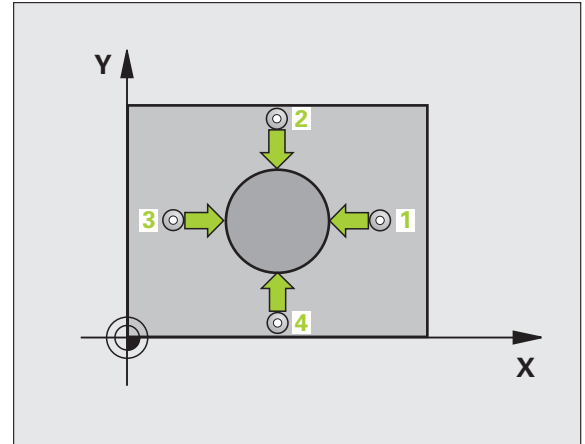
15.7 DATUM FROM OUTSIDE OF CIRCLE (Cycle 413, DIN/ISO: G413)

Cycle run

Touch Probe Cycle 413 finds the center of a circular stud and defines it as datum. If desired, the TNC can also enter the coordinates into a datum table or the preset table.

- 1 Following the positioning logic (see “Executing touch probe cycles” on page 306), the TNC positions the touch probe to the starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC calculates the probe starting points from the data in the cycle and the safety clearance from MP6140.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360). The TNC derives the probing direction automatically from the programmed starting angle.
- 3 Then the touch probe moves in a circular arc either at measuring height or at clearance height to the next starting point **2** and probes the second touch point.
- 4 The TNC positions the probe to starting point **3** and then to starting point **4** to probe the third and fourth touch points.
- 5 Finally the TNC returns the touch probe to the clearance height and processes the determined datum depending on the cycle parameters Q303 and Q305 (see “Saving the calculated datum” on page 332) and saves the actual values in the Q parameters listed below.
- 6 If desired, the TNC subsequently measures the datum in the touch probe axis in a separate probing.

Parameter number	Meaning
Q151	Actual value of center in reference axis
Q152	Actual value of center in minor axis
Q153	Actual value of diameter



Please note while programming:



Danger of collision!

To prevent a collision between touch probe and workpiece, enter a **high** estimate for the nominal diameter of the stud.

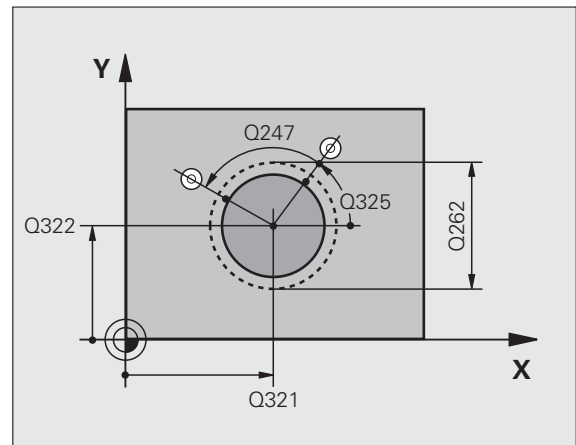
Before a cycle definition you must have programmed a tool call to define the touch probe axis.

The smaller the angle increment Q247, the less accurately the TNC can calculate the datum. Minimum input value: 5°.

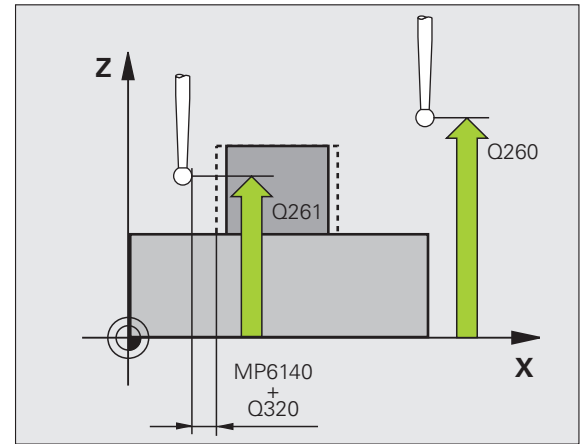
Cycle parameters



- ▶ **Center in 1st axis** Q321 (absolute): Center of the stud in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Center in 2nd axis** Q322 (absolute): Center of the stud in the minor axis of the working plane. If you program Q322 = 0, the TNC aligns the hole center to the positive Y axis. If you program Q322 not equal to 0, then the TNC aligns the hole center to the nominal position. Input range: -99999.9999 to 99999.9999
- ▶ **Nominal diameter** Q262: Approximate diameter of the stud. Enter a value that is more likely to be too large than too small. Input range: 0 to 99999.9999
- ▶ **Starting angle** Q325 (absolute): Angle between the reference axis of the working plane and the first touch point. Input range: -360.0000 to 360.0000
- ▶ **Stepping angle** Q247 (incremental): Angle between two measuring points. The algebraic sign of the stepping angle determines the direction of rotation (negative = clockwise) in which the touch probe moves to the next measuring point. If you wish to probe a circular arc instead of a complete circle, then program the stepping angle to be less than 90°. Input range: -120.0000 to 120.0000



- ▶ **Measuring height in the touch probe axis Q261** (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance Q320** (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height Q260** (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Traversing to clearance height Q301**: Definition of how the touch probe is to move between the measuring points:
 - 0**: Move at measuring height between measuring points
 - 1**: Move at clearance height between measuring points
 Alternatively **PREDEF**
- ▶ **Datum number in table Q305**: Enter the datum number in the table in which the TNC is to save the coordinates of the pocket center. If you enter Q305=0, the TNC automatically sets the display so that the new datum is on the stud center. Input range: 0 to 2999
- ▶ **New datum for reference axis Q331** (absolute): Coordinate in the reference axis at which the TNC should set the stud center. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **New datum for minor axis Q332** (absolute): Coordinate in the minor axis at which the TNC should set the stud center. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **Measured-value transfer (0, 1) Q303**: Specify whether the determined datum is to be saved in the datum table or in the preset table:
 - 1**: Do not use. Is entered by the TNC when old programs are read in (see "Saving the calculated datum" on page 332).
 - 0**: Write determined datum in the active datum table. The reference system is the active workpiece coordinate system.
 - 1**: Write determined datum in the preset table. The reference system is the machine coordinate system (REF system).



- ▶ **Probe in TS axis** Q381: Specify whether the TNC should also set the datum in the touch probe axis:
0: Do not set datum in the touch probe axis
1: Set datum in the touch probe axis
- ▶ **Probe TS axis: Coord. 1st axis** Q382 (absolute):
 Coordinate of the probe point in the reference axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 2nd axis** Q383 (absolute):
 Coordinate of the probe point in the minor axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 3rd axis** Q384 (absolute):
 Coordinate of the probe point in the touch probe axis at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **New datum in TS axis** Q333 (absolute): Coordinate in the touch probe axis at which the TNC should set the datum. Basic setting = 0
- ▶ **No. of measuring points (4/3)** Q423: Specify whether the TNC should measure the stud with 4 or 3 probing points:
4: Use 4 measuring points (standard setting)
3: Use 3 measuring points
- ▶ **Type of traverse? Line=0/Arc=1** Q365: Definition of the path function with which the tool is to move between the measuring points if "traverse to clearance height" (Q301=1) is active.
0: Move between operations on a straight line
1: Move between operations on the pitch circle

Example: NC blocks

5 TCH PROBE 413 DATUM OUTSIDE CIRCLE
Q321=+50 ;CENTER IN 1ST AXIS
Q322=+50 ;CENTER IN 2ND AXIS
Q262=75 ;NOMINAL DIAMETER
Q325=+0 ;STARTING ANGLE
Q247=+60 ;STEPPING ANGLE
Q261=-5 ;MEASURING HEIGHT
Q320=0 ;SETUP CLEARANCE
Q260=+20 ;CLEARANCE HEIGHT
Q301=0 ;MOVE TO CLEARANCE
Q305=15 ;NO. IN TABLE
Q331=+0 ;DATUM
Q332=+0 ;DATUM
Q303=+1 ;MEAS. VALUE TRANSFER
Q381=1 ;PROBE IN TS AXIS
Q382=+85 ;1ST CO. FOR TS AXIS
Q383=+50 ;2ND CO. FOR TS AXIS
Q384=+0 ;3RD CO. FOR TS AXIS
Q333=+1 ;DATUM
Q423=4 ;NO. OF MEAS. POINTS
Q365=1 ;TYPE OF TRAVERSE



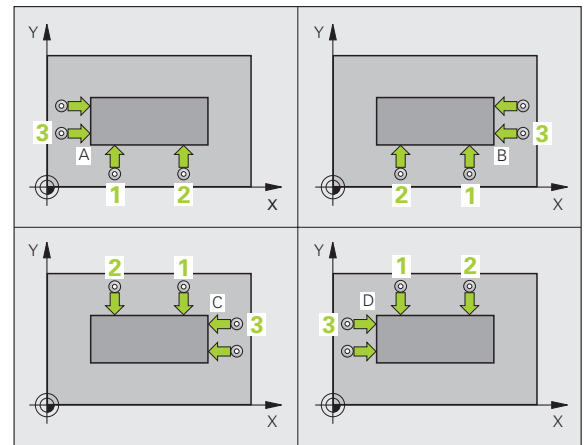
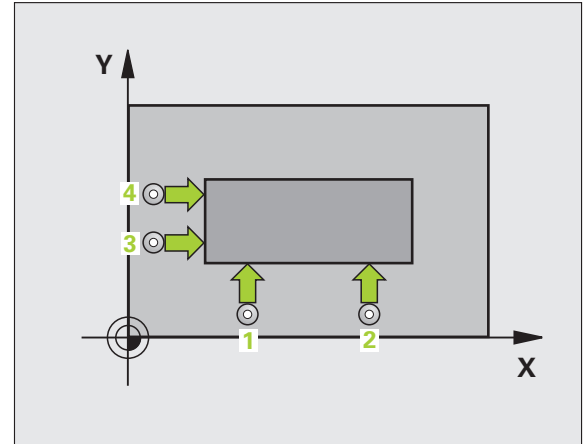
15.8 DATUM FROM OUTSIDE OF CORNER (Cycle 414, DIN/ISO: G414)

Cycle run

Touch Probe Cycle 414 finds the intersection of two lines and defines it as the datum. If desired, the TNC can also enter the intersection into a datum table or preset table.

- 1 Following the positioning logic (see "Executing touch probe cycles" on page 306), the TNC positions the touch probe at rapid traverse (value from MP6150 or MP6361) to the first touch point **1** (see figure at upper right). The TNC offsets the touch probe by the safety clearance in the direction opposite the respective traverse direction.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360). The TNC derives the probing direction automatically from the programmed 3rd measuring point.
- 3 Then the touch probe moves to the next starting position **2** and probes the second position.
- 4 The TNC positions the probe to starting point **3** and then to starting point **4** to probe the third and fourth touch points.
- 5 Finally the TNC returns the touch probe to the clearance height and processes the determined datum depending on the cycle parameters Q303 and Q305 (see "Saving the calculated datum" on page 332) and saves the coordinates of the determined corner in the Q parameters listed below.
- 6 If desired, the TNC subsequently measures the datum in the touch probe axis in a separate probing.

Parameter number	Meaning
Q151	Actual value of corner in reference axis
Q152	Actual value of corner in minor axis



Please note while programming:

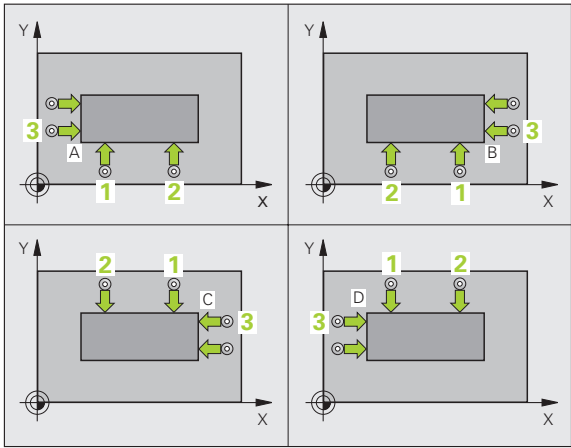


Before a cycle definition you must have programmed a tool call to define the touch probe axis.

The TNC always measures the first line in the direction of the minor axis of the working plane.

By defining the positions of the measuring points **1** and **3** you also determine the corner at which the TNC sets the datum (see figure at right and table at lower right).

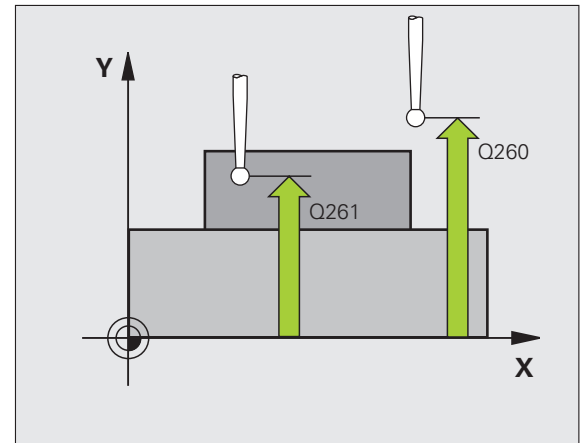
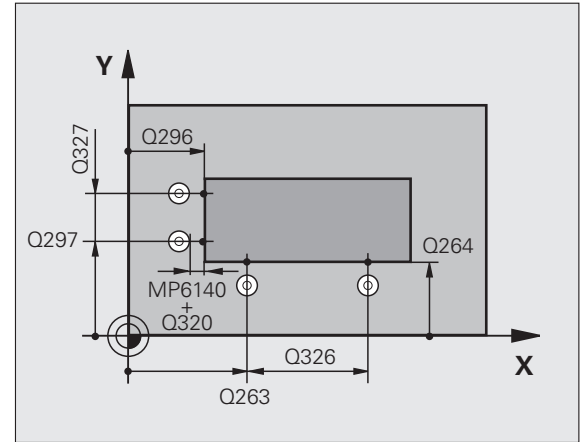
Corner	X coordinate	Y coordinate
A	Point 1 greater than point 3	Point 1 less than point 3
B	Point 1 less than point 3	Point 1 less than point 3
C	Point 1 less than point 3	Point 1 greater than point 3
D	Point 1 greater than point 3	Point 1 greater than point 3



Cycle parameters



- ▶ **1st meas. point 1st axis** Q263 (absolute):
Coordinate of the first touch point in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **1st meas. point 2nd axis** Q264 (absolute):
Coordinate of the first touch point in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Spacing in 1st axis** Q326 (incremental): Distance between the first and second measuring points in the reference axis of the working plane. Input range: 0 to 99999.9999
- ▶ **3rd meas. point 1st axis** Q296 (absolute):
Coordinate of the third touch point in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **3rd meas. point 2nd axis** Q297 (absolute):
Coordinate of the third touch point in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Spacing in 2nd axis** Q327 (incremental): Distance between third and fourth measuring points in the minor axis of the working plane. Input range: 0 to 99999.9999
- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**



- ▶ **Traversing to clearance height** Q301: Definition of how the touch probe is to move between the measuring points:
 - 0:** Move at measuring height between measuring points
 - 1:** Move at clearance height between measuring points
 Alternatively **PREDEF**
- ▶ **Execute basic rotation** Q304: Definition of whether the TNC should compensate workpiece misalignment with a basic rotation:
 - 0:** No basic rotation
 - 1:** Basic rotation
- ▶ **Datum number in table** Q305: Enter the datum number in the datum or preset table in which the TNC is to save the coordinates of the corner. If you enter Q305=0, the TNC automatically sets the display so that the new datum is on the corner. Input range: 0 to 2999
- ▶ **New datum for reference axis** Q331 (absolute): Coordinate in the reference axis at which the TNC should set the corner. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **New datum for minor axis** Q332 (absolute): Coordinate in the minor axis at which the TNC should set the calculated corner. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **Measured-value transfer (0, 1)** Q303: Specify whether the determined datum is to be saved in the datum table or in the preset table:
 - 1:** Do not use. Is entered by the TNC when old programs are read in (see "Saving the calculated datum" on page 332).
 - 0:** Write determined datum in the active datum table. The reference system is the active workpiece coordinate system.
 - 1:** Write determined datum in the preset table. The reference system is the machine coordinate system (REF system).



- ▶ **Probe in TS axis** Q381: Specify whether the TNC should also set the datum in the touch probe axis:
0: Do not set datum in the touch probe axis
1: Set datum in the touch probe axis
- ▶ **Probe TS axis: Coord. 1st axis** Q382 (absolute):
Coordinate of the probe point in the reference axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 2nd axis** Q383 (absolute):
Coordinate of the probe point in the minor axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 3rd axis** Q384 (absolute):
Coordinate of the probe point in the touch probe axis at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **New datum in TS axis** Q333 (absolute): Coordinate in the touch probe axis at which the TNC should set the datum. Default setting = 0. Input range: -99999.9999 to 99999.9999

Example: NC blocks

5 TCH PROBE 414 DATUM INSIDE CORNER
Q263=+37 ;1ST POINT 1ST AXIS
Q264=+7 ;1ST POINT 2ND AXIS
Q326=50 ;SPACING IN 1ST AXIS
Q296=+95 ;3RD POINT 1ST AXIS
Q297=+25 ;3RD POINT 2ND AXIS
Q327=45 ;SPACING IN 2ND AXIS
Q261=-5 ;MEASURING HEIGHT
Q320=0 ;SETUP CLEARANCE
Q260=+20 ;CLEARANCE HEIGHT
Q301=0 ;MOVE TO CLEARANCE
Q304=0 ;BASIC ROTATION
Q305=7 ;NO. IN TABLE
Q331=+0 ;DATUM
Q332=+0 ;DATUM
Q303=+1 ;MEAS. VALUE TRANSFER
Q381=1 ;PROBE IN TS AXIS
Q382=+85 ;1ST CO. FOR TS AXIS
Q383=+50 ;2ND CO. FOR TS AXIS
Q384=+0 ;3RD CO. FOR TS AXIS
Q333=+1 ;DATUM

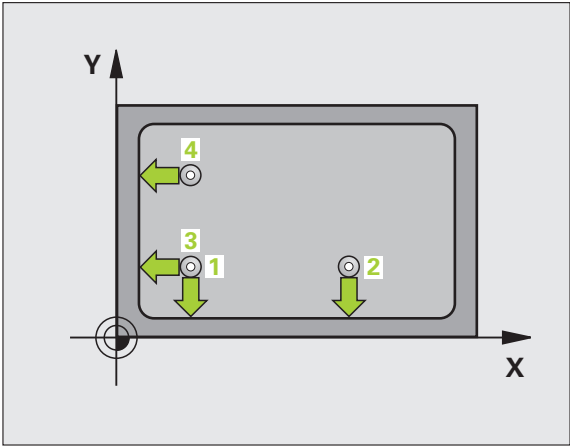
15.9 DATUM FROM INSIDE OF CORNER (Cycle 415, DIN/ISO: G415)

Cycle run

Touch Probe Cycle 415 finds the intersection of two lines and defines it as the datum. If desired, the TNC can also enter the intersection into a datum table or preset table.

- 1 Following the positioning logic (see “Executing touch probe cycles” on page 306), the TNC positions the touch probe at rapid traverse (value from MP6150 or MP6361) to the first touch point **1** (see figure at upper right) that you have defined in the cycle. The TNC offsets the touch probe by the safety clearance in the direction opposite the respective traverse direction.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360). The probing direction is derived from the number by which you identify the corner.
- 3 Then the touch probe moves to the next starting position **2** and probes the second position.
- 4 The TNC positions the probe to starting point **3** and then to starting point **4** to probe the third and fourth touch points.
- 5 Finally the TNC returns the touch probe to the clearance height and processes the determined datum depending on the cycle parameters Q303 and Q305 (see “Saving the calculated datum” on page 332) and saves the coordinates of the determined corner in the Q parameters listed below.
- 6 If desired, the TNC subsequently measures the datum in the touch probe axis in a separate probing.

Parameter number	Meaning
Q151	Actual value of corner in reference axis
Q152	Actual value of corner in minor axis



Please note while programming:



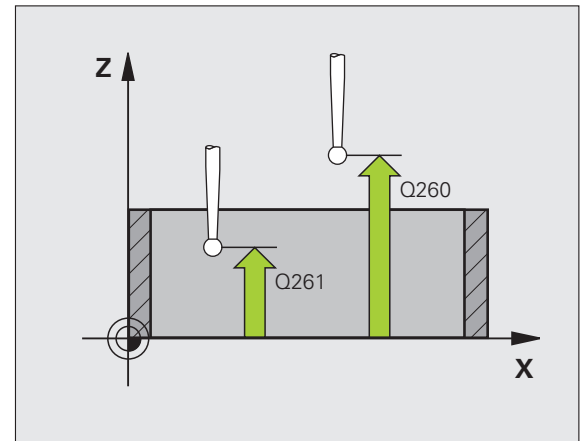
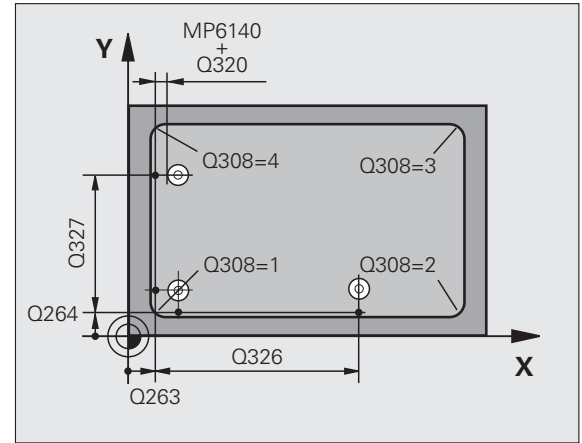
Before a cycle definition you must have programmed a tool call to define the touch probe axis.

The TNC always measures the first line in the direction of the minor axis of the working plane.

Cycle parameters



- ▶ **1st meas. point 1st axis** Q263 (absolute): Coordinate of the first touch point in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **1st meas. point 2nd axis** Q264 (absolute): Coordinate of the first touch point in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Spacing in 1st axis** Q326 (incremental): Distance between the first and second measuring points in the reference axis of the working plane. Input range: 0 to 99999.9999
- ▶ **Spacing in 2nd axis** Q327 (incremental): Distance between third and fourth measuring points in the minor axis of the working plane. Input range: 0 to 99999.9999
- ▶ **Corner** Q308: Number identifying the corner which the TNC is to set as datum. Input range: 1 to 4
- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**



- ▶ **Traversing to clearance height** Q301: Definition of how the touch probe is to move between the measuring points:
 - 0:** Move at measuring height between measuring points
 - 1:** Move at clearance height between measuring points
 Alternatively **PREDEF**
- ▶ **Execute basic rotation** Q304: Definition of whether the TNC should compensate workpiece misalignment with a basic rotation:
 - 0:** No basic rotation
 - 1:** Basic rotation
- ▶ **Datum number in table** Q305: Enter the datum number in the datum or preset table in which the TNC is to save the coordinates of the corner. If you enter Q305=0, the TNC automatically sets the display so that the new datum is on the corner. Input range: 0 to 2999
- ▶ **New datum for reference axis** Q331 (absolute): Coordinate in the reference axis at which the TNC should set the corner. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **New datum for minor axis** Q332 (absolute): Coordinate in the minor axis at which the TNC should set the calculated corner. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **Measured-value transfer (0, 1)** Q303: Specify whether the determined datum is to be saved in the datum table or in the preset table:
 - 1:** Do not use. Is entered by the TNC when old programs are read in (see "Saving the calculated datum" on page 332).
 - 0:** Write determined datum in the active datum table. The reference system is the active workpiece coordinate system.
 - 1:** Write determined datum in the preset table. The reference system is the machine coordinate system (REF system).



- ▶ **Probe in TS axis** Q381: Specify whether the TNC should also set the datum in the touch probe axis:
0: Do not set datum in the touch probe axis
1: Set datum in the touch probe axis
- ▶ **Probe TS axis: Coord. 1st axis** Q382 (absolute):
Coordinate of the probe point in the reference axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 2nd axis** Q383 (absolute):
Coordinate of the probe point in the minor axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 3rd axis** Q384 (absolute):
Coordinate of the probe point in the touch probe axis at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **New datum in TS axis** Q333 (absolute): Coordinate in the touch probe axis at which the TNC should set the datum. Default setting = 0. Input range: -99999.9999 to 99999.9999

Example: NC blocks

5	TCH	PROBE	415	DATUM	OUTSIDE	CORNER
Q263	=+37					;1ST POINT 1ST AXIS
Q264	=+7					;1ST POINT 2ND AXIS
Q326	=50					;SPACING IN 1ST AXIS
Q296	=+95					;3RD POINT 1ST AXIS
Q297	=+25					;3RD POINT 2ND AXIS
Q327	=45					;SPACING IN 2ND AXIS
Q261	=-5					;MEASURING HEIGHT
Q320	=0					;SETUP CLEARANCE
Q260	=+20					;CLEARANCE HEIGHT
Q301	=0					;MOVE TO CLEARANCE
Q304	=0					;BASIC ROTATION
Q305	=7					;NO. IN TABLE
Q331	=+0					;DATUM
Q332	=+0					;DATUM
Q303	=+1					;MEAS. VALUE TRANSFER
Q381	=1					;PROBE IN TS AXIS
Q382	=+85					;1ST CO. FOR TS AXIS
Q383	=+50					;2ND CO. FOR TS AXIS
Q384	=+0					;3RD CO. FOR TS AXIS
Q333	=+1					;DATUM

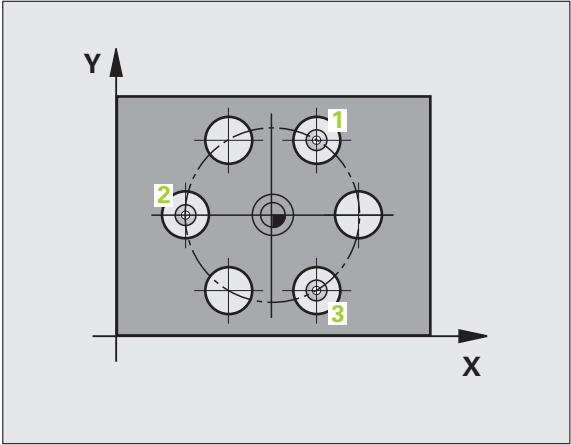
15.10 DATUM CIRCLE CENTER (Cycle 416, DIN/ISO: G416)

Cycle run

Touch Probe Cycle 416 finds the center of a bolt hole circle and defines its center as datum. If desired, the TNC can also enter the coordinates into a datum table or the preset table.

- 1 Following the positioning logic (see "Executing touch probe cycles" on page 306), the TNC positions the touch probe at rapid traverse (value from MP6150 or MP6361) to the point entered as center of the first hole **1**.
- 2 Then the probe moves to the entered measuring height and probes four points to find the first hole center.
- 3 The touch probe returns to the clearance height and then to the position entered as center of the second hole **2**.
- 4 The TNC moves the touch probe to the entered measuring height and probes four points to find the second hole center.
- 5 The touch probe returns to the clearance height and then to the position entered as center of the third hole **3**.
- 6 The TNC moves the touch probe to the entered measuring height and probes four points to find the third hole center.
- 7 Finally the TNC returns the touch probe to the clearance height and processes the determined datum depending on the cycle parameters Q303 and Q305 (see "Saving the calculated datum" on page 332) and saves the actual values in the Q parameters listed below.
- 8 If desired, the TNC subsequently measures the datum in the touch probe axis in a separate probing.

Parameter number	Meaning
Q151	Actual value of center in reference axis
Q152	Actual value of center in minor axis
Q153	Actual value of bolt hole circle diameter



Please note while programming:

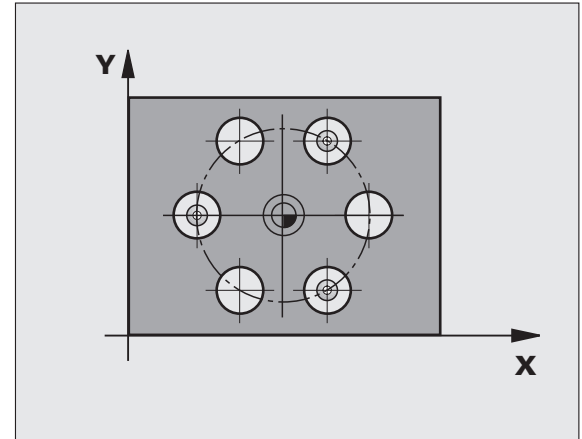
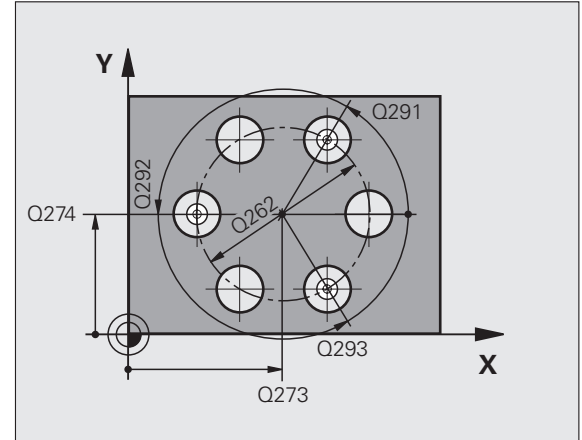


Before a cycle definition you must have programmed a tool call to define the touch probe axis.

Cycle parameters



- ▶ **Center in 1st axis** Q273 (absolute): Bolt hole circle center (nominal value) in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Center in 2nd axis** Q274 (absolute): Bolt hole circle center (nominal value) in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Nominal diameter** Q262: Enter the approximate bolt hole circle diameter. The smaller the hole diameter, the more exact the nominal diameter must be. Input range: -0 to 99999.9999
- ▶ **Angle of 1st hole** Q291 (absolute): Polar coordinate angle of the first hole center in the working plane. Input range: -360.0000 to 360.0000
- ▶ **Angle of 2nd hole** Q292 (absolute): Polar coordinate angle of the second hole center in the working plane. Input range: -360.0000 to 360.0000
- ▶ **Angle of 3rd hole** Q293 (absolute): Polar coordinate angle of the third hole center in the working plane. Input range: -360.0000 to 360.0000
- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range: -99999.9999 to 99999.9999, alternatively **PREDEF**



- ▶ **Datum number in table** Q305: Enter the number in the datum or preset table in which the TNC is to save the coordinates of the bolt-hole circle center. If you enter Q305=0, the TNC automatically sets the display so that the new datum is on the bolt hole center. Input range: 0 to 2999
- ▶ **New datum for reference axis** Q331 (absolute): Coordinate in the reference axis at which the TNC should set the bolt-hole center. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **New datum for minor axis** Q332 (absolute): Coordinate in the minor axis at which the TNC should set the bolt-hole center. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **Measured-value transfer (0, 1)** Q303: Specify whether the determined datum is to be saved in the datum table or in the preset table:
 - 1:** Do not use. Is entered by the TNC when old programs are read in (see "Saving the calculated datum" on page 332).
 - 0:** Write determined datum in the active datum table. The reference system is the active workpiece coordinate system.
 - 1:** Write determined datum in the preset table. The reference system is the machine coordinate system (REF system).



- ▶ **Probe in TS axis** Q381: Specify whether the TNC should also set the datum in the touch probe axis:
0: Do not set datum in the touch probe axis
1: Set datum in the touch probe axis
- ▶ **Probe TS axis: Coord. 1st axis** Q382 (absolute):
 Coordinate of the probe point in the reference axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 2nd axis** Q383 (absolute):
 Coordinate of the probe point in the minor axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 3rd axis** Q384 (absolute):
 Coordinate of the probe point in the touch probe axis at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **New datum in TS axis** Q333 (absolute): Coordinate in the touch probe axis at which the TNC should set the datum. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140, and is only effective when the datum is probed in the touch probe axis. Input range 0 to 99999.9999, alternatively **PREDEF**

Example: NC blocks

5 TCH PROBE 416 DATUM CIRCLE CENTER
Q273=+50 ;CENTER IN 1ST AXIS
Q274=+50 ;CENTER IN 2ND AXIS
Q262=90 ;NOMINAL DIAMETER
Q291=+34 ;ANGLE OF 1ST HOLE
Q292=+70 ;ANGLE OF 2ND HOLE
Q293=+210 ;ANGLE OF 3RD HOLE
Q261=-5 ;MEASURING HEIGHT
Q260=+20 ;CLEARANCE HEIGHT
Q305=12 ;NO. IN TABLE
Q331=+0 ;DATUM
Q332=+0 ;DATUM
Q303=+1 ;MEAS. VALUE TRANSFER
Q381=1 ;PROBE IN TS AXIS
Q382=+85 ;1ST CO. FOR TS AXIS
Q383=+50 ;2ND CO. FOR TS AXIS
Q384=+0 ;3RD CO. FOR TS AXIS
Q333=+1 ;DATUM
Q320=0 ;SETUP CLEARANCE

15.11 DATUM IN TOUCH PROBE AXIS (Cycle 417, DIN/ISO: G417)


Cycle run

Touch Probe Cycle 417 measures any coordinate in the touch probe axis and defines it as datum. If desired, the TNC can also enter the measured coordinate in a datum table or preset table.

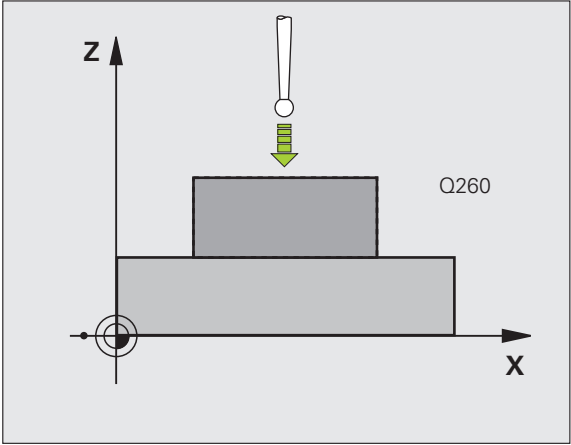
- 1 Following the positioning logic (see "Executing touch probe cycles" on page 306), the TNC positions the touch probe to the programmed starting point 1 at rapid traverse (value from MP6150 or MP6361). The TNC offsets the touch probe by the safety clearance in the positive direction of the touch probe axis.
- 2 Then the touch probe moves in its own axis to the coordinate entered as starting point 1 and measures the actual position with a simple probing movement.
- 3 Finally the TNC returns the touch probe to the clearance height and processes the determined datum depending on the cycle parameters Q303 and Q305 (see "Saving the calculated datum" on page 332) and saves the actual values in the Q parameters listed below.

Parameter number	Meaning
Q160	Actual value of measured point

Please note while programming:



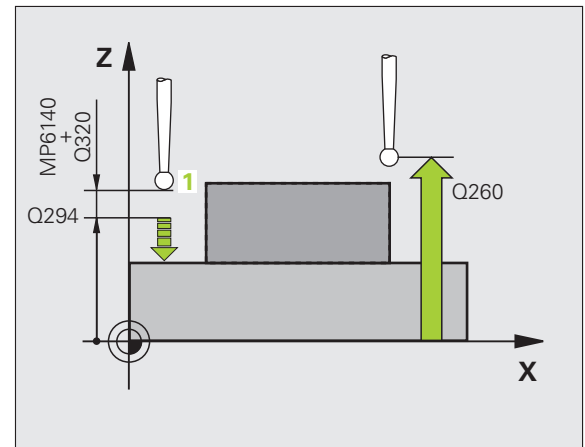
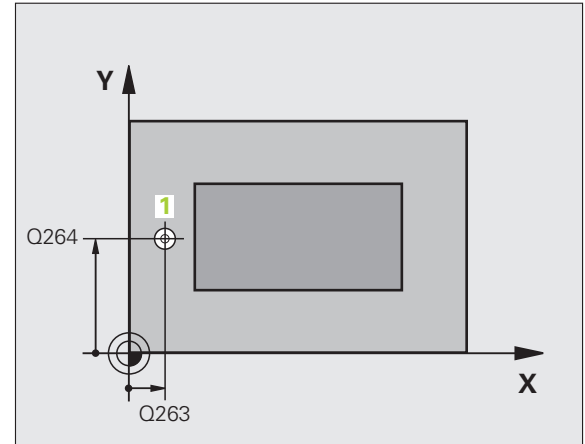
Before a cycle definition you must have programmed a tool call to define the touch probe axis. The TNC then sets the datum in this axis.



Cycle parameters



- ▶ **1st meas. point 1st axis** Q263 (absolute):
Coordinate of the first touch point in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **1st meas. point 2nd axis** Q264 (absolute):
Coordinate of the first touch point in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **1st meas. point 3rd axis** Q294 (absolute):
Coordinate of the first touch point in the touch probe axis. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Datum number in table** Q305: Enter the number in the datum or preset table in which the TNC is to save the coordinate. If you enter Q305=0, the TNC automatically sets the display so that the new datum is on the probed surface. Input range: 0 to 2999
- ▶ **New datum in TS axis** Q333 (absolute): Coordinate in the touch probe axis at which the TNC should set the datum. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **Measured-value transfer (0, 1)** Q303: Specify whether the determined datum is to be saved in the datum table or in the preset table:
-1: Do not use. Is entered by the TNC when old programs are read in (see "Saving the calculated datum" on page 332).
0: Write determined datum in the active datum table. The reference system is the active workpiece coordinate system.
1: Write determined datum in the preset table. The reference system is the machine coordinate system (REF system).



Example: NC blocks

```

5 TCH PROBE 417 DATUM IN TS AXIS
  Q263=+25 ;1ST POINT 1ST AXIS
  Q264=+25 ;1ST POINT 2ND AXIS
  Q294=+25 ;1ST POINT 3RD AXIS
  Q320=0   ;SETUP CLEARANCE
  Q260=+50 ;CLEARANCE HEIGHT
  Q305=0   ;NO. IN TABLE
  Q333=+0  ;DATUM
  Q303=+1  ;MEAS. VALUE TRANSFER
  
```

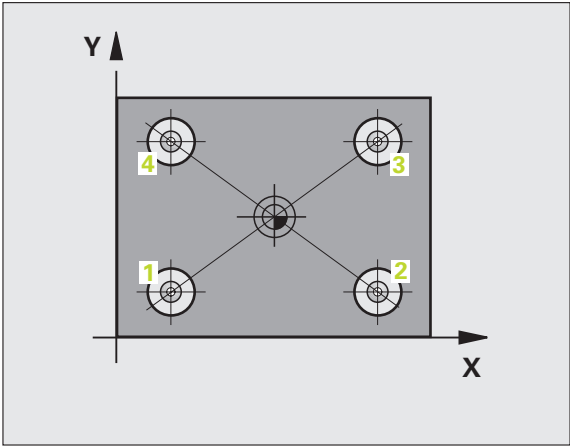
15.12 DATUM AT CENTER OF 4 HOLES (Cycle 418, DIN/ISO: G418)

Cycle run

Touch Probe Cycle 418 calculates the intersection of the lines connecting opposite holes and sets the datum at the intersection. If desired, the TNC can also enter the intersection into a datum table or preset table.

- 1 Following the positioning logic (see "Executing touch probe cycles" on page 306), the TNC positions the touch probe at rapid traverse (value from MP6150 or MP6361) to the center of the first hole **1**.
- 2 Then the probe moves to the entered measuring height and probes four points to find the first hole center.
- 3 The touch probe returns to the clearance height and then to the position entered as center of the second hole **2**.
- 4 The TNC moves the touch probe to the entered measuring height and probes four points to find the second hole center.
- 5 The TNC repeats steps 3 and 4 for the holes **3** and **4**.
- 6 Finally the TNC returns the touch probe to the clearance height and processes the determined datum depending on the cycle parameters Q303 and Q305 (see "Saving the calculated datum" on page 332). The TNC calculates the datum as the intersection of the lines connecting the centers of holes **1/3** and **2/4** and saves the actual values in the Q parameters listed below.
- 7 If desired, the TNC subsequently measures the datum in the touch probe axis in a separate probing.

Parameter number	Meaning
Q151	Actual value of intersection point in reference axis
Q152	Actual value of intersection point in minor axis



Please note while programming:

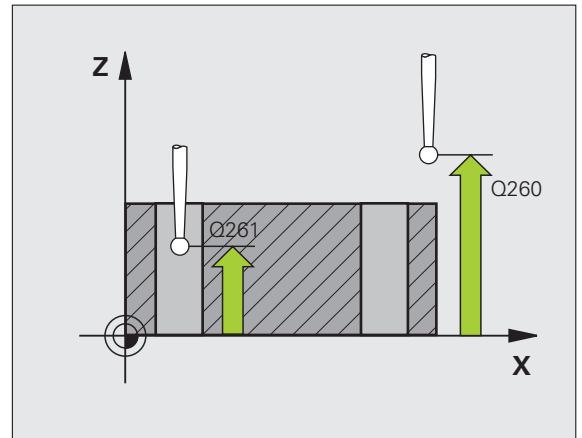
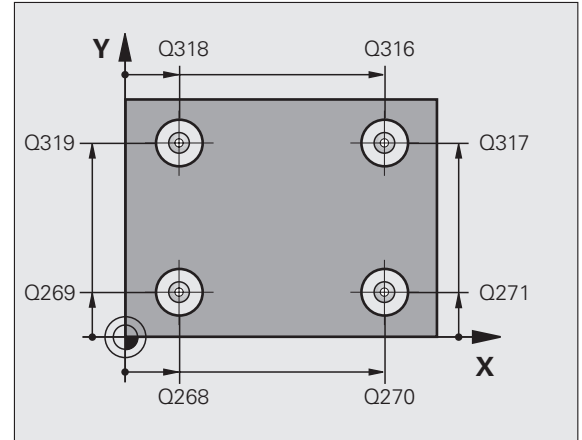


Before a cycle definition you must have programmed a tool call to define the touch probe axis.

Cycle parameters



- ▶ **First center in 1st axis** Q268 (absolute): center of the 1st hole in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **First center in 2nd axis** Q269 (absolute): center of the 1st hole in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **First center in 1st axis** Q270 (absolute): center of the 2nd hole in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **First center in 2nd axis** Q271 (absolute): center of the 2nd hole in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **First center in 1st axis** Q316 (absolute): center of the 3rd hole in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **3rd center in 2nd axis** Q317 (absolute): center of the 3rd hole in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **4th center in 1st axis** Q318 (absolute): center of the 4th hole in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **4th center in 2nd axis** Q319 (absolute): center of the 4th hole in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range: -99999.9999 to 99999.9999, alternatively **PREDEF**



- ▶ **Datum number in table** Q305: Enter the number in the datum or preset table in which the TNC is to save the coordinates of the line intersection. If you enter Q305=0, the TNC automatically sets the display so that the new datum is at the intersection of the connecting lines. Input range: 0 to 2999
- ▶ **New datum for reference axis** Q331 (absolute): Coordinate in the reference axis at which the TNC should set the calculated intersection of the connecting lines. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **New datum for minor axis** Q332 (absolute): Coordinate in the minor axis at which the TNC should set the calculated intersection of the connecting lines. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **Measured-value transfer (0, 1)** Q303: Specify whether the determined datum is to be saved in the datum table or in the preset table:
 - 1:** Do not use. Is entered by the TNC when old programs are read in (see "Saving the calculated datum" on page 332).
 - 0:** Write determined datum in the active datum table. The reference system is the active workpiece coordinate system.
 - 1:** Write determined datum in the preset table. The reference system is the machine coordinate system (REF system).



- ▶ **Probe in TS axis** Q381: Specify whether the TNC should also set the datum in the touch probe axis:
0: Do not set datum in the touch probe axis
1: Set datum in the touch probe axis
- ▶ **Probe TS axis: Coord. 1st axis** Q382 (absolute):
Coordinate of the probe point in the reference axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1.
- ▶ **Probe TS axis: Coord. 2nd axis** Q383 (absolute):
Coordinate of the probe point in the minor axis of the working plane at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **Probe TS axis: Coord. 3rd axis** Q384 (absolute):
Coordinate of the probe point in the touch probe axis at which point the datum is to be set in the touch probe axis. Only effective if Q381 = 1. Input range -99999.9999 to 99999.9999
- ▶ **New datum in TS axis** Q333 (absolute): Coordinate in the touch probe axis at which the TNC should set the datum. Default setting = 0. Input range: -99999.9999 to 99999.9999

Example: NC blocks

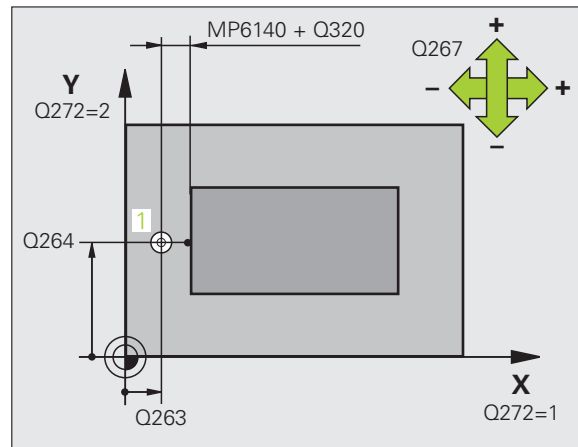
5 TCH PROBE 418 DATUM FROM 4 HOLES
Q268=+20 ;1ST CENTER IN 1ST AXIS
Q269=+25 ;1ST CENTER IN 2ND AXIS
Q270=+150 ;2ND CENTER IN 1ST AXIS
Q271=+25 ;2ND CENTER IN 2ND AXIS
Q316=+150 ;3RD CENTER IN 1ST AXIS
Q317=+85 ;3RD CENTER IN 2ND AXIS
Q318=+22 ;4TH CENTER IN 1ST AXIS
Q319=+80 ;4TH CENTER IN 2ND AXIS
Q261=-5 ;MEASURING HEIGHT
Q260=+10 ;CLEARANCE HEIGHT
Q305=12 ;NO. IN TABLE
Q331=+0 ;DATUM
Q332=+0 ;DATUM
Q303=+1 ;MEAS. VALUE TRANSFER
Q381=1 ;PROBE IN TS AXIS
Q382=+85 ;1ST CO. FOR TS AXIS
Q383=+50 ;2ND CO. FOR TS AXIS
Q384=+0 ;3RD CO. FOR TS AXIS
Q333=+0 ;DATUM

15.13 DATUM IN ONE AXIS (Cycle 419, DIN/ISO: G419)

Cycle run

Touch Probe Cycle 419 measures any coordinate in any axis and defines it as datum. If desired, the TNC can also enter the measured coordinate in a datum table or preset table.

- 1 Following the positioning logic (see "Executing touch probe cycles" on page 306), the TNC positions the touch probe to the programmed starting point 1 at rapid traverse (value from MP6150 or MP6361). The TNC offsets the touch probe by the safety clearance in the direction opposite the programmed probing direction.
- 2 Then the touch probe moves to the programmed measuring height and measures the actual position with a simple probing movement.
- 3 Finally the TNC returns the touch probe to the clearance height and processes the determined datum depending on the cycle parameters Q303 and Q305. (see "Saving the calculated datum" on page 332)



Please note while programming:



Before a cycle definition you must have programmed a tool call to define the touch probe axis.

If you use Cycle 419 several times in succession to save the datum in more than one axis in the preset table, you must activate the preset number last written to by Cycle 419 after every execution of Cycle 419 (this is not required if you overwrite the active preset).

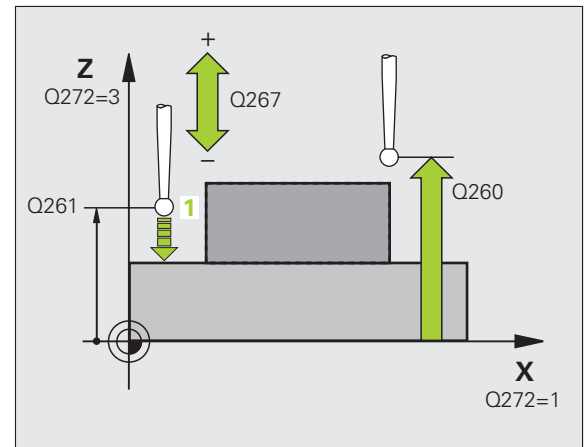
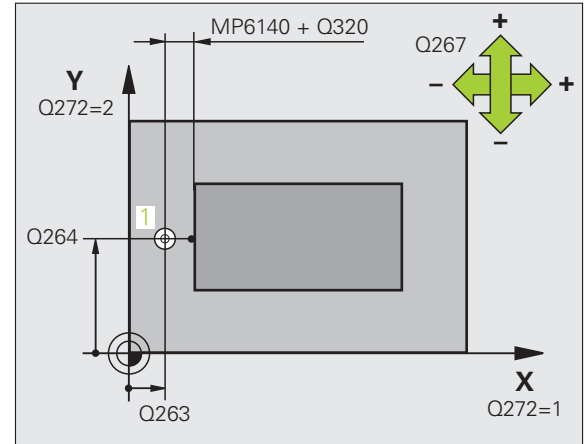


Cycle parameters



- ▶ **1st meas. point 1st axis** Q263 (absolute):
Coordinate of the first touch point in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **1st meas. point 2nd axis** Q264 (absolute):
Coordinate of the first touch point in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Measuring axis (1...3: 1=reference axis) Q272:**
Axis in which the measurement is to be made:
 1: Reference axis = measuring axis
 2: Minor axis = measuring axis
 3: Touch probe axis = measuring axis

Axis assignment		
Active touch probe axis: Q272= 3	Corresponding reference axis: Q272 = 1	Corresponding minor axis: Q272 = 2
Z	X	Y
Y	Z	X
X	Y	Z



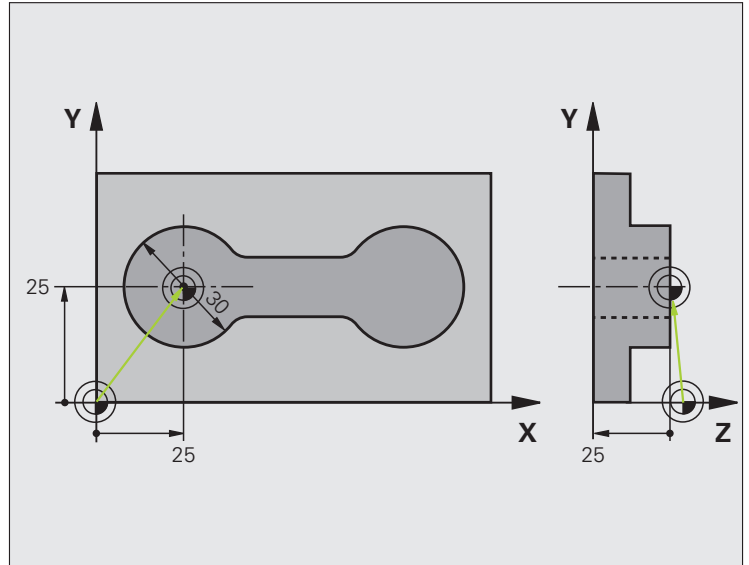
- ▶ **Traverse direction** Q267: Direction in which the probe is to approach the workpiece:
-1: Negative traverse direction
+1: Positive traverse direction
- ▶ **Datum number in table** Q305: Enter the number in the datum or preset table in which the TNC is to save the coordinate. If you enter Q305=0, the TNC automatically sets the display so that the new datum is on the probed surface. Input range: 0 to 2999
- ▶ **New datum** Q333 (absolute): Coordinate at which the TNC should set the datum. Default setting = 0. Input range: -99999.9999 to 99999.9999
- ▶ **Measured-value transfer (0, 1)** Q303: Specify whether the determined datum is to be saved in the datum table or in the preset table:
-1: Do not use. See "Saving the calculated datum," page 332
0: Write determined datum in the active datum table. The reference system is the active workpiece coordinate system.
1: Write determined datum in the preset table. The reference system is the machine coordinate system (REF system).

Example: NC blocks

5	TCH	PROBE	419	DATUM	IN	ONE	AXIS
Q263	=+25						;1ST POINT 1ST AXIS
Q264	=+25						;1ST POINT 2ND AXIS
Q261	=+25						;MEASURING HEIGHT
Q320	=0						;SETUP CLEARANCE
Q260	=+50						;CLEARANCE HEIGHT
Q272	=+1						;MEASURING AXIS
Q267	=+1						;TRAVERSE DIRECTION
Q305	=0						;NO. IN TABLE
Q333	=+0						;DATUM
Q303	=+1						;MEAS. VALUE TRANSFER



Example: Datum setting in center of a circular segment and on top surface of workpiece



0 BEGIN PGM CYC413 MM

1 TOOL CALL 69 Z

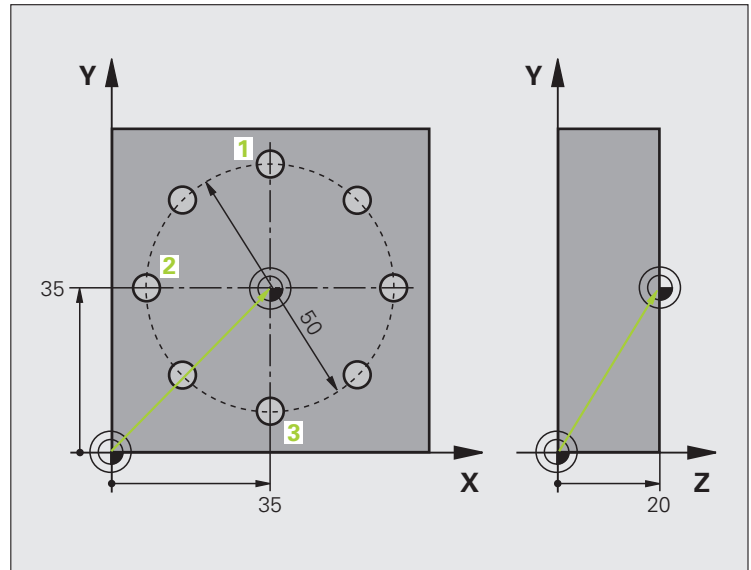
Call tool 0 to define the touch probe axis

2 TCH PROBE 413 DATUM OUTSIDE CIRCLE	
Q321=+25 ;CENTER IN 1ST AXIS	Center of circle: X coordinate
Q322=+25 ;CENTER IN 2ND AXIS	Center of circle: Y coordinate
Q262=30 ;NOMINAL DIAMETER	Diameter of circle
Q325=+90 ;STARTING ANGLE	Polar coordinate angle for 1st touch point
Q247=+45 ;STEPPING ANGLE	Stepping angle for calculating the starting points 2 to 4
Q261=-5 ;MEASURING HEIGHT	Coordinate in the touch probe axis in which the measurement is made
Q320=2 ;SETUP CLEARANCE	Safety clearance in addition to MP6140
Q260=+10 ;CLEARANCE HEIGHT	Height in the touch probe axis at which the probe can traverse without collision
Q301=0 ;MOVE TO CLEARANCE	Do not move to clearance height between measuring points
Q305=0 ;NO. IN TABLE	Set display
Q331=+0 ;DATUM	Set the display in X to 0
Q332=+10 ;DATUM	Set the display in Y to 10
Q303=+0 ;MEAS. VALUE TRANSFER	Without function, since display is to be set
Q381=1 ;PROBE IN TS AXIS	Also set datum in the touch probe axis
Q382=+25 ;1ST CO. FOR TS AXIS	X coordinate of touch point
Q383=+25 ;2ND CO. FOR TS AXIS	Y coordinate of touch point
Q384=+25 ;3RD CO. FOR TS AXIS	Z coordinate of touch point
Q333=+0 ;DATUM	Set the display in Z to 0
3 CALL PGM 35K47	Part program call
4 END PGM CYC413 MM	



Example: Datum setting on top surface of workpiece and in center of a bolt hole circle

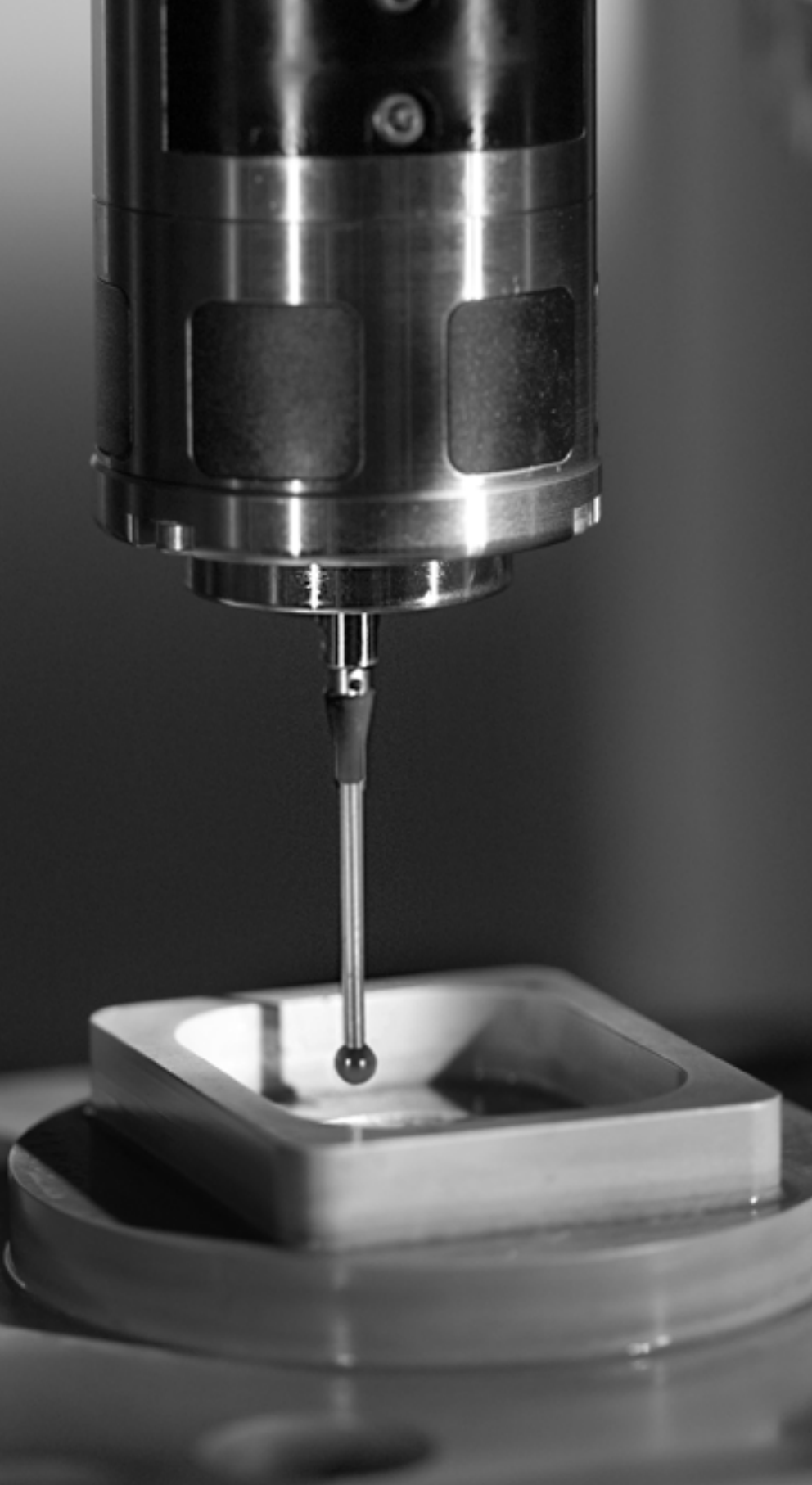
The measured bolt hole center shall be written in the preset table so that it may be used at a later time.



0 BEGIN PGM CYC416 MM	
1 TOOL CALL 69 Z	Call tool 0 to define the touch probe axis
2 TCH PROBE 417 DATUM IN TS AXIS	Cycle definition for datum setting in the touch probe axis
Q263=+7,5 ;1ST POINT 1ST AXIS	Touch point: X coordinate
Q264=+7,5 ;1ST POINT 2ND AXIS	Touch point: Y coordinate
Q294=+25 ;1ST POINT 3RD AXIS	Touch point: Z coordinate
Q320=0 ;SETUP CLEARANCE	Safety clearance in addition to MP6140
Q260=+50 ;CLEARANCE HEIGHT	Height in the touch probe axis at which the probe can traverse without collision
Q305=1 ;NO. IN TABLE	Write Z coordinate in line 1
Q333=+0 ;DATUM	Set touch-probe axis to 0
Q303=+1 ;MEAS. VALUE TRANSFER	In the preset table PRESET.PR, save the calculated datum referenced to the machine-based coordinate system (REF system)

3 TCH PROBE 416 DATUM CIRCLE CENTER	
Q273=+35 ;CENTER IN 1ST AXIS	Center of the bolt hole circle: X coordinate
Q274=+35 ;CENTER IN 2ND AXIS	Center of the bolt hole circle: Y coordinate
Q262=50 ;NOMINAL DIAMETER	Diameter of the bolt hole circle
Q291=+90 ;ANGLE OF 1ST HOLE	Polar coordinate angle for 1st hole center 1
Q292=+180 ;ANGLE OF 2ND HOLE	Polar coordinate angle for 2nd hole center 2
Q293=+270 ;ANGLE OF 3RD HOLE	Polar coordinate angle for 3rd hole center 3
Q261=+15 ;MEASURING HEIGHT	Coordinate in the touch probe axis in which the measurement is made
Q260=+10 ;CLEARANCE HEIGHT	Height in the touch probe axis at which the probe can traverse without collision
Q305=1 ;NO. IN TABLE	Enter center of bolt hole circle (X and Y) in line 1
Q331=+0 ;DATUM	
Q332=+0 ;DATUM	
Q303=+1 ;MEAS. VALUE TRANSFER	In the preset table PRESET.PR, save the calculated datum referenced to the machine-based coordinate system (REF system)
Q381=0 ;PROBE IN TS AXIS	Do not set a datum in the touch probe axis
Q382=+0 ;1ST CO. FOR TS AXIS	No function
Q383=+0 ;2ND CO. FOR TS AXIS	No function
Q384=+0 ;3RD CO. FOR TS AXIS	No function
Q333=+0 ;DATUM	No function
4 CYCL DEF 247 DATUM SETTING	Activate new preset with Cycle 247
Q339=1 ;DATUM NUMBER	
6 CALL PGM 35KLZ	Part program call
7 END PGM CYC416 MM	





16













**Touch Probe Cycles:
Automatic Workpiece
Inspection**



16.1 Fundamentals

Overview

The TNC offers twelve cycles for measuring workpieces automatically.

Cycle	Soft key	Page
0 REFERENCE PLANE Measuring a coordinate in a selectable axis		Page 390
1 POLAR DATUM PLANE Measuring a point in a probing direction		Page 391
420 MEASURE ANGLE Measuring an angle in the working plane		Page 392
421 MEASURE HOLE Measuring the position and diameter of a hole		Page 395
422 MEAS. CIRCLE OUTSIDE Measuring the position and diameter of a circular stud		Page 399
423 MEAS. RECTAN. INSIDE Measuring the position, length and width of a rectangular pocket		Page 403
424 MEAS. RECTAN. OUTSIDE Measuring the position, length and width of a rectangular stud		Page 407
425 MEASURE INSIDE WIDTH (2nd soft-key row) Measuring slot width		Page 411
426 MEASURE RIDGE WIDTH (2nd soft-key row) Measuring the width of a ridge		Page 414
427 MEASURE COORDINATE (2nd soft-key row) Measuring any coordinate in a selectable axis		Page 417
430 MEAS. BOLT HOLE CIRC. (2nd soft-key row) Measuring position and diameter of a bolt hole circle		Page 420
431 MEASURE PLANE (2nd soft-key row) Measuring the A and B axis angles of a plane		Page 424

Recording the results of measurement

For all cycles in which you automatically measure workpieces (with the exception of Cycles 0 and 1), you can have the TNC record the measurement results. In the respective probing cycle you can define if the TNC is to

- Save the measuring log to a file.
- Interrupt the program run and display the measuring log on the screen.
- Create no measuring log.

If you want to save the measuring log as a file, the TNC, by default, saves the measuring log as an ASCII file in the directory from which you run the measuring program. As an alternative, you can also send the measuring log directly to a printer or transfer it to a PC via the data interface. To do this, set the print function (in the interface configuration menu) to RS232:\ (see also the User's Manual under "MOD Functions, Setting Up the Data Interface").



All measured values listed in the log file are referenced to the datum active during the respective cycle you are running. In addition, the coordinate system may have been rotated in the plane or the plane may have been tilted by using 3D-ROT. In this case, the TNC converts the measuring results to the respective active coordinate system.

Use the HEIDENHAIN data transfer software TNCremo if you wish to output the measuring log via the data interface.



Example: Measuring log for touch probe cycle 421:

Measuring log for Probing Cycle 421 Hole Measuring

Date: 30-06-2005

Time: 6:55:04

Measuring program: TNC:\GEH35712\CHECK1.H

Nominal values: Center in reference axis: 50.0000

Center in minor axis: 65.0000

Diameter: 12.0000

Given limit values: Maximum dimension for center in reference axis:

50.1000 Minimum limit for center in reference axis: 49.9000

Maximum limit for center in minor axis: 65.1000

Minimum limit for center in minor axis: 64.9000

Maximum dimension for hole: 12.0450

Minimum dimension for hole: 12.0000

Actual values: Center in reference axis: 50.0810

Center in minor axis: 64.9530

Diameter: 12.0259

Deviations: Center in reference axis: 0.0810

Center in minor axis: -0.0470

Diameter: 0.0259

Further measuring results: Measuring height: -5.0000

End of measuring log

Measurement results in Q parameters

The TNC saves the measurement results of the respective touch probe cycle in the globally effective Q parameters Q150 to Q160. Deviations from the nominal value are saved in the parameters Q161 to Q166. Note the table of result parameters that are listed with every cycle description.

During cycle definition the TNC also shows the result parameters for the respective cycle in a help graphic (see figure at upper right). The highlighted result parameter belongs to that input parameter.

Classification of results

For some cycles you can inquire the status of measuring results through the globally effective Q parameters Q180 to Q182:

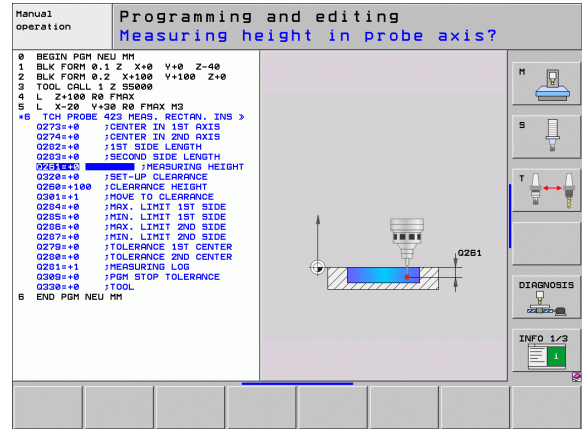
Class of results	Parameter value
Measurement results are within tolerance	Q180 = 1
Rework is required	Q181 = 1
Scrap	Q182 = 1

The TNC sets the rework or scrap marker as soon as one of the measuring values falls outside of tolerance. To determine which of the measuring results lies outside of tolerance, check the measuring log, or compare the respective measuring results (Q150 to Q160) with their limit values.

In Cycle 427 the TNC assumes that you are measuring an outside dimension (stud). However, you can correct the status of the measurement by entering the correct maximum and minimum dimension together with the probing direction.



The TNC also sets the status markers if you have not defined any tolerance values or maximum/minimum dimensions.



Tolerance monitoring

For most of the cycles for workpiece inspection you can have the TNC perform tolerance monitoring. This requires that you define the necessary limit values during cycle definition. If you do not wish to monitor for tolerances, simply leave the 0 (the default value) in the monitoring parameters.

Tool monitoring

For some cycles for workpiece inspection you can have the TNC perform tool monitoring. The TNC then monitors whether

- The tool radius should be compensated because of the deviations from the nominal value (values in Q16x).
- The deviations from the nominal value (values in Q16x) are greater than the tool breakage tolerance.

Tool compensation



This function works only:

- If the tool table is active.
- If tool monitoring is switched on in the cycle (enter a tool name or **Q330** unequal to 0. Select the tool name input by soft key. Specifically to AWT Weber: The TNC no longer displays the right single quotation mark.

If you perform several compensation measurements, the TNC adds the respective measured deviation to the value stored in the tool table.

The TNC always compensates the tool radius in the DR column of the tool table, even if the measured deviation lies within the given tolerance. You can inquire whether re-working is necessary via Parameter Q181 in the NC program (Q181=1: must be reworked).

For Cycle 427:

- If an axis of the active working plane is defined as measuring axis (Q272 = 1 or 2), the TNC compensates the tool radius as described above. From the defined traversing direction (Q267) the TNC determines the direction of compensation.
- If the touch probe axis is defined as measuring axis (Q272 = 3), the TNC compensates the tool length.

Tool breakage monitoring



This function works only:

- If the tool table is active.
- If tool monitoring is switched on in the cycle (enter Q330 not equal to 0).
- If the breakage tolerance RBREAK for the tool number entered in the table is greater than 0 (see also the User's Manual, section 5.2 "Tool Data").

The TNC will output an error message and stop program run if the measured deviation is greater than the breakage tolerance of the tool. At the same time the tool will be deactivated in the tool table (column TL = L).

Reference system for measurement results

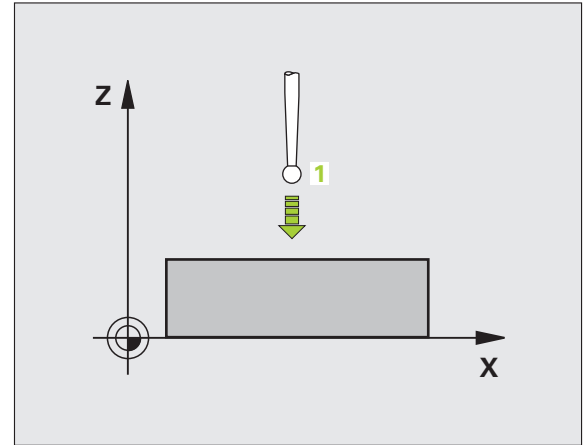
The TNC transfers all the measurement results to the result parameters and the protocol file in the active coordinate system, or as the case may be, the shifted or/and rotated/tilted coordinate system.



16.2 REF. PLANE (Cycle 0, DIN/ISO: G55)

Cycle run

- 1 The touch probe moves at rapid traverse (value from MP6150 or MP6361) to the starting position **1** programmed in the cycle.
- 2 Then the touch probe approaches the workpiece at the feed rate assigned in MP6120 or MP6360. The probing direction is to be defined in the cycle.
- 3 After the TNC has saved the position, the probe retracts to the starting point and saves the measured coordinate in a Q parameter. The TNC also stores the coordinates of the touch probe position at the time of the triggering signal in the parameters Q115 to Q119. For the values in these parameters the TNC does not account for the stylus length and radius.



Please note while programming:



Danger of collision!

Pre-position the touch probe in order to avoid a collision when the programmed pre-positioning point is approached.

Cycle parameters



- ▶ **Parameter number for result:** Enter the number of the Q parameter to which you want to assign the coordinate. Input range: 0 to 1999
- ▶ **Probing axis/Probing direction:** Enter the probing axis with the axis selection keys or ASCII keyboard and the algebraic sign for the probing direction. Confirm your entry with the ENT key. Input range: All NC axes
- ▶ **Nominal position value:** Use the axis selection keys or the ASCII keyboard to enter all coordinates of the nominal pre-positioning point values for the touch probe. Input range: -99999.9999 to 99999.9999
- ▶ To conclude the input, press the ENT key.

Example: NC blocks

```
67 TCH PROBE 0.0 REF. PLANE Q5 X-
```

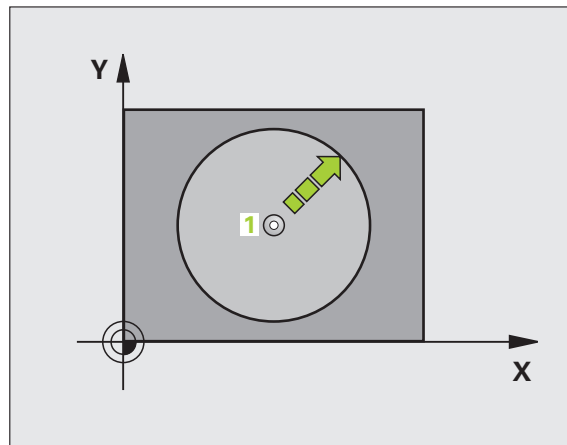
```
68 TCH PROBE 0.1 X+5 Y+0 Z-5
```

16.3 POLAR REFERENCE PLANE (Cycle 1, DIN/ISO)

Cycle run

Touch Probe Cycle 1 measures any position on the workpiece in any direction.

- 1 The touch probe moves at rapid traverse (value from MP6150 or MP6361) to the starting position 1 programmed in the cycle.
- 2 Then the touch probe approaches the workpiece at the feed rate assigned in MP6120 or MP6360. During probing the TNC moves simultaneously in 2 axes (depending on the probing angle). The scanning direction is defined by the polar angle entered in the cycle.
- 3 After the TNC has saved the position, the probe returns to the starting point. The TNC also stores the coordinates of the touch probe position at the time of the triggering signal in parameters Q115 to Q119.



Please note while programming:



Danger of collision!

Pre-position the touch probe in order to avoid a collision when the programmed pre-positioning point is approached.

Cycle parameters



- **Probing axis:** Enter the probing axis with the axis selection keys or ASCII keyboard. Confirm your entry with the ENT key. Input range: **X, Y or Z**
- **Probing angle:** Angle, measured from the probing axis, at which the touch probe is to move. Input range: -180.0000 to 180.0000
- **Nominal position value:** Use the axis selection keys or the ASCII keyboard to enter all coordinates of the nominal pre-positioning point values for the touch probe. Input range: -99999.9999 to 99999.9999
- To conclude the input, press the ENT key.

Example: NC blocks

```
67 TCH PROBE 1.0 POLAR DATUM PLANE
```

```
68 TCH PROBE 1.1 X ANGLE: +30
```

```
69 TCH PROBE 1.2 X+5 Y+0 Z-5
```



16.4 MEASURE ANGLE (Cycle 420, DIN/ISO: G420)

Cycle run

Touch Probe Cycle 420 measures the angle that any straight surface on the workpiece describes with respect to the reference axis of the working plane.

- 1 Following the positioning logic (see “Executing touch probe cycles” on page 306), the TNC positions the touch probe to the programmed starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC offsets the touch probe by the safety clearance in the direction opposite the defined traverse direction.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360).
- 3 Then the touch probe moves to the next starting position **2** and probes the second position.
- 4 The TNC returns the touch probe to the clearance height and saves the measured angle in the following Q parameter:

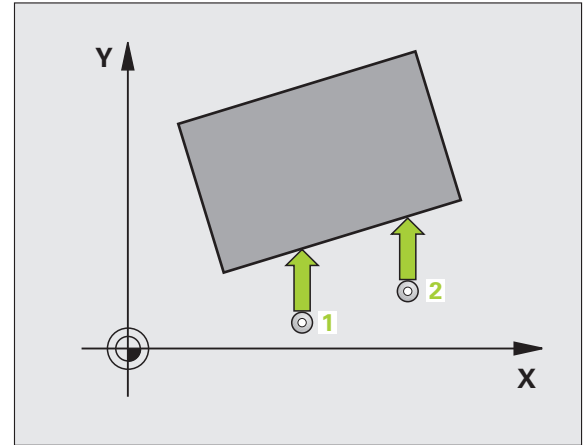
Parameter number	Meaning
Q150	The measured angle is referenced to the reference axis of the machining plane.

Please note while programming:



Before a cycle definition you must have programmed a tool call to define the touch probe axis.

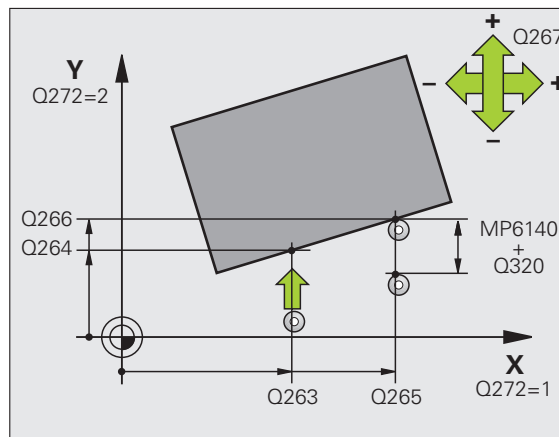
If touch probe axis = measuring axis, set **Q263** equal to **Q265** if the angle about the A axis is to be measured; set **Q263** not equal to **Q265** if the angle is to be measured about the B axis.



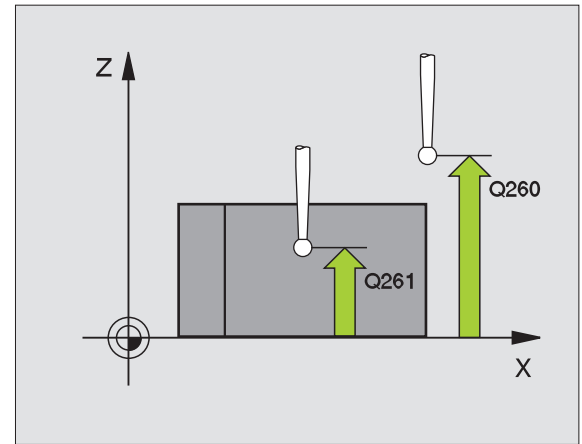
Cycle parameters



- ▶ **1st meas. point 1st axis** Q263 (absolute):
Coordinate of the first touch point in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **1st meas. point 2nd axis** Q264 (absolute):
Coordinate of the first touch point in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **2nd meas. point 1st axis** Q265 (absolute):
Coordinate of the second touch point in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **2nd meas. point 2nd axis** Q266 (absolute):
Coordinate of the second touch point in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Measuring axis** Q272: Axis in which the measurement is to be made:
 - 1: Reference axis = measuring axis
 - 2: Minor axis = measuring axis
 - 3: Touch probe axis = measuring axis



- ▶ **Traverse direction 1** Q267: Direction in which the probe is to approach the workpiece:
-1: Negative traverse direction
+1: Positive traverse direction
- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Traversing to clearance height** Q301: Definition of how the touch probe is to move between the measuring points:
0: Move at measuring height between measuring points
1: Move at clearance height between measuring points
 Alternatively **PREDEF**
- ▶ **Measuring log** Q281: Definition of whether the TNC is to create a measuring log:
0: No measuring log
1: Generate measuring log: with the standard setting the TNC saves the **log file TCHPR420.TXT** in the directory in which your measuring program is also stored.
2: Interrupt the program run and display the measuring log on the screen. Resume program run with NC Start.



Example: NC blocks

5 TCH PROBE 420 MEASURE ANGLE	
Q263=+10	;1ST POINT 1ST AXIS
Q264=+10	;1ST POINT 2ND AXIS
Q265=+15	;2ND POINT 1ST AXIS
Q266=+95	;2ND POINT 2ND AXIS
Q272=1	;MEASURING AXIS
Q267=-1	;TRAVERSE DIRECTION
Q261=-5	;MEASURING HEIGHT
Q320=0	;SETUP CLEARANCE
Q260=+10	;CLEARANCE HEIGHT
Q301=1	;MOVE TO CLEARANCE
Q281=1	;MEASURING LOG

16.5 MEASURE HOLE (Cycle 421, DIN/ISO: G421)

Cycle run

Touch Probe Cycle 421 measures the center and diameter of a hole (or circular pocket). If you define the corresponding tolerance values in the cycle, the TNC makes a nominal-to-actual value comparison and saves the deviation value in system parameters.

- 1 Following the positioning logic (see "Executing touch probe cycles" on page 306), the TNC positions the touch probe to the starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC calculates the probe starting points from the data in the cycle and the safety clearance from MP6140.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360). The TNC derives the probing direction automatically from the programmed starting angle.
- 3 Then the touch probe moves in a circular arc either at measuring height or at clearance height to the next starting point **2** and probes the second touch point.
- 4 The TNC positions the probe to starting point **3** and then to starting point **4** to probe the third and fourth touch points.
- 5 Finally the TNC returns the touch probe to the clearance height and saves the actual values and the deviations in the following Q parameters:

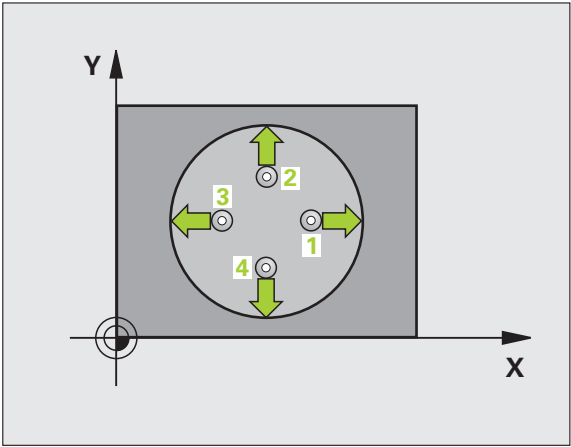
Parameter number	Meaning
Q151	Actual value of center in reference axis
Q152	Actual value of center in minor axis
Q153	Actual value of diameter
Q161	Deviation at center of reference axis
Q162	Deviation at center of minor axis
Q163	Deviation from diameter

Please note while programming:



Before a cycle definition you must have programmed a tool call to define the touch probe axis.

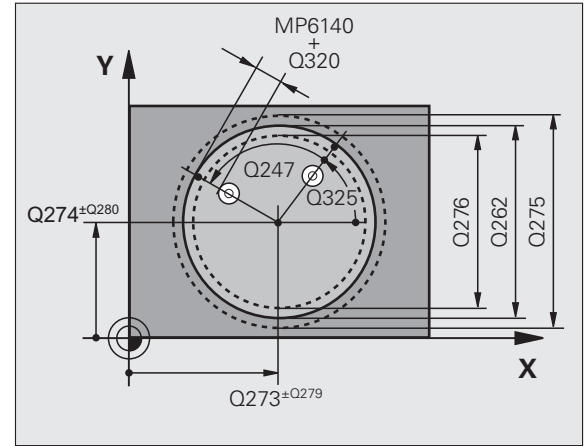
The smaller the angle, the less accurately the TNC can calculate the hole dimensions. Minimum input value: 5°.



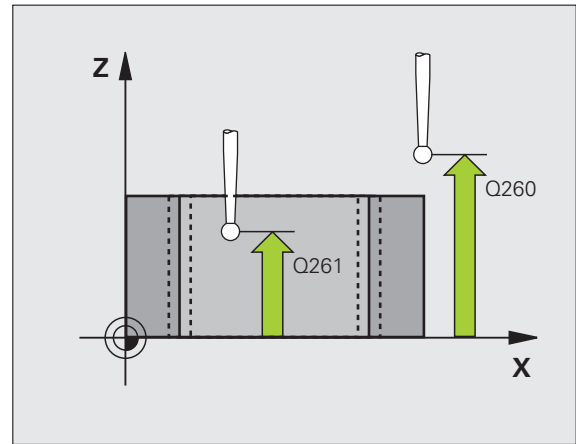
Cycle parameters



- ▶ **Center in 1st axis** Q273 (absolute): Center of the hole in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Center in 2nd axis** Q274 (absolute value): Center of the hole in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Nominal diameter** Q262: Enter the diameter of the hole. Input range: 0 to 99999.9999
- ▶ **Starting angle** Q325 (absolute): Angle between the reference axis of the working plane and the first touch point. Input range: -360.0000 to 360.0000
- ▶ **Stepping angle** Q247 (incremental): Angle between two measuring points. The algebraic sign of the stepping angle determines the direction of rotation (negative = clockwise). If you wish to probe a circular arc instead of a complete circle, then program the stepping angle to be less than 90°. Input range: -120.0000 to 120.0000



- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Traversing to clearance height** Q301: Definition of how the touch probe is to move between the measuring points:
 - 0:** Move at measuring height between measuring points
 - 1:** Move at clearance height between measuring points
 Alternatively **PREDEF**
- ▶ **Maximum limit of size for hole** Q275: Maximum permissible diameter for the hole (circular pocket). Input range: 0 to 99999.9999
- ▶ **Minimum limit of size for hole** Q276: Minimum permissible diameter for the hole (circular pocket). Input range: 0 to 99999.9999
- ▶ **Tolerance for center 1st axis** Q279: Permissible position deviation in the reference axis of the working plane. Input range: 0 to 99999.9999
- ▶ **Tolerance for center 2nd axis** Q280: Permissible position deviation in the minor axis of the working plane. Input range: 0 to 99999.9999



- ▶ **Measuring log** Q281: Definition of whether the TNC is to create a measuring log:
0: No measuring log
1: Generate measuring log: with the standard setting the TNC saves the **log file TCHPR421.TXT** in the directory in which your measuring program is also stored.
2: Interrupt the program run and display the measuring log on the screen. Resume program run with NC Start.
- ▶ **PGM stop if tolerance error** Q309: Definition of whether in the event of a violation of tolerance limits the TNC is to interrupt the program run and output an error message:
0: Do not interrupt program run, no error message
1: Interrupt program run, output an error message
- ▶ **Tool number for monitoring** Q330: Definition of whether the TNC is to monitor the tool (see "Tool monitoring" on page 388). Input range: 0 to 32767.9, alternatively tool name with max. 16 characters
0: Monitoring not active
>0: Tool number in the tool table TOOL.T
- ▶ **No. of measuring points (4/3)** Q423: Specify whether the TNC should measure the stud with 4 or 3 probing points:
4: Use 4 measuring points (standard setting)
3: Use 3 measuring points
- ▶ **Type of traverse? Line=0/Arc=1** Q365: Definition of the path function with which the tool is to move between the measuring points if "traverse to clearance height" (Q301=1) is active.
0: Move between operations on a straight line
1: Move between operations on the pitch circle

Example: NC blocks

5	TCH	PROBE	421	MEASURE	HOLE
Q273	=+50			;	CENTER IN 1ST AXIS
Q274	=+50			;	CENTER IN 2ND AXIS
Q262	=75			;	NOMINAL DIAMETER
Q325	=+0			;	STARTING ANGLE
Q247	=+60			;	STEPPING ANGLE
Q261	= -5			;	MEASURING HEIGHT
Q320	=0			;	SETUP CLEARANCE
Q260	=+20			;	CLEARANCE HEIGHT
Q301	=1			;	MOVE TO CLEARANCE
Q275	=75,12			;	MAX. LIMIT
Q276	=74,95			;	MIN. LIMIT
Q279	=0.1			;	TOLERANCE 1ST CENTER
Q280	=0.1			;	TOLERANCE 2ND CENTER
Q281	=1			;	MEASURING LOG
Q309	=0			;	PGM STOP IF ERROR
Q330	=			;	TOOL
Q423	=4			;	NO. OF MEAS. POINTS
Q365	=1			;	TYPE OF TRAVERSE

16.6 MEAS. CIRCLE OUTSIDE (Cycle 422, DIN/ISO: G422)

Cycle run

Touch Probe Cycle 422 measures the center and diameter of a circular stud. If you define the corresponding tolerance values in the cycle, the TNC makes a nominal-to-actual value comparison and saves the deviation value in system parameters.

- 1 Following the positioning logic (see “Executing touch probe cycles” on page 306), the TNC positions the touch probe to the starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC calculates the probe starting points from the data in the cycle and the safety clearance from MP6140.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360). The TNC derives the probing direction automatically from the programmed starting angle.
- 3 Then the touch probe moves in a circular arc either at measuring height or at clearance height to the next starting point **2** and probes the second touch point.
- 4 The TNC positions the probe to starting point **3** and then to starting point **4** to probe the third and fourth touch points.
- 5 Finally the TNC returns the touch probe to the clearance height and saves the actual values and the deviations in the following Q parameters:

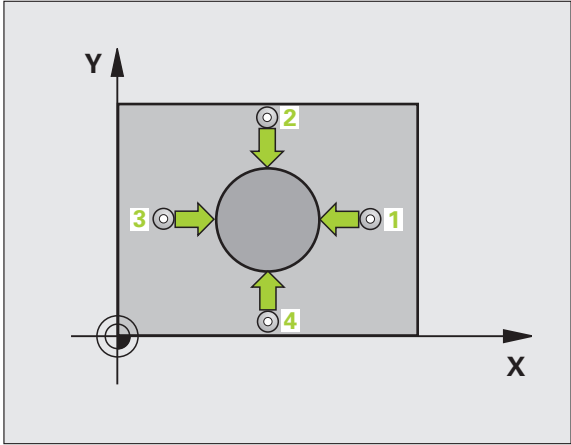
Parameter number	Meaning
Q151	Actual value of center in reference axis
Q152	Actual value of center in minor axis
Q153	Actual value of diameter
Q161	Deviation at center of reference axis
Q162	Deviation at center of minor axis
Q163	Deviation from diameter

Please note while programming:



Before a cycle definition you must have programmed a tool call to define the touch probe axis.

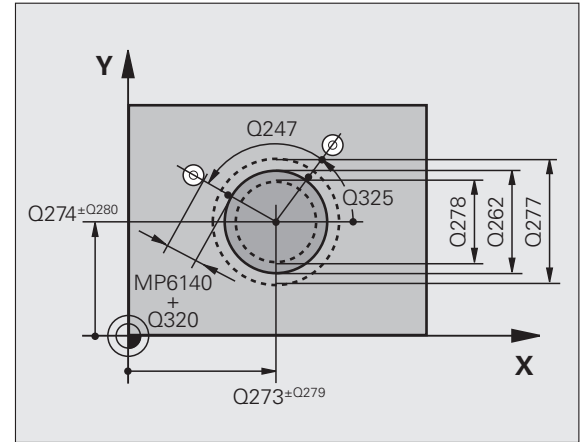
The smaller the angle, the less accurately the TNC can calculate the dimensions of the stud. Minimum input value: 5°



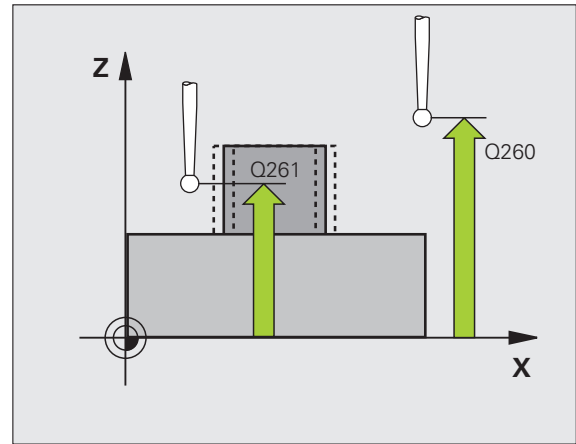
Cycle parameters



- ▶ **Center in 1st axis** Q273 (absolute): Center of the stud in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Center in 2nd axis** Q274 (absolute): Center of the stud in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Nominal diameter** Q262: Enter the diameter of the stud. Input range: 0 to 99999.9999
- ▶ **Starting angle** Q325 (absolute): Angle between the reference axis of the working plane and the first touch point. Input range: -360.0000 to 360.0000
- ▶ **Stepping angle** Q247 (incremental): Angle between two measuring points. The algebraic sign of the stepping angle determines the direction of rotation (negative = clockwise). If you wish to probe a circular arc instead of a complete circle, then program the stepping angle to be less than 90°. Input range: -120.0000 to 120.0000



- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Traversing to clearance height** Q301: Definition of how the touch probe is to move between the measuring points:
0: Move at measuring height between measuring points
1: Move at clearance height between measuring points
 Alternatively **PREDEF**
- ▶ **Maximum limit of size for stud** Q277: Maximum permissible diameter for the stud. Input range: 0 to 99999.9999
- ▶ **Minimum limit of size for the stud** Q278: Minimum permissible diameter for the stud. Input range: 0 to 99999.9999
- ▶ **Tolerance for center 1st axis** Q279: Permissible position deviation in the reference axis of the working plane. Input range: 0 to 99999.9999
- ▶ **Tolerance for center 2nd axis** Q280: Permissible position deviation in the minor axis of the working plane. Input range: 0 to 99999.9999



- ▶ **Measuring log** Q281: Definition of whether the TNC is to create a measuring log:
0: No measuring log
1: Generate measuring log: with the standard setting the TNC saves the **log file TCHPR422.TXT** in the directory in which your measuring program is also stored.
2: Interrupt the program run and display the measuring log on the screen. Resume program run with NC Start.
- ▶ **PGM stop if tolerance error** Q309: Definition of whether in the event of a violation of tolerance limits the TNC is to interrupt the program run and output an error message:
0: Do not interrupt program run, no error message
1: Interrupt program run, output an error message
- ▶ **Tool number for monitoring** Q330: Definition of whether the TNC is to monitor the tool (see "Tool monitoring" on page 388): Input range: 0 to 32767.9, alternatively tool name with max. 16 characters
0: Monitoring not active
>0: Tool number in the tool table TOOL.T
- ▶ **No. of measuring points (4/3)** Q423: Specify whether the TNC should measure the stud with 4 or 3 probing points:
4: Use 4 measuring points (standard setting)
3: Use 3 measuring points
- ▶ **Type of traverse? Line=0/Arc=1** Q365: Definition of the path function with which the tool is to move between the measuring points if "traverse to clearance height" (Q301=1) is active.
0: Move between operations on a straight line
1: Move between operations on the pitch circle

Example: NC blocks

5 TCH PROBE 422 MEAS. CIRCLE OUTSIDE
Q273=+50 ;CENTER IN 1ST AXIS
Q274=+50 ;CENTER IN 2ND AXIS
Q262=75 ;NOMINAL DIAMETER
Q325=+90 ;STARTING ANGLE
Q247=+30 ;STEPPING ANGLE
Q261=-5 ;MEASURING HEIGHT
Q320=0 ;SETUP CLEARANCE
Q260=+10 ;CLEARANCE HEIGHT
Q301=0 ;MOVE TO CLEARANCE
Q275=35.15;MAX. LIMIT
Q276=34.9 ;MIN. LIMIT
Q279=0.05 ;TOLERANCE 1ST CENTER
Q280=0.05 ;TOLERANCE 2ND CENTER
Q281=1 ;MEASURING LOG
Q309=0 ;PGM STOP IF ERROR
Q330= ;TOOL
Q423=4 ;NO. OF MEAS. POINTS
Q365=1 ;TYPE OF TRAVERSE

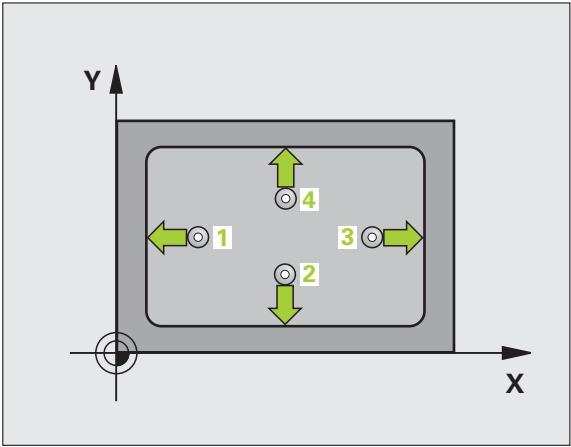
16.7 MEAS. RECTAN. INSIDE (Cycle 423, DIN/ISO: G423)

Cycle run

Touch Probe Cycle 423 finds the center, length and width of a rectangular pocket. If you define the corresponding tolerance values in the cycle, the TNC makes a nominal-to-actual value comparison and saves the deviation value in system parameters.

- 1 Following the positioning logic (see “Executing touch probe cycles” on page 306), the TNC positions the touch probe to the starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC calculates the probe starting points from the data in the cycle and the safety clearance from MP6140.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360).
- 3 Then the touch probe moves either paraxially at the measuring height or linearly at the clearance height to the next starting point **2** and probes the second touch point.
- 4 The TNC positions the probe to starting point **3** and then to starting point **4** to probe the third and fourth touch points.
- 5 Finally the TNC returns the touch probe to the clearance height and saves the actual values and the deviations in the following Q parameters:

Parameter number	Meaning
Q151	Actual value of center in reference axis
Q152	Actual value of center in minor axis
Q154	Actual value of length in the reference axis
Q155	Actual value of length in the minor axis
Q161	Deviation at center of reference axis
Q162	Deviation at center of minor axis
Q164	Deviation of side length in reference axis
Q165	Deviation of side length in minor axis



Please note while programming:



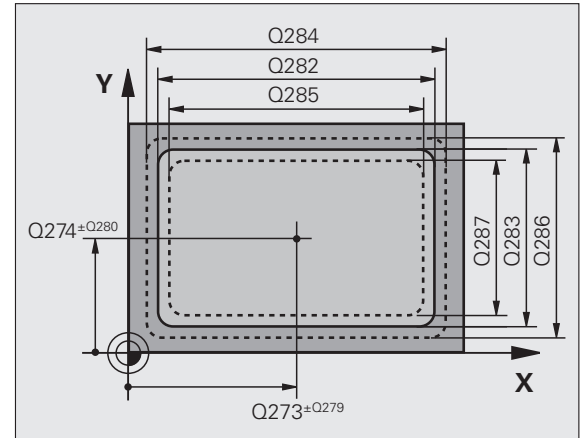
Before a cycle definition you must have programmed a tool call to define the touch probe axis.

If the dimensions of the pocket and the safety clearance do not permit pre-positioning in the proximity of the touch points, the TNC always starts probing from the center of the pocket. In this case the touch probe does not return to the clearance height between the four measuring points.

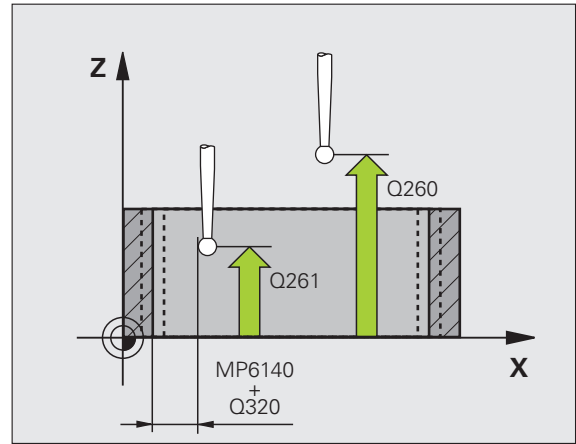
Cycle parameters



- ▶ **Center in 1st axis** Q273 (absolute): Center of the pocket in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Center in 2nd axis** Q274 (absolute): Center of the pocket in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **First side length** Q282: Pocket length, parallel to the reference axis of the working plane. Input range: 0 to 99999.9999
- ▶ **2nd side length** Q283: Pocket length, parallel to the minor axis of the working plane. Input range: 0 to 99999.9999
- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999



- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Traversing to clearance height** Q301: Definition of how the touch probe is to move between the measuring points:
 - 0:** Move at measuring height between measuring points
 - 1:** Move at clearance height between measuring points
 Alternatively **PREDEF**
- ▶ **Max. size limit 1st side length** Q284: Maximum permissible length of the pocket. Input range: 0 to 99999.9999
- ▶ **Min. size limit 1st side length** Q285: Minimum permissible length of the pocket. Input range: 0 to 99999.9999
- ▶ **Max. size limit 2nd side length** Q286: Maximum permissible width of the pocket. Input range: 0 to 99999.9999
- ▶ **Min. size limit 2nd side length** Q287: Minimum permissible width of the pocket. Input range: 0 to 99999.9999
- ▶ **Tolerance for center 1st axis** Q279: Permissible position deviation in the reference axis of the working plane. Input range: 0 to 99999.9999
- ▶ **Tolerance for center 2nd axis** Q280: Permissible position deviation in the minor axis of the working plane. Input range: 0 to 99999.9999



- ▶ **Measuring log** Q281: Definition of whether the TNC is to create a measuring log:
 - 0:** No measuring log
 - 1:** Generate measuring log: with the standard setting the TNC saves the **log file TCHPR423.TXT** in the directory in which your measuring program is also stored.
 - 2:** Interrupt the program run and display the measuring log on the screen. Resume program run with NC Start.
- ▶ **PGM stop if tolerance error** Q309: Definition of whether in the event of a violation of tolerance limits the TNC is to interrupt the program run and output an error message:
 - 0:** Do not interrupt program run, no error message
 - 1:** Interrupt program run, output an error message
- ▶ **Tool number for monitoring** Q330: Definition of whether the TNC is to monitor the tool (see "Tool monitoring" on page 388). Input range: 0 to 32767.9, alternatively tool name with max. 16 characters
 - 0:** Monitoring not active
 - >0:** Tool number in the tool table TOOL.T

Example: NC blocks

5 TCH PROBE 423 MEAS. RECTAN. INSIDE
Q273=+50 ;CENTER IN 1ST AXIS
Q274=+50 ;CENTER IN 2ND AXIS
Q282=80 ;FIRST SIDE LENGTH
Q283=60 ;2ND SIDE LENGTH
Q261=-5 ;MEASURING HEIGHT
Q320=0 ;SETUP CLEARANCE
Q260=+10 ;CLEARANCE HEIGHT
Q301=1 ;MOVE TO CLEARANCE
Q284=0 ;MAX. LIMIT 1ST SIDE
Q285=0 ;MIN. LIMIT 1ST SIDE
Q286=0 ;MAX. LIMIT 2ND SIDE
Q287=0 ;MIN. LIMIT 2ND SIDE
Q279=0 ;TOLERANCE 1ST CENTER
Q280=0 ;TOLERANCE 2ND CENTER
Q281=1 ;MEASURING LOG
Q309=0 ;PGM STOP IF ERROR
Q330= ;TOOL

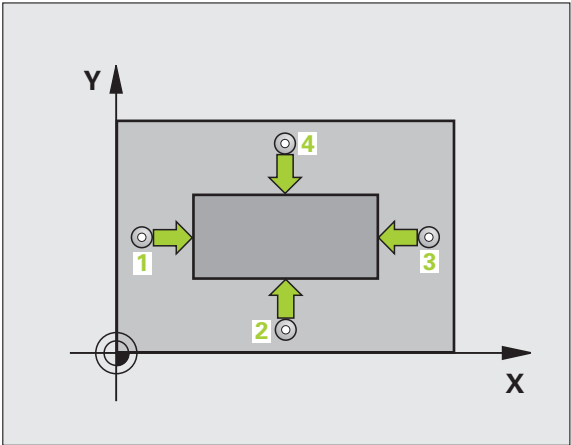
16.8 MEAS. RECTAN. OUTSIDE (Cycle 424, ISO: G424)

Cycle run

Touch Probe Cycle 424 finds the center, length and width of a rectangular stud. If you define the corresponding tolerance values in the cycle, the TNC makes a nominal-to-actual value comparison and saves the deviation value in system parameters.

- 1 Following the positioning logic (see “Executing touch probe cycles” on page 306), the TNC positions the touch probe to the starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC calculates the probe starting points from the data in the cycle and the safety clearance from MP6140.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360).
- 3 Then the touch probe moves either paraxially at the measuring height or linearly at the clearance height to the next starting point **2** and probes the second touch point.
- 4 The TNC positions the probe to starting point **3** and then to starting point **4** to probe the third and fourth touch points.
- 5 Finally the TNC returns the touch probe to the clearance height and saves the actual values and the deviations in the following Q parameters:

Parameter number	Meaning
Q151	Actual value of center in reference axis
Q152	Actual value of center in minor axis
Q154	Actual value of length in the reference axis
Q155	Actual value of length in the minor axis
Q161	Deviation at center of reference axis
Q162	Deviation at center of minor axis
Q164	Deviation of side length in reference axis
Q165	Deviation of side length in minor axis

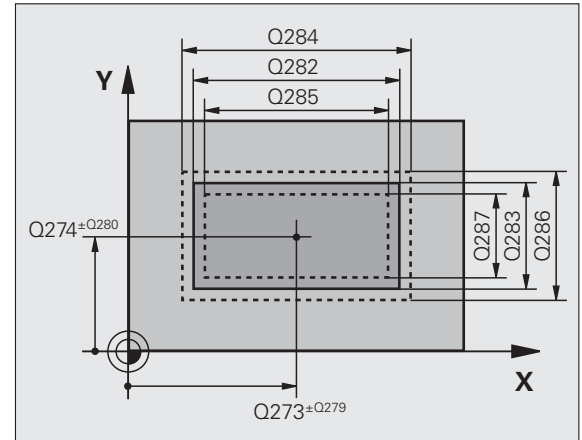


Please note while programming:

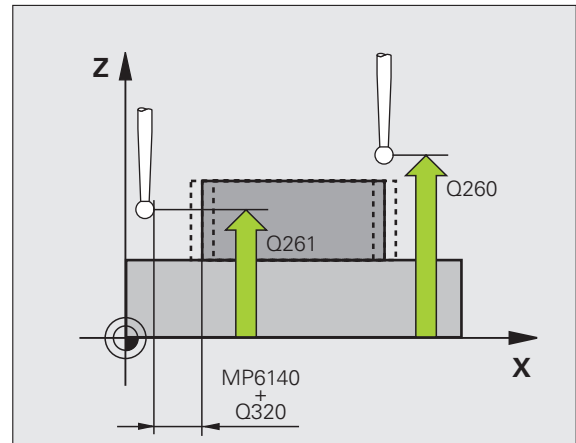
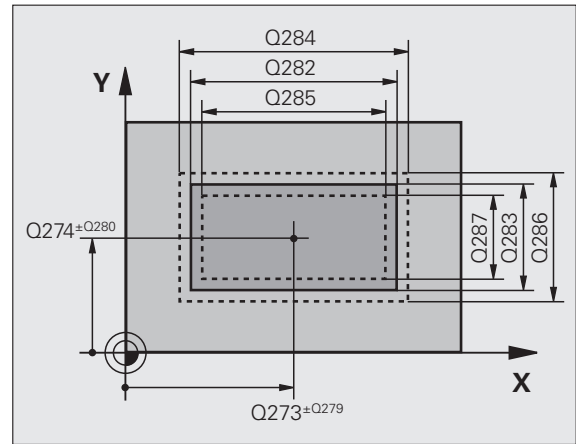
Before a cycle definition you must have programmed a tool call to define the touch probe axis.

Cycle parameters

- ▶ **Center in 1st axis** Q273 (absolute): Center of the stud in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Center in 2nd axis** Q274 (absolute): Center of the stud in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **First side length** Q282: Stud length, parallel to the reference axis of the working plane. Input range: 0 to 99999.9999
- ▶ **2nd side length** Q283: Stud length, parallel to the minor axis of the working plane. Input range: 0 to 99999.9999
- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999



- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range: 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Traversing to clearance height** Q301: Definition of how the touch probe is to move between the measuring points:
 - 0:** Move at measuring height between measuring points
 - 1:** Move at clearance height between measuring points
 Alternatively **PREDEF**
- ▶ **Max. size limit 1st side length** Q284: Maximum permissible length of the stud. Input range: 0 to 99999.9999
- ▶ **Min. size limit 1st side length** Q285: Minimum permissible length of the stud. Input range: 0 to 99999.9999
- ▶ **Max. size limit 2nd side length** Q286: Maximum permissible width of the stud. Input range: 0 to 99999.9999
- ▶ **Min. size limit 2nd side length** Q287: Minimum permissible width of the stud. Input range: 0 to 99999.9999
- ▶ **Tolerance for center 1st axis** Q279: Permissible position deviation in the reference axis of the working plane. Input range: 0 to 99999.9999
- ▶ **Tolerance for center 2nd axis** Q280: Permissible position deviation in the minor axis of the working plane. Input range: 0 to 99999.9999



- ▶ **Measuring log** Q281: Definition of whether the TNC is to create a measuring log:
 - 0:** No measuring log
 - 1:** Generate measuring log: with the standard setting the TNC saves the **log file TCHPR424.TXT** in the directory in which your measuring program is also stored.
 - 2:** Interrupt the program run and display the measuring log on the screen. Resume program run with NC Start.
- ▶ **PGM stop if tolerance error** Q309: Definition of whether in the event of a violation of tolerance limits the TNC is to interrupt the program run and output an error message:
 - 0:** Do not interrupt program run, no error message
 - 1:** Interrupt program run, output an error message
- ▶ **Tool number for monitoring** Q330: Definition of whether the TNC is to monitor the tool (see "Tool monitoring" on page 388). Input range: 0 to 32767.9, alternatively tool name with max. 16 characters:
 - 0:** Monitoring not active
 - >0:** Tool number in the tool table TOOL.T

Example: NC blocks

5 TCH PROBE 424 MEAS. RECTAN. OUTS.
Q273=+50 ;CENTER IN 1ST AXIS
Q274=+50 ;CENTER IN 2ND AXIS
Q282=75 ;FIRST SIDE LENGTH
Q283=35 ;2ND SIDE LENGTH
Q261=-5 ;MEASURING HEIGHT
Q320=0 ;SETUP CLEARANCE
Q260=+20 ;CLEARANCE HEIGHT
Q301=0 ;MOVE TO CLEARANCE
Q284=75,1 ;MAX. LIMIT 1ST SIDE
Q285=74,9 ;MIN. LIMIT 1ST SIDE
Q286=35 ;MAX. LIMIT 2ND SIDE
Q287=34,95 ;MIN. LIMIT 2ND SIDE
Q279=0.1 ;TOLERANCE 1ST CENTER
Q280=0.1 ;TOLERANCE 2ND CENTER
Q281=1 ;MEASURING LOG
Q309=0 ;PGM STOP IF ERROR
Q330= ;TOOL

16.9 MEASURE INSIDE WIDTH (Cycle 425, DIN/ISO: G425)


Cycle run

Touch Probe Cycle 425 measures the position and width of a slot (or pocket). If you define the corresponding tolerance values in the cycle, the TNC makes a nominal-to-actual value comparison and saves the deviation value in a system parameter.

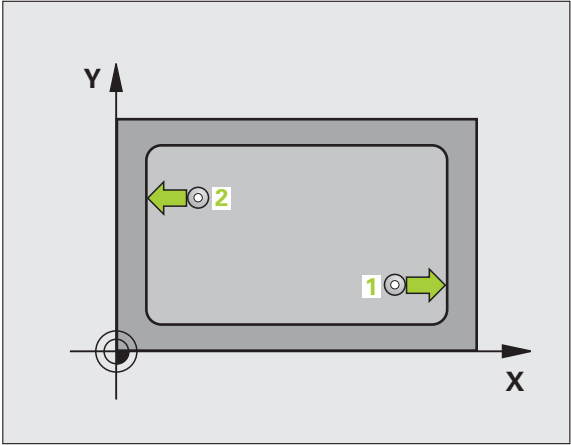
- 1 Following the positioning logic (see “Executing touch probe cycles” on page 306), the TNC positions the touch probe to the starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC calculates the probe starting points from the data in the cycle and the safety clearance from MP6140.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360). 1. The first probing is always in the positive direction of the programmed axis.
- 3 If you enter an offset for the second measurement, the TNC then moves the touch probe (if required, at clearance height) to the next starting point **2** and probes the second touch point. If the nominal length is large, the TNC moves the touch probe to the second touch point at rapid traverse. If you do not enter an offset, the TNC measures the width in the exact opposite direction.
- 4 Finally the TNC returns the touch probe to the clearance height and saves the actual values and the deviation in the following Q parameters:

Parameter number	Meaning
Q156	Actual value of measured length
Q157	Actual value of the centerline
Q166	Deviation of the measured length

Please note while programming:



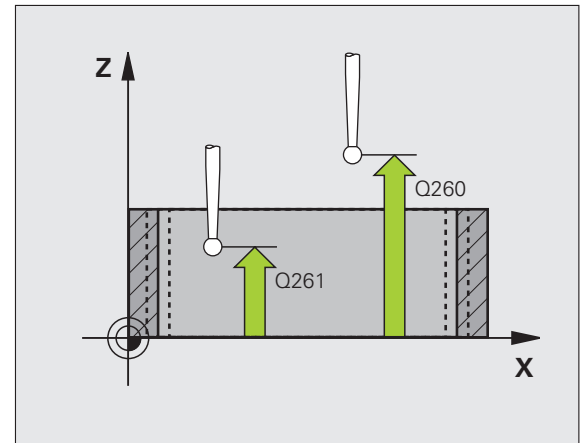
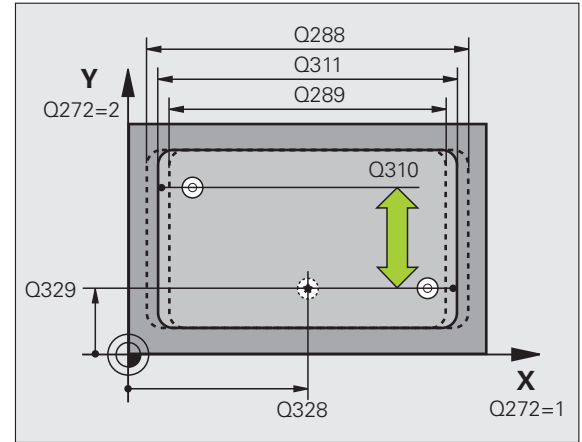
Before a cycle definition you must have programmed a tool call to define the touch probe axis.



Cycle parameters



- ▶ **Starting point in 1st axis** Q328 (absolute): Starting point for probing in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Starting point in 2nd axis** Q329 (absolute): Starting point for probing in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Offset for 2nd measurement** Q310 (incremental): Distance by which the touch probe is displaced before the second measurement. If you enter 0, the TNC does not offset the touch probe. Input range: -99999.9999 to 99999.9999
- ▶ **Measuring axis** Q272: Axis in the working plane in which the measurement is to be made:
 1: Reference axis = measuring axis
 2: Minor axis = measuring axis
- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Nominal length** Q311: Nominal value of the length to be measured. Input range: 0 to 99999.9999
- ▶ **Maximum dimension** Q288: Maximum permissible length. Input range: 0 to 99999.9999
- ▶ **Minimum dimension** Q289: Minimum permissible length. Input range: 0 to 99999.9999



- **Measuring log** Q281: Definition of whether the TNC is to create a measuring log:
 - 0:** No measuring log
 - 1:** Generate measuring log; with the standard setting the TNC saves the **log file TCHPR425.TXT** in the directory in which your measuring program is also stored.
 - 2:** Interrupt the program run and display the measuring log on the screen. Resume program run with NC Start.
- **PGM stop if tolerance error** Q309: Definition of whether in the event of a violation of tolerance limits the TNC is to interrupt the program run and output an error message:
 - 0:** Do not interrupt program run, no error message
 - 1:** Interrupt program run, output an error message
- **Tool number for monitoring** Q330: Definition of whether the TNC is to monitor the tool (see "Tool monitoring" on page 388): Input range: 0 to 32767.9, alternatively tool name with max. 16 characters
 - 0:** Monitoring not active
 - >0:** Tool number in the tool table TOOL.T
- **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- **Traversing to clearance height** Q301: Definition of how the touch probe is to move between the measuring points:
 - 0:** Move at measuring height between measuring points
 - 1:** Move at clearance height between measuring points
 Alternatively **PREDEF**

Example: NC blocks

5 TCH PROBE 425 MEASURE INSIDE WIDTH
Q328=+75 ;STARTNG PNT 1ST AXIS
Q329=-12.5;STARTNG PNT 2ND AXIS
Q310=+0 ;OFFS. 2ND MEASUREMENT
Q272=1 ;MEASURING AXIS
Q261=-5 ;MEASURING HEIGHT
Q260=+10 ;CLEARANCE HEIGHT
Q311=25 ;NOMINAL LENGTH
Q288=25.05;MAX. LIMIT
Q289=25 ;MIN. LIMIT
Q281=1 ;MEASURING LOG
Q309=0 ;PGM STOP IF ERROR
Q330= ;TOOL
Q320=0 ;SETUP CLEARANCE
Q301=0 ;MOVE TO CLEARANCE



16.10 MEASURE RIDGE WIDTH (Cycle 426, ISO: G426)

Cycle run

Touch Probe Cycle 426 measures the position and width of a ridge. If you define the corresponding tolerance values in the cycle, the TNC makes a nominal-to-actual value comparison and saves the deviation value in system parameters.

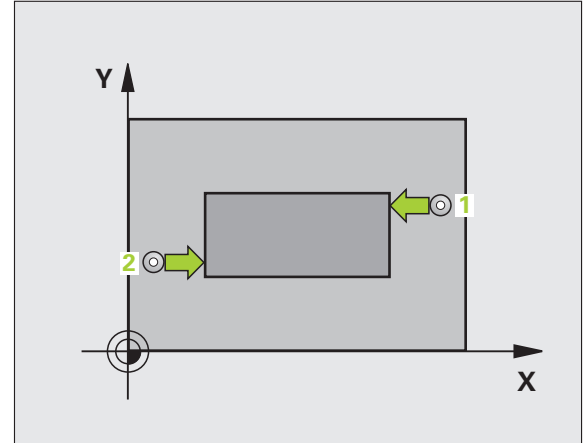
- 1 Following the positioning logic (see “Executing touch probe cycles” on page 306), the TNC positions the touch probe to the starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC calculates the probe starting points from the data in the cycle and the safety clearance from MP6140.
- 2 Then the touch probe moves to the entered measuring height and probes the first touch point at the probing feed rate (MP6120 or MP6360). 1. The first probing is always in the negative direction of the programmed axis.
- 3 Then the touch probe moves at clearance height to the next starting position and probes the second touch point.
- 4 Finally the TNC returns the touch probe to the clearance height and saves the actual values and the deviation in the following Q parameters:

Parameter number	Meaning
Q156	Actual value of measured length
Q157	Actual value of the centerline
Q166	Deviation of the measured length

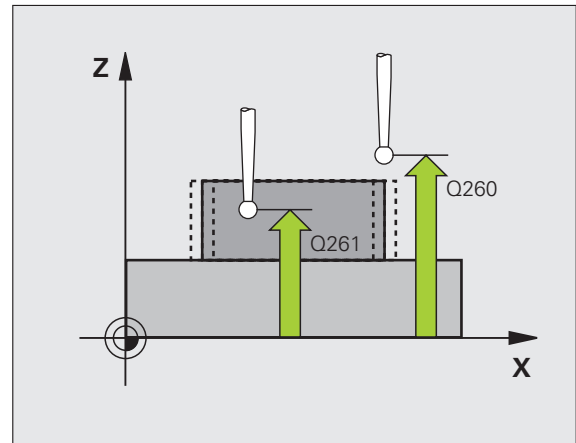
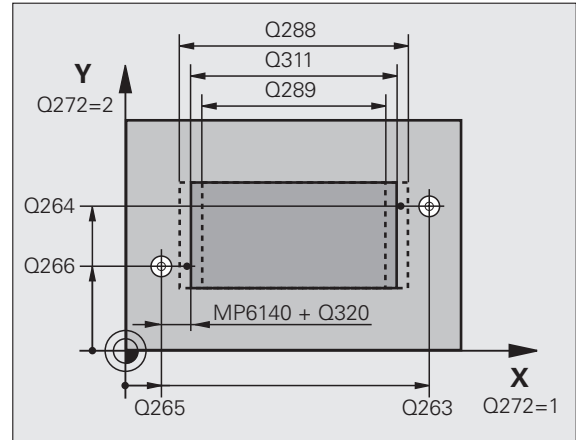
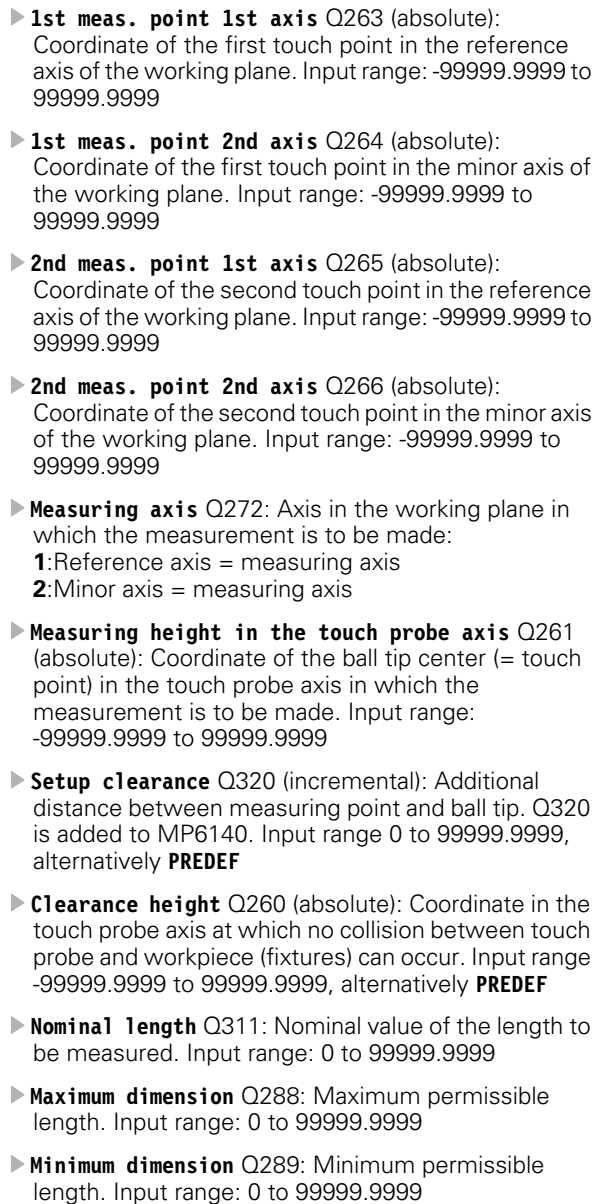
Please note while programming:



Before a cycle definition you must have programmed a tool call to define the touch probe axis.



16.10 MEASURE RIDGE WIDTH (Cycle 426, ISO: G426)



- ▶ **Measuring log** Q281: Definition of whether the TNC is to create a measuring log:
 - 0:** No measuring log
 - 1:** Generate measuring log: with the standard setting the TNC saves the **log file TCHPR426.TXT** in the directory in which your measuring program is also stored.
 - 2:** Interrupt the program run and display the measuring log on the screen. Resume program run with NC Start.
- ▶ **PGM stop if tolerance error** Q309: Definition of whether in the event of a violation of tolerance limits the TNC is to interrupt the program run and output an error message:
 - 0:** Do not interrupt program run, no error message
 - 1:** Interrupt program run, output an error message
- ▶ **Tool number for monitoring** Q330: Definition of whether the TNC is to monitor the tool (see "Tool monitoring" on page 388). Input range: 0 to 32767.9, alternatively tool name with max. 16 characters
 - 0:** Monitoring not active
 - >0:** Tool number in the tool table TOOL.T

Example: NC blocks

5	TCH	PROBE	426	MEASURE	RIDGE	WIDTH	
Q263	=+50			;1ST	POINT	1ST	AXIS
Q264	=+25			;1ST	POINT	2ND	AXIS
Q265	=+50			;2ND	POINT	1ST	AXIS
Q266	=+85			;2ND	POINT	2ND	AXIS
Q272	=2			;MEASURING	AXIS		
Q261	=-5			;MEASURING	HEIGHT		
Q320	=0			;SETUP	CLEARANCE		
Q260	=+20			;CLEARANCE	HEIGHT		
Q311	=45			;NOMINAL	LENGTH		
Q288	=45			;MAX.	LIMIT		
Q289	=44.95			;MIN.	LIMIT		
Q281	=1			;MEASURING	LOG		
Q309	=0			;PGM	STOP	IF	ERROR
Q330	=			;TOOL			

16.11 MEASURE COORDINATE (Cycle 427, DIN/ISO: G427)

Cycle run

Touch probe cycle 427 finds a coordinate in a selectable axis and saves the value in a system parameter. If you define the corresponding tolerance values in the cycle, the TNC makes a nominal-to-actual value comparison and saves the deviation value in system parameters.

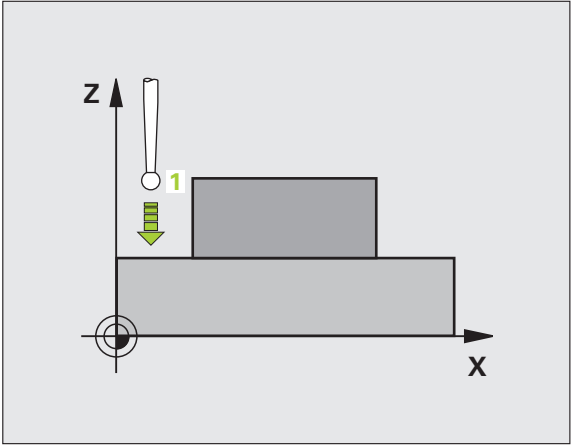
- 1 Following the positioning logic (see “Executing touch probe cycles” on page 306), the TNC positions the touch probe to the starting point **1** at rapid traverse (value from MP6150 or MP6361). The TNC offsets the touch probe by the safety clearance in the direction opposite the defined traverse direction.
- 2 Then the TNC positions the touch probe to the entered touch point **1** in the working plane and measures the actual value in the selected axis.
- 3 Finally the TNC returns the touch probe to the clearance height and saves the measured coordinate in the following Q parameter:

Parameter number	Meaning
Q160	Measured coordinate

Please note while programming:



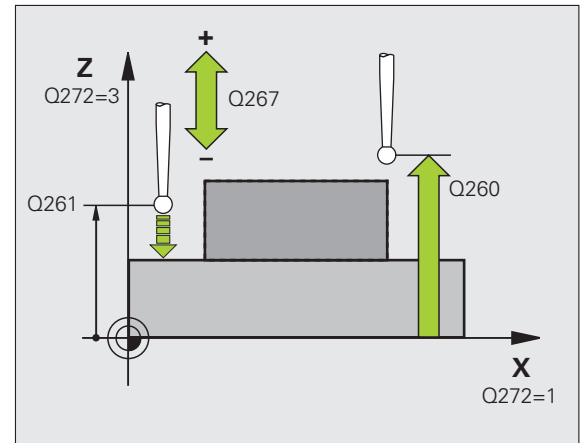
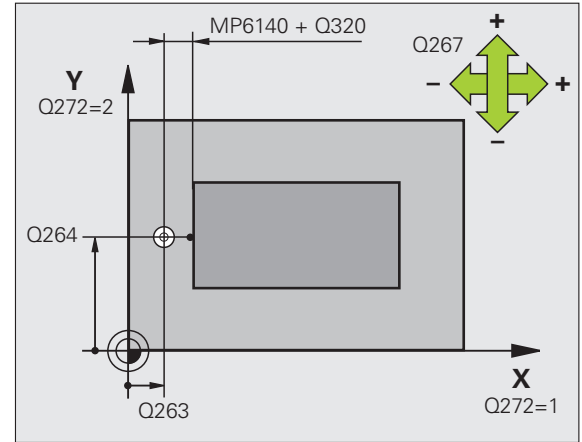
Before a cycle definition you must have programmed a tool call to define the touch probe axis.



Cycle parameters



- ▶ **1st meas. point 1st axis** Q263 (absolute):
Coordinate of the first touch point in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **1st meas. point 2nd axis** Q264 (absolute):
Coordinate of the first touch point in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Measuring height in the touch probe axis** Q261 (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Measuring axis (1..3: 1=reference axis)** Q272:
Axis in which the measurement is to be made:
 - 1:**Reference axis = measuring axis
 - 2:**Minor axis = measuring axis
 - 3:**Touch probe axis = measuring axis
- ▶ **Traverse direction 1** Q267: Direction in which the probe is to approach the workpiece:
 - 1:** Negative traverse direction
 - +1:** Positive traverse direction
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**



- ▶ **Measuring log** Q281: Definition of whether the TNC is to create a measuring log:
 - 0:** No measuring log
 - 1:** Generate measuring log; with the standard setting the TNC saves the **log file TCHPR427.TXT** in the directory in which your measuring program is also stored.
 - 2:** Interrupt the program run and display the measuring log on the screen. Resume program run with NC Start.
- ▶ **Maximum limit of size** Q288: Maximum permissible measured value. Input range: 0 to 99999.9999
- ▶ **Minimum limit of size** Q289: Minimum permissible measured value. Input range: 0 to 99999.9999
- ▶ **PGM stop if tolerance error** Q309: Definition of whether in the event of a violation of tolerance limits the TNC is to interrupt the program run and output an error message:
 - 0:** Do not interrupt program run, no error message
 - 1:** Interrupt program run, output an error message
- ▶ **Tool number for monitoring** Q330: Definition of whether the TNC is to monitor the tool (see "Tool monitoring" on page 388). Input range: 0 to 32767.9, alternatively tool name with max. 16 characters:
 - 0:** Monitoring not active
 - >0:** Tool number in the tool table TOOL.T

Example: NC blocks

5	TCH	PROBE	427	MEASURE	COORDINATE
Q263	=+35			;	1ST POINT 1ST AXIS
Q264	=+45			;	1ST POINT 2ND AXIS
Q261	=+5			;	MEASURING HEIGHT
Q320	=0			;	SETUP CLEARANCE
Q272	=3			;	MEASURING AXIS
Q267	=-1			;	TRAVERSE DIRECTION
Q260	=+20			;	CLEARANCE HEIGHT
Q281	=1			;	MEASURING LOG
Q288	=5.1			;	MAX. LIMIT
Q289	=4.95			;	MIN. LIMIT
Q309	=0			;	PGM STOP IF ERROR
Q330	=			;	TOOL



16.12 MEAS. BOLT HOLE CIRC. (Cycle 430, DIN/ISO: G430)

Cycle run

Touch Probe Cycle 430 finds the center and diameter of a bolt hole circle by probing three holes. If you define the corresponding tolerance values in the cycle, the TNC makes a nominal-to-actual value comparison and saves the deviation value in system parameters.

- 1 Following the positioning logic (see "Executing touch probe cycles" on page 306), the TNC positions the touch probe at rapid traverse (value from MP6150 or MP6361) to the point entered as center of the first hole **1**.
- 2 Then the probe moves to the entered measuring height and probes four points to find the first hole center.
- 3 The touch probe returns to the clearance height and then to the position entered as center of the second hole **2**.
- 4 The TNC moves the touch probe to the entered measuring height and probes four points to find the second hole center.
- 5 The touch probe returns to the clearance height and then to the position entered as center of the third hole **3**.
- 6 The TNC moves the touch probe to the entered measuring height and probes four points to find the third hole center.
- 7 Finally the TNC returns the touch probe to the clearance height and saves the actual values and the deviations in the following Q parameters:

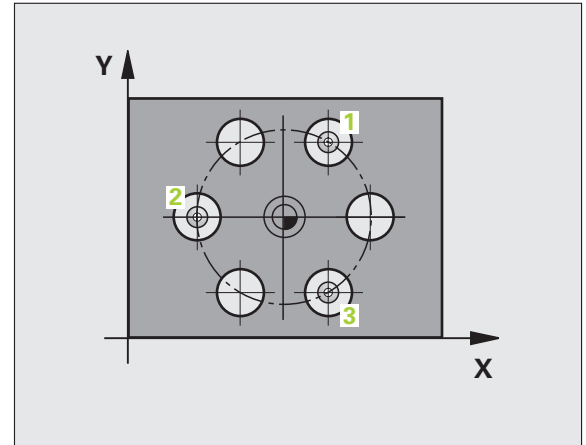
Parameter number	Meaning
Q151	Actual value of center in reference axis
Q152	Actual value of center in minor axis
Q153	Actual value of bolt hole circle diameter
Q161	Deviation at center of reference axis
Q162	Deviation at center of minor axis
Q163	Deviation of bolt hole circle diameter

Please note while programming:



Before a cycle definition you must have programmed a tool call to define the touch probe axis.

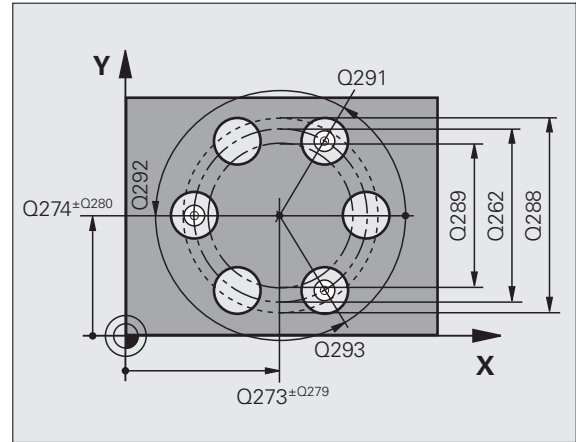
Cycle 430 only monitors for tool breakage, no automatic tool compensation.



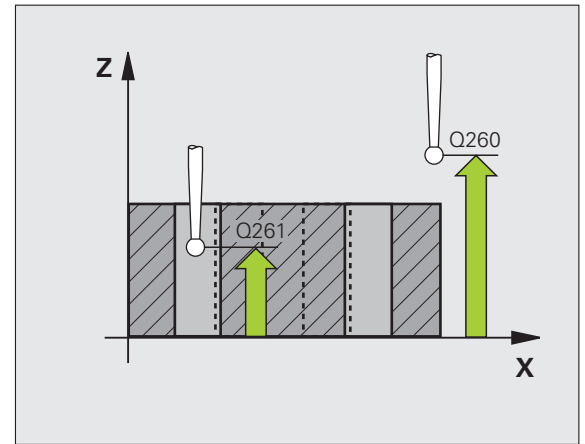
Cycle parameters



- ▶ **Center in 1st axis** Q273 (absolute): Bolt hole circle center (nominal value) in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Center in 2nd axis** Q274 (absolute): Bolt hole circle center (nominal value) in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **Nominal diameter** Q262: Enter the bolt hole circle diameter. Input range: 0 to 99999.9999
- ▶ **Angle of 1st hole** Q291 (absolute): Polar coordinate angle of the first hole center in the working plane. Input range: -360.0000 to 360.0000
- ▶ **Angle of 2nd hole** Q292 (absolute): Polar coordinate angle of the second hole center in the working plane. Input range: -360.0000 to 360.0000
- ▶ **Angle of 3rd hole** Q293 (absolute): Polar coordinate angle of the third hole center in the working plane. Input range: -360.0000 to 360.0000



- ▶ **Measuring height in the touch probe axis Q261** (absolute): Coordinate of the ball tip center (= touch point) in the touch probe axis in which the measurement is to be made. Input range: -99999.9999 to 99999.9999
- ▶ **Clearance height Q260** (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Maximum limit of size Q288**: Maximum permissible diameter of bolt hole circle. Input range: 0 to 99999.9999
- ▶ **Minimum limit of size Q289**: Minimum permissible diameter of bolt hole circle. Input range: 0 to 99999.9999
- ▶ **Tolerance for center 1st axis Q279**: Permissible position deviation in the reference axis of the working plane. Input range: 0 to 99999.9999
- ▶ **Tolerance for center 2nd axis Q280**: Permissible position deviation in the minor axis of the working plane. Input range: 0 to 99999.9999



- **Measuring log** Q281: Definition of whether the TNC is to create a measuring log:
 - 0:** No measuring log
 - 1:** Generate measuring log; with the standard setting the TNC saves the **log file TCHPR430.TXT** in the directory in which your measuring program is also stored.
 - 2:** Interrupt the program run and display the measuring log on the screen. Resume program run with NC Start.
- **PGM stop if tolerance error** Q309: Definition of whether in the event of a violation of tolerance limits the TNC is to interrupt the program run and output an error message:
 - 0:** Do not interrupt program run, no error message
 - 1:** Interrupt program run, output an error message
- **Tool number for monitoring** Q330: Definition of whether the TNC is to monitor for tool breakage (see "Tool monitoring" on page 388): Input range: 0 to 32767.9, alternatively tool name with max. 16 characters.
 - 0:** Monitoring not active
 - >0:** Tool number in the tool table TOOL.T

5 TCH PROBE 430 MEAS. BOLT HOLE CIRC	
Q273=+50	;CENTER IN 1ST AXIS
Q274=+50	;CENTER IN 2ND AXIS
Q262=80	;NOMINAL DIAMETER
Q291=+0	;ANGLE OF 1ST HOLE
Q292=+90	;ANGLE OF 2ND HOLE
Q293=+180	;ANGLE OF 3RD HOLE
Q261=-5	;MEASURING HEIGHT
Q260=+10	;CLEARANCE HEIGHT
Q288=80.1	;MAX. LIMIT
Q289=79.9	;MIN. LIMIT
Q279=0.15	;TOLERANCE 1ST CENTER
Q280=0.15	;TOLERANCE 2ND CENTER
Q281=1	;MEASURING LOG
Q309=0	;PGM STOP IF ERROR
Q330=	;TOOL



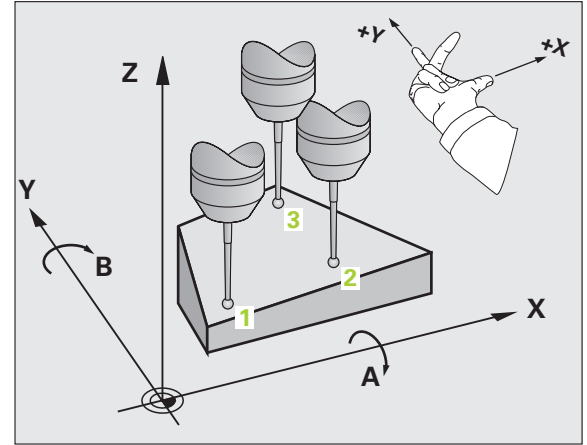
16.13 MEASURE PLANE (Cycle 431, DIN/ISO: G431)

Cycle run

Touch Probe Cycle 431 finds the angle of a plane by measuring three points. It saves the measured values in system parameters.

- 1 Following the positioning logic (see "Executing touch probe cycles" on page 306), the TNC positions the touch probe at rapid traverse (value from MP6150 or MP6361) to the programmed starting point **1** and measures the first touch point of the plane. The TNC offsets the touch probe by the safety clearance in the direction opposite to the direction of probing.
- 2 The touch probe returns to the clearance height and then moves in the working plane to starting point **2** and measures the actual value of the second touch point of the plane.
- 3 The touch probe returns to the clearance height and then moves in the working plane to starting point **3** and measures the actual value of the third touch point.
- 4 Finally the TNC returns the touch probe to the clearance height and saves the measured angle values in the following Q parameters:

Parameter number	Meaning
Q158	Projection angle of the A axis
Q159	Projection angle of the B axis
Q170	Spatial angle A
Q171	Spatial angle B
Q172	Spatial angle C
Q173 to Q175	Measured values in the touch probe axis (first to third measurement)



Please note while programming:



Before a cycle definition you must have programmed a tool call to define the touch probe axis.

For the TNC to be able to calculate the angular values, the three measuring points must not be positioned on one straight line.

The spatial angles that are needed for tilting the working plane are saved in parameters Q170 – Q172. With the first two measuring points you also specify the direction of the reference axis when tilting the working plane.

The third measuring point determines the direction of the tool axis. Define the third measuring point in the direction of the positive Y axis to ensure that the position of the tool axis in a clockwise coordinate system is correct.

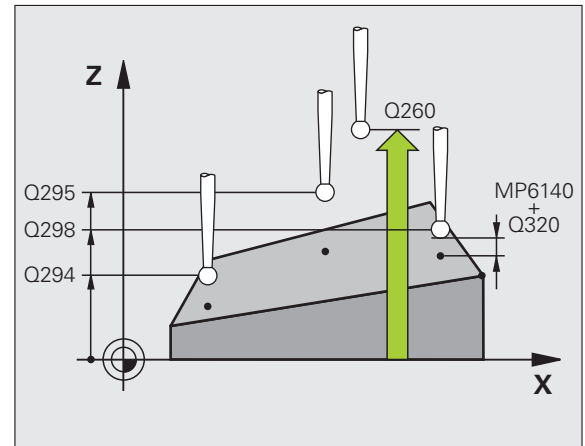
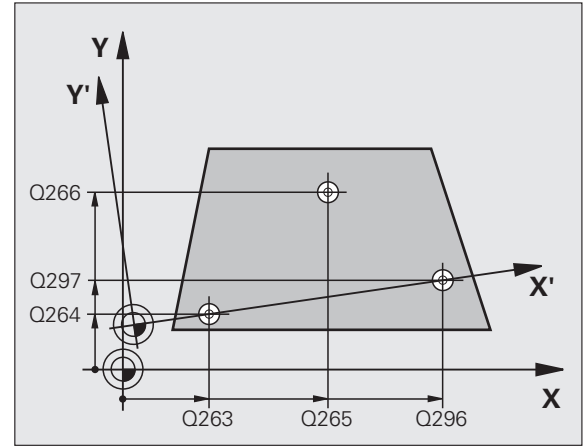
If you run the cycle while a tilted working plane is active, the spatial angle is measured with respect to the tilted coordinate system. In this case, use the measured spatial angle with **PLANE RELATIV**.



Cycle parameters



- ▶ **1st meas. point 1st axis** Q263 (absolute):
Coordinate of the first touch point in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **1st meas. point 2nd axis** Q264 (absolute):
Coordinate of the first touch point in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **1st meas. point 3rd axis** Q294 (absolute):
Coordinate of the first touch point in the touch probe axis. Input range: -99999.9999 to 99999.9999
- ▶ **2nd meas. point 1st axis** Q265 (absolute):
Coordinate of the second touch point in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **2nd meas. point 2nd axis** Q266 (absolute):
Coordinate of the second touch point in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **2nd meas. point 3rd axis** Q295 (absolute):
Coordinate of the second touch point in the touch probe axis. Input range: -99999.9999 to 99999.9999
- ▶ **3rd meas. point 1st axis** Q296 (absolute):
Coordinate of the third touch point in the reference axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **3rd meas. point 2nd axis** Q297 (absolute):
Coordinate of the third touch point in the minor axis of the working plane. Input range: -99999.9999 to 99999.9999
- ▶ **3rd meas. point 3rd axis** Q298 (absolute):
Coordinate of the third touch point in the touch probe axis. Input range: -99999.9999 to 99999.9999



- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between touch probe and workpiece (fixtures) can occur. Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Measuring log** Q281: Definition of whether the TNC is to create a measuring log:
 - 0:** No measuring log
 - 1:** Generate measuring log: with the standard setting the TNC saves the **log file TCHPR431.TXT** in the directory in which your measuring program is also stored.
 - 2:** Interrupt the program run and display the measuring log on the screen. Resume program run with NC Start.

Example: NC blocks

5	TCH	PROBE	431	MEASURE	PLANE
Q263	=+20			;1ST	POINT 1ST AXIS
Q264	=+20			;1ST	POINT 2ND AXIS
Q294	=-10			;1ST	POINT 3RD AXIS
Q265	=+50			;2ND	POINT 1ST AXIS
Q266	=+80			;2ND	POINT 2ND AXIS
Q295	=+0			;2ND	POINT 3RD AXIS
Q296	=+90			;3RD	POINT 1ST AXIS
Q297	=+35			;3RD	POINT 2ND AXIS
Q298	=+12			;3RD	POINT 3RD AXIS
Q320	=0			;SETUP	CLEARANCE
Q260	=+5			;CLEARANCE	HEIGHT
Q281	=1			;MEASURING	LOG

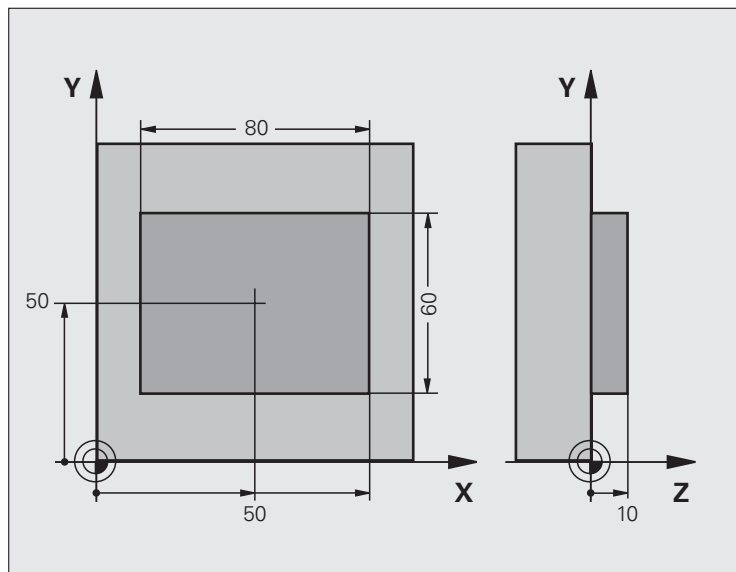


16.14 Programming examples

Example: Measuring and reworking a rectangular stud

Program sequence:

- Roughing with 0.5 mm finishing allowance
- Measuring
- Rectangular stud finishing in accordance with the measured values

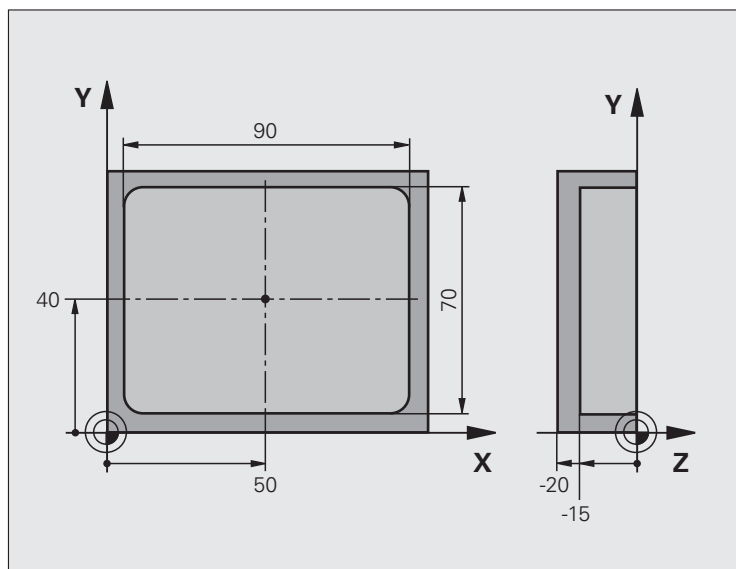


0 BEGIN PGM BEAMS MM	
1 TOOL CALL 69 Z	Prepare tool call
2 L Z+100 R0 FMAX	Retract the tool
3 FN 0: Q1 = +81	Pocket length in X (roughing dimension)
4 FN 0: Q2 = +61	Pocket length in Y (roughing dimension)
5 CALL LBL 1	Call subprogram for machining
6 L Z+100 R0 FMAX	Retract the tool, change the tool
7 TOOL CALL 99 Z	Call the touch probe
8 TCH PROBE 424 MEAS. RECTAN. OUTS.	Measure the rough-milled rectangle
Q273=+50 ;CENTER IN 1ST AXIS	
Q274=+50 ;CENTER IN 2ND AXIS	
Q282=80 ;FIRST SIDE LENGTH	Nominal length in X (final dimension)
Q283=60 ;2ND SIDE LENGTH	Nominal length in Y (final dimension)
Q261=-5 ;MEASURING HEIGHT	
Q320=0 ;SETUP CLEARANCE	
Q260=+30 ;CLEARANCE HEIGHT	
Q301=0 ;MOVE TO CLEARANCE	
Q284=0 ;MAX. LIMIT 1ST SIDE	Input values for tolerance checking not required

Q285=0 ;MIN. LIMIT 1ST SIDE	
Q286=0 ;MAX. LIMIT 2ND SIDE	
Q287=0 ;MIN. LIMIT 2ND SIDE	
Q279=0 ;TOLERANCE 1ST CENTER	
Q280=0 ;TOLERANCE 2ND CENTER	
Q281=0 ;MEASURING LOG	No measuring log transmission
Q309=0 ;PGM STOP IF ERROR	Do not output an error message
Q330=0 ;TOOL NUMBER	No tool monitoring
9 FN 2: Q1 = +Q1 - +Q164	Calculate length in X including the measured deviation
10 FN 2: Q2 = +Q2 - +Q165	Calculate length in Y including the measured deviation
11 L Z+100 R0 FMAX	Retract the touch probe, change the tool
12 TOOL CALL 1 Z \$5000	Tool call for finishing
13 CALL LBL 1	Call subprogram for machining
14 L Z+100 R0 FMAX M2	Retract in the tool axis, end program
15 LBL 1	Subprogram with fixed cycle for rectangular studs
16 CYCL DEF 213 STUD FINISHING	
Q200=20 ;SETUP CLEARANCE	
Q201=-10 ;DEPTH	
Q206=150 ;FEED RATE FOR PLUNGING	
Q202=5 ;PLUNGING DEPTH	
Q207=500 ;FEED RATE FOR MILLING	
Q203=+10 ;SURFACE COORDINATE	
Q204=20 ;2ND SETUP CLEARANCE	
Q216=+50 ;CENTER IN 1ST AXIS	
Q217=+50 ;CENTER IN 2ND AXIS	
Q218=Q1 ;FIRST SIDE LENGTH	Length in X variable for roughing and finishing
Q219=Q2 ;2ND SIDE LENGTH	Length in Y variable for roughing and finishing
Q220=0 ;CORNER RADIUS	
Q221=0 ;ALLOWANCE IN 1ST AXS	
17 CYCL CALL M3	Cycle call
18 LBL 0	End of subprogram
19 END PGM BEAMS MM	



Example: Measuring a rectangular pocket and recording the results



0 BEGIN PGM BSMEAS MM	
1 TOOL CALL 1 Z	Tool call for touch probe
2 L Z+100 R0 FMAX	Retract the touch probe
3 TCH PROBE 423 MEAS. RECTAN. INSIDE	
Q273=+50 ;CENTER IN 1ST AXIS	
Q274=+40 ;CENTER IN 2ND AXIS	
Q282=90 ;FIRST SIDE LENGTH	Nominal length in X
Q283=70 ;2ND SIDE LENGTH	Nominal length in Y
Q261=-5 ;MEASURING HEIGHT	
Q320=0 ;SETUP CLEARANCE	
Q260=+20 ;CLEARANCE HEIGHT	
Q301=0 ;MOVE TO CLEARANCE	

Q284=90.15;MAX. LIMIT 1ST SIDE	Maximum limit in X
Q285=89.95;MIN. LIMIT 1ST SIDE	Minimum limit in X
Q286=70.1 ;MAX. LIMIT 2ND SIDE	Maximum limit in Y
Q287=69.9 ;MIN. LIMIT 2ND SIDE	Minimum limit in Y
Q279=0.15 ;TOLERANCE 1ST CENTER	Permissible position deviation in X
Q280=0.1 ;TOLERANCE 2ND CENTER	Permissible position deviation in Y
Q281=1 ;MEASURING LOG	Save measuring log to a file
Q309=0 ;PGM STOP IF ERROR	Do not display an error message in case of a tolerance violation
Q330=0 ;TOOL NUMBER	No tool monitoring
4 L Z+100 R0 FMAX M2	Retract in the tool axis, end program
5 END PGM BSMEAS MM	





TS 440 IdNr. 372 401-90
HEDENHAIN IdNr. X 9434 1038 C12
D-85829 Tübingen
Made in Germany

17







**Touch Probe Cycles:
Special Functions**



17.1 Fundamentals

Overview

The TNC provides six cycles for the following special purposes:

Cycle	Soft key	Page
2 CALIBRATE TS Radius calibration of the touch trigger probe		Page 435
9 CALIBRATE TS LENGTH Length calibration of the touch trigger probe		Page 436
3 MEASURING Cycle for defining OEM cycles		Page 437
4 MEASURING IN 3-D Measuring cycle for 3-D probing for defining OEM cycles		Page 439
440 MEASURE AXIS SHIFT		Page 441
441 FAST PROBING		Page 444



17.2 CALIBRATE TS (Cycle 2)

Cycle run

Touch probe cycle 2 automatically calibrates a touch trigger probe using a ring gauge or a precision stud as calibration standard.

- 1 The touch probe moves at rapid traverse (value from MP6150) to the clearance height (but only if the current position is below the clearance height).
- 2 Then the TNC positions the touch probe in the working plane to the center of the ring gauge (calibration from inside) or in its proximity (calibration from outside).
- 3 The touch probe then moves to the measuring depth (result of machine parameters 618x.2 and 6185.x) and probes the ring gauge successively in X+, Y+, X- and Y-.
- 4 Finally, the TNC moves the touch probe to the clearance height and writes the effective radius of the ball tip to the calibration data.

Please note while programming:



Before you begin calibrating, you must define in Machine Parameters 6180.0 to 6180.2 the center of the calibrating workpiece in the working space of the machine (REF coordinates).

If you are working with several traverse ranges you can save a separate set of coordinates for the center of each calibrating workpiece (MP6181.1 to 6181.2 and MP6182.1 to 6182.2).

Cycle parameters



- **Clearance height** (absolute): Coordinate in the touch probe axis at which the touch probe cannot collide with the calibration workpiece or any fixtures. Input range: -99999.9999 to 99999.9999
- **Radius of ring gauge:** Radius of the calibrating workpiece. Input range: 0 to 99999.9999
- **Inside calib. =0/outs. calib.=1:** Definition of whether the TNC is to calibrate from inside or outside:
0: Calibrate from inside
1: Calibrate from outside

Example: NC blocks

```
5 TCH PROBE 2.0 CALIBRATE TS
```

```
6 TCH PROBE
```

```
2.1 HEIGHT: +50 R +25.003 DIRECTION: 0
```



17.3 CALIBRATE TS LENGTH (Cycle 9)

Cycle run

Touch probe cycle 9 automatically calibrates the length of a touch trigger probe at a point that you determine.

- 1 Pre-position the touch probe so that the coordinate defined in the cycle can be accessed without collision.
- 2 The TNC moves the touch probe in the direction of the negative tool axis until a trigger signal is released.
- 3 Finally, the TNC moves the touch probe back to the starting point of the probing process and writes the effective touch probe length into the calibration data.

Cycle parameters



- **Coordinate of datum** (absolute): Exact coordinate of the point that is to be probed. Input range: -99999.9999 to 99999.9999
- **Reference system? (0=ACT/1=REF):** Specify the coordinate system on which the entered datum is to be based:
 - 0:** Entered datum is based on the active workpiece coordinate system (ACT system)
 - 1:** Entered datum is based on the active machine coordinate system (REF system)

Example: NC blocks

```
5 L X-235 Y+356 R0 FMAX
```

```
6 TCH PROBE 9.0 CALIBRATE TS LENGTH
```

```
7 TCH PROBE 9.1 DATUM +50 REFERENCE  
SYSTEM 0
```


17.4 MEASURING (Cycle 3)

Cycle run

Touch Probe Cycle 3 measures any position on the workpiece in a selectable direction. Unlike other measuring cycles, Cycle 3 enables you to enter the measuring path **DIST** and feed rate **F** directly. Also, the touch probe retracts by a definable value after determining the measured value **MB**.

- 1 The touch probe moves from the current position at the entered feed rate in the defined probing direction. The probing direction must be defined in the cycle as a polar angle.
- 2 After the TNC has saved the position, the touch probe stops. The TNC saves the X, Y, Z coordinates of the probe-tip center in three successive Q parameters. The TNC does not conduct any length or radius compensations. You define the number of the first result parameter in the cycle.
- 3 Finally, the TNC moves the touch probe back by that value against the probing direction that you defined in the parameter **MB**.

Please note while programming:



The exact behavior of touch probe cycle 3 is defined by your machine tool builder or a software manufacturer who uses it within specific touch probe cycles.



The machine parameters 6130 (maximum traverse to touch point) and 6120 (probing feed rate), which are effective in other measuring cycles, do not apply in touch probe cycle 3.

Remember that the TNC always writes to 4 successive Q parameters.

If the TNC was not able to determine a valid touch point, the program is run without error message. In this case the TNC assigns the value -1 to the 4th result parameter so that you can deal with the error yourself.

The TNC retracts the touch probe by no more than the retraction distance **MB** and does not pass the starting point of the measurement. This rules out any collision during retraction.

With function **FN17: SYSWRITE ID 990 NR 6** you can set whether the cycle runs through the probe input X12 or X13.



Cycle parameters



- ▶ **Parameter number for result:** Enter the number of the Q parameter to which you want the TNC to assign the first measured coordinate (X). The values Y and Z are in the immediately following Q parameters. Input range: 0 to 1999
- ▶ **Probing angle:** Enter the angle in whose direction the probe is to move and confirm with the ENT key. Input range: X, Y or Z
- ▶ **Probing angle:** Angle, measured from the **probing axis** at which the touch probe is to move. Confirm with ENT. Input range: -180.0000 to 180.0000
- ▶ **Maximum measuring path:** Enter the maximum distance from the starting point by which the touch probe is to move. Confirm with ENT. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for measurement:** Enter the measuring feed rate in mm/min. Input range: 0 to 3000.000
- ▶ **Maximum retraction path:** Traverse path in the direction opposite the probing direction, after the stylus was deflected. The TNC returns the touch probe to a point no farther than the starting point, so that there can be no collision. Input range: 0 to 99999.9999
- ▶ **Reference system? (0=ACT/1=REF):** Specify whether the probing direction and the result of measurement are to be referenced to the actual coordinate system (**ACT**, can be shifted or rotated), or to the machine coordinate system (**REF**):
 - 0:** Probe in the current system and save measurement result in the **ACT** system
 - 1:** Probe in the machine-based REF system and save measurement result in the **REF** system
- ▶ **Error mode (0=OFF/1=ON):** Specify whether the TNC is to issue an error message if the stylus is deflected at cycle start. If you select mode **1**, the TNC saves the value **2.0** in the 4th result parameter and continues the cycle.
- ▶ **Error mode (0=OFF/1=ON):** Specify whether the TNC is to issue an error message if the stylus is deflected at cycle start. If you select mode **1**, the TNC saves the value **2.0** in the 4th result parameter and continues the cycle:
 - 0:** Issue error message
 - 1:** Do not issue error message

Example: NC blocks

```

4 TCH PROBE 3.0 MEASURING
5 TCH PROBE 3.1 Q1
6 TCH PROBE 3.2 X ANGLE: +15
7 TCH PROBE 3.3 DIST +10 F100 MB1
  REFERENCE SYSTEM:0
8 TCH PROBE 3.4 ERRORMODE1
  
```

17.5 MEASURING IN 3-D (Cycle 4, FCL 3 function)

Cycle run

Touch probe cycle 4 measures any position on the workpiece in the probing direction defined by a vector. Unlike other measuring cycles, Cycle 4 enables you to enter the measuring path and feed rate directly. Also, the touch probe retracts by a definable value after determining the measured value.

- 1 The touch probe moves from the current position at the entered feed rate in the defined probing direction. Define the probing direction in the cycle by using a vector (delta values in X, Y and Z).
- 2 After the TNC has saved the position, the touch probe stops. The TNC saves the X, Y, Z coordinates of the probe-tip center (without calculation of the calibration data) in three successive Q parameters. You define the number of the first parameter in the cycle.
- 3 Finally, the TNC moves the touch probe back by that value against the probing direction that you defined in the parameter **MB**.

Please note while programming:



The TNC retracts the touch probe by no more than the retraction distance **MB** and does not pass the starting point of the measurement. This rules out any collision during retraction.

Remember that the TNC always writes to 4 successive Q parameters. If the TNC could not determine a valid touch point, the fourth result parameter will have the value -1.

The TNC saves the measured values without calculating the calibration data of the touch probe.

With function **FN17: SYSWRITE ID 990 NR 6** you can set whether the cycle runs through the probe input X12 or X13.



Cycle parameters



- ▶ **Parameter number for result:** Enter the number of the Q parameter to which you want the TNC to assign the first coordinate (X). Input range: 0 to 1999
- ▶ **Relative measuring path in X:** X component of the direction vector defining the direction in which the touch probe is to move. Input range: -99999.9999 to 99999.9999
- ▶ **Relative measuring path in Y:** Y component of the direction vector defining the direction in which the touch probe is to move. Input range: -99999.9999 to 99999.9999
- ▶ **Relative measuring path in Z:** Z component of the direction vector defining the direction in which the touch probe is to move. Input range: -99999.9999 to 99999.9999
- ▶ **Maximum measuring path:** Enter the maximum distance from the starting point by which the touch probe may move along the direction vector. Input range: -99999.9999 to 99999.9999
- ▶ **Feed rate for measurement:** Enter the measuring feed rate in mm/min. Input range: 0 to 3000.000
- ▶ **Maximum retraction path:** Traverse path in the direction opposite the probing direction, after the stylus was deflected. Input range: 0 to 99999.9999
- ▶ **Reference system? (0=ACT/1=REF):** Specify whether the result of measurement is to be saved in the actual coordinate system (**IST**, can therefore be shifted or rotated), or with respect to the machine coordinate system (**REF**).
0: Save the measurement result in the **ACT** system
1: Save the measurement result in the **REF** system

Example: NC blocks

```
5 TCH PROBE 4.0 MEASURING IN 3-D
6 TCH PROBE 4.1 Q1
7 TCH PROBE 4.2 IX-0.5 IY-1 IZ-1
8 TCH PROBE
4.3 DIST +45 F100 MB50 REFERENCE SYSTEM:0
```



17.6 MEASURE AXIS SHIFT (touch probe cycle 440, DIN/ISO: G440)

Cycle run

Touch probe cycle 440 measures the axis shifts of the machine. Make sure that the cylindrical calibrating tool used in connection with the TT 130 has the correct dimensions.

- 1 The TNC positions the calibrating tool at rapid traverse (value from MP6150 or MP6361) and following the positioning logic (refer to chapter 1.2) in the vicinity of the TT.
- 2 At first the TNC makes a measurement in the touch probe axis. The calibrating tool is offset by the value you have defined in the tool table TOOL.T under TT: R-OFFS (standard = tool radius). The TNC always performs the measurement in the touch probe axis.
- 3 Then the TNC makes the measurement in the working plane. You define via parameter Q364 in which axis and in which direction of the working plane the measurement is to be made.
- 4 If you make a calibration, the TNC saves the calibration data. Whenever you make a measurement, the TNC compares the measured values to the calibration data and writes the deviations to the following Q parameters:

Parameter number	Meaning
Q185	Deviation from calibration value in X
Q186	Deviation from calibration value in Y
Q187	Deviation from calibration value in Z

You can use this value for compensating the deviation through an incremental datum shift (Cycle 7).

- 5 Finally, the calibrating tool returns to the clearance height.



Please note while programming:

Before running cycle 440 for the first time, you must have calibrated the tool touch probe with tool-touch-probe cycle 30.

Ensure that the tool data of the calibrating tool has been entered in the tool table TOOL.T.

Before running the cycle, you must activate the calibrating tool with TOOL CALL.

Ensure that the TT tool touch probe is connected to input X13 of the logic unit and is ready to function (Machine Parameter 65xx).

Before you perform a measurement, you must have made at least one calibration, otherwise the TNC will output an error message. If you are working with several traverse ranges, you have to make a calibration for each of them.

The TNC calculates incorrect values if the probing directions for calibrating and measuring do not correspond.

Each time you run cycle 440, the TNC resets the result parameters Q185 to Q187.

If you want to set a limit for the axis shift in the machine axes, enter the desired limits in the tool table TOOL.T under LTOL for the spindle axis and under RTOL for the working plane. If the limits are exceeded, the TNC outputs a corresponding error message after a control measurement.

After the cycle is completed, the TNC restores the spindle settings that were active before the cycle (**M3/M4**).

Cycle parameters



- ▶ **Operation: 0=calibr., 1=measure?** Q363: Specify whether you want to calibrate or make a verification measurement:
0: Calibrate
1: Measure
- ▶ **Probing directions** Q364: Definition of probing direction(s) in the working plane:
0: Measuring only in the positive direction of the reference axis
1: Measuring only in the positive direction of the minor axis
2: Measuring only in the negative direction of the reference axis
3: Measuring only in the negative direction of the minor axis
4: Measuring in the positive directions of the reference axis and the minor axis
5: Measuring in the positive direction of the reference axis and in the negative direction of the minor axis
6: Measuring in the negative direction of the reference axis and in the positive direction of the minor axis
7: Measuring in the negative directions of the reference axis and the minor axis
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and probe contact. Q320 is added to MP6540. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Clearance height** Q260 (absolute): Coordinate in the touch probe axis at which no collision between tool and workpiece (fixtures) can occur (referenced to the active datum). Input range -99999.9999 to 99999.9999, alternatively **PREDEF**

Example: NC blocks

```

5 TCH PROBE 440 MEASURE AXIS SHIFT
      Q363=1      ;DIRECTION
      Q364=0      ;PROBING DIRECTIONS
      Q320=2      ;SETUP CLEARANCE
      Q260=+50    ;CLEARANCE HEIGHT
  
```



17.7 FAST PROBING (Cycle 441, DIN/ISO: G441, FCL 2 function)

Cycle run

Touch probe cycle 441 allows the global setting of different touch probe parameters (e.g. positioning feed rate) for all subsequently used touch probe cycles. This makes it easy to optimize the programs so that reductions in total machining time are achieved.

Please note while programming:



Before programming, note the following

There are no machine movements contained in Cycle 441. It only sets different probing parameters.

END PGM, M02, M30 resets the global settings of Cycle 441.

You can activate automatic angle tracking (Cycle Parameter **Q399**) only if Machine Parameter 6165=1. If you change Machine Parameter 6165, you must recalibrate the touch probe.

Cycle parameters



- ▶ **Positioning feed rate** Q396: Define the feed rate at which the touch probe is moved to the specified positions. Input range: 0 to 99999.9999
- ▶ **Positioning feed rate=FMAX (0/1)** Q397: Define whether the touch probe is to move at **FMAX** (rapid traverse) to the specified positions.
 - 0:** Move at feed rate from **Q396**
 - 1:** Move at **FMAX**
- ▶ **Angle tracking** Q399: Define whether the TNC is to orient the touch probe before each probing process.
 - 0:** Do not orient
 - 1:** Orient the spindle before each probing process to increase the accuracy
- ▶ **Automatic interruption** Q400: Define whether the TNC is to interrupt program run and display the measurement results on the screen after a measuring cycle for automatic workpiece measurement:
 - 0:** Never interrupt the program run, not even if the output of the measurement results on the screen is selected in the respective probing cycle.
 - 1:** Always interrupt program run and display the measurement results on the screen. To continue the program run, press the NC Start button

Example: NC blocks

```
5 TCH PROBE 441 FAST PROBING
  Q396=3000 ;POSITIONING FEED RATE
  Q397=0    ;SELECT FEED RATE
  Q399=1    ;ANGLE TRACKING
  Q400=1    ;INTERRUPTION
```





18

**Touch Probe Cycles:
Automatic Kinematics
Measurement**



18.1 Kinematic Measurement with TS Touch Probes (Option KinematicsOpt)

Fundamentals

Accuracy requirements are becoming increasingly stringent, particularly in the area of 5-axis machining. Complex parts are required to be manufactured with precision and reproducible accuracy even over long periods.




Some of the reasons for inaccuracy in multi-axis machining are deviations between the kinematic model saved in the control (see figure 1 at right), and the kinematic conditions actually existing on the machine (see figure 2 at right). When the rotary axes are positioned, these deviations cause inaccuracy of the workpiece (see figure 3 at right). It is therefore necessary for the model to approach reality as closely as possible.

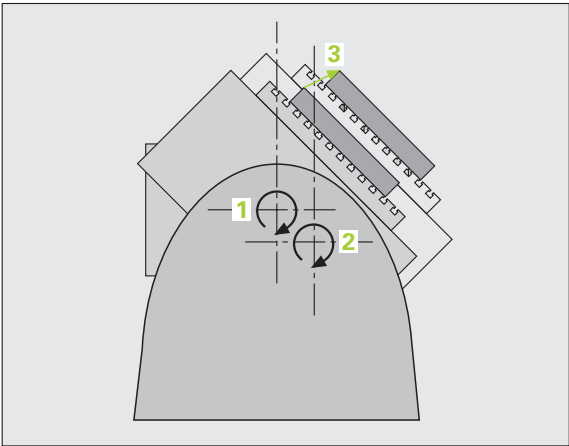
The new TNC function **KinematicsOpt** is an important component that helps you to really fulfill these complex requirements: A 3-D touch probe cycle measures the rotary axes on your machine fully automatically, regardless of whether they are in the form of tables or spindle heads. A calibration ball is fixed at any position on the machine table, and measured with a resolution that you define. You simply define for each rotary axis the area that you want to measure.

From the measured values, the TNC calculates the static tilting accuracy. The software minimizes the positioning error arising from the tilting movements and, at the end of the measurement process, automatically saves the machine geometry in the respective machine constants of the kinematic table.

Overview

The TNC offers cycles that enable you to automatically save, check and optimize the machine kinematics:

Cycle	Soft key	Page
450 SAVE KINEMATICS: Automatically saving and restoring kinematic configurations		Page 450
451 MEASURE KINEMATICS: Automatically checking or optimizing the machine kinematics		Page 452
452 PRESET COMPENSATION: Automatically checking or optimizing the machine kinematics		Page 466



18.2 Prerequisites

The following are prerequisites for using the KinematicsOpt option:

- The software options 48 (KinematicsOpt) and 8 (software option1) and FCL3 must be enabled.
- The 3-D touch probe used for the measurement must be calibrated.
- A calibration ball with an exactly known radius and sufficient rigidity must be attached to some position on the machine table. Calibrations balls can be purchased from various manufacturers of measuring equipment.
- The kinematics description of the machine must be complete and correct. The transformation values must be entered with an accuracy of approx. 1 mm.
- All rotary axes must be NC axes. KinematicsOpt does not support measurement of manual axes.
- The complete machine geometry must be measured (by the machine tool builder during commissioning).
- Machine parameter **MP6600** must define the tolerance limit starting from which the TNC displays a note in the Optimizing mode when the measured kinematic data is greater than this limit value (see "KinematicsOpt: Tolerance limit in Optimization mode: MP6600" on page 305).
- Machine parameter **MP6601** must define the maximum permissible deviation from the entered cycle parameter by the calibration ball radius measured in the cycles (see "KinematicsOpt, permissible deviation of the calibration ball radius: MP6601" on page 305).



18.3 SAVE KINEMATICS (Cycle 450, DIN/ISO: G450; option)

Cycle run

With touch probe cycle 450, you can save the active machine kinematics, restore a previously saved one, or output the current saving status on the screen and in a log file. There are 10 memory spaces available (numbers 0 to 9).

Please note while programming:



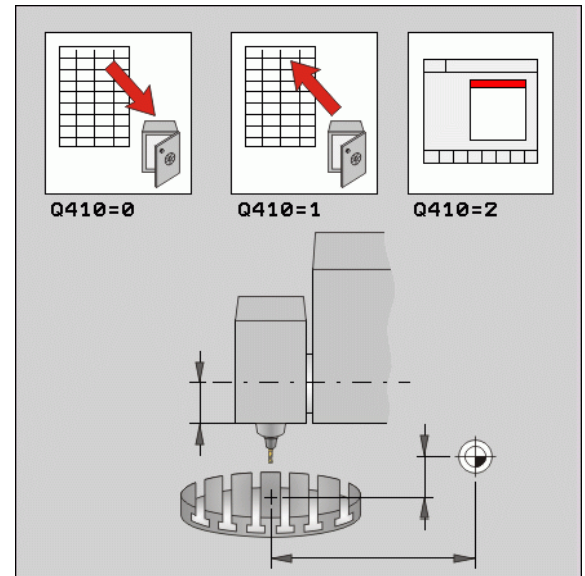
Always save the active kinematics configuration before running a kinematics optimization. Advantage:

- You can restore the old data if you are not satisfied with the results or if errors occur during optimization (e.g. power failure).

Save mode: In addition to the kinematic configuration, the TNC always saves the code number (freely definable) last entered under MOD. Then you cannot overwrite this memory space unless you enter this code number. If you have saved a kinematic configuration without a code number, the TNC automatically overwrites this memory space during the next saving process!

Restore mode: The TNC must restore saved data only to a matching kinematic configuration.

Restore mode: Note that a change in the kinematics always changes the preset as well. Set the preset again if necessary.



Cycle parameters



- **Mode (0/1/2)** Q410: Specify whether to save or restore a kinematics configuration:
 - 0:** Save active kinematics
 - 1:** Restore previously saved kinematics configuration
 - 2:** Display the saving status
- **Memory (0...9)** Q409: Number of the memory space to which you want to save the entire kinematics configuration, or the number of the memory space from which you want to restore it. Input range 0 to 9, no function if mode 2 is selected.

Example: NC blocks

5 TCH PROBE 450 SAVE KINEMATICS	
Q410=0	;MODE
Q409=1	;MEMORY

Log function

After running Cycle 450, the TNC creates a measuring log (TCHPR450.TXT) containing the following information:

- Creation date and time of the log
- Path of the NC program from which the cycle was run
- Mode used (0=Save/1=Restore/2=Saving status)?
- Number of the memory space (0 to 9)
- Line number of the kinematics configuration in the kinematic table
- Code number, if you entered one immediately before running Cycle 450.

The other data in the log vary depending on the selected mode:

- Mode 0:
Logging of all axis entries and transformation entries of the kinematics chain that the TNC has saved.
- Mode 1:
Logging of all transformation entries before and after restoring the kinematics configuration
- Mode 2:
List with the current saving status on the screen and in the log, including the number of the memory space, code numbers, kinematics numbers and date of saving



18.4 MEASURE KINEMATICS (Cycle 451, DIN/ISO: G451; option)

Cycle run

The touch probe cycle 451 enables you to check and, if required, optimize the kinematics of your machine. Use the 3-D TS touch probe to measure a HEIDENHAIN calibration ball that you have attached to the machine table.



HEIDENHAIN recommends using the HEIDENHAIN calibration balls **KKH 250** (ID number 655 475-01) or **KKH 100** (ID number 655 475-02), which have high rigidity and are designed especially for machine calibration. Please contact HEIDENHAIN if you have any questions in this regard.

The TNC evaluates the static tilting accuracy. The software minimizes the spatial error arising from the tilting movements and, at the end of the measurement process, automatically saves the machine geometry in the respective machine constants of the kinematics description.

- 1 Clamp the calibration ball and check for potential collisions
- 2 In the Manual Operation mode, set the reference point in the ball center, or if **Q431=1** or **Q431=3** is defined: In the touch probe axis, manually position the touch probe over the calibration ball, and in the working plane, over the ball center.
- 3 Select the Program Run mode and start the calibration program.
- 4 The TNC automatically measures all three axes successively in the resolution you defined.



- 5 Finally, the TNC returns the rotary axes to the initial position and saves the measured values and deviations in the following Q parameters:

Parameter number	Meaning
Q141	Standard deviation measured in the A axis (-1 if axis was not measured)
Q142	Standard deviation measured in the B axis (-1 if axis was not measured)
Q143	Standard deviation measured in the C axis (-1 if axis was not measured)
Q144	Optimized standard deviation in the A axis (-1 if axis was not measured)
Q145	Optimized standard deviation in the B axis (-1 if axis was not measured)
Q146	Optimized standard deviation in the C axis (-1 if axis was not measured)



Positioning direction

The positioning direction of the rotary axis to be measured is determined from the start angle and the end angle that you define in the cycle. A reference measurement is automatically performed at 0°. The TNC will issue an error message if the selected start angle, end angle and number of measuring points result in a measuring position of 0°.

Specify the start and end angles to ensure that the same position is not measured twice. As mentioned above, a duplicated point measurement (e.g. measuring positions +90° und -270°) is not advisable, however it does not cause an error message.

- Example: start angle = +90°, end angle = -90°
 - Start angle = +90°
 - End angle = -90°
 - No. of measuring points = 4
 - Angle step resulting from the calculation = $(-90 - +90) / (4-1) = -60^\circ$
 - Measuring point 1 = +90°
 - Measuring point 2 = +30°
 - Measuring point 3 = -30°
 - Measuring point 4 = -90°
- Example: start angle = +90°, end angle = +270°
 - Start angle = +90°
 - End angle = +270°
 - No. of measuring points = 4
 - Angle step resulting from the calculation = $(270 - 90) / (4-1) = +60^\circ$
 - Measuring point 1 = +90°
 - Measuring point 2 = +150°
 - Measuring point 3 = +210°
 - Measuring point 4 = +270°



In order to be positioned, the axis must move out of the Hirth coupling. So remember to leave a large enough safety clearance to prevent any risk of collision between the touch probe and calibration ball. Also ensure that there is enough space to reach the safety clearance (software limit switch).

Define a retraction height **Q408** greater than 0 if software option 2 (**M128, FUNCTION TCPM**) is not available.

If necessary, the TNC rounds the calculated measuring positions so that they fit into the Hirth grid (depending on the start angle, end angle and number of measuring points).

The measuring positions are calculated from the start angle, end angle and number of measurements for the respective axis.

Example calculation of measuring positions for an A axis:

Start angle **Q411** = -30

End angle **Q412** = +90

Number of measuring points **Q414** = 4

Calculated angular step = $(Q412 - Q411) / (Q414 - 1)$

Calculated angular step = $(90 - -30) / (4 - 1) = 120 / 3 = 40$

Measuring position 1 = $Q411 + 0 * \text{angular step} = -30^\circ$

Measuring position 2 = $Q411 + 1 * \text{angular step} = +10^\circ$

Measuring position 3 = $Q411 + 2 * \text{angular step} = +50^\circ$

Measuring position 4 = $Q411 + 3 * \text{angular step} = +90^\circ$



Choice of number of measuring points

To save time you can make a rough optimization with a small number of measuring points (1-2).

You then make a fine optimization with a medium number of measuring points (recommended value = 4). Higher numbers of measuring points do not usually improve the results. Ideally, you should distribute the measuring points evenly over the tilting range of the axis.

This is why you should measure an axis with a tilting range of $0^\circ - 360^\circ$ at 3 measuring points at 90° , 180° and 270° .

If you want to check the accuracy accordingly, you can enter a higher number of measuring points in the **Check** mode.



You must not define a measuring point at 0° or 360° . These positions do not provide any metrologically relevant data.

Choice of the calibrating ball position on the machine table

In principle, you can fix the calibrating ball to any position to the machine table. If it is possible, you can also fasten the calibration ball on fixtures or workpieces (e.g. using a magnetic clamp). The following factors can influence the result of measurement:

- On machines with rotary tables/tilting tables:
Clamp the calibrating ball as far as possible away from the center of rotation.
- Machines with very large traverse:
Clamp the calibration ball as closely as possible to the position intended for subsequent machining.

Notes on the accuracy

The geometrical and positioning error of the machine influences the measured values and therefore also the optimization of a rotary axis. For this reason there will always be a certain amount of error.

If there were no geometrical and positioning error, any values measured by the cycle at any point on the machine at a certain time would be exactly reproducible. The greater the geometrical and positioning error, the greater is the dispersion of measured results when you fix the calibrating ball to different positions in the machine coordinate system.

The dispersion of results recorded by the TNC in the measuring log is a measure of the machine's static tilting accuracy. However, the measuring circle radius and the number and position of measuring points have to be included in the evaluation of accuracy. One measuring point alone is not enough to calculate dispersion. For only one point, the result of the calculation is the spatial error of that measuring point.

If several rotary axes are moved simultaneously, their error values are combined. In the worst case they are added together.



If your machine is equipped with a controlled spindle, you should activate the angle tracking using machine parameter **MP6165**. This generally increases the accuracy of measurements with a 3-D touch probe.

If required, deactivate the lock on the rotary axes for the duration of the calibration. Otherwise it may falsify the results of measurement. The machine tool manual provides further information.



Notes on various calibration methods

- **Rough optimization during commissioning after entering approximate dimensions.**
 - Number of measuring points between 1 and 2
 - Angular step of the rotary axes: Approx. 90°
- **Fine optimization over the entire range of traverse**
 - Number of measuring points between 3 and 6
 - The start and end angles should cover the largest possible traverse range of the rotary axes
 - Position the calibrating ball on the machine table so that on rotary table axes there is a large measuring circle, or so that on swivel head axes the measurement can be made at a representative position (e.g. in the center of the traverse range).
- **Optimization of a specific rotary axis position**
 - Number of measuring points between 2 and 3
 - The measurements are made near the rotary axis angle at which the workpiece is to be machined
 - Position the calibration ball on the machine table for calibration at the position subsequently intended for machining
- **Inspecting the machine accuracy**
 - Number of measuring points between 4 and 8
 - The start and end angles should cover the largest possible traverse range of the rotary axes
- **Determining the rotary axis backlash during inspection**
 - Number of measuring points between 8 and 12
 - The start and end angles should cover the largest possible traverse range of the rotary axes

Backlash

Backlash is a small amount of play between the rotary or angle encoder and the table that occurs when the traverse direction is reversed. If the rotary axes have backlash outside of the control loop it can result in significant error during tilting. The cycle automatically activates internal backlash compensation of 1 degree in digital rotary axes without separate position measurement input.

In the Check mode, the TNC runs the measurement series for each axis to be able to reach the measuring positions from both directions. The TNC documents the arithmetic mean of absolute values of the measured rotary axis backlash.



For reasons of accuracy, if the measuring circle radius is < 1 mm, the TNC does not calculate the backlash. The larger the measuring circle radius, the more accurately the TNC can determine the backlash (See also "Log function" on page 464).



Please note while programming:

Note that all functions for tilting in the working plane are reset. **M128** or **FUNCTION TCPM** are deactivated.

Position the calibrating ball on the machine table so that there can be no collisions during the measuring process.

Before defining the cycle you must set the reference point in the center of the calibrating ball and activate it.

For rotary axes without separate position encoders, select the measuring points in such a way that you have to traverse a distance of 1° to the limit switch. The TNC needs this distance for internal backlash compensation.

For the positioning feed rate when moving to the probing height in the touch probe axis, the TNC uses the value from cycle parameter **Q253** or machine parameter **MP6150**, whichever is smaller. The TNC always moves the rotary axes at positioning feed rate **Q253**, while the probe monitoring is inactive.

If the kinematic data attained in the optimize mode are greater than the permissible limit (**MP6600**), the TNC shows a warning. Then you have to confirm acceptance of the attained value by pressing NC start.

Note that a change in the kinematics always changes the preset as well. After an optimization, reset the preset.

In every probing process the TNC first measures the radius of the calibrating ball. If the measured ball radius differs from the entered ball radius by more than you have defined in machine parameter **MP6601**, the TNC shows an error message and ends the measurement.

If you interrupt the cycle during the measurement, the kinematic data might no longer be in the original condition. Save the active kinematic configuration before an optimization with Cycle 450, so that in case of a failure the most recently active kinematic configuration can be restored.

Programming in inches: The TNC always records the log data and results of measurement in millimeters.

Cycle parameters



- **Mode (0=Check/1=Measure)** Q406: Specify whether the TNC should check or optimize the active kinematics:
 - 0:** Check the active machine kinematics. The TNC measures the kinematics in the axes you have defined, but it does not make any changes to it. The TNC displays the results of measurement in a measurement log
 - 1:** Optimize the active machine kinematics. The TNC measures and optimizes the kinematics in the axes you have defined.
- **Exact calibration sphere radius** Q407: Enter the exact radius of the calibrating ball used. Input range: 0.0001 to 99.9999
- **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- **Retraction height** Q408 (absolute): Input range 0.0001 to 99999.9999
 - Input 0:
Do not move to any retraction height. The TNC moves to the next measuring position in the axis to be measured. Not allowed for Hirth axes! The TNC moves to the first measuring position in the series A, then B, then C.
 - Input >0:
Retraction height in the untilted workpiece coordinate system to which the TNC positions before a rotary axis positioning in the spindle axis. Also, the TNC moves the touch probe in the working plane to the datum. The probe monitoring is not active in this mode. Define the positioning velocity in parameter Q253.
- **Feed rate for pre-positioning** Q253: Traversing speed of the tool during positioning in mm/min. Input range: 0.0001 to 99999.9999; alternatively **FMAX**, **FAUTO**, **PREDEF**.
- **Reference angle** Q380 (absolute): Reference angle (basic rotation) for measuring the measuring points in the active workpiece coordinate system. Defining a reference angle can considerably enlarge the measuring range of an axis. Input range: 0 to 360.0000

Example: Calibration program

```

4 TOOL CALL "TASTER" Z
5 TCH PROBE 450 SAVE KINEMATICS

  Q410=0    ;MODE
  Q409=5    ;MEMORY

6 TCH PROBE 451 MEASURE KINEMATICS

  Q406=1    ;MODE
  Q407=12.5 ;SPHERE RADIUS
  Q320=0    ;SETUP CLEARANCE
  Q408=0    ;RETR. HEIGHT
  Q253=750  ;F PRE-POSITIONING
  Q380=0    ;REFERENCE ANGLE
  Q411=-90  ;START ANGLE A AXIS
  Q412=+90  ;END ANGLE A AXIS
  Q413=0    ;INCID. ANGLE A AXIS
  Q414=0    ;MEAS. POINTS A AXIS
  Q415=-90  ;START ANGLE B AXIS
  Q416=+90  ;END ANGLE B AXIS
  Q417=0    ;INCID. ANGLE B AXIS
  Q418=2    ;MEAS. POINTS B AXIS
  Q419=-90  ;START ANGLE C AXIS
  Q420=+90  ;END ANGLE C AXIS
  Q421=0    ;INCID. ANGLE C AXIS
  Q422=2    ;MEAS. POINTS C AXIS
  Q423=4    ;NO. OF MEAS. POINTS

  Q432=1    ;PRESET
  
```



- ▶ **Start angle A axis** Q411 (absolute): Starting angle in the A axis at which the first measurement is to be made. Input range: -359.999 to 359.999
- ▶ **End angle A axis** Q412 (absolute): Ending angle in the A axis at which the last measurement is to be made. Input range: -359.999 to 359.999
- ▶ **Angle of incid. A axis** Q413: Angle of incidence in the A axis at which the other rotary axes are to be measured. Input range: -359.999 to 359.999
- ▶ **Number meas. points A axis** Q414: Number of probe measurements with which the TNC is to measure the A axis. If input value = 0, the TNC does not measure the respective axis. Input range: 0 to 12
- ▶ **Start angle B axis** Q415 (absolute): Starting angle in the B axis at which the first measurement is to be made. Input range: -359.999 to 359.999
- ▶ **End angle B axis** Q416 (absolute): Ending angle in the B axis at which the last measurement is to be made. Input range: -359.999 to 359.999
- ▶ **Angle of incid. in B axis** Q417: Angle of incidence in the B axis at which the other rotary axes are to be measured. Input range: -359.999 to 359.999
- ▶ **Number meas. points B axis** Q418: Number of probe measurements with which the TNC is to measure the B axis. If input value = 0, the TNC does not measure the respective axis. Input range: 0 to 12

- ▶ **Start angle C axis** Q419 (absolute): Starting angle in the C axis at which the first measurement is to be made. Input range: -359.999 to 359.999
- ▶ **End angle C axis** Q420 (absolute): Ending angle in the C axis at which the last measurement is to be made. Input range: -359.999 to 359.999
- ▶ **Angle of incid. in C axis** Q421: Angle of incidence in the C axis at which the other rotary axes are to be measured. Input range: -359.999 to 359.999
- ▶ **Number meas. points C axis** Q422: Number of probe measurements with which the TNC is to measure the C axis. If input value = 0, the TNC does not measure the respective axis. Input range 0 to 12.
- ▶ **No. of measuring points (4/3)** Q423: Specify whether the TNC should measure the calibration ball in the plane with 4 or 3 probing points. 3 probing points increase the measuring speed:
 - 4:** Use 4 measuring points (standard setting)
 - 3:** Use 3 measuring points
- ▶ **Preset (0/1/2/3)** Q431: Specify whether the TNC is to set the active preset (reference point) automatically in the ball center:
 - 0:** Do not set the preset automatically in the ball center: Set the preset manually before the start of the cycle
 - 1:** Set the preset automatically in the ball center before measurement: Preposition the touch probe manually over the calibration ball before the start of the cycle
 - 2:** Set the preset automatically in the ball center after measurement: Set the preset manually before the start of the cycle
 - 3:** Set the preset in the ball center before and after measurement: Preposition the touch probe manually over the calibration ball before the start of the cycle



If you have activated "Preset" before measurement (Q431 = 1/3), then move the touch probe to a position above the center of the calibration ball before the start of the cycle.



Log function

After running Cycle 451, the TNC creates a measuring log (**TCHPR451.TXT**) containing the following information:

- Creation date and time of the log
- Path of the NC program from which the cycle was run
- Mode used (0=Check/1=Optimize)
- Active kinematic number
- Entered calibrating ball radius
- For each measured rotary axis:
 - Start angle
 - End angle
 - Angle of incidence
 - Number of measuring points
 - Measured dispersion (measured standard deviation)
 - Optimized dispersion (optimized standard deviation)
 - Ascertained backlash
 - Averaged positioning error
 - Measuring circle radius
 - Compensation values in all axes
 - Measurement uncertainty of rotary axes

Notes on log data

Valuation number

The valuation number is a measure of the quality of the measuring positions with respect to the changeable transformations of the kinematics model. The higher the valuation number, the greater the benefit from optimization by the TNC.

Because the TNC always needs two transformations for measuring the position of a rotary axis, two valuation numbers per rotary axis are determined. If a complete valuation is missing, the position of a rotary axis in the kinematics model is not completely defined. The higher the valuation number, the greater the benefit from changing the deviations of the measuring points by adjusting the transformation. The valuation numbers are independent of the measured errors. They are defined by the kinematics model, the position and the number of measuring points per rotary axis.

The valuation of any rotary axis should not fall below a value of **2**. Values greater or equal to **4** are desirable.



If the valuation numbers are too small, increase the measurement range of the rotary axis, or also the number of measuring points. If these measures do not improve the valuation number it may be because of an incorrect kinematic description. If necessary, inform your service agency.

Dispersion (standard deviation)

In the log, 'dispersion', a term from statistics, is used as a measure of accuracy.

Measured dispersion (measured standard deviation) means that 68.3% of the actually measured spatial errors are within the specified range (+/-).

Optimized dispersion (optimized standard deviation) means that 68.3% of the spatial errors to be expected after the correction of the kinematics are within the specified range (+/-).

Measurement uncertainty of angles

The TNC always indicates measurement uncertainty in degrees per 1 μm of system uncertainty. This information is important for evaluating the quality of the measured positioning errors, or the backlash of a rotary axis.

The system uncertainty includes at least the repeatability of the axes (backlash) as well as the positioning uncertainty of the linear axes (positioning errors) and of the touch probe. Since the TNC does not know the accuracy of the complete system, you must make a separate evaluation.

- Example of uncertainty of the calculated positioning errors:
 - Positioning uncertainty of each linear axis: 10 μm
 - Uncertainty of touch probe: 2 μm
 - Logged measurement uncertainty: 0.0002 $^\circ/\mu\text{m}$
 - System uncertainty = $\text{SQRT}(3 * 10^2 + 2^2) = 17.4 \mu\text{m}$
 - Measurement uncertainty = $0.0002 \text{ }^\circ/\mu\text{m} * 17.4 \mu\text{m} = 0.0034^\circ$
- Example of uncertainty of the calculated backlash:
 - Repeatability of each linear axis: 5 μm
 - Uncertainty of touch probe: 2 μm
 - Logged measurement uncertainty: 0.0002 $^\circ/\mu\text{m}$
 - System uncertainty = $\text{SQRT}(3 * 5^2 + 2^2) = 8.9 \mu\text{m}$
 - Measurement uncertainty = $0.0002 \text{ }^\circ/\mu\text{m} * 8.9 \mu\text{m} = 0.0018^\circ$



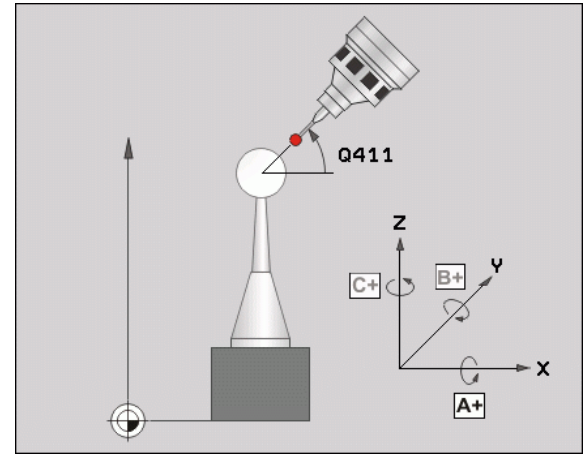
18.5 PRESET COMPENSATION (Cycle 452, DIN/ISO: G452, option)

Cycle run

Touch probe cycle 452 optimizes the kinematic transformation chain of your machine (see "MEASURE KINEMATICS (Cycle 451, DIN/ISO: G451; option)" on page 452). Then the TNC corrects the workpiece coordinate system in the kinematics model in such a way that the current preset is in the center of the calibration ball after optimization.

This cycle enables you, for example, to adjust different tool changer heads so that the workpiece preset applies for all heads.

- 1 Clamp the calibration ball
- 2 Measure the complete reference head with Cycle 451, and use Cycle 451 to finally set the preset in the ball center.
- 3 Insert the second head
- 4 Use Cycle 452 to measure the tool changer head up to the point where the head is changed
- 5 Use Cycle 452 to adjust other tool changer heads to the reference head.



If it is possible to leave the calibration ball clamped to the machine table during machining, you can compensate for machine drift, for example. This procedure is also possible on a machine without rotary axes.

- 1 Clamp the calibration ball and check for potential collisions.
- 2 Set the preset in the calibration ball.
- 3 Set the preset on the workpiece, and start machining the workpiece.
- 4 Use Cycle 452 for preset compensation at regular intervals. The TNC measures the drift of the axes involved and compensates it in the kinematics description.

Parameter number	Meaning
Q141	Standard deviation measured in the A axis (-1 if axis was not measured)
Q142	Standard deviation measured in the B axis (-1 if axis was not measured)
Q143	Standard deviation measured in the C axis (-1 if axis was not measured)
Q144	Optimized standard deviation in the A axis (-1 if axis was not measured)
Q145	Optimized standard deviation in the B axis (-1 if axis was not measured)
Q146	Optimized standard deviation in the C axis (-1 if axis was not measured)



Please note while programming:

In order to be able to perform a preset compensation, the kinematics must be specially prepared. The machine tool manual provides further information.

Note that all functions for tilting in the working plane are reset. **M128** or **FUNCTION TCPM** are deactivated.

Position of the calibrating ball on the machine table so that there can be no collisions during the measuring process.

Before defining the cycle you must set the reference point in the center of the calibrating ball and activate it.

For rotary axes without separate position encoders, select the measuring points in such a way that they have to traverse a distance of 1° to the limit switch. The TNC needs this distance for internal backlash compensation.

For the positioning feed rate when moving to the probing height in the touch probe axis, the TNC uses the value from cycle parameter **Q253** or machine parameter MP6150, whichever is smaller. The TNC always moves the rotary axes at positioning feed rate **Q253**, while the probe monitoring is inactive.

If the kinematic data attained in the optimize mode are greater than the permissible limit (**MP6600**), the TNC shows a warning. Then you have to confirm acceptance of the attained value by pressing NC start.

Note that a change in the kinematics always changes the preset as well. After an optimization, reset the preset.

In every probing process the TNC first measures the radius of the calibrating ball. If the measured ball radius differs from the entered ball radius by more than you have defined in machine parameter **MP6601**, the TNC shows an error message and ends the measurement.

If you interrupt the cycle during the measurement, the kinematic data might no longer be in the original condition. Save the active kinematic configuration before an optimization with Cycle 450, so that in case of a failure the most recently active kinematic configuration can be restored.

Programming in inches: The TNC always records the log data and results of measurement in millimeters.

Cycle parameters



- ▶ **Exact calibration sphere radius** Q407: Enter the exact radius of the calibrating ball used. Input range: 0.0001 to 99.9999
- ▶ **Setup clearance** Q320 (incremental): Additional distance between measuring point and ball tip. Q320 is added to MP6140. Input range 0 to 99999.9999, alternatively **PREDEF**
- ▶ **Retraction height** Q408 (absolute): Input range 0.0001 to 99999.9999
 - Input 0:
Do not move to any retraction height. The TNC moves to the next measuring position in the axis to be measured. Not allowed for Hirth axes! The TNC moves to the first measuring position in the series A, the B, the then C
 - Input >0:
Retraction height in the untilted workpiece coordinate system to which the TNC positions before a rotary axis positioning in the spindle axis. Also, the TNC moves the touch probe in the working plane to the datum. The probe monitoring is not active in this mode. Define the positioning velocity in parameter Q253.
- ▶ **Feed rate for pre-positioning** Q253: Traversing speed of the tool during positioning in mm/min. Input range: 0.0001 to 99999.9999; alternatively **FMAX**, **FAUTO**, **PREDEF**.
- ▶ **Reference angle** Q380 (absolute): Reference angle (basic rotation) for measuring the measuring points in the active workpiece coordinate system. Defining a reference angle can considerably enlarge the measuring range of an axis. Input range: 0 to 360.0000

Example: Calibration program

```

4 TOOL CALL "TASTER" Z
5 TCH PROBE 450 SAVE KINEMATICS
  Q410=0    ;MODE
  Q409=5    ;MEMORY
6 TCH PROBE 452 PRESET COMPENSATION
  Q407=12.5 ;SPHERE RADIUS
  Q320=0    ;SETUP CLEARANCE
  Q408=0    ;RETR. HEIGHT
  Q253=750  ;F PRE-POSITIONING
  Q380=0    ;REFERENCE ANGLE
  Q411=-90  ;START ANGLE A AXIS
  Q412=+90  ;END ANGLE A AXIS
  Q413=0    ;INCID. ANGLE A AXIS
  Q414=0    ;MEAS. POINTS A AXIS
  Q415=-90  ;START ANGLE B AXIS
  Q416=+90  ;END ANGLE B AXIS
  Q417=0    ;INCID. ANGLE B AXIS
  Q418=2    ;MEAS. POINTS B AXIS
  Q419=-90  ;START ANGLE C AXIS
  Q420=+90  ;END ANGLE C AXIS
  Q421=0    ;INCID. ANGLE C AXIS
  Q422=2    ;MEAS. POINTS C AXIS
  Q423=4    ;NO. OF MEAS. POINTS
    
```



- ▶ **Start angle A axis** Q411 (absolute): Starting angle in the A axis at which the first measurement is to be made. Input range: -359.999 to 359.999
- ▶ **End angle A axis** Q412 (absolute): Ending angle in the A axis at which the last measurement is to be made. Input range: -359.999 to 359.999
- ▶ **Angle of incid. A axis** Q413: Angle of incidence in the A axis at which the other rotary axes are to be measured. Input range: -359.999 to 359.999
- ▶ **Number meas. points A axis** Q414: Number of probe measurements with which the TNC is to measure the A axis. If input value = 0, the TNC does not measure the respective axis. Input range: 0 to 12
- ▶ **Start angle B axis** Q415 (absolute): Starting angle in the B axis at which the first measurement is to be made. Input range: -359.999 to 359.999
- ▶ **End angle B axis** Q416 (absolute): Ending angle in the B axis at which the last measurement is to be made. Input range: -359.999 to 359.999
- ▶ **Angle of incid. in B axis** Q417: Angle of incidence in the B axis at which the other rotary axes are to be measured. Input range: -359.999 to 359.999
- ▶ **Number meas. points B axis** Q418: Number of probe measurements with which the TNC is to measure the B axis. If input value = 0, the TNC does not measure the respective axis. Input range: 0 to 12
- ▶ **Start angle C axis** Q419 (absolute): Starting angle in the C axis at which the first measurement is to be made. Input range: -359.999 to 359.999
- ▶ **End angle C axis** Q420 (absolute): Ending angle in the C axis at which the last measurement is to be made. Input range: -359.999 to 359.999
- ▶ **Angle of incid. in C axis** Q421: Angle of incidence in the C axis at which the other rotary axes are to be measured. Input range: -359.999 to 359.999
- ▶ **Number meas. points C axis** Q422: Number of probe measurements with which the TNC is to measure the C axis. If input value = 0, the TNC does not measure the respective axis. Input range: 0 to 12
- ▶ **No. of measuring points (4/3)** Q423: Specify whether the TNC should measure the calibration ball in the plane with 4 or 3 probing points. 3 probing points increase the measuring speed:
4: Use 4 measuring points (standard setting)
3: Use 3 measuring points

Adjustment of tool changer heads

The goal of this procedure is for the workpiece preset to remain unchanged after changing rotary axes (head exchange).

In the following example, a fork head is adjusted to the A and C axes. The A axis is changed, whereas the C axis continues being a part of the basic configuration.

- ▶ Insert the tool changer head that will be used as a reference head.
- ▶ Clamp the calibration ball.
- ▶ Insert the touch probe.
- ▶ Use Cycle 451 to measure the complete kinematics, including the reference head.
- ▶ Set the preset (using Q432 = 2 or 3 in Cycle 451) after measuring the reference head

Example: Measuring a reference head

1	TOOL CALL "TASTER" Z
2	TCH PROBE 451 MEASURE KINEMATICS
	Q406=1 ;MODE
	Q407=12.5 ;SPHERE RADIUS
	Q320=0 ;SET-UP CLEARANCE
	Q408=0 ;RETR. HEIGHT
	Q253=2000 ;F PRE-POSITIONING
	Q380=45 ;REFERENCE ANGLE
	Q411=-90 ;START ANGLE A AXIS
	Q412=+90 ;END ANGLE A AXIS
	Q413=45 ;INCID. ANGLE A AXIS
	Q414=4 ;MEAS. POINTS A AXIS
	Q415=-90 ;START ANGLE B AXIS
	Q416=+90 ;END ANGLE B AXIS
	Q417=0 ;INCID. ANGLE B AXIS
	Q418=2 ;MEAS. POINTS B AXIS
	Q419=+90 ;START ANGLE C AXIS
	Q420=+270 ;END ANGLE C AXIS
	Q421=0 ;INCID. ANGLE C AXIS
	Q422=3 ;MEAS. POINTS C AXIS
	Q423=4 ;NO. OF MEAS. POINTS
	Q431=3 ;PRESET



- ▶ Insert the second tool changer head.
- ▶ Insert the touch probe.
- ▶ Measure the head with Cycle 452.
- ▶ Measure only the axes that have actually been changed (in this example: only the A axis; the C axis is hidden with Q422).
- ▶ The preset and the position of the calibration ball must not be changed during the complete process.
- ▶ All other tool changer heads can be adjusted in the same way.



The head change function can vary depending on the individual machine tool. Refer to your machine manual.

Example: Adjusting a tool changer head

3	TOOL CALL "TASTER" Z
4	TCH PROBE 452 PRESET COMPENSATION
	Q407=12.5 ;SPHERE RADIUS
	Q320=0 ;SET-UP CLEARANCE
	Q408=0 ;RETR. HEIGHT
	Q253=2000 ;F PRE-POSITIONING
	Q380=45 ;REFERENCE ANGLE
	Q411=-90 ;START ANGLE A AXIS
	Q412=+90 ;END ANGLE A AXIS
	Q413=45 ;INCID. ANGLE A AXIS
	Q414=4 ;MEAS. POINTS A AXIS
	Q415=-90 ;START ANGLE B AXIS
	Q416=+90 ;END ANGLE B AXIS
	Q417=0 ;INCID. ANGLE B AXIS
	Q418=2 ;MEAS. POINTS B AXIS
	Q419=+90 ;START ANGLE C AXIS
	Q420=+270 ;END ANGLE C AXIS
	Q421=0 ;INCID. ANGLE C AXIS
	Q422=0 ;MEAS. POINTS C AXIS
	Q423=4 ;NO. OF MEAS. POINTS

Drift Compensation

During machining various machine components are subject to drift due to varying ambient conditions. If the drift remains sufficiently constant over the range of traverse, and if the calibration ball can be left on the machine table during machining, the drift can be measured and compensated with Cycle 452.

- ▶ Clamp the calibration ball.
- ▶ Insert the touch probe.
- ▶ Measure the complete kinematics with Cycle 451 before starting the machining process.
- ▶ Set the preset (using Q432 = 2 or 3 in Cycle 451) after measuring the kinematics.
- ▶ Then set the presets on your workpieces and start the machining process.

Example: Reference measurement for drift compensation

1	T00L CALL "TASTER" Z
2	CYCL DEF 247 DATUM SETTING
	Q339=1 ;DATUM NUMBER
3	TCH PROBE 451 MEASURE KINEMATICS
	Q406=1 ;MODE
	Q407=12.5 ;SPHERE RADIUS
	Q320=0 ;SET-UP CLEARANCE
	Q408=0 ;RETR. HEIGHT
	Q253=750 ;F PRE-POSITIONING
	Q380=45 ;REFERENCE ANGLE
	Q411=+90 ;START ANGLE A AXIS
	Q412=+270 ;END ANGLE A AXIS
	Q413=45 ;INCID. ANGLE A AXIS
	Q414=4 ;MEAS. POINTS A AXIS
	Q415=-90 ;START ANGLE B AXIS
	Q416=+90 ;END ANGLE B AXIS
	Q417=0 ;INCID. ANGLE B AXIS
	Q418=2 ;MEAS. POINTS B AXIS
	Q419=+90 ;START ANGLE C AXIS
	Q420=+270 ;END ANGLE C AXIS
	Q421=0 ;INCID. ANGLE C AXIS
	Q422=3 ;MEAS. POINTS C AXIS
	Q423=4 ;NO. OF MEAS. POINTS
	Q431=3 ;PRESET

- ▶ Measure the drift of the axes at regular intervals.
- ▶ Insert the touch probe.
- ▶ Activate the preset in the calibration ball.
- ▶ Use Cycle 452 to measure the kinematics.
- ▶ The preset and the position of the calibration ball must not be changed during the complete process.



This procedure can also be performed on machines without rotary axes.

Example: Drift compensation

```
4 TOOL CALL "TASTER" Z
5 TCH PROBE 452 PRESET COMPENSATION
  Q407=12.5 ;SPHERE RADIUS
  Q320=0    ;SET-UP CLEARANCE
  Q408=0    ;RETR. HEIGHT
  Q253=99999;F PRE-POSITIONING
  Q380=45   ;REFERENCE ANGLE
  Q411=-90  ;START ANGLE A AXIS
  Q412=+90  ;END ANGLE A AXIS
  Q413=45   ;INCID. ANGLE A AXIS
  Q414=4     ;MEAS. POINTS A AXIS
  Q415=-90  ;START ANGLE B AXIS
  Q416=+90  ;END ANGLE B AXIS
  Q417=0     ;INCID. ANGLE B AXIS
  Q418=2     ;MEAS. POINTS B AXIS
  Q419=+90  ;START ANGLE C AXIS
  Q420=+270 ;END ANGLE C AXIS
  Q421=0     ;INCID. ANGLE C AXIS
  Q422=3     ;MEAS. POINTS C AXIS
  Q423=3     ;NO. OF MEAS. POINTS
```

Log function

After running Cycle 452, the TNC creates a measuring log (**TCHPR452.TXT**) containing the following information:

- Creation date and time of the log
- Path of the NC program from which the cycle was run
- Active kinematic number
- Entered calibrating ball radius
- For each measured rotary axis:
 - Start angle
 - End angle
 - Angle of incidence
 - Number of measuring points
 - Measured dispersion (measured standard deviation)
 - Optimized dispersion (optimized standard deviation)
 - Ascertained backlash
 - Averaged positioning error
 - Measuring circle radius
 - Compensation values in all axes
 - Value of preset compensation
 - Measurement uncertainty of rotary axes

Notes on log data

(see “Notes on log data” on page 464)





19

**Touch Probe Cycles:
Automatic Tool
Measurement**



19.1 Fundamentals

Overview



The TNC and the machine tool must be set up by the machine tool builder for use of the TT touch probe.

Some cycles and functions may not be provided on your machine tool. Refer to your machine manual.

In conjunction with the TNC’s tool measurement cycles, the tool touch probe enables you to measure tools automatically. The compensation values for tool length and radius can be stored in the central tool file TOOL.T and are accounted for at the end of the touch probe cycle. The following types of tool measurement are provided:

- Tool measurement while the tool is at standstill.
- Tool measurement while the tool is rotating.
- Measuring individual teeth.

You can program the cycles for tool measurement in the Programming and Editing mode of operation via the TOUCH PROBE key. The following cycles are available:

Cycle	New format	Old format	Page
Calibrating the TT, Cycles 30 and 480			Page 483
Calibrating the wireless TT 449, Cycle 484			Page 484
Measuring the tool length, Cycles 31 and 481			Page 485
Measuring the tool radius, Cycles 32 and 482			Page 487
Measuring the tool length and radius, Cycles 33 and 483			Page 489



The measuring cycles can be used only when the central tool file TOOL.T is active.

Before working with the measuring cycles, you must first enter all the required data into the central tool file and call the tool to be measured with TOOL CALL.

You can also measure tools in a tilted working plane.



Differences between Cycles 31 to 33 and Cycles 481 to 483

The features and the operating sequences are absolutely identical. There are only two differences between Cycles 31 to 33 and Cycles 481 to 483:

- Cycles 481 to 483 are also available in controls for ISO programming under G481 to G483.
- Instead of a selectable parameter for the status of the measurement, the new cycles use the fixed parameter **Q199**.

Setting the machine parameters



The TNC uses the feed rate for probing defined in MP6520 when measuring a tool at standstill.

When measuring a rotating tool, the TNC automatically calculates the spindle speed and feed rate for probing.

The spindle speed is calculated as follows:

$n = \text{MP6570} / (r \cdot 0.0063)$ where

n	Spindle speed [rpm]
MP6570	Maximum permissible cutting speed in m/min
r	Active tool radius in mm

The feed rate for probing is calculated from:

$v = \text{meas. tolerance} \cdot n$ where

v	Feed rate for probing in mm/min
Measuring tolerance	Measuring tolerance [mm], depending on MP6507
n	Speed in rpm

MP6507 determines the calculation of the probing feed rate:

MP6507=0:

The measuring tolerance remains constant regardless of the tool radius. With very large tools, however, the feed rate for probing is reduced to zero. The smaller you set the maximum permissible rotational speed (MP6570) and the permissible tolerance (MP6510), the sooner you will encounter this effect.

MP6507=1:

The measuring tolerance is adjusted relative to the size of the tool radius. This ensures a sufficient feed rate for probing even with large tool radii. The TNC adjusts the measuring tolerance according to the following table:

Tool radius	Measuring tolerance
Up to 30 mm	MP6510
30 to 60 mm	2 • MP6510
60 to 90 mm	3 • MP6510
90 to 120 mm	4 • MP6510

MP6507=2:

The feed rate for probing remains constant, the error of measurement, however, rises linearly with the increase in tool radius:

Measuring tolerance = (r • MP6510)/ 5 mm), where

- rActive tool radius in mm
- MP6510Maximum permissible error of measurement



Entries in the tool table TOOL.T

Abbr.	Inputs	Dialog
CUT	Number of teeth (20 teeth maximum)	Number of teeth?
LTOL	Permissible deviation from tool length L for wear detection. If the entered value is exceeded, the TNC locks the tool (status L). Input range: 0 to 0.9999 mm	Wear tolerance: length?
RTOL	Permissible deviation from tool radius R for wear detection. If the entered value is exceeded, the TNC locks the tool (status I). Input range: 0 to 0.9999 mm	Wear tolerance: radius?
DIRECT.	Cutting direction of the tool for measuring the tool during rotation	Cutting direction (M3 = -)?
TT:R-OFFS	For tool length measurement: Tool offset between stylus center and tool center. Preset value: Tool radius R (NO ENT means R).	Tool offset: radius?
TT:L-OFFS	Tool radius measurement: Tool offset in addition to MP6530 between upper surface of stylus and lower surface of tool. Default: 0	Tool offset: length?
LBREAK	Permissible deviation from tool length L for breakage detection. If the entered value is exceeded, the TNC locks the tool (status L). Input range: 0 to 0.9999 mm	Breakage tolerance: length?
RBREAK	Permissible deviation from tool radius R for breakage detection. If the entered value is exceeded, the TNC locks the tool (status I). Input range: 0 to 0.9999 mm	Breakage tolerance: radius?

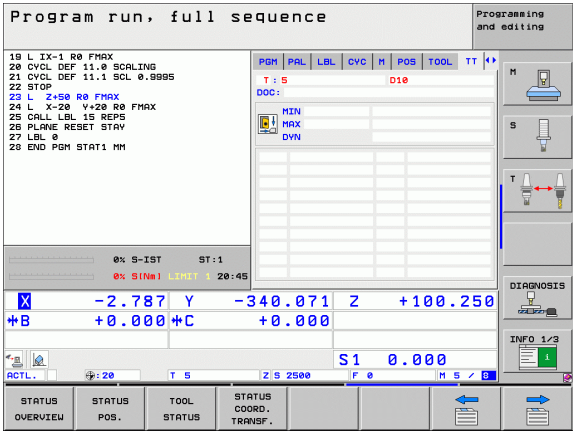
Input examples for common tool types

Tool type	CUT	TT:R-OFFS	TT:L-OFFS
Drill	– (no function)	0 (no offset required because tool tip is to be measured)	
End mill with diameter of < 19 mm	4 (4 teeth)	0 (no offset required because tool diameter is smaller than the contact plate diameter of the TT)	0 (no additional offset required for radius calibration; offset from MP6530 is used.)
End mill with diameter of > 19 mm	4 (4 teeth)	R (offset required because tool diameter is larger than the contact plate diameter of the TT)	0 (no additional offset required for radius calibration; offset from MP6530 is used.)
Radius cutter	4 (4 teeth)	0 (no offset required because the south pole of the ball is to be measured)	5 (always define the tool radius as the offset so that the diameter is not measured in the radius)



Display the results of measurement

You can display the results of tool measurement in the additional status display (in the machine operating modes). The TNC then shows the program blocks in the left and the measuring results in the right screen window. The measuring results that exceed the permissible wear tolerance are marked in the status display with an asterisk " * "; the results that exceed the permissible breakage tolerance are marked with the character B.



19.2 Calibrating the TT (Cycle 30 or 480, DIN/ISO: G480)

Cycle run

The TT is calibrated with the measuring cycle TCH PROBE 30 or TCH PROBE 480 (See also "Differences between Cycles 31 to 33 and Cycles 481 to 483" on page 479). The calibration process is automatic. The TNC also measures the center misalignment of the calibrating tool automatically by rotating the spindle by 180° after the first half of the calibration cycle.

The calibrating tool must be a precisely cylindrical part, for example a cylinder pin. The resulting calibration values are stored in the TNC memory and are accounted for during subsequent tool measurement.

Please note while programming:



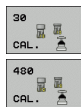
The functioning of the calibration cycle is dependent on MP 6500. Refer to your Machine Manual.

Before calibrating the touch probe, you must enter the exact length and radius of the calibrating tool into the tool table TOOL.T.

The position of the TT within the machine working space must be defined by setting the Machine Parameters 6580.0 to 6580.2.

If you change the setting of any of the Machine Parameters 6580.0 to 6580.2, you must recalibrate the TT.

Cycle parameters



- **Clearance height:** Enter the position in the spindle axis at which there is no danger of collision with the workpiece or fixtures. The clearance height is referenced to the active workpiece datum. If you enter such a small clearance height that the tool tip would lie below the level of the probe contact, the TNC automatically positions the calibration tool above the level of the probe contact (safety zone from MP6540). Input range -99999.9999 to 99999.9999, alternatively **PREDEF**

Example: NC blocks in old format

```
6 TOOL CALL 1 Z
7 TCH PROBE 30.0 CALIBRATE TT
8 TCH PROBE 30.1 HEIGHT: +90
```

Example: NC blocks in new format

```
6 TOOL CALL 1 Z
7 TCH PROBE 480 CALIBRATE TT
Q260=+100 ;CLEARANCE HEIGHT
```



19.3 Calibrating the wireless TT 449 (Cycle 484, DIN/ISO: G484)

Fundamentals

With Cycle 484, you calibrate the wireless infrared TT 449 tool touch probe. The calibration process is not completely automated, because the TT's position on the table is not defined.

Cycle run

- ▶ Insert the calibrating tool.
- ▶ Define and start the calibration cycle.
- ▶ Position the calibrating tool manually above the center of the touch probe and follow the instructions in the pop-up window. Ensure that the calibrating tool is located above the measuring surface of the probe contact.

The calibration process is semi-automatic. The TNC also measures the center misalignment of the calibrating tool by rotating the spindle by 180° after the first half of the calibration cycle.

The calibrating tool must be a precisely cylindrical part, for example a cylinder pin. The resulting calibration values are stored in the TNC memory and are accounted for during subsequent tool measurement.

Please note while programming:



The functioning of the calibration cycle is dependent on MP 6500. Refer to your Machine Manual.

Before calibrating the touch probe, you must enter the exact length and radius of the calibrating tool into the tool table TOOL.T.

The TT needs to be recalibrated if you change its position on the table.

Cycle parameters

Cycle 484 has no cycle parameters.

19.4 Measuring the tool length (Cycle 31 or 481, DIN/ISO: G481)

Cycle run

To measure the tool length, program the measuring cycle TCH PROBE 31 or TCH PROBE 480 (See also "Differences between Cycles 31 to 33 and Cycles 481 to 483" on page 479). Via input parameters you can measure the length of a tool by three methods:

- If the tool diameter is larger than the diameter of the measuring surface of the TT, you can measure the tool while it is rotating.
- If the tool diameter is smaller than the diameter of the measuring surface of the TT, or if you are measuring the length of a drill or spherical cutter, you can measure the tool while it is at standstill.
- If the tool diameter is larger than the diameter of the measuring surface of the TT, you can measure the individual teeth of the tool while it is at standstill.

Cycle for measuring a tool during rotation

The control determines the longest tooth of a rotating tool by positioning the tool to be measured at an offset to the center of the touch probe system and then moving it toward the measuring surface until it contacts the surface. The offset is programmed in the tool table under Tool offset: Radius (**TT: R-OFFS**).

Cycle for measuring a tool during standstill (e.g. for drills)

The control positions the tool to be measured over the center of the measuring surface. It then moves the non-rotating tool toward the measuring surface of the TT until it touches the surface. To activate this function, enter zero for the Tool offset: Radius (**TT: R-OFFS**) in the tool table.

Cycle for measuring individual teeth

The TNC pre-positions the tool to be measured to a position at the side of the touch probe head. The distance from the tip of the tool to the upper edge of the touch probe head is defined in MP6530. You can enter an additional offset with Tool offset: Length (**TT: L-OFFS**) in the tool table. The TNC probes the tool radially during rotation to determine the starting angle for measuring the individual teeth. It then measures the length of each tooth by changing the corresponding angle of spindle orientation. To activate this function, program TCH PROBE 31 = 1 for CUTTER MEASUREMENT.



Please note while programming:



Before measuring a tool for the first time, enter the following data on the tool into the tool table TOOL.T: the approximate radius, the approximate length, the number of teeth, and the cutting direction.

You can run an individual tooth measurement of tools with up to **20 teeth**.

Cycle parameters



- ▶ **Measure tool=0 / Check tool=1:** Select whether the tool is to be measured for the first time or whether a tool that has already been measured is to be inspected. If the tool is being measured for the first time, the TNC overwrites the tool length L in the central tool file TOOL.T by the delta value DL = 0. If you wish to inspect a tool, the TNC compares the measured length with the tool length L that is stored in TOOL.T. It then calculates the positive or negative deviation from the stored value and enters it into TOOL.T as the delta value DL. The deviation can also be used for Q parameter Q115. If the delta value is greater than the permissible tool length tolerance for wear or break detection, the TNC will lock the tool (status L in TOOL.T).
- ▶ **Parameter number for result?:** Parameter number in which the TNC stores the status of the measurement:
 - 0.0:** Tool is within the tolerance
 - 1.0:** Tool is worn (**LTOL** exceeded)
 - 2.0:** Tool is broken (**LBREAK** exceeded). If you do not wish to use the result of measurement within the program, answer the dialog prompt with NO ENT.
- ▶ **Clearance height:** Enter the position in the spindle axis at which there is no danger of collision with the workpiece or fixtures. The clearance height is referenced to the active workpiece datum. If you enter such a small clearance height that the tool tip would lie below the level of the probe contact, the TNC automatically positions the tool above the level of the probe contact (safety zone from MP6540). Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- ▶ **Cutter measurement? 0=No / 1=Yes:** Choose whether the control is to measure the individual teeth (maximum of 20 teeth)

Example: Measuring a rotating tool for the first time; old format

```
6 TOOL CALL 12 Z
7 TCH PROBE 31.0 TOOL LENGTH
8 TCH PROBE 31.1 CHECK: 0
9 TCH PROBE 31.2 HEIGHT: +120
10 TCH PROBE 31.3 PROBING THE TEETH: 0
```

Example: Inspecting a tool and measuring the individual teeth and saving the status in Q5; old format

```
6 TOOL CALL 12 Z
7 TCH PROBE 31.0 TOOL LENGTH
8 TCH PROBE 31.1 CHECK: 1 Q5
9 TCH PROBE 31.2 HEIGHT: +120
10 TCH PROBE 31.3 PROBING THE TEETH: 1
```

Example: NC blocks in new format

```
6 TOOL CALL 12 Z
7 TCH PROBE 481 TOOL LENGTH
   Q340=1 ;CHECK
   Q260=+100 ;CLEARANCE HEIGHT
   Q341=1 ;PROBING THE TEETH
```

19.5 Measuring the tool radius (Cycle 32 or 482, ISO: G482)

Cycle run

To measure the tool radius, program the cycle TCH PROBE 32 or TCH PROBE 482 (See also "Differences between Cycles 31 to 33 and Cycles 481 to 483" on page 479). Via input parameters you can measure the radius of a tool by two methods:

- Measuring the tool while it is rotating.
- Measuring the tool while it is rotating and subsequently measuring the individual teeth.

The TNC pre-positions the tool to be measured to a position at the side of the touch probe head. The distance from the tip of the milling tool to the upper edge of the touch probe head is defined in MP6530. The TNC probes the tool radially while it is rotating. If you have programmed a subsequent measurement of individual teeth, the control measures the radius of each tooth with the aid of oriented spindle stops.

Please note while programming:



Before measuring a tool for the first time, enter the following data on the tool into the tool table TOOL.T: the approximate radius, the approximate length, the number of teeth, and the cutting direction.

Cylindrical tools with diamond surfaces can be measured with stationary spindle. To do so, define the number of teeth (CUT) with 0 and adjust the machine parameter 6500. Refer to your machine manual.



Cycle parameters



- **Measure tool=0 / Check tool=1:** Select whether the tool is to be measured for the first time or whether a tool that has already been measured is to be inspected. If the tool is being measured for the first time, the TNC overwrites the tool radius R in the central tool file TOOL.T by the delta value DR = 0. If you wish to inspect a tool, the TNC compares the measured radius with the tool radius R that is stored in TOOL.T. It then calculates the positive or negative deviation from the stored value and enters it into TOOL.T as the delta value DR. The deviation can also be used for Q parameter Q116. If the delta value is greater than the permissible tool radius tolerance for wear or break detection, the TNC will lock the tool (status L in TOOL.T).
- **Parameter number for result?:** Parameter number in which the TNC stores the status of the measurement:
 - 0.0:** Tool is within the tolerance
 - 1.0:** Tool is worn (**RTOL** exceeded)
 - 2.0:** Tool is broken (**RBREAK** exceeded). If you do not wish to use the result of measurement within the program, answer the dialog prompt with NO ENT.
- **Clearance height:** Enter the position in the spindle axis at which there is no danger of collision with the workpiece or fixtures. The clearance height is referenced to the active workpiece datum. If you enter such a small clearance height that the tool tip would lie below the level of the probe contact, the TNC automatically positions the tool above the level of the probe contact (safety zone from MP6540). Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- **Cutter measurement? 0=No / 1=Yes:** Choose whether the control is also to measure the individual teeth (maximum of 20 teeth)

Example: Measuring a rotating tool for the first time; old format

```
6 TOOL CALL 12 Z
7 TCH PROBE 32.0 TOOL RADIUS
8 TCH PROBE 32.1 CHECK: 0
9 TCH PROBE 32.2 HEIGHT: +120
10 TCH PROBE 32.3 PROBING THE TEETH: 0
```

Example: Inspecting a tool and measuring the individual teeth and saving the status in Q5; old format

```
6 TOOL CALL 12 Z
7 TCH PROBE 32.0 TOOL RADIUS
8 TCH PROBE 32.1 CHECK: 1 Q5
9 TCH PROBE 32.2 HEIGHT: +120
10 TCH PROBE 32.3 PROBING THE TEETH: 1
```

Example: NC blocks in new format

```
6 TOOL CALL 12 Z
7 TCH PROBE 482 TOOL RADIUS
Q340=1 ;CHECK
Q260=+100 ;CLEARANCE HEIGHT
Q341=1 ;PROBING THE TEETH
```



19.6 Measuring tool length and radius (Cycle 33 or 483, ISO: G483)

Cycle run

To measure both the length and radius of a tool, program the measuring cycle TCH PROBE 33 or TCH PROBE 482 (See also "Differences between Cycles 31 to 33 and Cycles 481 to 483" on page 479). This cycle is particularly suitable for the first measurement of tools, as it saves time when compared with individual measurement of length and radius. In input parameters you can select the desired type of measurement:

- Measuring the tool while it is rotating.
- Measuring the tool while it is rotating and subsequently measuring the individual teeth.

The TNC measures the tool in a fixed programmed sequence. First it measures the tool radius, then the tool length. The sequence of measurement is the same as for measuring cycles 31 and 32.

Please note while programming:



Before measuring a tool for the first time, enter the following data on the tool into the tool table TOOL.T: the approximate radius, the approximate length, the number of teeth, and the cutting direction.

Cylindrical tools with diamond surfaces can be measured with stationary spindle. To do so, define the number of teeth (CUT) with 0 and adjust the machine parameter 6500. Refer to your machine manual.



Cycle parameters



- **Measure tool=0 / Check tool=1:** Select whether the tool is to be measured for the first time or whether a tool that has already been measured is to be inspected. If the tool is being measured for the first time, the TNC overwrites the tool radius R and the tool length L in the central tool file TOOL.T by the delta values DR = 0 and DL = 0. If you wish to inspect a tool, the TNC compares the measured data with the tool data stored in TOOL.T. The TNC calculates the deviations and enters them as positive or negative delta values DR and DL in TOOL.T. The deviations are also available in the Q parameters Q115 and Q116. If the delta values are greater than the permissible tool tolerances for wear or break detection, the TNC will lock the tool (status L in TOOL.T).
- **Parameter number for result?:** Parameter number in which the TNC stores the status of the measurement:
 - 0.0:** Tool is within the tolerance
 - 1.0:** Tool is worn (**LTOL** or/and **RTOL** exceeded)
 - 2.0:** Tool is broken (**LBREAK** or/and **RBREAK** exceeded). If you do not wish to use the result of measurement within the program, answer the dialog prompt with NO ENT.
- **Clearance height:** Enter the position in the spindle axis at which there is no danger of collision with the workpiece or fixtures. The clearance height is referenced to the active workpiece datum. If you enter such a small clearance height that the tool tip would lie below the level of the probe contact, the TNC automatically positions the tool above the level of the probe contact (safety zone from MP6540). Input range -99999.9999 to 99999.9999, alternatively **PREDEF**
- **Cutter measurement? 0=No / 1=Yes:** Choose whether the control is also to measure the individual teeth (maximum of 20 teeth)

Example: Measuring a rotating tool for the first time; old format

```
6 TOOL CALL 12 Z
7 TCH PROBE 33.0 MEASURE TOOL
8 TCH PROBE 33.1 CHECK: 0
9 TCH PROBE 33.2 HEIGHT: +120
10 TCH PROBE 33.3 PROBING THE TEETH: 0
```

Example: Inspecting a tool and measuring the individual teeth and saving the status in Q5; old format

```
6 TOOL CALL 12 Z
7 TCH PROBE 33.0 MEASURE TOOL
8 TCH PROBE 33.1 CHECK: 1 Q5
9 TCH PROBE 33.2 HEIGHT: +120
10 TCH PROBE 33.3 PROBING THE TEETH: 1
```

Example: NC blocks in new format

```
6 TOOL CALL 12 Z
7 TCH PROBE 483 MEASURE TOOL
  Q340=1 ;CHECK
  Q260=+100 ;CLEARANCE HEIGHT
  Q341=1 ;PROBING THE TEETH
```

Symbole

- 3-D touch probes ... 40, 300
- Calibrating
- Triggering ... 435, 436

A

- Angle of a plane, measuring ... 424
- Angle, measuring in a plane ... 424
- Automatic presetting ... 330
 - Center of 4 holes ... 371
 - Center of bolt hole circle ... 365
 - Center of circular pocket (or hole) ... 348
 - Center of circular stud ... 352
 - Center of rectangular pocket ... 340
 - Center of rectangular stud ... 344
 - In any axis ... 375
 - In inside corner ... 361
 - In the touch probe axis ... 369
 - Outside corner ... 356
 - Ridge center ... 337
 - Slot center ... 333
- Automatic tool measurement ... 481
- Axis-specific scaling ... 276

B

- Back boring ... 83
- Basic rotation
 - Measuring during program run ... 308
 - Setting directly ... 322
- Bolt hole circle ... 169
- Bolt hole circle, measuring ... 420
- Bore milling ... 91
- Boring ... 75

C

- Centering ... 69
- Circle, measuring from inside ... 395
- Circle, measuring from outside ... 399
- Circular pocket
 - Roughing+finishing ... 142
- Circular slot
 - Roughing+finishing ... 151
- Circular stud ... 160
- Classification of results ... 387
- Compensating workpiece misalignment
 - By measuring two points of a line ... 310
 - Over two holes ... 313
 - Over two studs ... 316
 - Via rotary axis ... 319, 323

C

- Confidence range ... 304
- Contour cycles ... 178
- Contour train ... 197
- Contour train data ... 199
- Coordinate transformation ... 260
- Coordinate, measuring a single ... 417
- Cycle
 - Calling ... 46
 - Defining ... 45
- Cycles and point tables ... 66
- Cylinder surface
 - Contour machining ... 211
 - Contour milling ... 220
 - Ridge machining ... 217
 - Slot machining ... 214

D

- Datum shift
 - With datum tables ... 263
 - Within the program ... 262
- Deepened starting point for drilling ... 90, 95
- Drilling ... 71, 79, 87
 - Deepened starting point ... 90, 95
- Drilling cycles ... 68
- Dwell time ... 291

E

- External thread milling ... 128

F

- Face milling ... 251
- Fast probing ... 444
- FCL function ... 6
- Feature content level ... 6
- Floor finishing ... 194

G

- Global settings ... 444

H

- Helical thread drilling/milling ... 124
- Hole, measuring ... 395

I

- Internal thread milling ... 113

K

- Key-way milling
 - Roughing+finishing ... 146
- Kinematic measurement ... 448, 452
 - Accuracy ... 457
 - Backlash ... 459
 - Calibration methods ... 458, 471, 473
 - Hirth coupling ... 455
 - Kinematic measurement ... 452
 - Kinematics measurement ... 466
 - Kinematics, save ... 450
 - Log function ... 451, 464, 475
 - Measuring points, choice of ... 456
 - Measuring positions, choice of ... 456
 - Prerequisites ... 449
- Kinematics measurement
 - Preset compensation ... 466
- KinematicsOpt ... 448

M

- Machine parameters for 3-D touch probes ... 303
- Machining patterns ... 55
- Measurement results in Q
 - parameters ... 332, 387
- Measuring angles ... 392
- Mirror image ... 270
- Multiple measurements ... 304

O

- Oriented spindle stop ... 294

P

- Pattern definition ... 55
- Pecking ... 87, 94
 - Deepened starting point ... 90, 95
- Point pattern
 - Circular ... 169
 - Linear ... 172
 - Overview ... 168
- Point patterns
- Point tables ... 63
- Positioning logic ... 306
- Preset table ... 332
- Probing feed rate ... 305
- Program call
 - Via cycle ... 292

R

- Reaming ... 73
- Recording the results of measurement ... 385
- Rectangular pocket
 - Roughing+finishing ... 137
- Rectangular pocket measurement ... 407
- Rectangular stud ... 156
- Rectangular stud, measuring ... 403
- Reference point
 - Save in a datum table ... 332
 - Save in the preset table ... 332
- Result parameters ... 332, 387
- Ridge, measuring from outside ... 414
- Rotation ... 272
- Rough out: See SL Cycles: Rough-out
- Ruled surface ... 247
- Run 3-D data ... 243

S

- Scaling factor ... 274
- Side finishing ... 195
- Single-fluted deep-hole drilling ... 94
- SL Cycles
- SL cycles
 - Contour data ... 186
 - Contour geometry cycle ... 181
 - Contour train ... 197
 - Contour train data ... 199
 - Floor finishing ... 194
 - Fundamentals ... 178, 238
 - Overlapping contours ... 182, 232
 - Pilot drilling ... 188
 - Rough-out ... 190
 - Side finishing ... 195
- SL Cycles with Complex Contour
 - Formula
- SL cycles with simple contour
 - formula ... 238
- Slot width, measuring ... 411

T

- Tapping
 - With a floating tap holder ... 103
 - With chip breaking ... 108
 - Without floating tap holder ... 105, 108
- Thermal expansion, measuring ... 441
- Thread drilling/milling ... 120
- Thread milling, fundamentals ... 111
- Thread milling/countersinking ... 116
- Tilting the working plane ... 278
 - Cycle ... 278
 - Guide ... 284
- Tolerance monitoring ... 388
- Tool compensation ... 388
- Tool measurement ... 481
 - Calibrating the TT ... 483, 484
 - Displaying the measuring results ... 482
 - Machine parameters ... 479
 - Measuring tool length and radius ... 489
 - Tool length ... 485
 - Tool radius ... 487
- Tool monitoring ... 388
- Touch probe cycles
 - Touch probe cycles for automatic operation ... 302

U

- Universal drilling ... 79, 87

W

- Width, measuring from inside ... 411
- Width, measuring from outside ... 414
- Workpiece measurement ... 384

Overview

Machining cycles

Cycle number	Cycle designation	DEF-active	CALL-active	Page
7	Datum shift	■		Page 262
8	Mirror image	■		Page 270
9	Dwell time	■		Page 291
10	Rotation	■		Page 272
11	Scaling factor	■		Page 274
12	Program call	■		Page 292
13	Oriented spindle stop	■		Page 294
14	Contour definition	■		Page 181
19	Tilting the working plane	■		Page 278
20	Contour data SL II	■		Page 186
21	Pilot drilling SL II		■	Page 188
22	Rough out SL II		■	Page 190
23	Floor finishing SL II		■	Page 194
24	Side finishing SL II		■	Page 195
25	Contour train		■	Page 197
26	Axis-specific scaling	■		Page 276
27	Cylinder surface		■	Page 211
28	Cylindrical surface slot		■	Page 214
29	Cylinder surface ridge		■	Page 217
30	Run 3-D data		■	Page 243
32	Tolerance	■		Page 295
39	Cylinder surface external contour		■	Page 220
200	Drilling		■	Page 71
201	Reaming		■	Page 73
202	Boring		■	Page 75
203	Universal drilling		■	Page 79



Cycle number	Cycle designation	DEF-active	CALL-active	Page
204	Back boring		■	Page 83
205	Universal pecking		■	Page 87
206	Tapping with a floating tap holder, new		■	Page 103
207	Rigid tapping, new		■	Page 105
208	Bore milling		■	Page 91
209	Tapping with chip breaking		■	Page 108
220	Circular point pattern	■		Page 169
221	Linear point pattern	■		Page 172
230	Multipass milling		■	Page 245
231	Ruled surface		■	Page 247
232	Face milling		■	Page 251
240	Centering		■	Page 69
241	Single-fluted deep-hole drilling		■	Page 94
247	Datum setting	■		Page 269
251	Rectangular pocket (complete machining)		■	Page 137
252	Circular pocket (complete machining)		■	Page 142
253	Key-way milling		■	Page 146
254	Circular slot		■	Page 151
256	Rectangular stud (complete machining)		■	Page 156
257	Circular stud (complete machining)		■	Page 160
262	Thread milling		■	Page 113
263	Thread milling/countersinking		■	Page 116
264	Thread drilling/milling		■	Page 120
265	Helical thread drilling/milling		■	Page 124
267	Outside thread milling		■	Page 128
270	Contour train data	■		Page 199

Touch Probe Cycles

Cycle number	Cycle designation	DEF-active	CALL-active	Page
0	Reference plane	■		Page 390
1	Polar datum	■		Page 391
2	Calibrate TS radius	■		Page 435
3	Measuring	■		Page 437
4	Measuring in 3-D	■		Page 439
9	Calibrate TS length	■		Page 436
30	Calibrating the TT	■		Page 483
31	Measure/Inspect the tool length	■		Page 485
32	Measure/Inspect the tool radius	■		Page 487
33	Measure/Inspect the tool length and the tool radius	■		Page 489
400	Basic rotation using two points	■		Page 310
401	Basic rotation from two holes	■		Page 313
402	Basic rotation from two studs	■		Page 316
403	Compensate misalignment with rotary axis	■		Page 319
404	Set basic rotation	■		Page 322
405	Compensate misalignment with the C axis	■		Page 323
408	Reference point at slot center (FCL 3 function)	■		Page 333
409	Reference point at ridge center (FCL 3 function)	■		Page 337
410	Datum from inside of rectangle	■		Page 340
411	Datum from outside of rectangle	■		Page 344
412	Datum from inside of circle (hole)	■		Page 348
413	Datum from outside of circle (stud)	■		Page 352
414	Datum from outside of corner	■		Page 356
415	Datum from inside of corner	■		Page 361
416	Datum from circle center	■		Page 365
417	Datum in touch probe axis	■		Page 369
418	Datum at center between four holes	■		Page 371
419	Datum in any one axis	■		Page 375



Cycle number	Cycle designation	DEF-active	CALL-active	Page
420	Workpiece—measure angle	■		Page 392
421	Workpiece—measure hole (center and diameter of hole)	■		Page 395
422	Workpiece—measure circle from outside (diameter of circular stud)	■		Page 399
423	Workpiece—measure rectangle from inside	■		Page 403
424	Workpiece—measure rectangle from outside	■		Page 407
425	Workpiece—measure inside width (slot)	■		Page 411
426	Workpiece—measure outside width (ridge)	■		Page 414
427	Workpiece—measure in any selectable axis	■		Page 417
430	Workpiece—measure bolt hole circle	■		Page 420
431	Workpiece—measure plane	■		Page 420
440	Measure axis shift	■		Page 441
441	Rapid probing: Set global touch probe parameters (FCL 2 function)	■		Page 444
450	KinematicsOpt: Save kinematics (option)	■		Page 450
451	KinematicsOpt: Measure kinematics (option)	■		Page 452
452	KinematicsOpt: Preset compensation (option)	■		Page 452
480	Calibrating the TT	■		Page 483
481	Measure/Inspect the tool length	■		Page 485
482	Measure/Inspect the tool radius	■		Page 487
483	Measure/Inspect the tool length and the tool radius	■		Page 489
484	Calibrate infrared TT	■		Page 484

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