

VISION

FANUC 0 - M / 21 - M

- **Fräsen**
- **Milling**
- **Fraisage**
- **Fresar**

Ref. Nr.: VS 9973

Hersteller:

EMCO MAIER Gesellschaft m.b.H.- P.O.Box 131- A-5400 Hallein/Austria- Tel.(06245) 891-0 Fax (06245) 86965

INHALTSVERZEICHNIS

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12	G02 Kreisinterpolation im Uhrzeigersinn
13	G03 Kreisinterpolation im Gegenuhrzeigersinn
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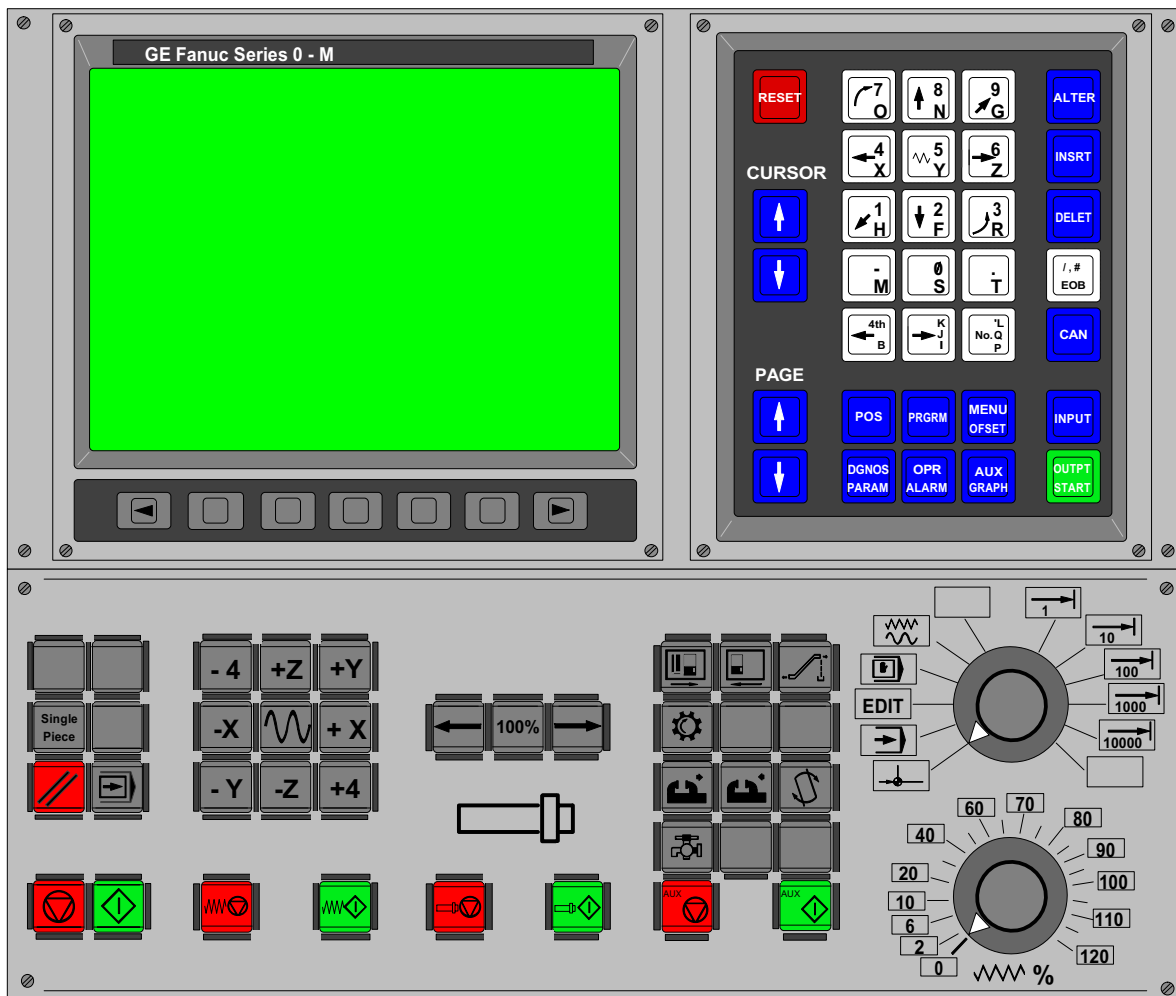
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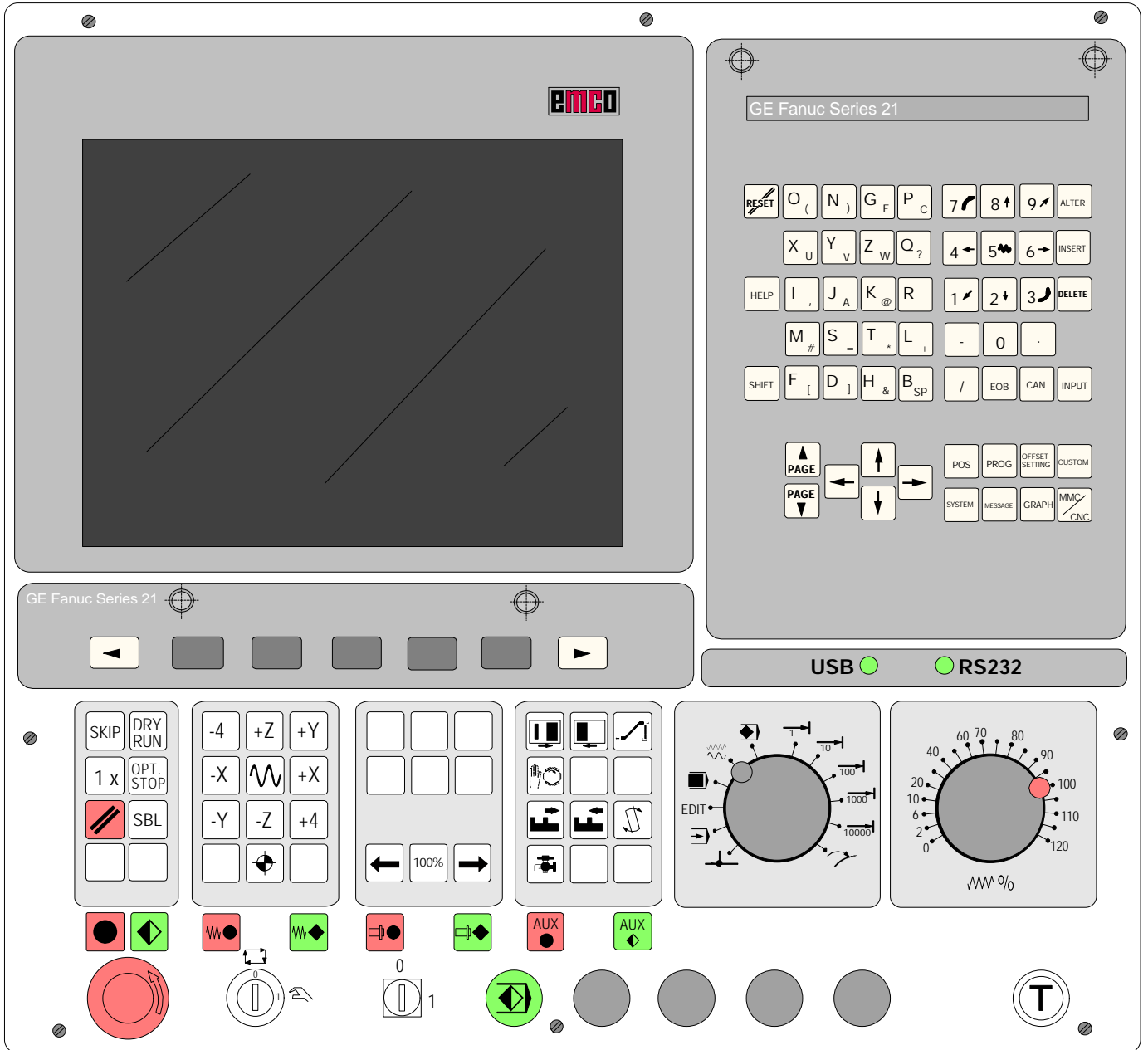
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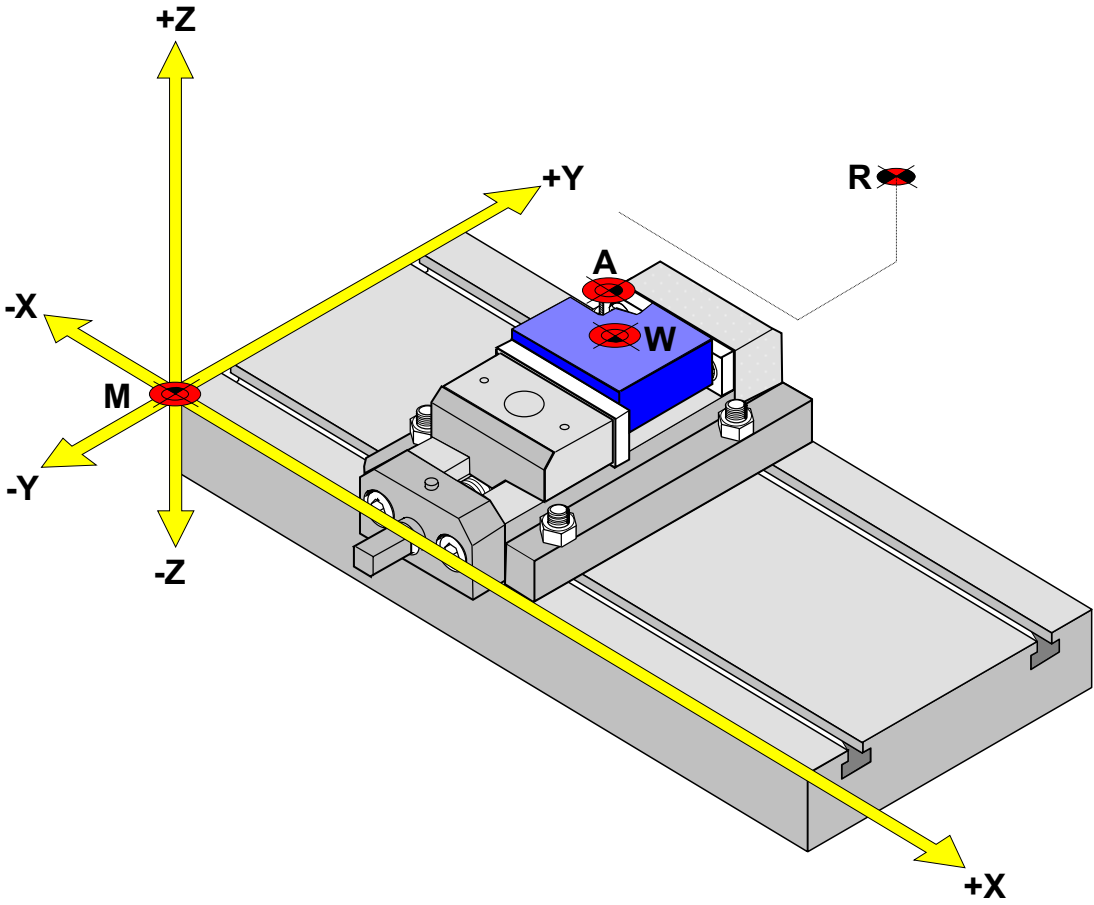
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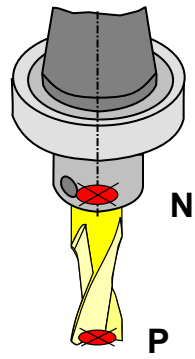
Hoja no.	Tema
1, 1a	Pupitre de mando Fanuc 0 - M, 21 - M
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31	M98, M99 Técnica de subprogramas



21-M









M

Maschinennullpunkt
Machine zero point
Origine de la machine
Punto cero de la máquina



A

Anschlag-Punkt
Dead stop point
Point d'arrêt du pièce
Punto de tope



W

Werkstücknullpunkt
Workpiece zero point
Origine de la pièce
Punto cero de la pieza



R

Referenzpunkt
Reference point
Référence de la machine
Punto de referencia



T

Werkzeugträger-Bezugspunkt
Toolholder reference point
Référence des portes-outils
Punto de referencia del portaherramientas



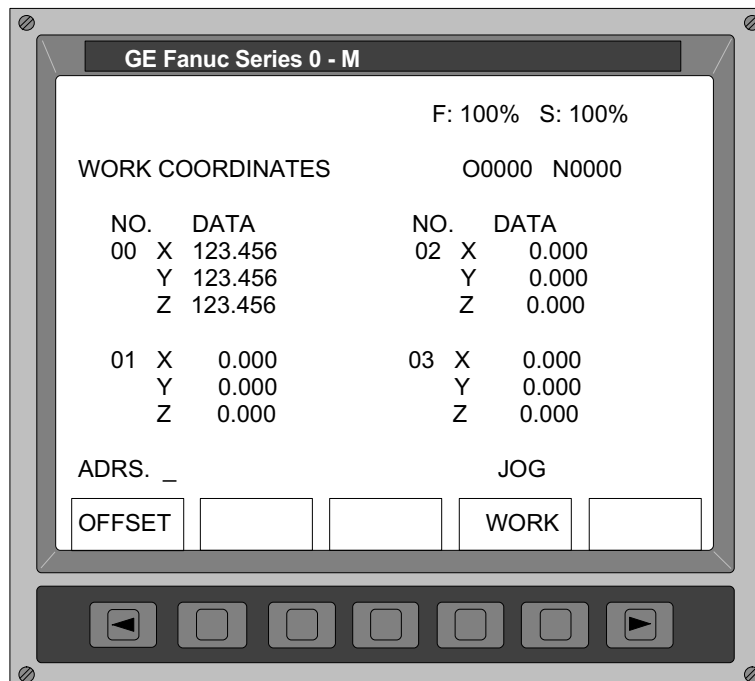
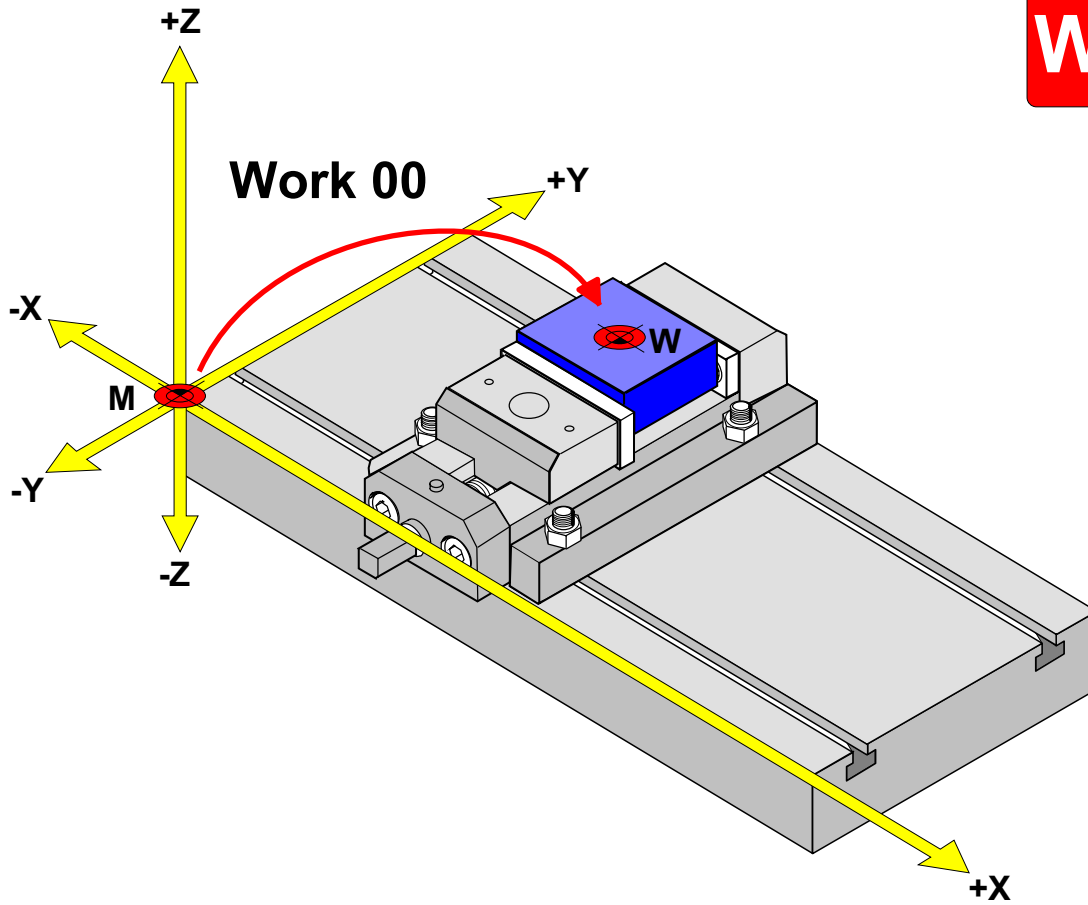
N

Werkzeugaufnahme-Bezugspunkt
Tool mount reference point
Référence du système d'outillage
Punto de referencia para toma de herramienta

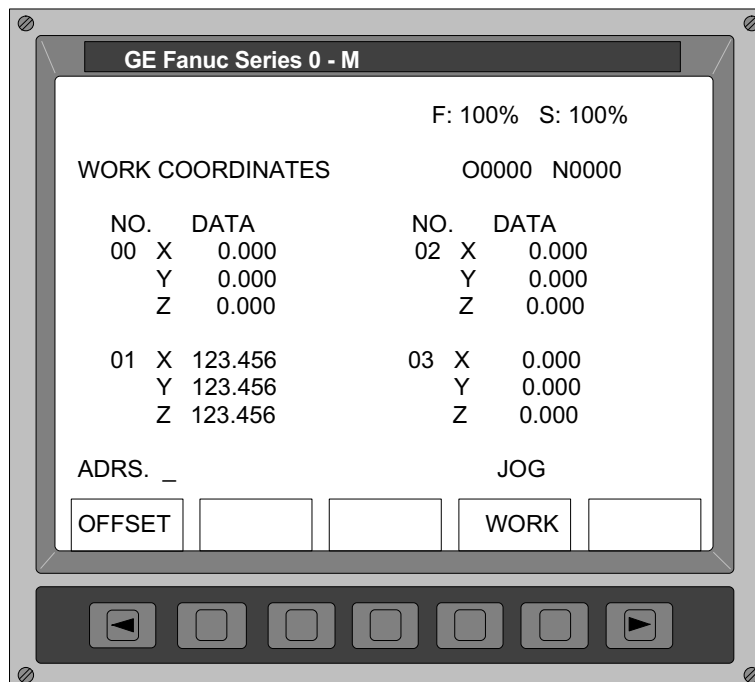
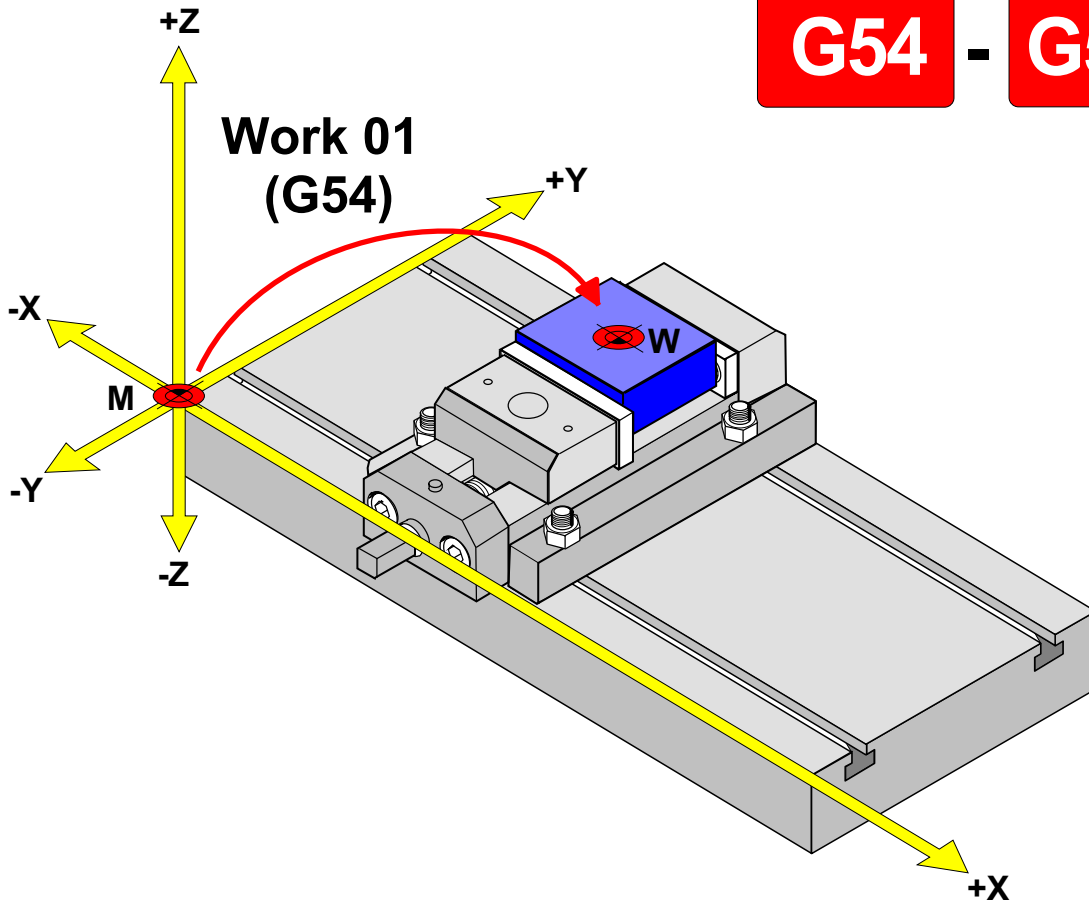


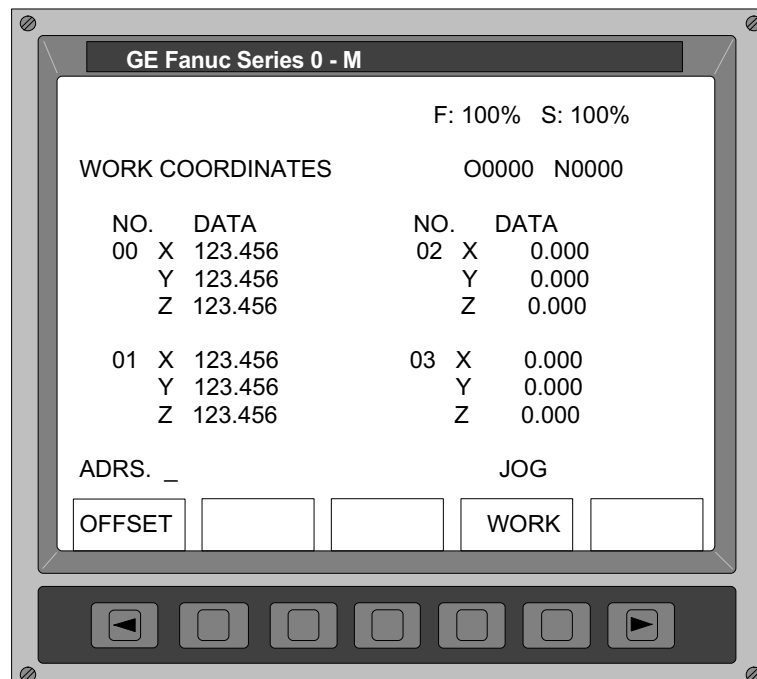
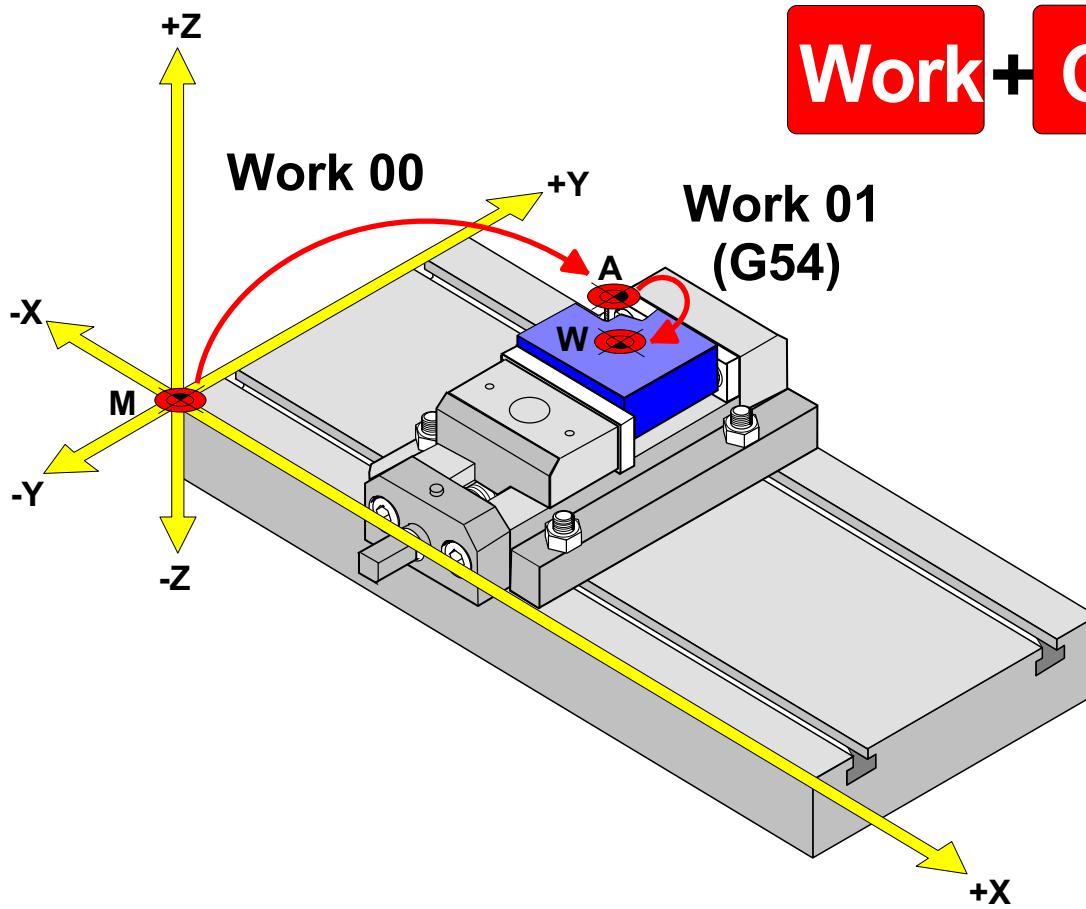
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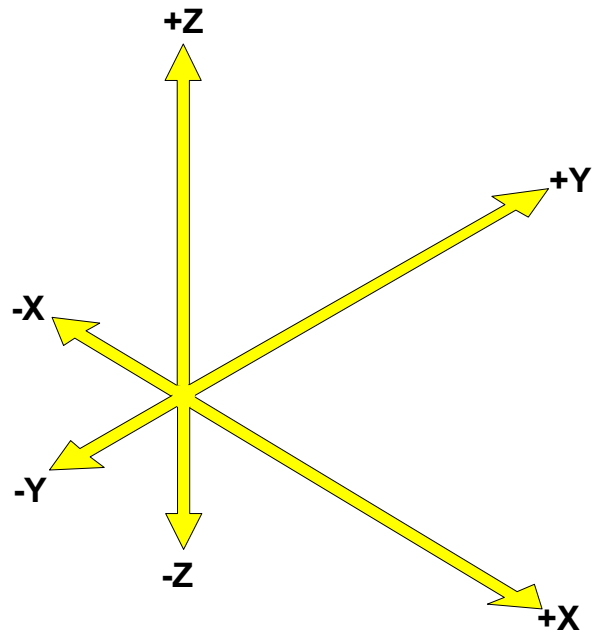
Werkzeugpunkt
Cutterpoint
Point tranchant d'outil
Punta de herramienta

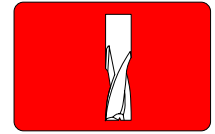


G54 - G59

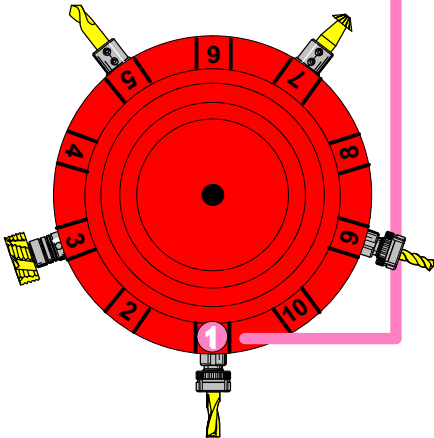






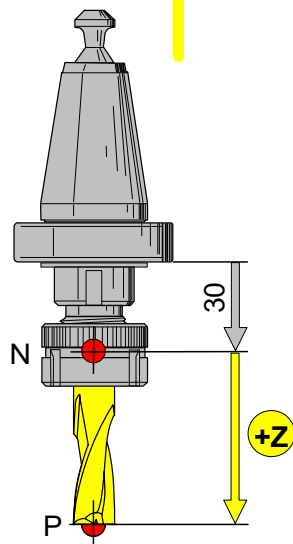


T1 G43 H1

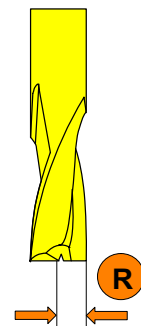


GE Fanuc Series 0 - M

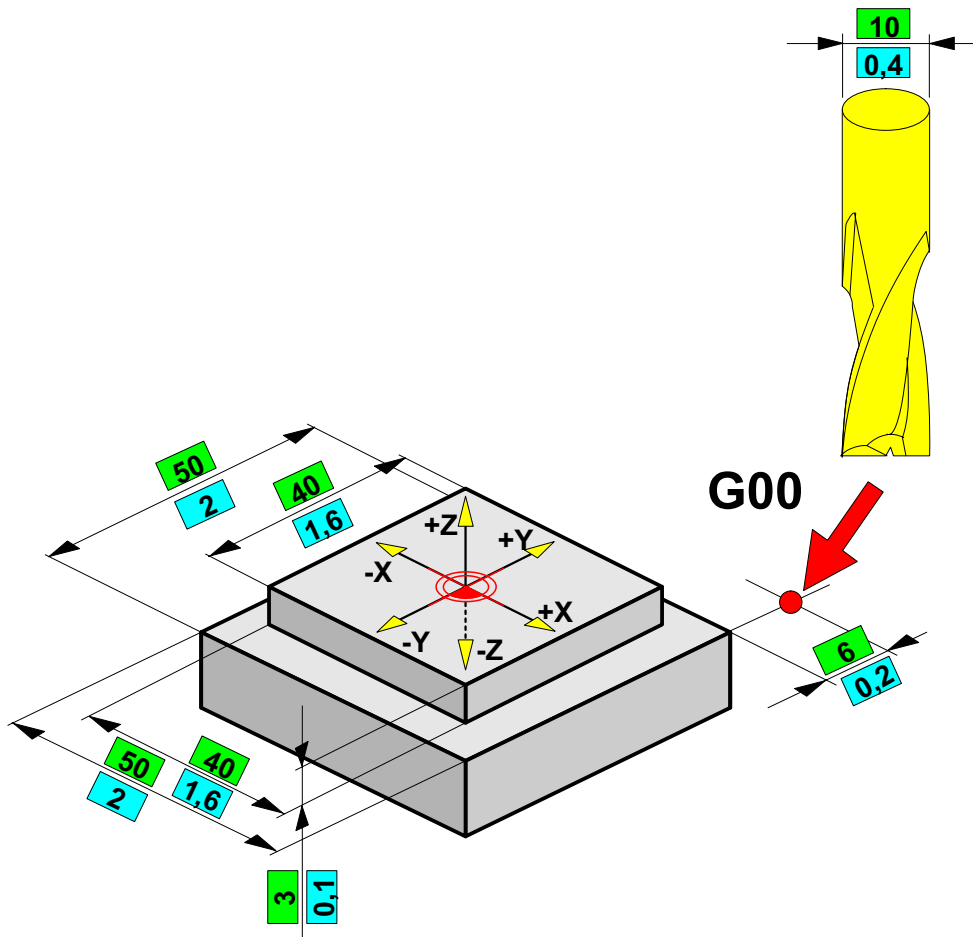
OFFSET			
NO.	DATA	NO.	DATA
001	12.345	009	0.000
002	0.000	010	0.000
003	0.000	011	0.000
004	0.000	012	1.234
005	0.000	013	0.000
...



**G41 H12
G42 H12**



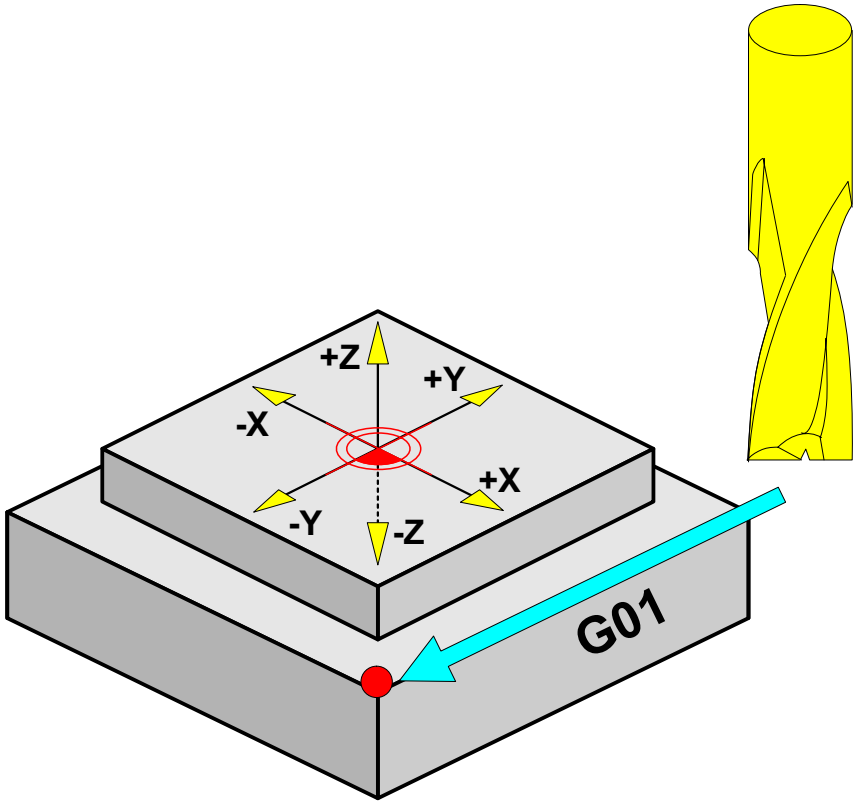
G00



N1234 G00 X25 Y31 Z-3 LF mm

N1234 G00 X1 Y1.2 Z-0.1 LF inch

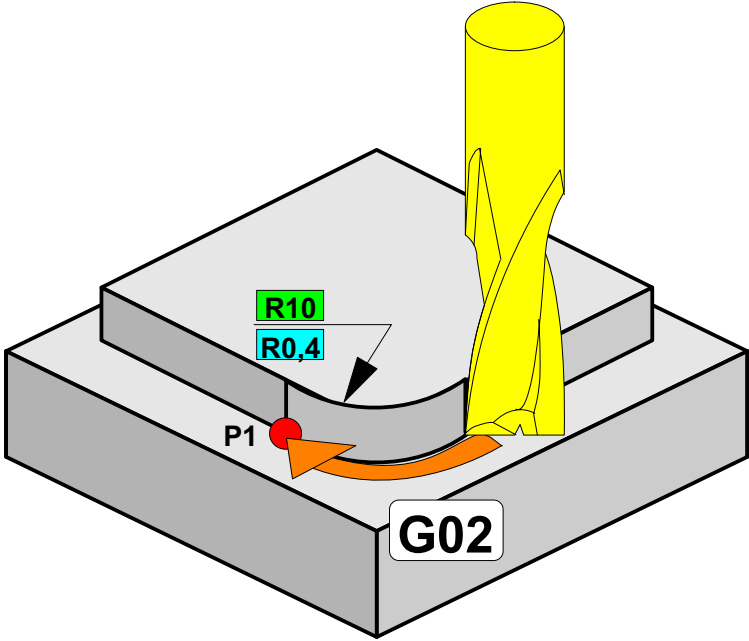
G01



```
N1234 G01 X25 Y-25 LF mm
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N1234 G01 X1 Y-1 LF inch
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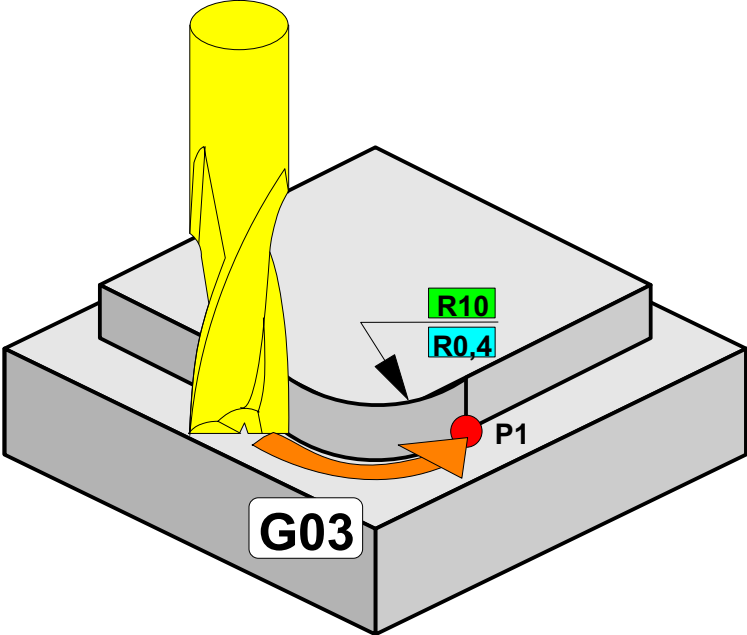
G02



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N1234 G02 X... Y... R10 LF mm
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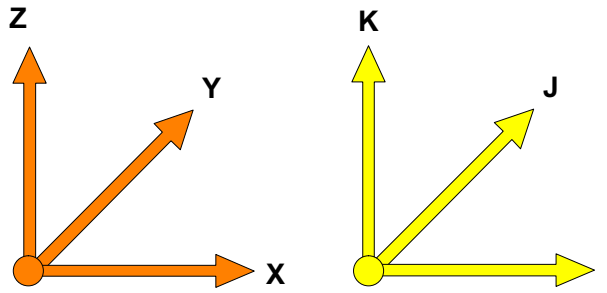
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N1234 G02 X... Y... R0.4 LF inch
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G03



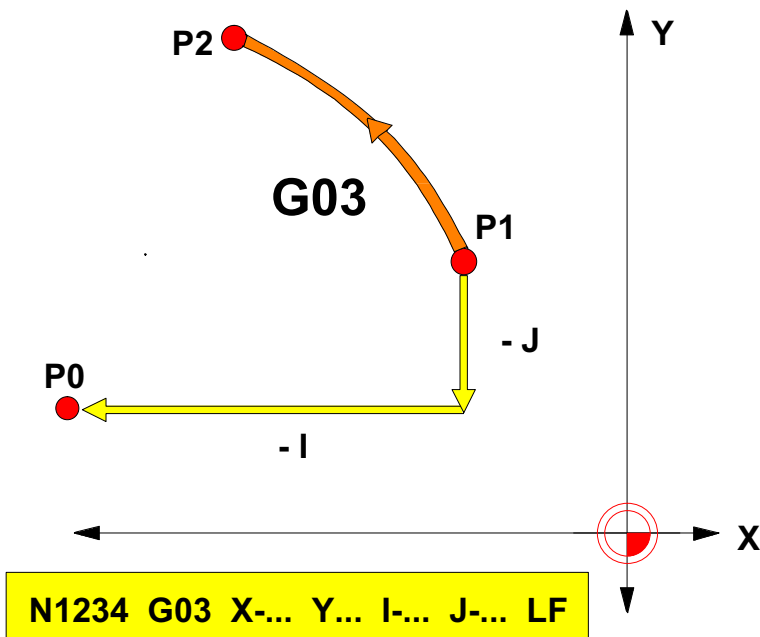
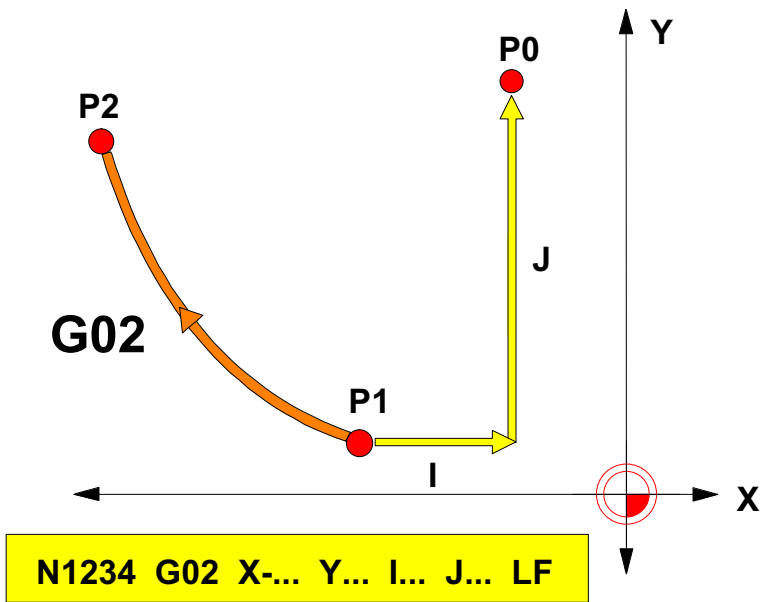
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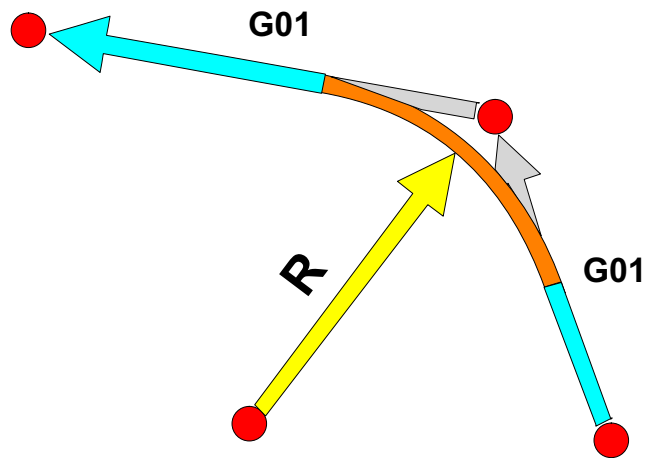
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N1234 G03 X... Y... R0.4 LF inch
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G02

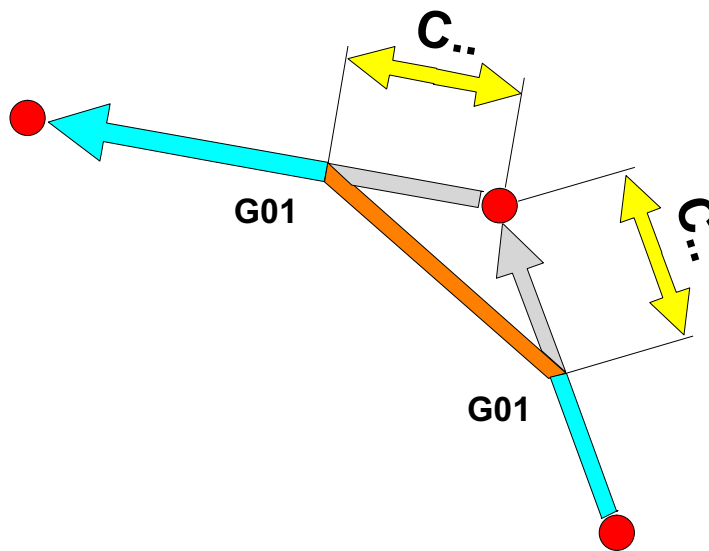
G03





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N0042 G01 X... Y... R... LF
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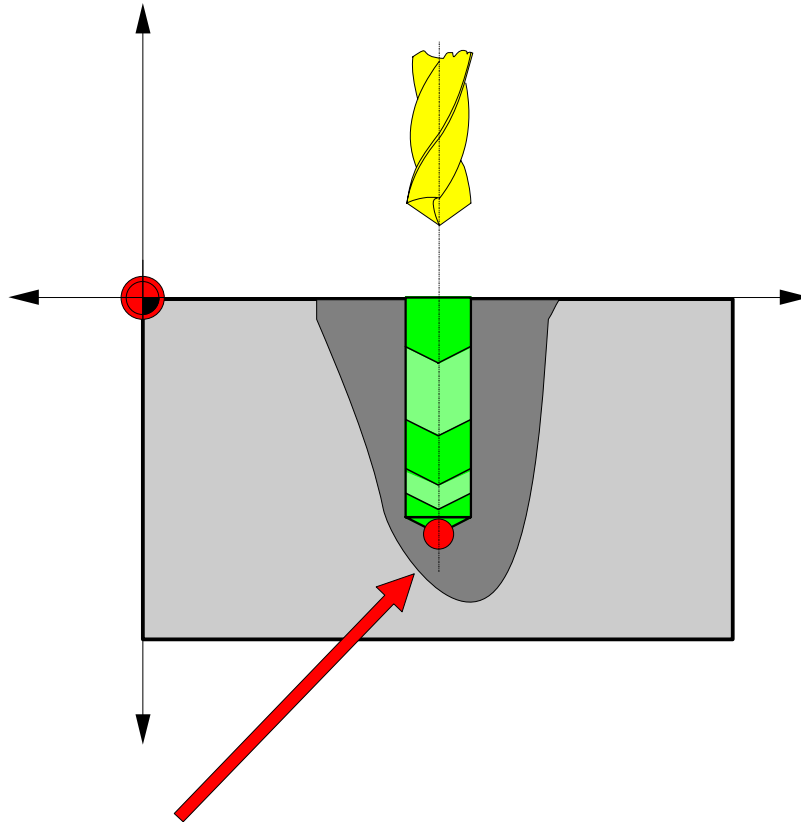
```
N0043 G01 X... Y... LF
```



```
N0042 G01 X... Y... C... LF
```

```
N0043 G01 X... Y... LF
```

G04



N1234 G04 X... LF

(sec.)

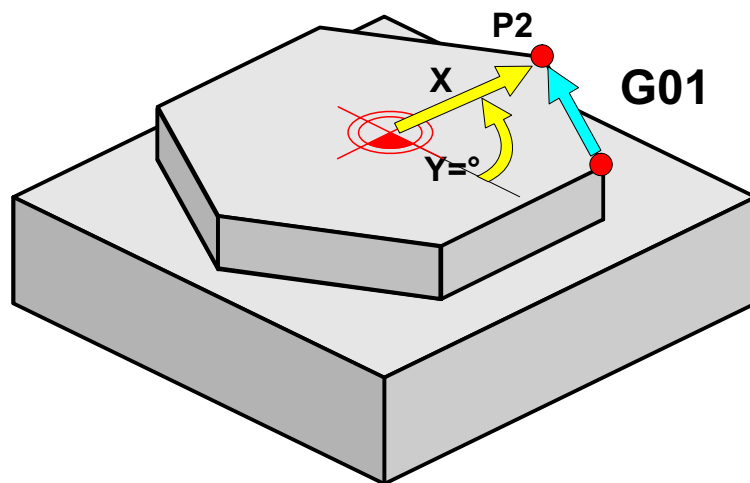
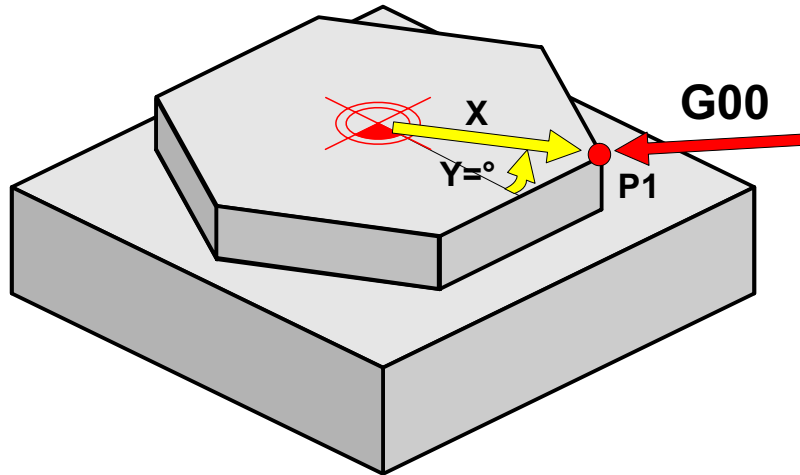


N1234 G04 P... LF

(msec.)

G15

G16



N1234 G16

N1234 G00 X... Y...° (P1)

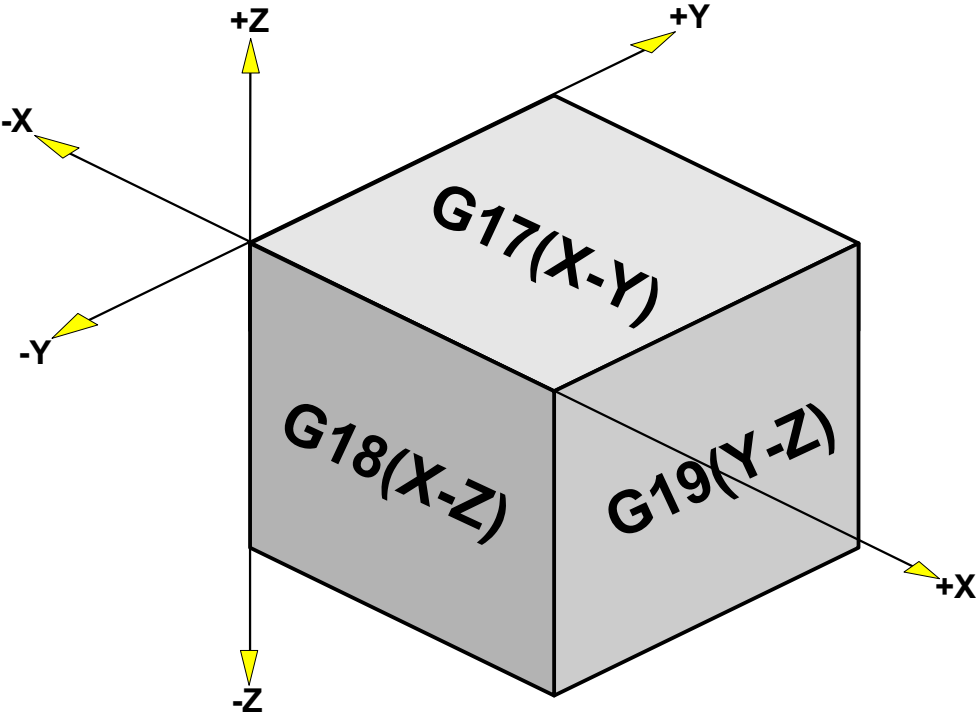
N1234 G01 X... Y...° (P2)

N1234 G15

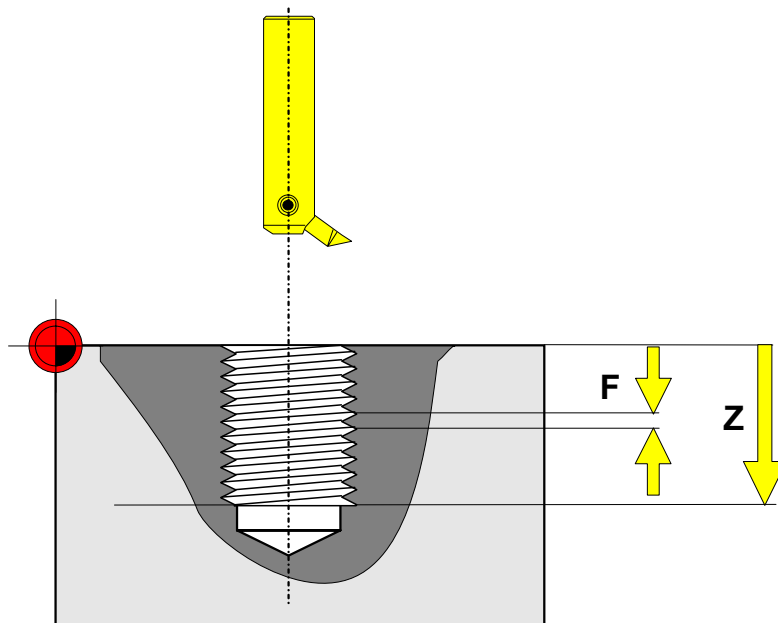
G17

G18

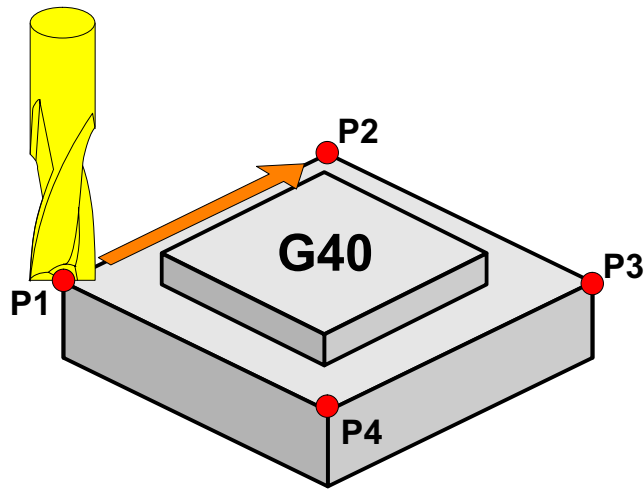
G19



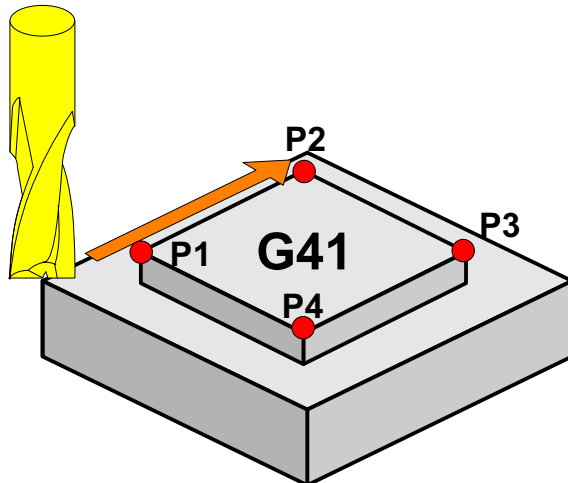
G33



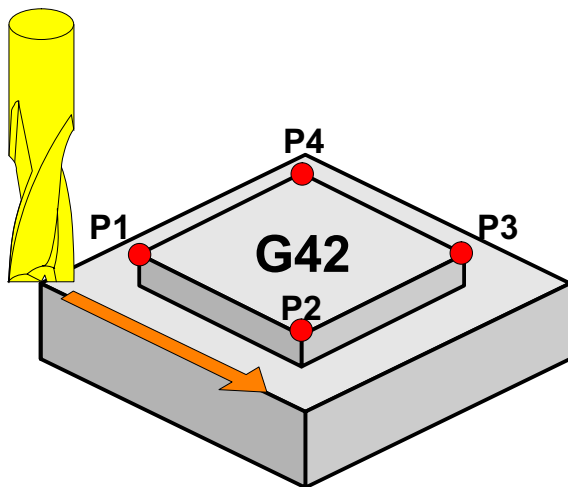
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N1234 G33 Z ... F ...  
N1234 G01 .....
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G40



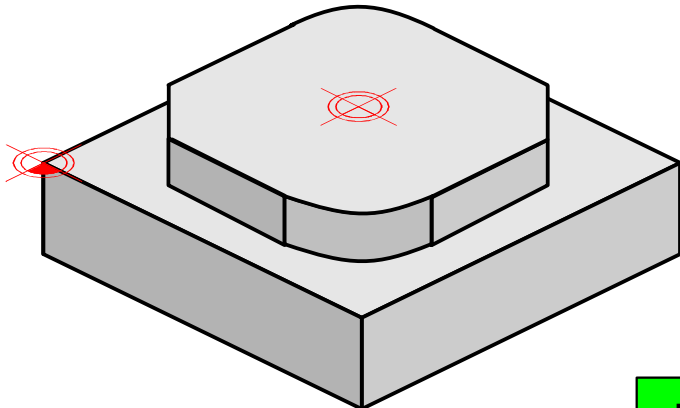
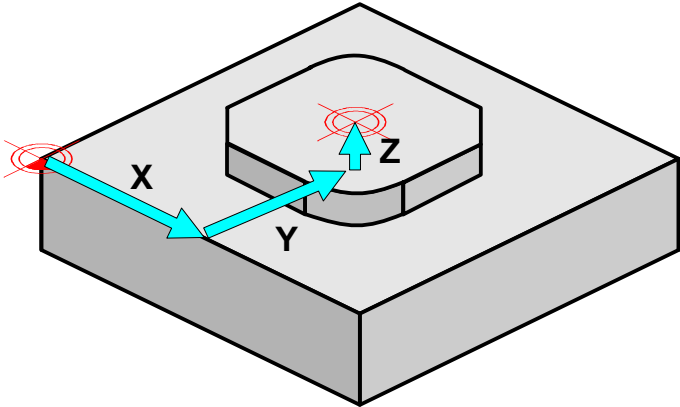
G41



G42

G50

G51

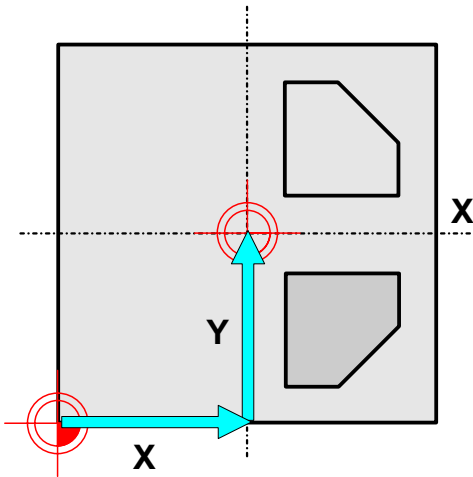


I, J, K	M / S
1000	1 : 1
2000	1 : 2
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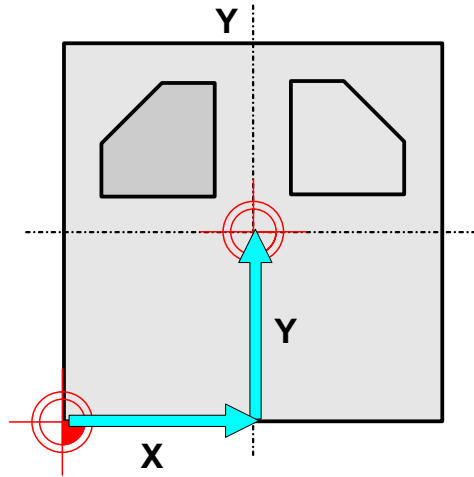
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G50

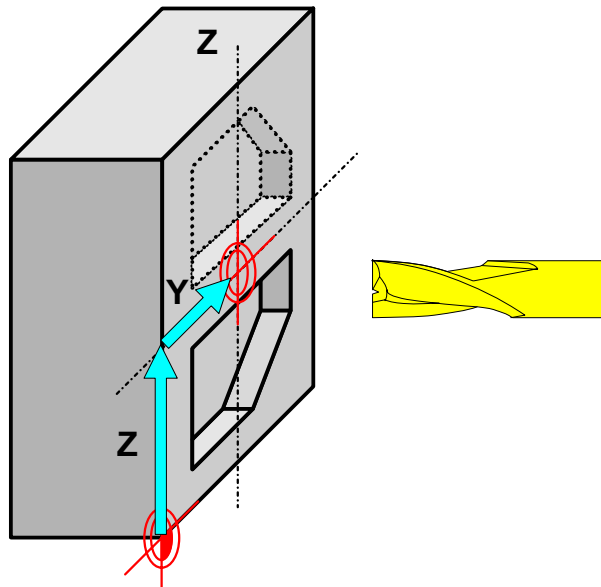
G51



N1234 G51 X... Y... J-1000



N1234 G51 X... Y... I-1000

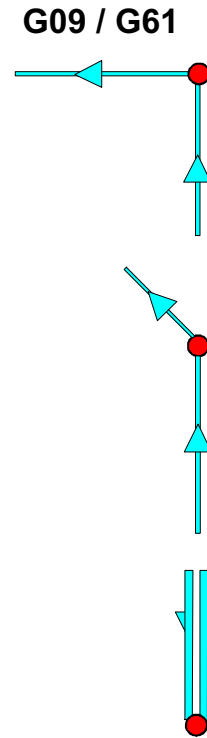
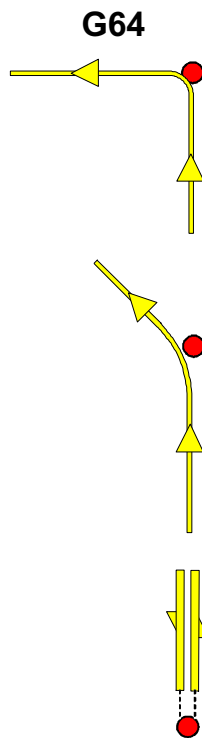
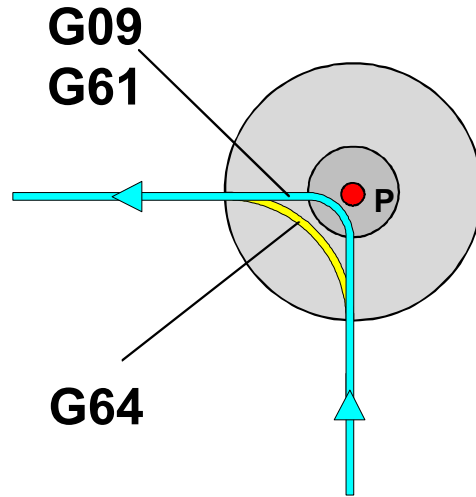


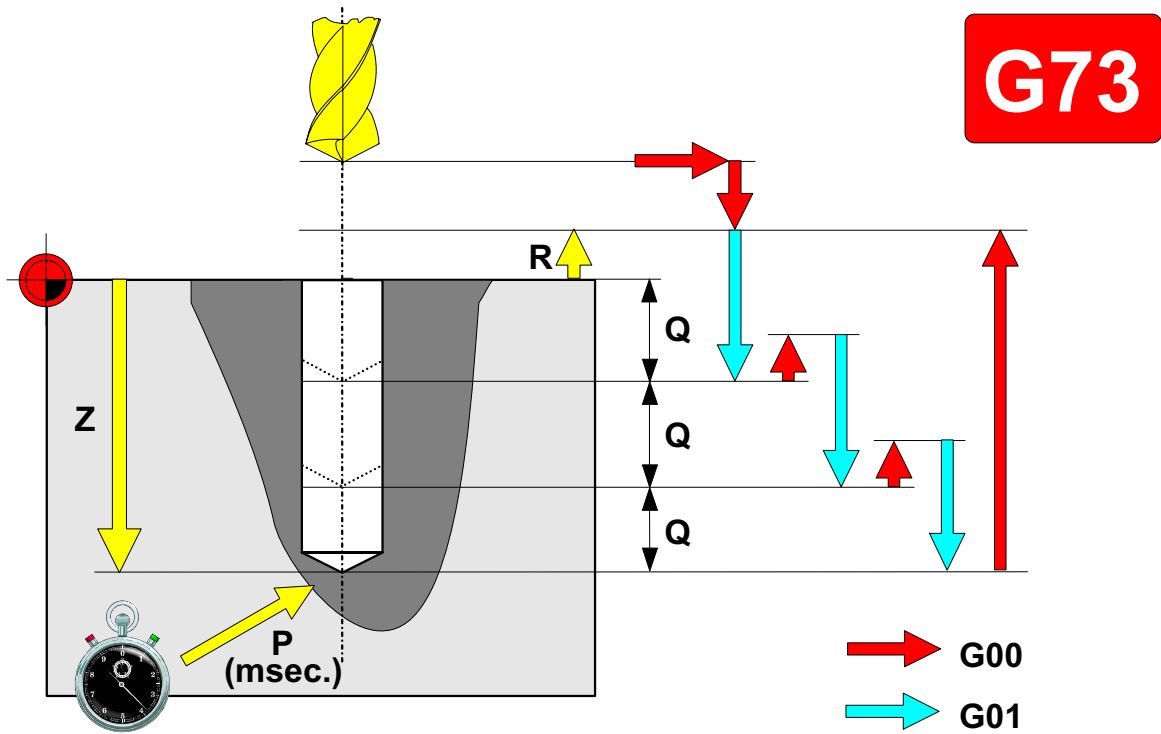
N1234 G51 Y... Z... K-1000

G09

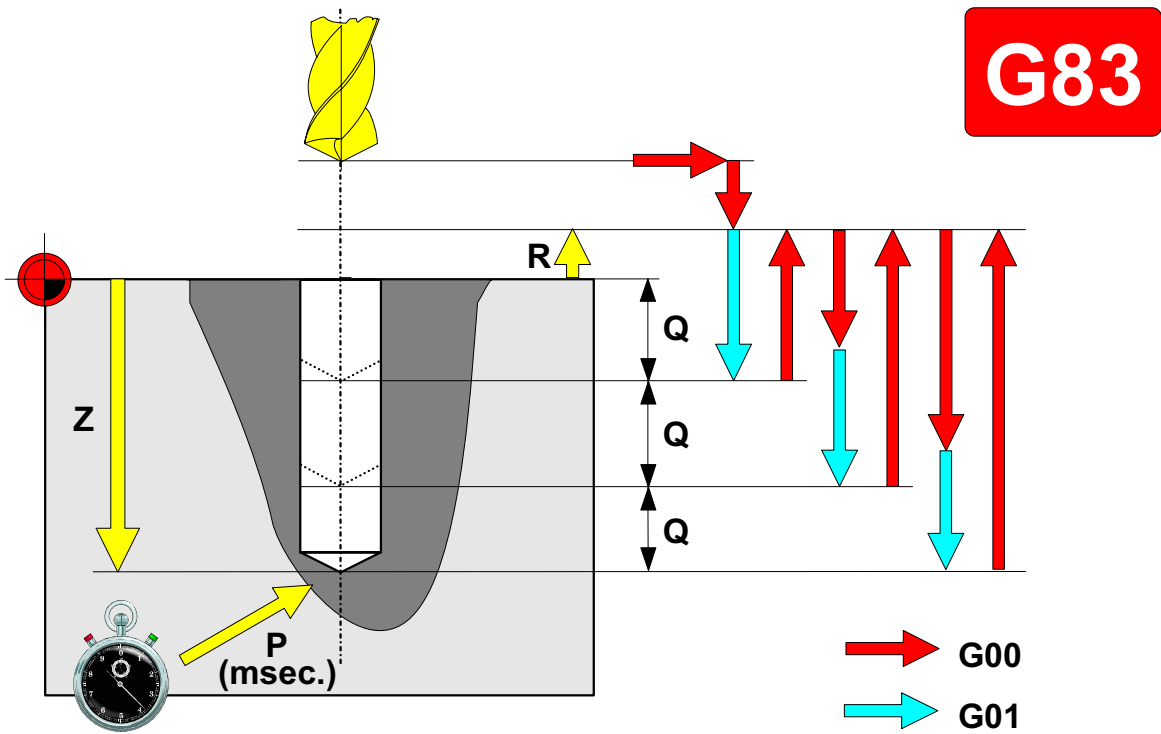
G61

G64





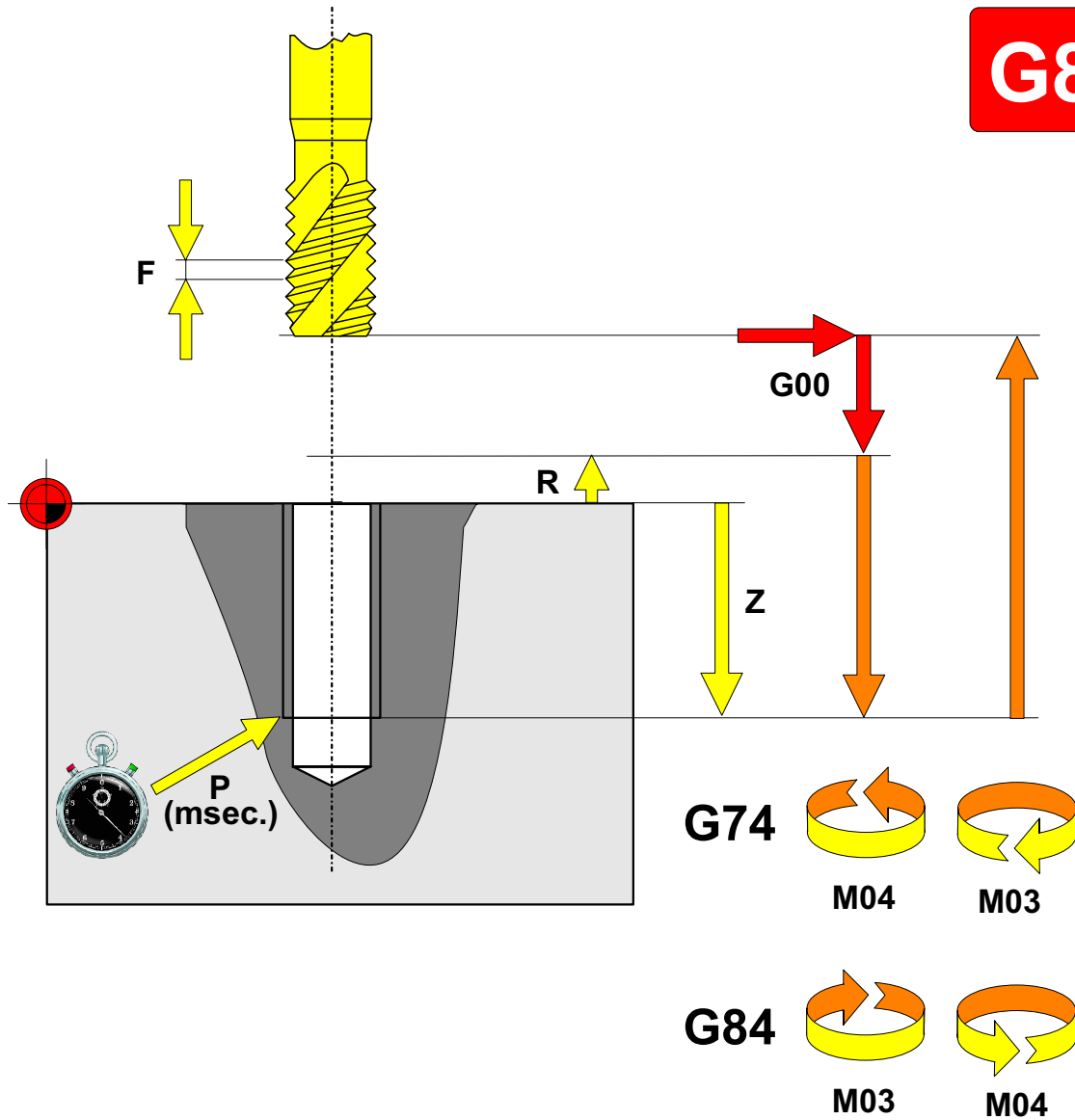
N1234 G73 X... Y... Z... R... P... Q... F...



N1234 G83 X... Y... Z... R... P... Q... F...

G74

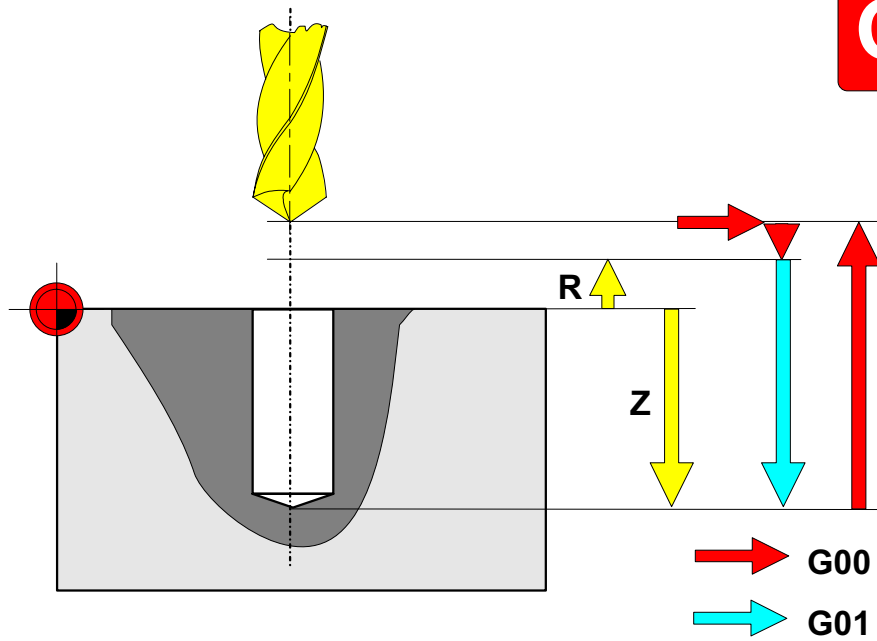
G84



N1234 G74 X... Y... Z... R... F... P ...

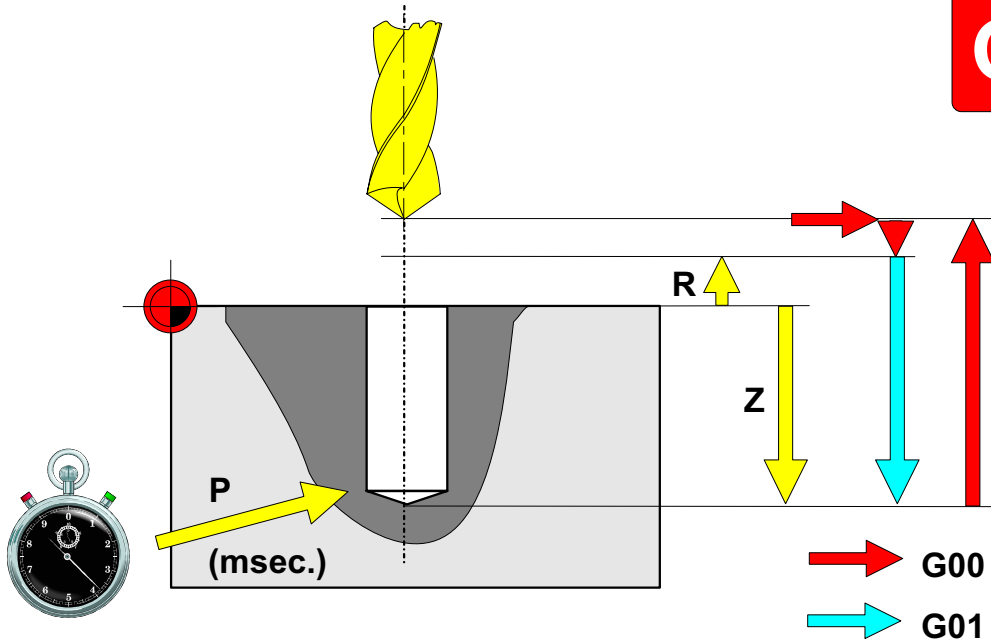
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G81



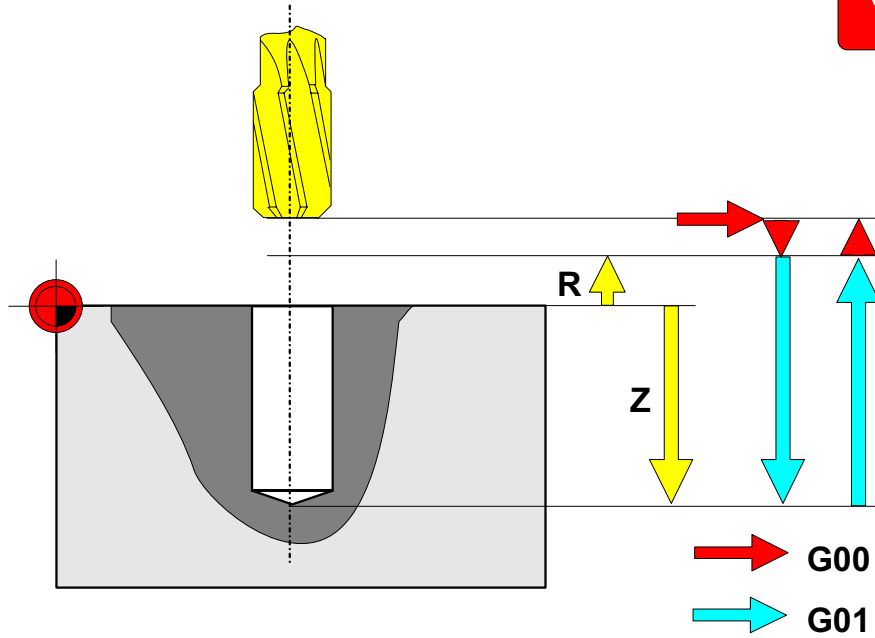
N1234 G81 X... Y... Z... R... F...

G82



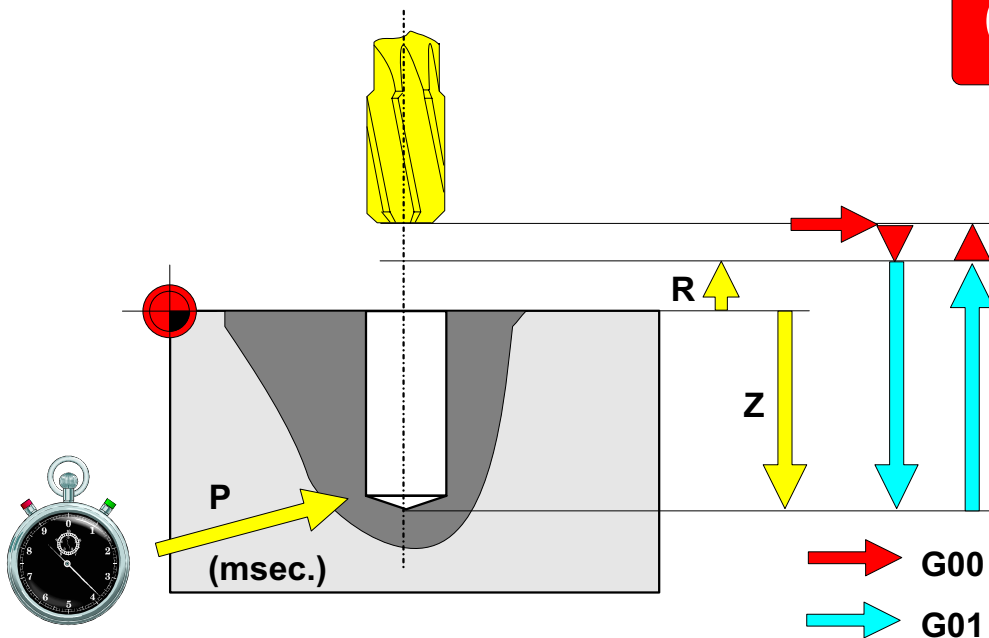
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G85



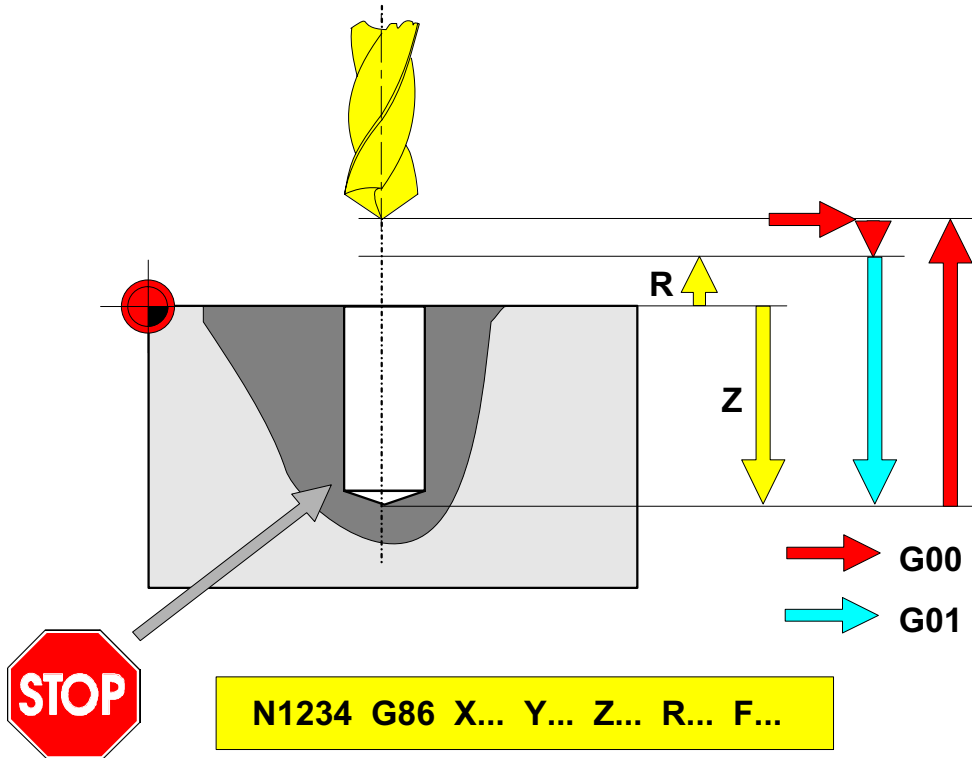
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N1234 G85 X... Y... Z... R... F...
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G89

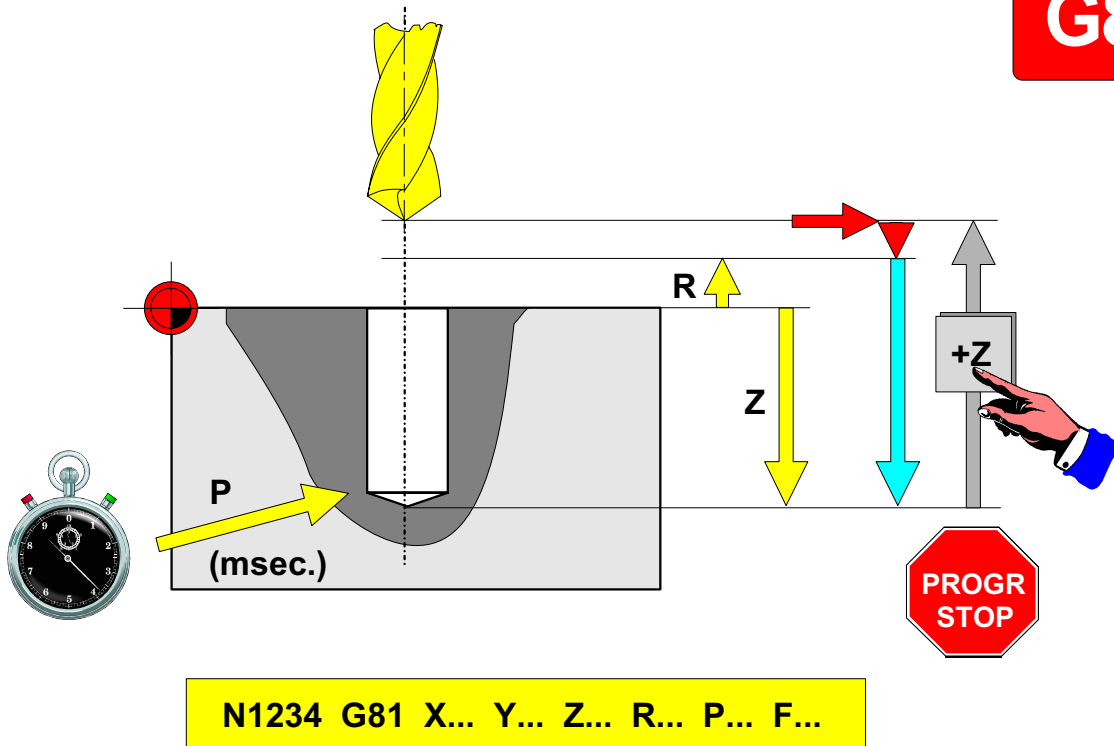


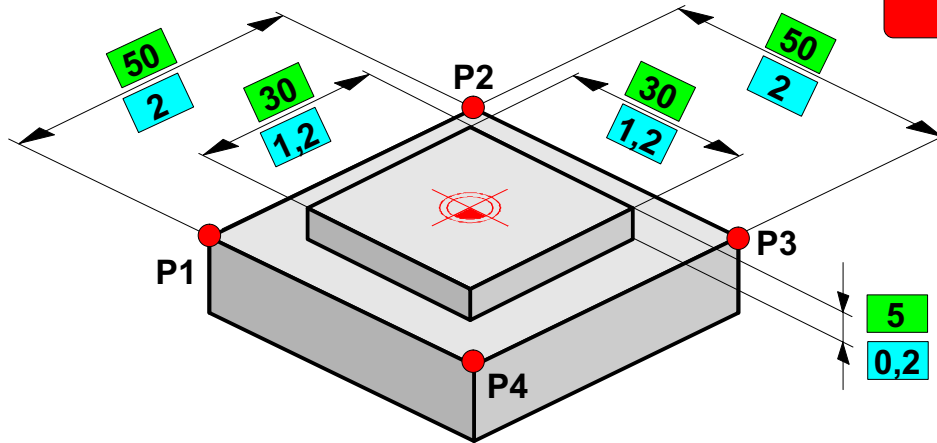
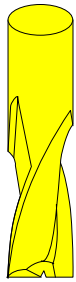
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N1234 G89 X... Y... Z... R... P... F...
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G86



G88





G90

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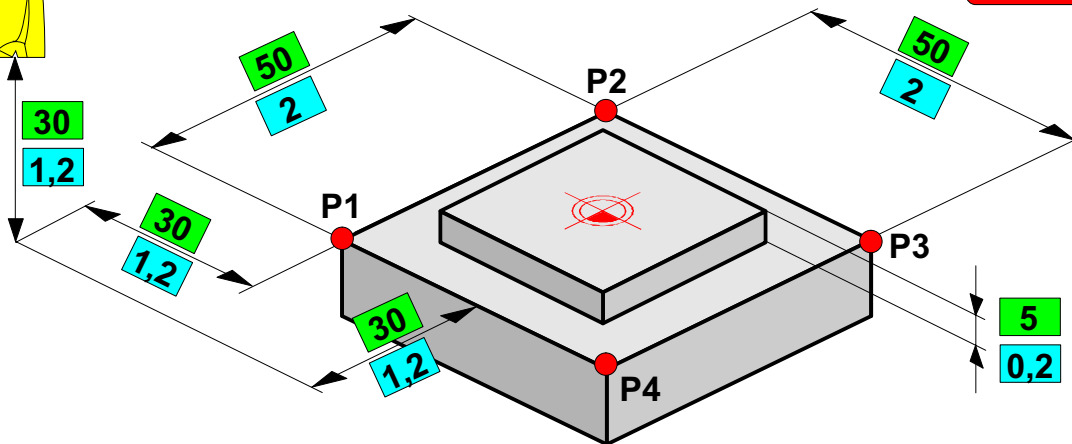
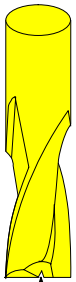
N0100 G01 X-25 Y-25 Z-5 LF
N0105 X-25 Y25 LF
N0110 X25 Y25 LF
N0115 X25 Y-25 LF
N0120 X-25 Y-25 LF
    
```

mm

```

N0100 G01 X-1 Y-1 Z-0.2 LF
N0105 X-1 Y1 LF
N0110 X1 Y1 LF
N0115 X1 Y-1 LF
N0120 X-1 Y-1 LF
    
```

Inch



G91

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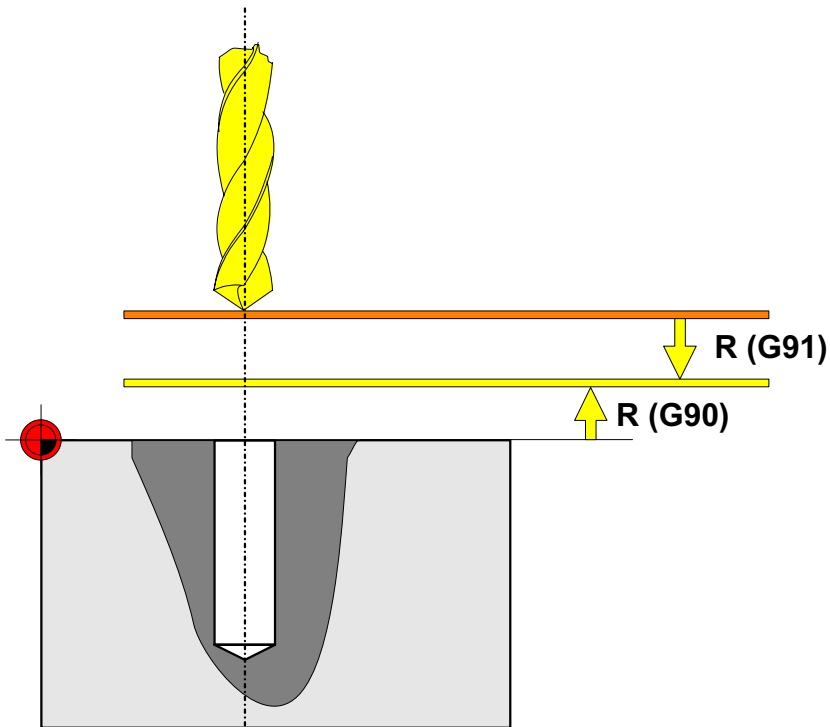
N0100 G01 X30 Y30 Z-30 LF
N0105 X0 Y50 LF
N0110 X50 Y0 LF
N0115 X0 Y-50 LF
N0120 X-50 Y0 LF
    
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mm

```

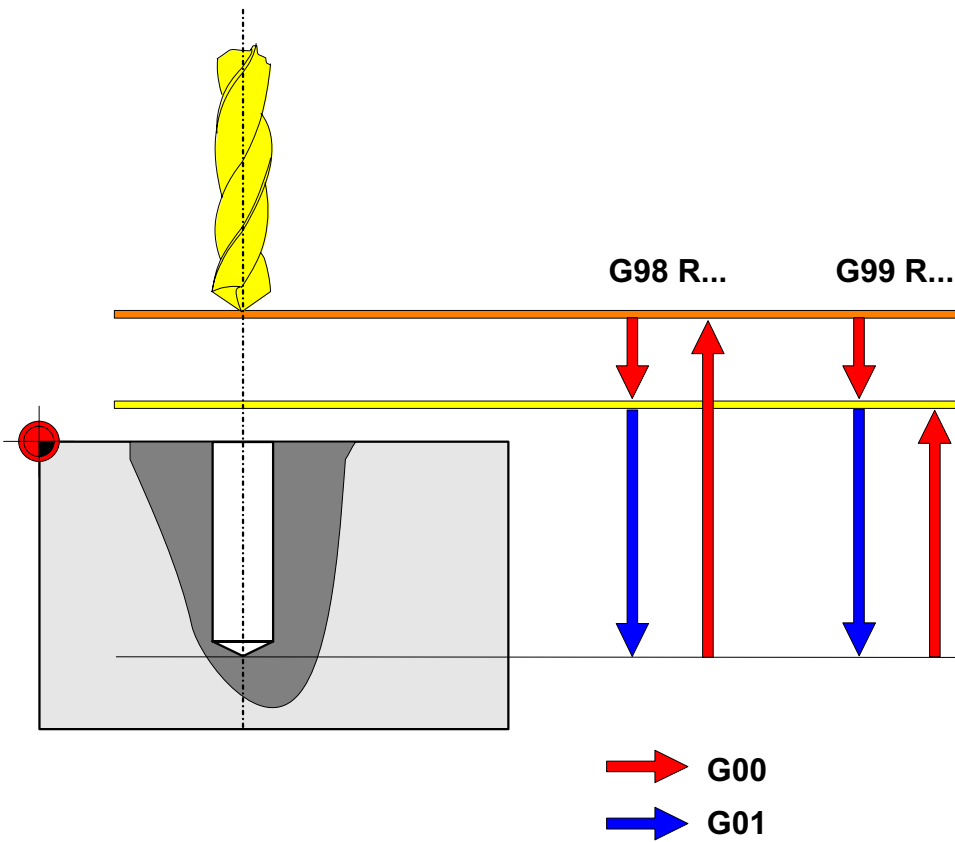
N0100 G01 X1.2 Y1.2 Z-1.2 LF
N0105 X0 Y2 LF
N0110 X2 Y0 LF
N0115 X0 Y-2 LF
N0120 X-2 Y0 LF
    
```

Inch



G98

G99



 **G00**

 **G01**

M98

M99

