



# HEIDENHAIN



## MANUALplus 620 User's Manual

NC Software  
548431-06

English (en)  
12/2018



## **Overview of keys**






## Controls and displays

### Keys





If you are using a control with touch operation, you can replace some keystrokes with hand gestures.

**Further information:** "Operating the Touchscreen", Page 83












#### Keys on visual display unit

Key	Function
	Switches the help graphics between outside and inside machining (only during cycle programming)
	No function
	Selects the function in the display unit with the soft key selection key
 	Shift between soft-key rows









#### Operating mode keys

Key	Function
	Select machine operating modes: <ul style="list-style-type: none"> <li>Machine</li> <li>Teach-in</li> <li>Program run</li> <li>Reference</li> </ul>
	Select programming operating modes: <ul style="list-style-type: none"> <li>smart.Turn                             <ul style="list-style-type: none"> <li>DINplus – Unit mode</li> <li>ISO Mode</li> </ul> </li> <li>Simulation</li> <li>AWG</li> </ul>
	Select tool data and technology data: <ul style="list-style-type: none"> <li>Tool editor</li> <li>Technology editor</li> </ul>
	Select Organization operating mode: <ul style="list-style-type: none"> <li>Machine parameters</li> <li>Transfer                             <ul style="list-style-type: none"> <li>Project management</li> <li>Network connection</li> </ul> </li> <li>Diagnostics</li> </ul>




### Numeric keypad

Key	Function
 	Number keys 0 to 9: <ul style="list-style-type: none"> <li>Enter numbers</li> <li>Operate the menu</li> </ul>
	Insert a decimal point
	Switch over between positive and negative values
	<ul style="list-style-type: none"> <li>Cancel the dialog</li> <li>Navigate to the top of the menu</li> </ul>
Escape	
	<ul style="list-style-type: none"> <li>Confirm a dialog</li> <li>Create a new NC block in the editor</li> </ul>
Insert	
	Delete the selected range
Delete Block	
	Erase the character to the left of the cursor
BACKSPACE	
	Clear error messages in the Machine operating modes
Clear Entry	
	Enable dialog input fields for further input
	Confirm the entry
Enter	





## Navigation keys

Key	Function
 	Move the cursor up or down
 	Move the cursor to the left or to the right
 	Scroll back or forward one screen or dialog page
Page Up and Page Down	
 	Go to beginning of program/list or end of program/list












## smart.Turn keys

Key	Function
	Go to the next form
 	Go to next or previous group

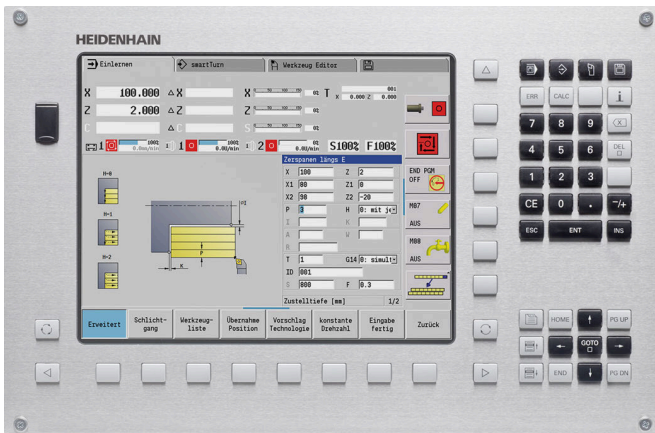
## Special keys

Key	Function
	Open the error window
Error	
	Start the integrated calculator
Calculator	
	<ul style="list-style-type: none"> <li>Show additional information in the parameter editor</li> <li>Call the TURNguide</li> </ul>
Information	
	<ul style="list-style-type: none"> <li>Select alternative input</li> <li>Activate the alphabetic keyboard</li> </ul>
Go to	
Print Screen	
DIADUR	

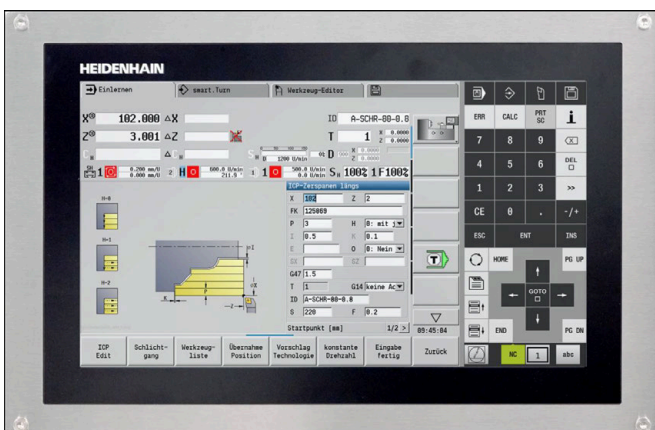
## Machine operating panel

Key	Function
 	Start or stop machining
	Feed stop
	Stop the spindle
 	Switch on the spindle
 	<b>Spindle jog</b> The spindle rotates as long as you press the key.
 	Move the axes, e.g. in +X or +Y direction
	Change the spindle (machine-dependent)

## Operating panel of the control



MC 7410T



MC 8420T

**Fundamentals**

## Notes in this documentation

### Safety precautions

Comply with all safety precautions indicated in this document and in your machine tool builder's documentation!

Precautionary statements warn of hazards in handling software and devices and provide information on their prevention. They are classified by hazard severity and divided into the following groups:

#### **DANGER**

**Danger** indicates hazards for persons. If you do not follow the avoidance instructions, the hazard **will result in death or severe injury**.

#### **WARNING**

**Warning** indicates hazards for persons. If you do not follow the avoidance instructions, the hazard **could result in death or serious injury**.

#### **CAUTION**

**Caution** indicates hazards for persons. If you do not follow the avoidance instructions, the hazard **could result in minor or moderate injury**.

#### **NOTICE**

**Notice** indicates danger to material or data. If you do not follow the avoidance instructions, the hazard **could result in things other than personal injury, such as property damage**.

### Sequence of information in precautionary statements

All precautionary statements comprise the following four sections:

- Signal word indicating the hazard severity
- Type and source of hazard
- Consequences of ignoring the hazard, e.g.: "There is danger of collision during subsequent machining operations"
- Escape – Hazard prevention measures



### Informational notes

Observe the informational notes provided in these instructions to ensure reliable and efficient operation of the software.

In these instructions, you will find the following informational notes:



The information symbol indicates a **tip**.  
A tip provides additional or supplementary information.



This symbol prompts you to follow the safety precautions of your machine tool builder. This symbol also indicates machine-dependent functions. Possible hazards for the operator and the machine are described in the machine manual.



The book symbol represents a **cross reference** to external documentation, e.g. the documentation of your machine tool builder or other supplier.

### Have you found any errors or would you like to suggest changes?

We are continuously striving to improve our documentation for you. Please help us by sending your suggestions to the following e-mail address:

**tnc-userdoc@heidenhain.de**

## Software and features

This manual describes functions that are available in the control with NC software number 548431-06.

smart.Turn and DIN-PLUS programming are not included in this manual. These functions are described in the User's Manual for smart.Turn and DIN PLUS Programming (ID 685556-xx). Please contact HEIDENHAIN if you require a copy of this manual.

The machine manufacturer adapts the usable features of the control to his machine by setting the machine parameters. Some of the functions described in this manual may not be among the features possible on your machine tool.

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

- Positioning of spindle (**M19**) and driven tool
- Machining with the C or Y axis
- Machining with the B axis

In order to find out about the specific support for your machine, please contact the machine manufacturer.

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

HEIDENHAIN also offers the DataPilot MP 620 or DataPilot CP 640 software for PCs, both of which are designed for use with the respective control. The DataPilot is suitable for both shop-floor programming as well as off-location program creation and testing. It is also ideal for training purposes. The DataPilot can be run on PCs with WINDOWS operating systems. HEIDENHAIN provides the DataPilot as a Windows programming station and as a software package running in an Oracle VM Virtual Box. Oracle VM VirtualBox is a software application (virtual machine), in which the control runs as a separate system, i.e. in a virtual environment.

### Intended place of operation

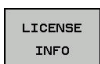
The control complies with the limits for a Class A device in accordance with the specifications in EN 55022, and is intended for use primarily in industrially-zoned areas.

### Legal information

This product uses open-source software. Further information is available on the control under:



- ▶ **Organization** operating mode



- ▶ **LICENSE INFO** soft key

## New functions of software 54843x-05

- The control displays error messages of different classes in various colors, see "Display of errors", Page 68
- If the programmed spindle speed is displayed in red in the machine data display, a limitation is active and the programmed nominal value will not be reached, see "Machine data display", Page 102
- Additional functions were added to the machine data display, e.g. a handwheel symbol and the C axis datum shift, see "Machine data display", Page 102
- To restart the control only, the **RESTART** soft key was added, see "Switch-off", Page 95
- In **Teach-in** submode, the input range for the **Angle in the B axis BW** cycle parameter in the T,S,F dialog was extended to 4 decimal places.
- In **Teach-in** submode and in DIN Programming, the input range for **Thread pitch** was extended to 4 decimal places.
- In **Simulation** submode, the **Mark the machining area** miscellaneous function was added, see "Mark the machining area", Page 560
- In **Simulation** submode, the **C0 - Marking on workpiece/3D** miscellaneous function was added, see "C0 – Marking on workpiece/3D", Page 561
- In **Simulation** submode, a new status display was added, see "Status display", Page 545
- In 3-D simulation, tool holder display is now supported, see "3-D simulation in Simulation submode", Page 562
- In **Program run** submode, it is possible to display the variables defined in the **PROGRAM HEAD** program section, see "Program execution", Page 153
- In **Tool editor** operating mode, you can edit the diagnostic bits displayed in the open tool dialog, see "Diagnostic bits", Page 579
- In **Tool editor** operating mode, the **Max. shaft speed NMX** tool parameter was added, see "General tool parameters", Page 585

- In **Tool editor** operating mode, the **Tool radius 2 R2** and **Tool radius 2 oversize DR2** tool parameters were added for standard milling cutters, see "Standard milling tools", Page 598
- In **Tool editor** operating mode, the **CA1** and **CA2** tool parameters (calibration values) were added for 3-D touch probes, see "Length Gauges", Page 603
- In **Tool editor** operating mode, the **Depth of holder WHT** and **Offset for depth TOF** parameters were added to the tool holder dialogs, see "Holder editor", Page 580
- The **Delete all** soft key was added to the **Table of the tool holder**, see "Holder editor", Page 580
- The **Save** and **Cancel** soft keys were added to the **Tool text list**, see "Tool texts", Page 574
- The columns **LA**, **XL** and **ZL** are displayed in the **Turret assignment** and **Magazine list**.
- The arrow keys enable you to move to the next or previous column within the **Turret assignment** and **Magazine list**.
- In order to allow you to transfer screenshots (created with the **PRT SC** key) in **Transfer** operating mode, the **Select TNC:** soft key was added to the **Service** area, see "Transferring programs (files)", Page 659
- To check the usable length of the cutting edge for finishing operations, the **checkCuttingLength** (602322) machine parameter was added, see "List of machine parameters", Page 616
- In order to suppress the **Residual material due to cutting edge geometry!** warning, we added the **suppressRestMatWar** (201010) machine parameter, see "List of machine parameters", Page 616
- To automatically load the program last used in **Program run** submode, the **autoPgmSelect** (601814) machine parameter was added, see "List of machine parameters", Page 616, see "Loading a program", Page 148
- The **DefaultG14** machine parameter was extended to include additional traverse options to the **G14** tool change position, see "List of machine parameters", Page 616
- With the G function for engraving, you can engrave the date and time using variables, see the smart.Turn and DIN Programming User's Manual
- Contents of variables can be converted to string variables, see the smart.Turn and DIN Programming User's Manual
- Touchscreen operation is supported, see "Operating the Touchscreen", Page 83
- Operation of the new HR 520 and HR 550FS electronic handwheels is supported, see "Configuring the HR 550 FS wireless handwheel", Page 134
- The machine tool builder can extend the machine data display to 5 lines on 19" screens, see "Machine data display", Page 102
- On 19" screens, the **Transfer machine** soft key is located in the first soft-key row, see the smart.Turn and DIN Programming User's Manual

- The machine tool builder can make custom G functions available to the user in the G menu, see the smart.Turn and DIN Programming User's Manual
- The machine tool builder can provide machine-specific start units, see the smart.Turn and DIN Programming User's Manual
- The machine tool builder can make custom units available to the user, see the smart.Turn and DIN Programming User's Manual
- The machine tool builder can make program templates available to the user, see the smart.Turn and DIN Programming User's Manual
- In the **PROGRAM HEAD** program section, you can specify up to 20 global variables, see the smart.Turn and DIN Programming User's Manual
- The **Delete history** soft key was added to the **PROGRAM HEAD** dialog, see the smart.Turn and DIN Programming User's Manual
- New **Bore milling G75** G function, see the smart.Turn and DIN Programming User's Manual
- New **Compens. for helical teeth G728** G function, see the smart.Turn and DIN Programming User's Manual
- New **Information to DNC G941** G function, see the smart.Turn and DIN Programming User's Manual
- New **LIFTOFF G977** G function, see the smart.Turn and DIN Programming User's Manual
- The **G14** G function was extended to include additional traverse options to the tool change position, see the smart.Turn and DIN Programming User's Manual
- The **Slide mov.diff. B** parameter was added to the **G810** and **G820** G functions, see the smart.Turn and DIN Programming User's Manual
- The **Workpc. blank contour RH** parameter was added to the **G810**, **G820**, **G830** and **G835** G functions and units, see the smart.Turn and DIN Programming User's Manual
- The **Mirror writing O** parameter was added to the **G801**, **G802**, **G803**, and **G804** G functions and units , see the smart.Turn and DIN Programming User's Manual

#### Functions changed in software 54843x-05

- **Start blk search** is not available for **Reference machining** operations required during **load monitoring** (option 151), see "Block scan", Page 151
- The input range of the **DX**, **DY**, **DZ**, and **DS** tool parameters was extended to 4 decimal places (**mm**) and 5 decimal places (**inch**), see "General tool parameters", Page 585
- The Pocket type (**PTYP/T** column) and the PLC settings (**PTYP/M** column) are displayed in the magazine list.
- The input range of the Overlap factor **U** cycle parameter was extended to 0.99 for milling cycles.
- In order to avoid unwanted loss of data, the default setting for **Parameter restore** was set to **Pocket table No.**

## New functions of software 54843x-06

- In the **Tastsysteme einrichten** menu, you can configure touch probes, see "Setting up touch probes", Page 127
- With the **TCH PROBE MONITOR OFF** soft key, you can suppress touch-probe monitoring for 30 seconds after a **Touch probe not ready** message has been displayed, see "Suppressing touch probe monitoring ", Page 131
- User administration enables you to assign different access rights to the users, see "User administration", Page 720
- With the **State Reporting Interface (SRI)**, HEIDENHAIN offers a simple and reliable interface for acquiring the operating states of your machine, see "State Reporting Interface (option 137)", Page 696
- The **G847** function can be used to rough-out a contour by trochoidal milling, see the smart.Turn and DIN Programming User's Manual
- The **G848** function can be used to rough-out a figure by trochoidal milling, see the smart.Turn and DIN Programming User's Manual
- the Generate Structure program and Generate contour groups machining parameters can be selected directly in the TURN PLUS function, see the smart.Turn and DIN Programming User's Manual
- New **MANUAL TOOL** program section identifier for AWG with manually changed tools, see the smart.Turn and DIN Programming User's Manual
- **Manual tool selection** was added to the **Machining sequence**, see the smart.Turn and DIN Programming User's Manual
- The NC program can read and also write PLC variables. Access to text operands is also possible, see the smart.Turn and DIN Programming User's Manual

**Functions changed in software 54843x-06**

- Machining operations with **G16** in a tilted working plane no longer require the **B-Axis Machining** option (option 54).
- The **O** parameter was added to the TURN PLUS attributes, see "TURN PLUS attributes", Page 484
- If you perform a block scan in a program section with active spindle coupling, the control will issue an error message, see "Block scan", Page 151
- The **G928 TCPM** function is now available in the G menu as well, see the smart.Turn and DIN Programming User's Manual
- Deburring of holes is now also possible from the rear using the **TO = 8** tool orientation, see the smart.Turn and DIN Programming User's Manual
- In the **WINDOW** file output, you can now preset a variable string for the log file name, see the smart.Turn and DIN Programming User's Manual
- The **#i** variables were extended, see the smart.Turn and DIN Programming User's Manual
- The **O** parameter was added to the **G308** function, see the smart.Turn and DIN Programming User's Manual
- The **W** parameter was added to the **G977** function, see the smart.Turn and DIN Programming User's Manual





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# 1

**Introduction and  
fundamentals**

## 1.1 Fundamentals on the MANUALplus 620 control

The control was conceived for CNC lathes. It is suitable for horizontal and vertical lathes. The control supports machines with a tool magazine or tool turret. The tool carrier of horizontal lathes can be located in front of or behind the workpiece.

The control supports lathes with spindle, one slide (X and Z axis), C axis or positionable spindle, driven tool, and machines with a Y axis.



### The MANUALplus for cycle lathes

On the MANUALplus 620, rework or simple tasks can be done in the same way as on a conventional lathe. You move the axes in the normal manner by turning the handwheels. The cycles of the MANUALplus 620 are available for difficult cuts like tapers, undercuts or threads. For small and medium-size production runs, cycle programming will increase your revenue. When machining the first workpiece, you can store the machining cycles, and already save valuable time when machining the second workpiece. For increased requirements and complex machining tasks, you will benefit from the **smart.Turn** programming mode.

### MANUALplus for CNC lathes

With the MANUALplus 620, you can position up to four axes, the traverse paths will be interpolated.

Regardless of whether you are turning simple parts or complex workpieces, the MANUALplus 620 provides you with the benefits of graphical contour input and convenient programming with the **smart.Turn** operating mode. Programming with variables, controlling special machine components, or using externally created programs is no problem: Simply switch to DINplus. This programming mode helps you solve all your special tasks. The MANUALplus 620 supports operations with the C axis in cycle, smart.Turn and DIN programming. In the Y axis, the MANUALplus 620 supports operations with smart.Turn and DIN programming.

## 1.2 Configuration

In the standard version, the control is equipped with the axes X and Z and a main spindle. Optionally, a C axis, a Y axis, and a driven tool can be configured.

### Slide position

The machine tool builder configures the control depending on the slide position.

- Z axis **horizontal** with tool slide behind the workpiece
- **Z axis** horizontal with tool slide in front of the workpiece
- **Z axis** vertical with tool slide to the right of the workpiece

The menu symbols, help graphics and graphic representations during ICP and simulation consider the slide position.

The representations in this User's Manual assume a lathe with a tool carrier centered behind the workpiece.

### Tool carrier systems

The control supports the following systems as tool carriers:

- Multifix holder with **one** tool mount
- Turret with **n** tool mounts
- Turret with **n** tool mounts and **one** multifix holder with one tool mount. Here it is possible for one of the two tool carriers to be arranged mirrored on the workpiece side opposite from the standard tool carrier
- Two multifix holders, each with **one** tool mount. The tool carriers are arranged opposite to each other. One of them is then mirrored.
- Magazine with **n** tool mounts and one tool carrier in the working space with one tool mount

## C axis

With a C axis you can drill and mill a workpiece on its face and lateral surfaces.

When the C axis is used, one axis interpolates linearly or circularly with the spindle in the given working plane, while the third axis interpolates linearly.

The control supports part program creation with the C axis in:

- **Teach-in** submode
- **smart.Turn** mode of operation
- DINplus programming



## Y axis

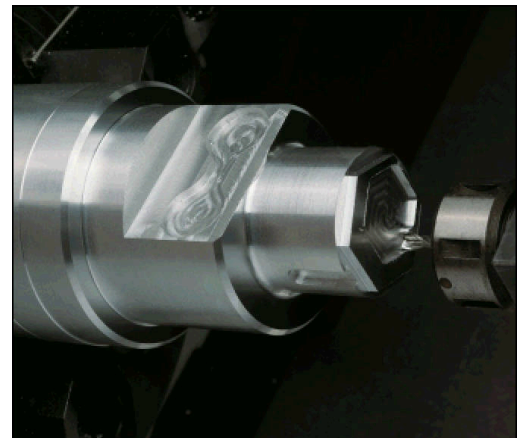
With a Y axis you can drill and mill a workpiece on its face and lateral surfaces.

During use of the Y axis, two axes interpolate linearly or circularly in the given working plane, while the third axis interpolates linearly.

This enables you to machine slots or pockets, for example, with plane floors and perpendicular edges. By defining the spindle angle, you can determine the position of the milling contour on the workpiece.

The control supports part program creation with the Y axis in:

- **Teach-in** submode
- **smart.Turn** mode of operation
- DINplus programming





## Full-surface machining

Functions that ensure perfectly timed machining and easy programming for multi-operation machining include the following:

- Angle-synchronous part transfer with spindle in rotation
- Traversing to a fixed stop
- Controlled parting
- Coordinate transformations

The control supports full-surface machining for all common machine designs with:

- Rotating gripping device
- Movable counter spindle
- Several spindles and tool carriers



## 1.3 Features

### Configuration

- Basic version: X and Z axis, spindle
- Positionable spindle and driven tool
- C axis and driven tool
- Y axis and driven tool
- B axis for machining in a tilted plane
- Digital current and speed control

### Modes of operation

#### Machine operating modeMachine

Manual slide movement through axis-direction keys or electronic handwheels.

Graphic support for entering and running Teach-in cycles without saving the machining steps in alternation with manual machine operation.

Thread reworking (thread repair in a second workpiece setup).

#### Teach-in submodeTeach-in

Sequential linking of Teach-in cycles, where each cycle is run immediately after input, or is graphically simulated and subsequently saved.

#### Program run submodeProgram run

All are possible in single-block and full-sequence modes:

- DINplus programs
- smart.Turn programs
- Teach-in programs

#### Setup functions in Machine mode of operationMachine

- Setting the workpiece datum
- Defining the tool change point
- Defining the protection zone
- Tool measurement through touch-off, touch probe or optical gauge

**Programming**

- Teach-in programming
- Interactive contour programming (**ICP**)
- smart.Turn programming
- Automatic program creation with **TURN PLUS**
- DINplus programming

**Simulation**

- Graphic representation of the sequence of smart.Turn or DINplus programs and graphic representation of a Teach-in cycle or Teach-in program
- Simulation of the tool paths as wire-frame or cutting-path graphics, special identification of the rapid-traverse paths
- Motion simulation (2-D material-removal graphic)
- Side or face view, or 2-D view of cylindrical surface
- Display of programmed contours
- Shifting and magnifying functions

## Tool system

- Database for 250 tools, optionally 999 tools
- Description can be entered for every tool
- Optional support of multipoint tools (tools with multiple reference points or multiple cutting edges)
- Turret or multifix system
- Optional tool magazine

## Technology database

- Cutting data is entered in the cycle or in the UNIT as default values
- 9 workpiece-material/tool-material combinations (144 entries)
- Optionally 62 workpiece-material/tool-material combinations (992 entries)

## Interpolation

- Straight line: in 2 principal axes (max.  $\pm 100$  m)
- Circular: in 2 axes (radius max. 999 m)
- C axis: Interpolation in the linear axes X and Z with the C axis
- Y axis: Linear or circular interpolation of two axes in the given plane. The respective third axis can simultaneously perform linear interpolation.
  - **G17**: XY plane
  - **G18**: XZ plane
  - **G19**: YZ plane
- B axis: Drilling, boring and milling operations in oblique planes

## 1.4 Data backup

HEIDENHAIN recommends saving new programs and files created on a PC at regular intervals.

HEIDENHAIN provides a backup function for this purpose in the data transfer software TNCremo. Your machine tool builder can provide you with a copy. You additionally need a data medium on which all machine-specific data, such as the PLC program, machine parameters, etc., are stored.

Please contact your machine tool builder for this.

## 1.5 Explanation of terms

- **Cursor:** **Marks** the current position in a list or input field  
Input and operations, such as copying, deleting, inserting, etc., refer to the current cursor position.
- **Cursor keys:** Keys for moving the cursor
  - **Arrow keys**
  - **PG UP** and **PG DN** keys
- **Active window, functions, or menu items:** Item on the screen shown in color.  
In the inactive windows, the title bar appears **dimmed**. Inactive function keys or menu items also appear **dimmed**
- **Menu:** Functions or function groups are displayed as a 9-field box
- **Menu item:** Individual symbols of a menu
- **Default value:** Preset value of a cycle parameter or DIN command parameter
- **File name extension:** String following the file name  
Example:
  - **\*.nc**—DIN programs
  - **\*.ncs**—DIN subprograms (DIN macros)
- **Soft key:** Functions available at the side and bottom of the screen pages
- **Soft key selection keys:** Keys that you can press to select a soft key function.
- **Form:** Individual pages of a dialog
- **UNITS:** Grouped dialogs for a function in **smart.Turn** mode of operation

## 1.6 Control design

The dialog between machinist and control takes place via:

- Screen
- Soft keys
- Keyboard
- Machine operating panel

The entered data can be displayed and checked on the screen.

With the soft keys directly below the screen, you can select functions, capture position values, confirm entries, and a lot more.

With the **ERR** key you can call error and PLC information.

The data input keyboard (on the operating panel) is used to enter machine data, position data, etc. For the MANUALplus 620, an alphanumeric keyboard is not necessary. When you enter tool descriptions, program descriptions or comments in an NC program, an alphabetic keyboard is displayed on the screen. The machine operating panel contains all necessary controls for manual operation of the lathe.

Cycle programs, ICP contours and NC programs are stored in the internal memory of the control.

For data exchange and data backup, you can use the **Ethernet interface** or the **USB interface**.



If you are using a control with touch operation, you can replace some keystrokes with hand gestures.

**Further information:** "Operating the Touchscreen",  
Page 83

## 1.7 Fundamentals

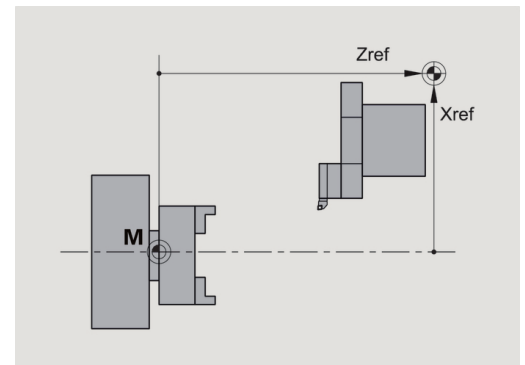
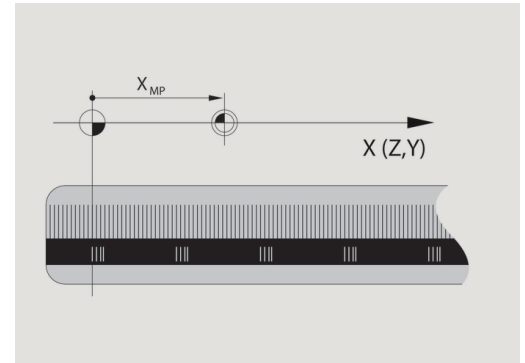
### Position encoders and reference marks

The machine axes are equipped with position encoders that register the positions of the slide or tool. When a machine axis moves, the corresponding position encoder generates an electrical signal. The control evaluates this signal and calculates the precise actual position of the machine axis.

If there is a power interruption, the calculated position will no longer correspond to the actual position of the machine slide. To recover this assignment, incremental position encoders are provided with reference marks. The scales of the position encoders contain one or more reference marks that transmit a signal to the control when they are crossed over. This enables the control to re-establish the assignment of the displayed position to the current machine position. For linear encoders with distance-coded reference marks, you only need to move each axis a maximum of 20 mm (0.8 in.), and a maximum of 20° for angle encoders.

If incremental position encoders are without reference marks, fixed reference positions have to be traversed after switch-on. The control knows the exact distance between these reference positions and the machine datum (see figure).

With absolute encoders, an absolute position value is transmitted to the control immediately upon switch-on. In this way the assignment of the actual position to the machine slide position is re-established directly after switch-on.



### Axis designations

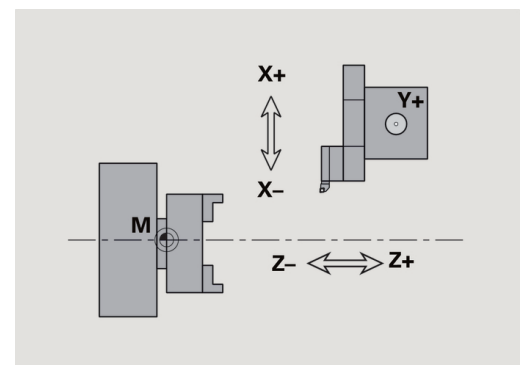
The cross slide is referred to as the **X axis** and the saddle as the **Z axis**.

All X-axis values that are displayed or entered are regarded as **diameters**.

Lathes with **Y axis**: The Y axis is perpendicular to the X axis and Z axis (Cartesian system).

When programming paths of traverse, remember to:

- Program a **positive value** to depart the workpiece
- Program a **negative value** to approach the workpiece





## Coordinate system

The meanings of the coordinates X, Y, Z, and C are specified in DIN 66 217.

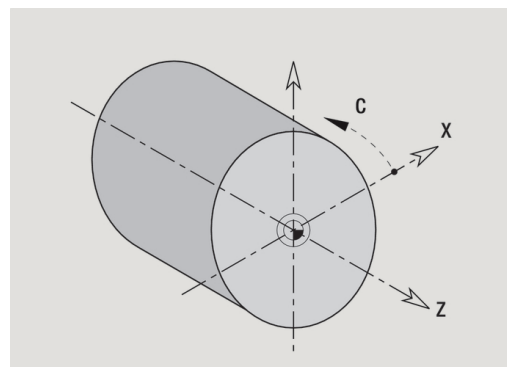
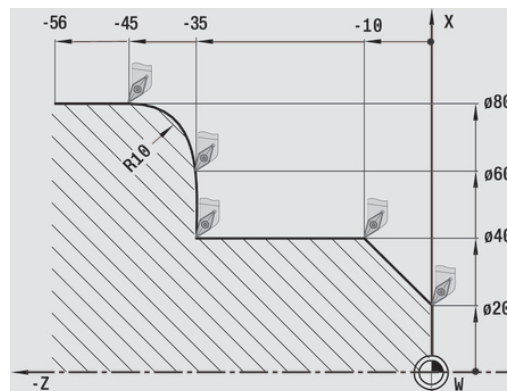
The coordinates entered for the principal axes X, Y and Z are referenced to the workpiece datum. The angles entered for the rotary axis (C axis) are referenced to the datum of the C axis.

The axis designations X and Z describe positions in a two-dimensional coordinate system. As you can see from the figure to the center right, the position of the tool tip is clearly defined by its X and Z coordinates.

The control can connect points by linear and circular traverses (interpolations). Workpiece machining can be programmed by entering the coordinates for a succession of points and connecting the points by linear or circular traverses.

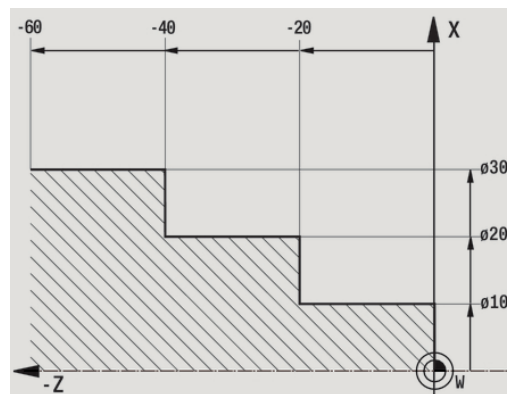
Like the paths of traverse, you can also describe the complete contour of a workpiece by defining single points through their coordinates and connecting them by linear or circular paths of traverse.

Positions can be programmed to an accuracy of 1  $\mu\text{m}$  (0.001 mm). This is also the accuracy with which they are displayed.



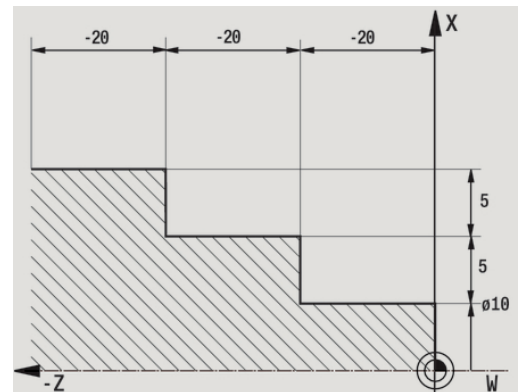
## Absolute coordinates

If the coordinates of a position are referenced to the workpiece datum, they are referred to as absolute coordinates. Each position on a workpiece is clearly defined by its absolute coordinates.



## Incremental coordinates

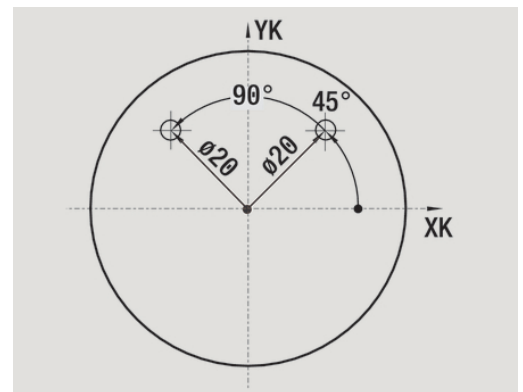
Incremental coordinates are always given with respect to the last programmed position. They specify the distance from the last active position to the subsequent position. Each position on a workpiece is clearly defined by its incremental coordinates.



## Polar coordinates

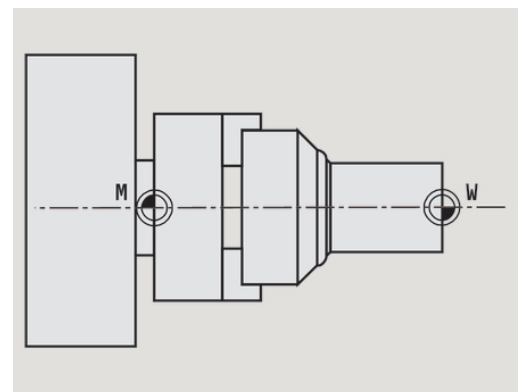
Positions located on the face or lateral surface can either be entered in Cartesian coordinates or polar coordinates.

When programming with polar coordinates, a position on the workpiece is clearly defined by the entries for diameter and angle.



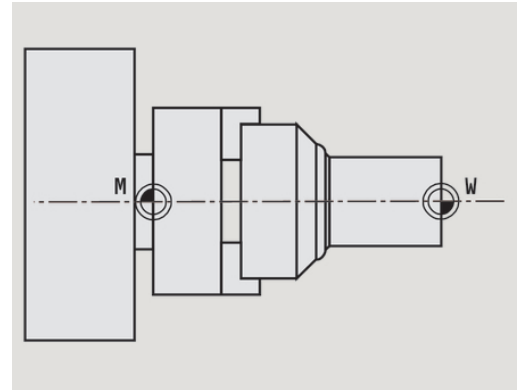
## Machine datum

The point of intersection of the X and Z axes is called the **machine datum**. On a lathe, the machine datum is usually the point of intersection of the spindle axis and the spindle surface. The machine datum is designated with the letter **M**.



## Workpiece datum

To machine a workpiece, it is easier to enter all input data with respect to a zero point located on the workpiece. By programming the zero point used in the workpiece drawing, you can take the dimensions directly from the drawing, without further calculation (dimensioning origin). This point is the workpiece datum. The workpiece datum is designated with the letter **W**.



## Units of measure

You can program the control either in the **metric** or **inch** system. The units of measurement listed in the table below apply to all inputs and displays.

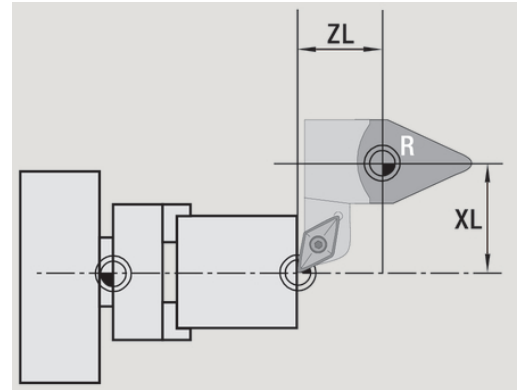
Dimensions	Metric	Inches
Coordinates	mm	inch
Lengths	mm	inch
Angle	Degrees	Degrees
Spindle speed	rpm	rpm
Cutting speed	m/min	ft/min
Feed per revolution	mm/rev	inch/rev
Feed per minute	mm/min	inch/min
Acceleration	m/s <sup>2</sup>	ft/s <sup>2</sup>

## 1.8 Tool dimensions

The control requires information on the specific tools for a variety of tasks, such as positioning the axes, calculating the cutting radius compensation or the proportioning of cuts.

### Tool length

All programmed and displayed position values are given with respect to the distance between the tool tip and workpiece datum. Since the control only knows the absolute position of the tool carrier (slide), it needs the dimensions **XL** and **ZL** to calculate and display the position of the tool tip.



### Tool compensation

The tool tip is subjected to wear during machining processes. To compensate for this wear, the control uses compensation values. The compensation values are managed independent of the values for length. The system automatically adds the compensation values to the values for length.

## Tool-tip radius compensation (TRC)

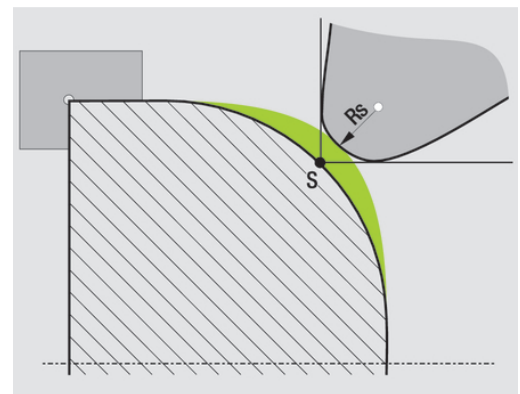
The tip of a lathe tool has a certain radius. When machining tapers, chamfers and radii, this results in inaccuracies which the control compensates with its cutting radius compensation function.

Programmed paths of traverse are referenced to the theoretical tool tip **S**. With non-paraxial contours, this will lead to inaccuracies during machining.

The TRC function compensates for this error by calculating a new path of traverse, the **equidistant line**.

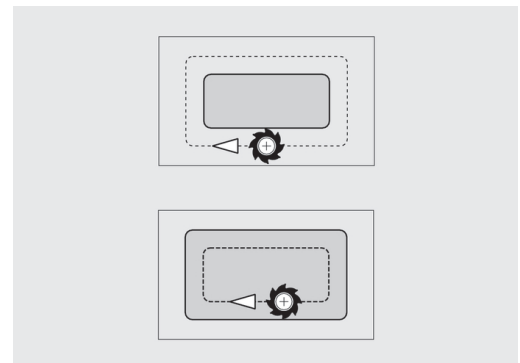
The control calculates the TRC for cycle programming. The smart.Turn and DIN programming feature also takes the TRC into account in clearance cycles. During DIN programming with single paths, you can also enable/disable TRC.

The control displays a warning if residual material is left behind due to the angle of the cutting edges or the tool angle. You can suppress the warning with machine parameter **suppressResMatWar** (no. 201000).



## Milling cutter radius compensation (MCRC)

In milling operations, the outside diameter of the milling cutter determines the contour. When the MCRC function is not active, the center of the cutter is used as the point of reference. The MCRC function compensates for this error by calculating a new path of traverse, the **equidistant line**.





# 2

**Basics of operation**

## 2.1 General information on operation

### Operation

- Select the desired operating mode with the corresponding operating mode key
- Within the operating mode, you can change the mode through the soft keys
- With the numeric keypad you can select the function within the menus
- Dialogs can consist of multiple pages
- Besides with the soft keys, dialogs can be concluded positively with **INS** or negatively with **ESC**
- Changes made in lists are effective immediately  
They are also kept if the list is closed with **ESC** or **Cancel**

### Setup

- You will find all setup functions in the **Machine** operating mode in **Manual mode**
- All preparatory work can be performed through the **Setup** and **Set T, S, F** menu items



**Program name**

The **program name** starts with a digit or a letter, followed by up to 40 characters and the **.nc** extension for main programs and the **.ncs** extension for subprograms.











For program names, you can use any ASCII characters except:

~ \* ? < > | / \ : " % #

The following characters have special meanings:

Character	Meaning
.	The last period (dot) in a file name is the extension separator
\ and /	Directory separators
:	Separates the drive name from the directory

**Programming in Teach-in operating mode**

-  ▶ Select the **Machine** operating mode
-  ▶ Select the **Teach-in** submode
-  ▶ Press the **Program list** soft key
-  ▶ Open a new cycle program
-  ▶ Press the **Add cycle** soft key to enable the cycle menu
- ▶ Select and specify the desired machining operations
-  ▶ Press the **Input finished** soft key
-  ▶ Start the simulation and check the machining sequence
-  ▶ Select the desired graphics options, if applicable
-  ▶ Press **NC Start** to start machining
-  ▶ Save the cycle after the operation is completed
- ▶ Repeat the above steps for each new machining operation

## Programming in smart.Turn operating mode

- Convenient programming with **Units»** in a structured NC program
- Combinable with DIN functions
- Contour definition graphically possible
- Contour follow-up when used with a workpiece blank
- Conversion of cycle programs to smart.Turn programs with the same functions

## 2.2 Control screen

The control shows the data to be displayed in windows. Some windows only appear when they are needed, for example, for typing in entries.

In addition, the control shows the **type of operation**, the **soft-key display** and the **PLC soft key display** on the screen. Each function that appears in a field of the soft-key row is activated by pressing the soft key directly below it.



If you are using a control with touch operation, you can replace some keystrokes with hand gestures.

**Further information:** "Operating the Touchscreen", Page 83

### Operating mode line

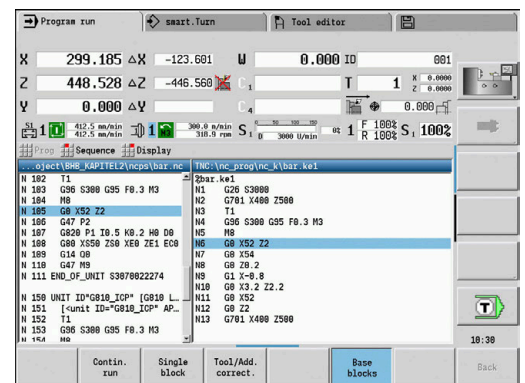
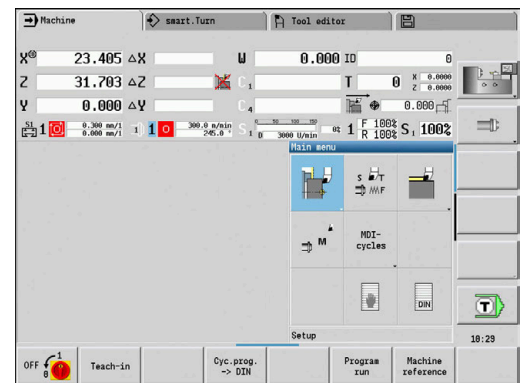
The operating mode tabs (at the top of the screen) show the four operating modes as well as the submodes.

### Machine display

The machine display field (beneath the operating mode tabs) is configurable. It shows all important information on axis positions, feed rates, rotational speeds, and tools.

### Other windows used

- **List and program windows:** Here, program, tool, and parameter lists, etc. are displayed  
You can use the arrow keys to **navigate** within the list and select the list items to be edited.
- **Menu window:** Displays the menu symbols  
This window only appears on the screen in the **Teach-in** submode and **Machine** operating mode
- **Input window / dialog window:** For entering the parameters of a cycle, ICP element, DIN command, etc.  
View the existing data, then delete or edit them in the dialog window.
- **Help graphics:** Input data (such as cycle parameters, tool data, etc.) are explained with graphics.  
The **triple-arrow key** (at the left edge of the screen) allows you to switch between the help graphics for inside and outside machining (only for cycle programming).
- **Simulation window:** The simulation window shows a graphic representation of the contour elements and a simulation of the tool movements.  
This way, you can check cycles, entire cycle programs, and DIN programs.
- **ICP contour graphics:** Display of the contour during ICP programming
- **DIN editing window:** Display of the DIN program during DIN programming
- **Error window:** Display of encountered errors and warnings



## 2.3 Operation and data input

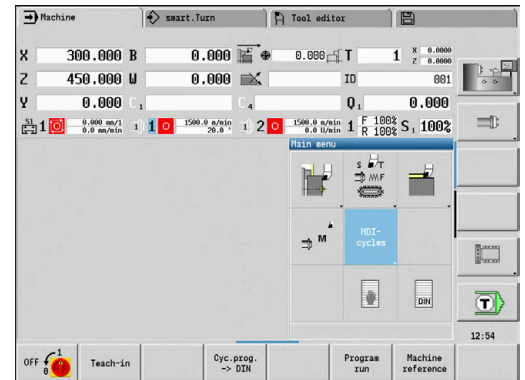
### Modes of operation

The active mode of operation is highlighted in the operating-mode tab. The control differentiates between the following operating modes:

- **Machine**—with the submodes:
  - Teach-in
  - Program run
  - ICP editor
  - Reference
  - Simulation
- **smart.Turn**—with the submodes:
  - ICP editor
  - Automatic working plan generation **AWG**
  - Simulation
- **Tool editor**—with the submodes:
  - Technology editor
- **Organization**—with the submodes:
  - Machine par. programming
  - Transfer

You can use the operating mode keys to switch between the modes. The selected submode and the current menu position remain when the operating mode is switched.

If you press the operating mode key in a submode, the control switches back to the main level of the mode.



In some situations, it is not possible to switch modes (e.g. in **Tool editor** operating mode).

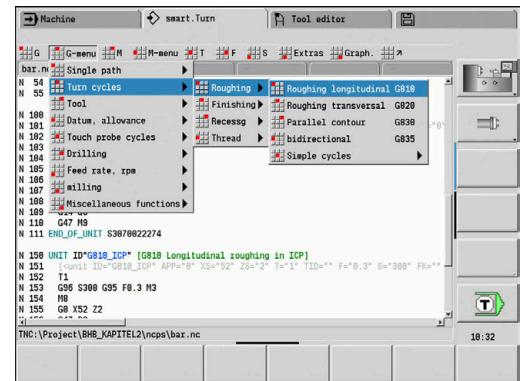
In such cases, you need to terminate the editing process or close the dialog before switching the operating mode.

## Menu selection

The numerical keypad is used for activating a menu and for entering data. They are displayed differently depending on the operating mode:

- During setup, for example in **Teach-in** submode, the functions are shown in a 9-field box, the **menu window**  
The meaning of the selected symbol / menu item is described in the bottom line.
- In other operating modes, the keypad symbol is shown with the position of the function marked.

Press the corresponding numerical key, or move the highlight with the arrow keys to the symbol on the screen and press the **ENT** key.



## Soft keys

- With some system functions, the available functions are arranged on several soft-key levels
- Some soft keys work like **toggle switches**.  
A function is active when the associated field in the soft-key row is **highlighted** in color. The setting remains in effect until the function is switched off again.
- With functions like **Take over position**, you do not have to enter values manually  
The data are automatically written into the appropriate input fields.
- Data input is not concluded until you press the **Save** or **Input finished** soft key
- The **Back** soft key takes you back to the previous operating level

## Data input

Input windows comprise several **input fields**. You can move the cursor to the desired input field with the **up** or **down** arrow key. The control shows the function of the selected field in the bottom line of the window or directly before the input field.

Place the highlight on the desired input field and enter the data. Existing data are overwritten. With the **left** or **right** arrow key, you can move the cursor **within** the input field and place it on the position where you want to delete, copy or add characters.

To confirm the data you entered in a field, press the **up** or **down** arrow key or the **ENT** key.

If there are more input fields than a window can show, a second input window is used. You will recognize this through the symbol in the bottom line of the input window. To switch back and forth between the windows, press the **PgUp/PgDn** keys.



Data entry is concluded when you press the **OK**, **Input finished** or **Save** soft key. The **Back** or **Cancel** soft key discards input or changes.

TCP cut longitud.			
X	23.405	Z	31.7025
FK	Hueelse		
P	5	H	0: With €
I		K	
E		O	0: No
SX		SZ	-27
G47	2		
T	1	G14	0: Simult
ID	001		
S	200	F	0.35
Starting point [mm]			1/2

## smart.Turn dialogs

The unit dialog is divided into fillable forms and the forms are divided again into groups. The forms are identified by tabs and fine lines divide each tab into groups. You can navigate between the forms and groups with the smart.Turn keys.

### smart.Turn keys



Go to the next form



Go to next or previous group

G820 Roughing, direct transverse			
Overvw.	Tool	Contour	Cycle
Appro...	XS	52	Appro... ZS
ID number		TID	
		5	
Feed			F
			0.3
Cutting speed			S
			300
Start point contour			X1
			50
Start point contour			Z1
			0
End point contour			X2
			0
End point contour			Z2
			1
Maximum infeed			P
			2
Oversize X			I
			0.500
Oversize Z			K
			0.200
Approach position X [mm]			1/7

## List operations

Cycle programs, DIN programs, tool lists, etc. are displayed as lists. You can scroll through a list with the arrow keys to check data or to highlight elements for operations like deleting, copying, editing, etc.

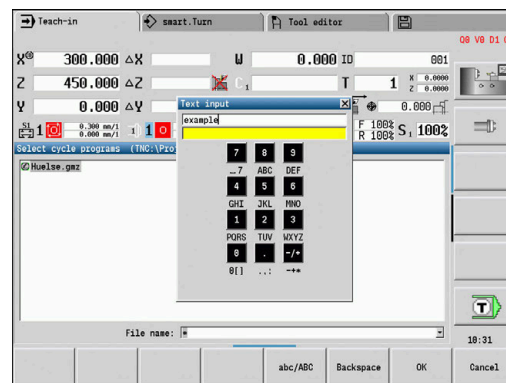
## Alphabetic keyboard

You enter letters and special characters with the screen keypad or (if available) with a PC keyboard connected over the USB port.

### Entering text with the screen keyboard

- ▶ Press the **Alphabetic keyboard** soft key or the **GOTO** key to enter text.
- ▶ The control opens the **Text input** window.
- ▶ Enter the desired character or special character by pressing the numerical key multiple times.
- ▶ Use the **abc/ABC** soft key to select upper or lower case.
- ▶ Wait until the selected character appears in the input field.
- ▶ Then, enter the next character.
- ▶ Use the **OK** soft key to transfer the text into the open dialog field.

To delete individual characters, use the **BACKSPACE** soft key.



## 2.4 Calculator

### Calculator functions

The calculator can be selected only from open dialogs in cycle programming or smart.Turn programming.

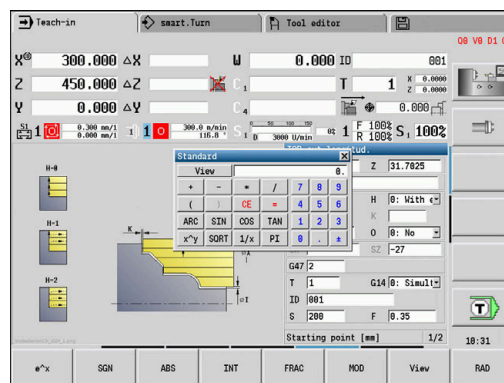
You can use the calculator in the following three **views**:

- Scientific
- Standard
- Equation editor: Here, you can perform multiple calculations in immediate sequence (for example  $17*3+5/9$ )






The calculator remains active even after a change in operating modes. Press the **END** soft key to close the calculator.

The **GET CURRENT VALUE** soft key enables you to transfer a numerical value from the active input field to the calculator. The **CONFIRM VALUE** soft key enables you to transfer the current value from the calculator to the active input field.






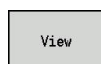
## Using the calculator

-  ▶ Use the cursor keys to select the input field.
-  ▶ Use the **CALC** key to activate or deactivate the calculator
-  ▶ Shift the soft-key menu until the desired function appears

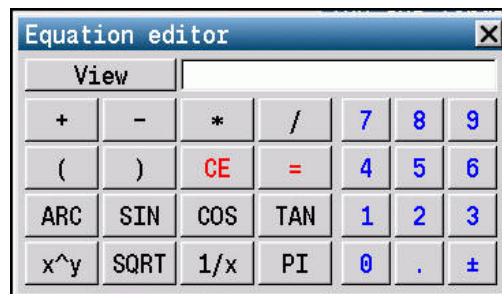
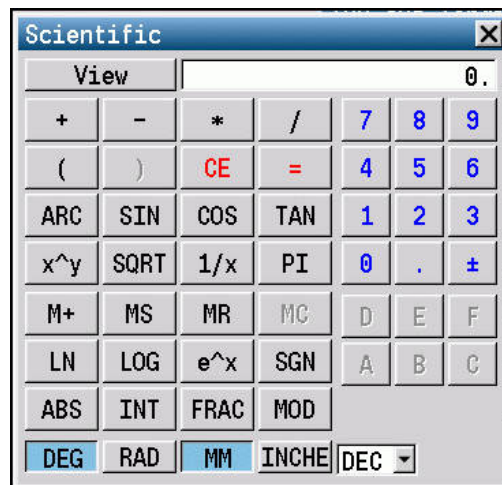
Performing the calculation:

-  ▶ Press the **CONFIRM VALUE** soft key
- ▶ The control transfers the value into the active input field and closes the calculator.

Switching the view of the calculator:

-  ▶ Press the **View** soft key until the desired view is set.

Calculate function	Shortcut (soft key)
Addition	+
Subtraction	-
Multiplication	*
Division	/
Calculating with parentheses	()
Arc	ARC
Sine	SIN
Cosine	COS
Tangent	TAN
Powers of values	x <sup>y</sup>
Square root	SQRT
Inversion	1/x
pi (3.14159265359)	PI
Add value to buffer memory	M+
Save the value to buffer memory	MS
Recall from buffer memory	MR
Delete buffer memory contents	MC
Natural logarithm	LN
Logarithm	LOG
Exponent function	e <sup>x</sup>
Check the algebraic sign	SGN
Form the absolute value	ABS
Truncate decimal places	INT



Calculate function	Shortcut (soft key)
Truncate places before the decimal point	<b>FRAC</b>
Modulus operator	<b>MOD</b>
Select view	<b>View</b>
Delete value	<b>DEL</b>
Unit of measure	<b>MM</b> or <b>INCH</b>
Display mode for angle values	<b>DEG</b> (degree) or <b>RAD</b> (radian measure)
Display mode of the numerical value	<b>DEC</b> (decimal) or <b>HEX</b> (hexadecimal)



The arc calculate function only has a function in connection with **SIN**, **COS** or **TAN**.  
The calculator writes the inverse function as **ASIN**, **ACOS** or **ATAN**.

## Adjusting the position of the calculator

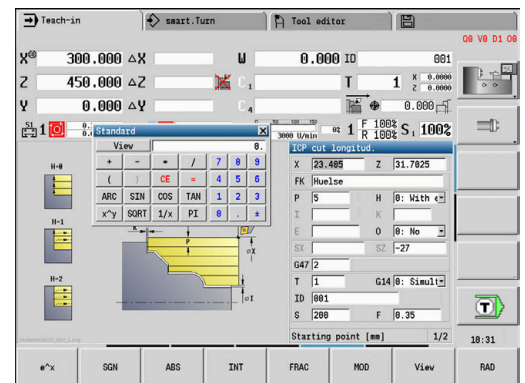
You can move the calculator as follows:



- ▶ Move the calculator with the arrow keys



You can also move the calculator with a connected mouse.



## 2.5 Program types

The control supports the following programs/contours:

- **Teach-in programs** (cycle programs) are used in the **Teach-in** submode
- **smart.Turn** and **DIN main programs** are written in the **smart.Turn** mode of operation
- **DIN subprograms** are written in the **smart.Turn** operating mode and are used in cycle programs and smart.Turn main programs
- **ICP contours** are generated in **Machine** operating mode or in **Teach-in** submode.

The file name extension depends on the contour described.

In **smart.Turn** operating mode, the contours are saved directly in the main program.

Program type	Folder	Extension
Teach-in programs (cycle programs)	nc_prog\gtz	*.gmz
smart.Turn and DIN main programs	nc_prog\ncps	*.nc
DIN subprograms	nc_prog\ncps	*.ncs
ICP contours	nc_prog\gti	
<ul style="list-style-type: none"> <li>■ Turning contours</li> <li>■ Contours of workpiece blanks</li> <li>■ Contours on face</li> <li>■ Lateral surface contours</li> </ul>		<ul style="list-style-type: none"> <li>■ *.gmi</li> <li>■ *.gmr</li> <li>■ *.gms</li> <li>■ *.gmm</li> </ul>

## 2.6 Error messages

### Display of errors

The control will display error messages in the following situations:

- Incorrect input
- Logical errors in the program
- Impossible contour elements

When an error occurs, it is displayed in red type in the header. Long and multi-line error messages are displayed in abbreviated form. If an error occurs in a background mode, the error symbol is shown in the operating mode tab. Complete information on all pending errors is shown in the error window.



The control uses different colors for different error classes:

- red for errors
- yellow for warnings
- green for notes
- blue for information

If a rare **processor check error** should occur, the control automatically opens the error window. You cannot correct such an error. Shut down the system and restart the control.

The error message is displayed in the header until it is cleared or replaced by a higher-priority error.

An error message that contains the block number of an NC program was caused by an error in the indicated block or in the preceding block.

### Opening the error window



- ▶ Press the **ERR** key.
- > The control opens the error window and displays all accumulated error messages.

### Closing the error window



- ▶ Press the **END** soft key







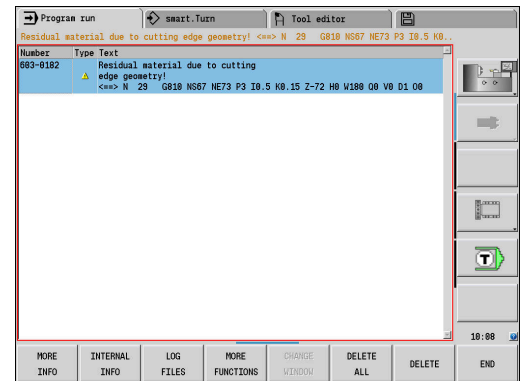
- ▶ Press the **ERR** key.
- > The control closes the error window.

## Detailed error messages

The control displays possible causes of the error and suggestions for solving the problem.





Information on error causes and remedies:

-  ▶ Open the error window
-  ▶ Position the cursor on the error message
-  ▶ Press the **MORE INFO** soft key.  
▶ The control opens a window with information on the error cause and corrective action.
-  ▶ Press the **MORE INFO** soft key again to close the window.



## INTERNAL INFO soft key

The **INTERNAL INFO** soft key supplies information on the error message. This information is only required if servicing is needed.

-  ▶ Open the error window
-  ▶ Position the cursor on the error message
-  ▶ Press the **INTERNAL INFO** soft key.  
▶ The control opens a window with information on the error cause and corrective action.
-  ▶ Press the **INTERNAL INFO** soft key again to close the window.

## Clearing errors

Clearing errors outside of the error window:



- ▶ Open the error window



- ▶ Press the **CE** key to clear the errors or information displayed in the header.



In some operating modes (such as the **Tool editor**), the **CE** button cannot be used to clear the error, since the button is reserved for other functions.

Clearing more than one error:



- ▶ Open the error window



- ▶ Position the cursor on the error message.
- ▶ Press the **DELETE** soft key to clear an individual error message.








- ▶ Press the **DELETE ALL** soft key to clear all errors.



If the cause of the error has not been corrected, the error message cannot be deleted. In this case, the error message remains in the window.

## Error log






The control stores errors and important events (e.g. system startup) in an error log file. The capacity of error logs is limited. If the log file is full, the control switches to the next one, etc. If the last log file is full, the first one is overwritten by a new one, etc. If necessary, switch to another log file to see the history. Five log files are available.

- |   |                                       |
|---|---------------------------------------|
|  | ▶ Open the error window               |
|  | ▶ Press the <b>LOG FILES</b> soft key |
|  | ▶ Open the current log file           |
|  | ▶ Select previous log file, if needed |
|  | ▶ Select current log file, if needed  |

The oldest entry is at the beginning of the log file, and the most recent entry is at the end.

## Keystroke log

The control stores keystrokes and important events (e.g. system startup) in the keystroke log file. The capacity of keystroke logs is limited. If the log file is full, it switches to the next one, etc. If the last log file is full, the first one is overwritten by a new one, etc. If necessary, switch the log file to see the history. Ten log files are available.

-  ▶ Open the error window
-  ▶ Press the **LOG FILES** soft key
-  ▶ Open protocol
-  ▶ Select previous log file, if needed
-  ▶ Select current log file, if needed

The control saves each key pressed during operation in the keystroke log file. The oldest entry is at the beginning of the log file, and the most recent entry is at the end.



## Saving service files




If necessary, you can save the **Current status** of the control, and make it available to a service technician for evaluation. A group of service files is saved that contain information about the current status of the machine and the machining.

**Further information:** "Creating service files", Page 666

The information is summarized in a service files data record as a zip file: **TNC:\SERVICEx.zip**

The **x** designates a consecutive serial number. The control always generates the service file with the number **1**, and all existing files are renamed to the numbers **2 to 5**. An existing file with the number **5** is deleted.

Saving service files

-  ▶ Open the error window
-  ▶ Press the **LOG FILES** soft key
-  ▶ Press the **SAVE SERVICE FILES** soft key

## 2.7 TURNguide context-sensitive help

### Application



Before you can use the TURNguide, you need to download the help files from the HEIDENHAIN home page.

**Further information:** "Downloading current help files", Page 79

The **TURNguide** context-sensitive help system includes the user documentation in HTML format. The TURNguide is called with the **Info** key, and the control often immediately displays the information specific to the condition from which the help was called (context-sensitive call). Even if you are editing in a cycle and press the **Info** key, you are usually brought to the exact place in the documentation that describes the corresponding function.



The control tries to start the TURNguide in the language that you have selected as the conversational language on your control. If the files with this language are not yet available on your control, the control automatically opens the English version.

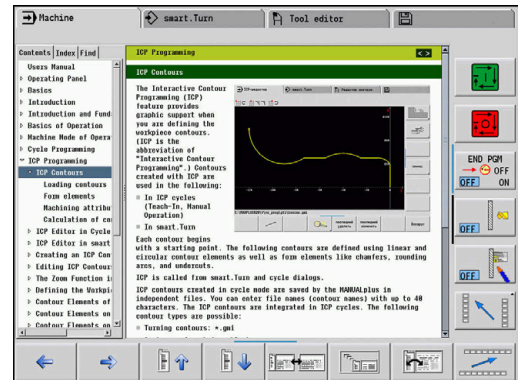
The following user documentation is available in the TURNguide:

- User's Manual (**BHBoperating.chm**)
- smart.Turn and DIN programming (**BHBsmartturn.chm**)
- List of All Error Messages (**errors.chm**)

In addition, the **main.chm** "book" file is available, with the contents of all existing .chm files.



As an option, your machine tool builder can embed machine-specific documentation in the TURNguide. These documents then appear as a separate book in the **main.chm** file.



## Working with the TURNguide

### Calling the TURNguide

There are several ways to start the TURNguide:

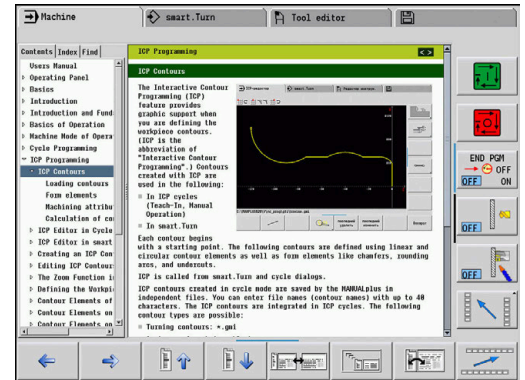


- ▶ Press the **Info** key if the control is not already showing an error message
- ▶ First click the help symbol in the lower right-hand corner of the screen, then click the appropriate soft key



If one or more error messages are waiting for your attention, the control shows the help directly associated with the error messages. To start the TURNguide, you first have to acknowledge all error messages.

When the help system is called on the programming station, the control starts the internally defined standard browser (usually the Internet Explorer), or otherwise a browser adapted by HEIDENHAIN.



For many soft keys there is a context-sensitive call through which you can go directly to the description of the soft key's function. This functionality requires using a mouse.

Proceed as follows:

- ▶ Select the soft-key row containing the desired soft key
- ▶ Click with the mouse on the help symbol that the control displays just above the soft-key row
- ▶ The cursor turns into a question mark.
- ▶ Move the question mark to the soft key for which you want an explanation
- ▶ The control opens the TURNguide.
- ▶ If no specific part of the help is assigned to the selected soft key, the control opens the book file, **main.chm**, in which you can use the full text search function or the navigation to find the desired explanation manually.

Even while you are editing a cycle, context-sensitive help is available:

- ▶ Select any cycle



- ▶ Press the **Info** key
- ▶ The control starts the help system and shows a description for the active function (does not apply to miscellaneous functions or cycles that were integrated by your machine tool builder).

## Navigating in the TURNguide







It's easiest to use the mouse to navigate in the TURNguide. A table of contents appears on the left side of the screen. By clicking the rightward pointing triangle you open subordinate sections, and by clicking the respective entry you open the individual pages. It is operated in the same manner as the Windows Explorer.










Linked text positions (cross references) are shown underlined and in blue. Clicking the link opens the associated page.

Of course you can also operate the TURNguide through keys and soft keys. The following table contains an overview of the corresponding key functions.



The key functions described below are available only on the control hardware, and not on the programming station.

Operating element	Function
 	<ul style="list-style-type: none"> <li>■ If the table of contents at the left is active: Select the entry above or below the current one.</li> <li>■ If the text window at right is active: Move the page downward or upward if texts or graphics are not shown completely</li> </ul>
	<ul style="list-style-type: none"> <li>■ If the table of contents at the left is active: Expand the current entry or, if it is fully expanded, move to the window at the right.</li> <li>■ If the text window at right is active: No function</li> </ul>
	<ul style="list-style-type: none"> <li>■ If the table of contents at left is active: Close a branch of the table of contents</li> <li>■ If the text window at right is active: No function</li> </ul>
	<ul style="list-style-type: none"> <li>■ If the table of contents at the left is active: Display the selected page.</li> <li>■ If the text window at right is active: If the cursor is on a link, jump to the linked page</li> </ul>
	<ul style="list-style-type: none"> <li>■ If the table of contents at left is active: Switch the tab between the display of the table of contents, display of the subject index, and the full-text search function and switching to the screen half at right</li> <li>■ If the text window at right is active: Jump back to the window at left</li> </ul>

Operating element	Function
	<ul style="list-style-type: none"> <li>■ If the table of contents at the left is active: Select the entry above or below the current one.</li> <li>■ If the text window at right is active: Jump to next link</li> </ul>
	Select the page last shown
	Page forward if you have used the <b>Select page last shown</b> function multiple times.
	Move up by one page
	Move down by one page
	Display or hide table of contents
	<p>Switch between full-screen display and reduced display.</p> <p>With the reduced display, you can still see parts of the control window.</p>
	<p>The focus is switched internally to the control application so that you can operate the control when the TURNguide is open.</p> <p>If the full screen is active, the control reduces the window size automatically before changing the focus.</p>
	Exit TURNguide

## Subject index

The most important keywords are listed in the index (Index tab). Select the desired keyword directly by clicking it or by highlighting it with the arrow keys.

The left side is active:



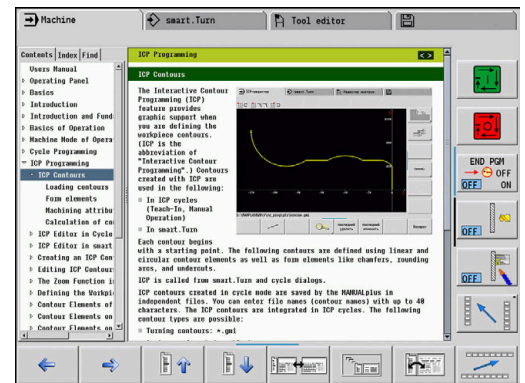
- ▶ Select the **Index** tab
- ▶ Activate the **Keyword** input field
- ▶ Enter the search word
- ▶ The control synchronizes the keyword index based on the text you entered and creates a list in which you can find the keyword more easily.



- ▶ Alternative: Use the **arrow key** to highlight the desired keyword



- ▶ Use the **ENT** key to display information on the selected keyword.



You can enter the search word only with a keyboard connected via USB.

## Full-text search

In the Find tab you can search the entire TURNguide for a specific word.

The left side is active:



- ▶ Select the **Find** tab
- ▶ Activate the **Find:** input field
- ▶ Enter the search word
- ▶ Press the **ENT** key
- ▶ The control lists all sources containing the word.



- ▶ Use the arrow key to highlight the desired source



- ▶ Press the **ENT** key to go to the selected source



You can enter the search word only with a keyboard connected via USB.

The full-text search only works for single words.

If you activate the **Search only in titles** function (by mouse or by pressing the keys), the control searches only through headings and ignores the body text.

## Downloading current help files

You'll find the help files for your control software on the HEIDENHAIN homepage [www.heidenhain.de](http://www.heidenhain.de).

Help files for most conversational languages are at:

- ▶ Documentation
- ▶ Manuals
- ▶ Product, e.g. MANUALplus 620 CNC PILOT 620/640
- ▶ NC software number, e.g. 68894x-03
- ▶ Download the compressed CHM file in the desired language and extract it
- ▶ Move the extracted CHM files to the **TNC:\tncguide\en** directory and the respective language subdirectory on the control



If you want to use TNCremo to transfer the .chm files to the control, in the connection configuration on the mode form you must select the third option in the transfer area in binary mode.

Language	Directory in TNCremo
German	TNC:\tncguide\de
English	TNC:\tncguide\en
Czech	TNC:\tncguide\cs
French	TNC:\tncguide\fr
Italian	TNC:\tncguide\it
Spanish	TNC:\tncguide\es
Portuguese	TNC:\tncguide\pt
Swedish	TNC:\tncguide\sv
Danish	TNC:\tncguide\da
Finnish	TNC:\tncguide\fi
Dutch	TNC:\tncguide\nl
Polish	TNC:\tncguide\pl
Hungarian	TNC:\tncguide\hu
Russian	TNC:\tncguide\ru
Chinese (simplified)	TNC:\tncguide\zh
Chinese (traditional)	TNC:\tncguide\zh-tw
Slovenian	TNC:\tncguide\sl
Norwegian	TNC:\tncguide\no
Slovak	TNC:\tncguide\sk
Korean	TNC:\tncguide\kr
Turkish	TNC:\tncguide\tr
Romanian	TNC:\tncguide\ro

## 2.8 DataPilot programming station

### Application

Intended for use with the **CNC PILOT 640** and **MANUALplus 620** controls, respectively, the PC programs DataPilot CP 640 and DataPilot MP 620 enable you to create NC programs on a PC, test them before execution, transfer them to the control, and archive them after production is concluded.

DataPilot **can be used for** shop-floor programming as well as for office and off-location program creation and testing. Its practicality and wide range of functions also make DataPilot ideal for training purposes.

### Operation

DataPilot is operated through function keys and numerical keys of the PC keyboard.



For more information about installation and operation, please refer to the DataPilot installation and operating instructions.



## 2.9 HEROS menu

The **HEROS menu** includes all additional applications available to the control on the **HEROS** operating system. Most of these functions are available to all users of the control. Specific functions, such as the **REMOTE DESKTOP MANAGER**, must be enabled via options.

**Further information:** "HEROS-Funktionen", Page

To open the **HEROS menu**, you can do the following:

- Press the **DIADUR** key
- Go to the **Service** menu and select the **HEROS** icon



# 3

**Operating the  
Touchscreen**

## 3.1 Display unit and operation

### Touchscreen



Refer to your machine manual.

This function must be enabled and adapted by the machine tool builder.

The touchscreen is distinguished by a black frame and the lack of soft-key selection keys.

#### 1 Header

When the control is on, the screen displays the selected operating modes in the header. To switch to the desired operating mode, tap on that operating mode in the header.

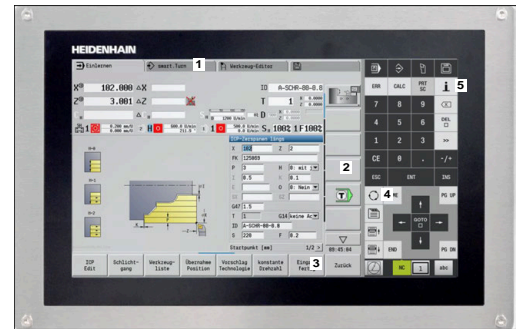
#### 2 Soft-key row for the machine tool builder

#### 3 Soft-key row

The control shows further functions in a soft-key row. The active soft-key row is shown as a blue bar.

#### 4 Screen toggle key for the display of help graphics in cycle programming

#### 5 Call the TURNguide





15.6" touchscreen

## Operating panel

### Basic operation






The following keys, for example, can easily be replaced by hand gestures:




Key	Function	Gesture
	Shift the soft-key row	Swipe horizontally over the soft-key row
	Soft-key selection keys	Tap on the function in the touchscreen

## 3.2 Gestures

### Overview of possible gestures




The screen of the control is multi-touch capable. That means that it can distinguish various gestures, including with two or more fingers at once.

Symbol	Gesture	Meaning
	Tap	A brief touch by a finger on the screen
	Double tap	Two brief touches on the screen
	Long press	Continuous contact of fingertip on the screen
	Swipe	Flowing motion over the screen
	Drag	A combination of long-press and then swipe, moving a finger over the screen when the starting point is clearly defined

Symbol	Gesture	Meaning
	Two-finger drag	A combination of long-press and then swipe, moving two fingers in parallel over the screen when the starting point is clearly defined
	Spread	Two fingers long-press and move away from each other
	Pinch	Two fingers move toward each other

### Navigating in the table and NC programs

You can navigate in an NC program or a table as follows:

Symbol	Gesture	Function
	Tap	Mark the NC block or table line Stop scrolling
	Double tap	Activate the table line Edit NC block or unit
	Swipe	Scroll through the NC program or table







### Operating the Simulation

The control offers touch operation with the following graphics:

- Programming graphics in **smart.Turn** mode of operation
- 3-D view in **Simulation** submode
- 2-D view in **Simulation** submode
- 2-D view in **ICP editor** submode



#### Rotate, zoom or move a graphic

The control supports the following gestures:

Symbol	Gesture	Function
	Double tap	Set the graphic to its original size
	Drag	Rotate the graphic (only 3-D graphics)
	Drag	Adjust the detail (only 2-D graphics, zoom function)
	Two-finger drag	A combination of long-press and then swipe, moving two fingers in parallel over the screen when the starting point is clearly defined
	Spread	Magnify the graphic
	Pinch	Reduce the graphic

## Using the HEROS menu

You can use the **HEROS menu** menu as follows:

Symbol	Gesture	Function
	Tap	Select the application
	Long press	Open the application



## 3.3 Functions in the taskbar

### Touchscreen Configuration

With the **Touchscreen Configuration** function you can define the properties of the screen.

#### Adjusting sensitivity

Proceed as follows to adjust the sensitivity:

- ▶ Press the **DIADUR** key to open **HEROS menu** menu
- ▶ As an alternative, go to the **Service** menu and select the **HEROS menu** menu
- ▶ Select the **Touchscreen Configuration** menu item
- > The control opens a pop-up window.
- ▶ Select the sensitivity
- ▶ Confirm with **OK**

#### Display of the touch points

Proceed as follows to show or hide the touch points:

- ▶ Press the **DIADUR** key to open the **HEROS menu**
- ▶ As an alternative, go to the **Service** menu and select the **HEROS menu** menu
- ▶ Select the **Touchscreen Configuration** menu item
- > The control opens a pop-up window.
- ▶ Select the **Show Touch Points** display
  - **Disable Touchfingers** to hide the touch points
  - **Enable Single Touchfinger** to show the touch point
  - **Enable Full Touchfingers** to show the touch points of all fingers involved
- ▶ Confirm with **OK**

### Touchscreen Cleaning

With the **Touchscreen Cleaning** function you can lock the screen in order to clean it.

#### Activating the cleaning mode

Proceed as follows to change activate the cleaning mode:

- ▶ Press the **DIADUR** key to open **HEROS menu** menu
- ▶ As an alternative, go to the **Service** menu and select the **HEROS menu** menu
- ▶ Select the **Touchscreen Cleaning** menu item
- > The control locks the screen for 90 seconds.
- ▶ Clean the screen

If you would like to stop the cleaning mode:

- ▶ Pull the displayed sliders apart at the same time



# 4

**Machine mode of  
operation**

## 4.1 Machine mode of operation

The **Machine** mode of operation includes all functions for machine setup, workpiece machining, and Teach-in program definition:

- **Machine setup:** For preparations like setting axis values (defining workpiece datum), measuring tools or setting the protection zone
- **Manual mode:** Machine a workpiece manually or semi-automatically
- **Teach-in submode:** "Teach-in" a new cycle program, change an existing program, or graphically simulate cycles
- **Program run submode:** Graphically simulate existing cycle programs or smart.Turn programs and use them for the production of parts

You can produce a part in the usual manner by moving the axes with the handwheels and jog controls, just like on a conventional lathe. In most cases, however, it is much more convenient to use the cycles offered by MANUALplus.

A **Teach-in cycle** is a machining step that has already been programmed for you. This can be any machining operation from a single cut through to a complex machining task like thread cutting. In any case, a cycle is always a complete machining step that is immediately executable once you have defined a few parameters that describe the workpiece to be machined.

In **Machine** mode of operation, cycles are **not saved**. In **Teach-in** submode, each machining step is executed using cycles and then stored and integrated into a complete **teach-in program**. You can subsequently use this **teach-in program** in parts production by repeating it as often as desired in **Program run** submode.

In **ICP programming**, any contour can be defined using linear/circular elements and transition elements (chamfers, rounding arcs, undercuts). You include the contour description in ICP cycles.

**Further information:** "ICP contours", Page 424

You write **smart.Turn** and **DIN programs** in **smart.Turn** mode of operation. The DIN programming feature provides you with commands for simple traversing movements, DIN cycles for complex machining tasks, switching functions, mathematical operations and programming with variables.

You can either create **independent** programs that already contain all necessary switching and traversing commands and are executed in **Program run** submode, or program **DIN subprograms** that are integrated in teach-in cycles. The commands that you use in a DIN subprogram depend on the task to be performed. DIN subprograms support the complete range of commands that is available for DIN programs.

You can also convert Teach-in programs to smart.Turn programs. This enables you to make use of straightforward Teach-in programming and then optimize or complete the NC program following conversion into **DIN format**.

## 4.2 Switch-on / Switch-off

### Switch-on

#### DANGER

##### Caution: Danger for the operator!

Machines and machine components always present mechanical hazards. Electric, magnetic or electromagnetic fields are particularly hazardous for persons with cardiac pacemakers or implants. The hazard starts when the machine is powered up!

- ▶ Read and follow the machine manual
- ▶ Read and follow the safety precautions and safety symbols
- ▶ Use the safety devices

The control displays the startup status. When the control has completed all tests and initializations, it switches to **Machine** mode of operation. The tool display shows the tool that was last used. If errors are encountered during system startup, the control displays the error symbol on the screen. You can check these error messages as soon as the system is ready.

**Further information:** "Error messages", Page 68



After system start, the control assumes that the tool which was last used is still inserted in the tool holder. If this is not the case, you must inform the control of the tool change.

### Monitoring EnDat encoders

If EnDat encoders are used, the control saves the axis positions during switch-off of the machine. During switch-on, the control compares for each axis the position during switch-on with the position saved during switch-off.

If there is a difference, one of the following messages appears:

- **S-RAM error: Saved position of the axis is invalid:** This message is correct if the control has been switched on for the first time, or if the encoder or other control components involved were exchanged
- **Axis was moved after power-off. Position difference: xx mm or degrees:** Check and confirm the current position if the axis was actually moved
- **HW parameters changed: Saved position of the axis is invalid:** This message is correct if configuration parameters were changed

The cause for one of the above listed messages can also be a defect in the encoder or control. Please contact your machine supplier if the problem recurs.

## Reference submodeReference

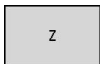


Switching on the machine and traversing the reference points can vary depending on the machine tool.

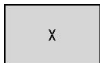
Whether a reference run is necessary or not depends on the encoders used:

- **EnDat encoder:** Reference run is not necessary
- **Distance-coded encoder:** The position of the axes is ascertained after a short reference run
- **Standard encoder:** The axes move to known, machine-based points. As soon as a reference position is traversed, a signal is transmitted to the control. The control knows the distance between the reference position and the machine datum and can now establish the precise position of the axis

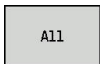
Reference run:



- ▶ Press the **Z** reference soft key



- ▶ Press the **X** reference soft key



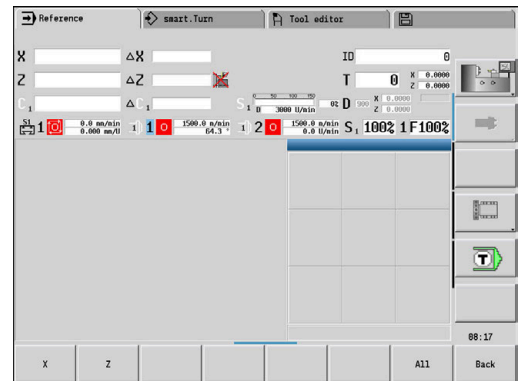
- ▶ Alternative: Press the **All** soft key



- ▶ Press the **NC start** key
- > The control approaches the reference positions.
- > The control activates the position display and activates the **main menu**.



In case you traverse the reference marks separately for the X and Z axes, you only traverse in either the X or the Z axis.



## Switch-off



Refer to your machine manual.

Switch-on and restart can vary depending on the machine tool.

To prevent data from being lost at switch-off, you need to shut down the operating system of the control as follows:



- ▶ Select the **Machine** operating mode

If an error message is pending:



- ▶ Activate the error window



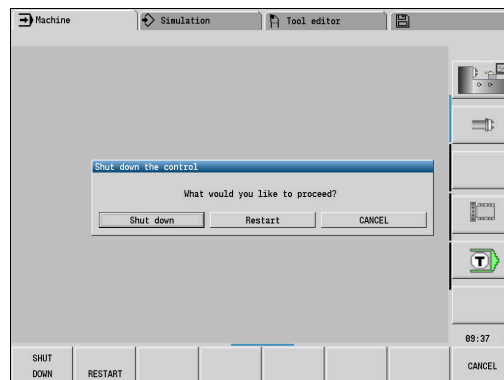
- ▶ Press the **MORE FUNCTIONS** soft key



- ▶ Press the **OFF** soft key



- ▶ Confirm with the **SHUT DOWN** soft key
- ▶ The control shuts down.



## NOTICE

### Caution: Data may be lost!

The control must be shut down so that running processes can be concluded and data can be saved. Immediate switch-off of the control by turning off the main switch can lead to data loss not matter what state the control was in!

- ▶ Always shut down the control
- ▶ Only operate the main switch after being prompted on the screen

## Restarting the control

Proceed as follows to force a restart:



- ▶ Select the **Machine** operating mode



- ▶ Press the **OFF** soft key



- ▶ Press the **RESTART** soft key
- ▶ The control restarts.

## 4.3 Machine data

### Input of machine data

In **Machine** mode of operation, enter the information for tool, spindle speed and feed rate/cutting speed in the **TSF** menu (**Set T, S, F** input window).

In the **TSF** menu you also define the maximum speed, the stopping angle and the workpiece material.

Cycle parameters:

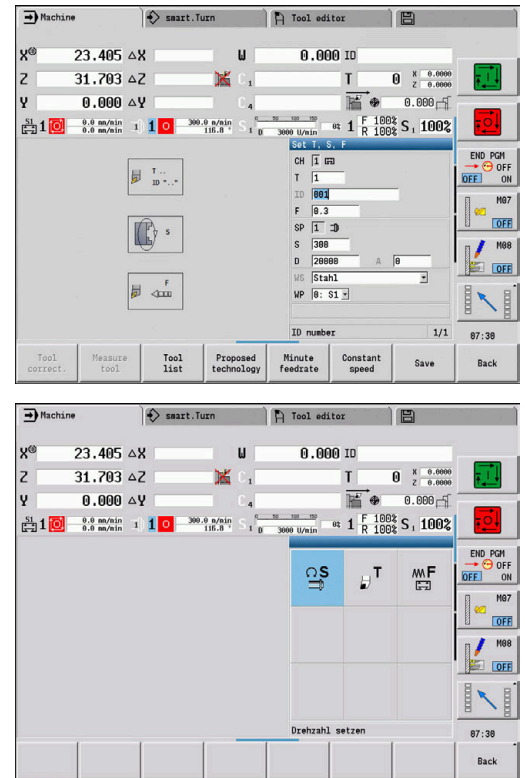
- **T: Tool number** or **Tool pocket**
- **ID: ID no.**
- **F: Feed per revolution** or **Minute feed**
- **SP: Spindle**
- **S: Cutting speed** or **Shaft speed constant**
- **D: Maximum speed**
- **A: Stopping angle**
- **WS: Material**

You can save the cutting data (cutting speed, feed rate) in the technology database as a function of the workpiece material, the tool's cutting material and the type of machining. With the **Proposed technology** soft key, the data is transferred into the dialog.

If the **Minute feed** soft key is activated, the **F** value is evaluated in **[mm/min]**.

If the **Constant spindle speed** soft key is activated, the **S** value is evaluated in **[rev/min]**.

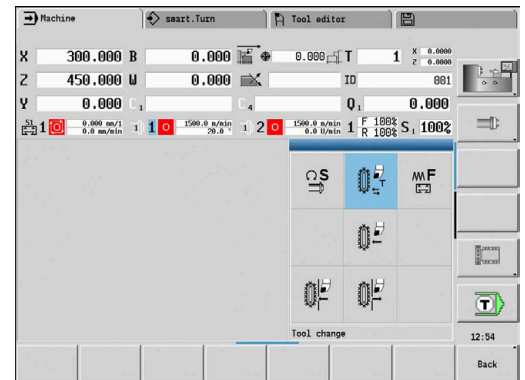
In Teach-in programs the tool information and technology data are included in the cycle parameters, and in smart.Turn programs they are part of the NC program.





### Soft keys for Set T, S, F

Tool correct.	<b>Further information:</b> "Tool compensation", Page 142
Measure tool	<b>Further information:</b> "Touch-off", Page 139
Tool list	Call tool list or turret list <b>Further information:</b> "Pocket table setup", Page 108
Turret list	
Proposed technology	Transfer of cutting speed and feed rate from the technology data
Minute feedrate	<ul style="list-style-type: none"> <li>■ <b>On:</b> Feed per minute (mm/min)</li> <li>■ <b>Off:</b> Programmed feed rate per revolution (mm/rev)</li> </ul>
Constant speed	<ul style="list-style-type: none"> <li>■ <b>On:</b> Constant speed (rpm)</li> <li>■ <b>Off:</b> Constant surface speed (m/min)</li> </ul>



## Machine-dependent variants of the TSF dialog

### Machine operating panel with spindle change key

If the manufacturer has equipped your machine operating panel with a spindle change key, specify per key for which spindle the entries for **S**, **D** and **A** apply. The **SP** field displays the number of the selected spindle in the **TSF** menu.



In the **separateTSFDlg** (604906) machine parameter, you can define how you want the **TSF** dialog to be displayed on machines with turrets:

- **TSF** dialog with input of all cutting data
- Separate dialogs for **T**, **S** and **F**

For machines with tool magazine, separate dialogs are automatically available in the **TSF** menu.

### Machine operating panel without spindle change key

For machines with only one main spindle the entries **S**, **D** and **A** always apply to the main spindle.

For machines with one main spindle and one tool spindle, the entries, depending on the inserted tool, apply to the main or tool spindle:

- **Without driven tool:** The parameters **S**, **D** and **A** apply to the main spindle
- **With driven tool:** The parameters **S**, **D** and **A** apply to the selected spindle

### Machine with counter spindle and/or B axis

Depending on the machine design, the TSF dialog may contain further information for controlling a counter spindle and/or B axis.

Additional cycle parameter for counter spindle:

- **WP: No. of spindle** (machine-dependent)

Additional cycle parameters for B axis:

- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)

**TSF entry via a form**

For machines with a tool magazine, separate dialogs are automatically available.

Entering the tool data and technology data:



- ▶ Select **Set T, S, F** (is only selectable in **Machine** mode of operation)
- ▶ Define the parameters
- ▶ Press the **Save** soft key

**NOTICE****Danger of collision!**

Depending on the machine, the input of data in the **T** dialog might cause a tilting movement of the tool carrier (e.g. turret). There is a danger of collision during the tilting movement!

- ▶ Move the tool or the tool carrier to a safe position before entering data

**TSF entry via separate forms**

Entering the tool data or technology data:



- ▶ Select **Set T, S, F** (is only selectable in **Machine** mode of operation)



- ▶ Select **T** for tool change



- ▶ Alternative: Select **S** for spindle speed



- ▶ Alternative: Select **F** for feed rate

- ▶ Enter the parameters in the submenu
- ▶ Press the **Save** soft key

**NOTICE****Danger of collision!**

Depending on the machine, the input of data in the **T** dialog might cause a tilting movement of the tool carrier (e.g. turret). There is a danger of collision during the tilting movement!

- ▶ Move the tool or the tool carrier to a safe position before entering data

### Machine with counter spindle

You have to select a workpiece spindle depending on the machine.

If your machine is equipped with a counter spindle, the **WP** parameter is shown in the **TSF** dialog.

Cycle parameters:

- **WP: No. of spindle** (machine-dependent)

The **WP** parameter allows you to select the workpiece spindle for machining in **Teach-in** submode and with the MDI cycles of **Machine** mode of operation.

Select the workpiece spindle for machining with **WP**:

- Main drive
- Counter spindle for rear-face machining

The **WP** parameter setting is saved in the Teach-in and MDI cycles and displayed in the corresponding cycle form.

If you selected the counter spindle for rear-face machining with the **WP** parameter, the cycle is mirrored (in the opposite Z direction). Use tools with suitable tool orientation.



In the TSF menu, the setting for the **WP** parameter is changed when you:

- Run a cycle with another **WP** parameter setting
- Select a program in **Program run** submode

### Machine with B axis

Machines with B axis allow the tool carrier to be tilted for flexible use of tools during turning and milling. By tilting the B axis and rotating the tool you can bring it into positions that enable you to use one and the same tool to machine in the longitudinal and transverse (or radial and axial) directions on the main and counter spindles. In this way, you need fewer tools and fewer tool changes.

**Tool data:** All tools are described in the tool database by specifying the X, Z and Y dimensions as well as the compensation values. These dimensions and tool orientation must be entered referenced to the **tilt angle B=0°** (reference position).

Cycle parameters:

- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)

The **BW** and **CW** parameter settings are saved in the Teach-in and MDI cycles and displayed in the corresponding cycle form.

### NOTICE

#### Danger of collision!

Depending on the machine, the input of the additional tool parameters might cause a tilting movement of the tool carrier (e.g. turret) or the B axis, and a rotation of the tool. There is a danger of collision during the tilting movement and the rotation!

- ▶ Move the tool or the tool carrier to a safe position before entering data

## Machine data display



Refer to your machine manual.

The machine data display varies depending on the machine.

The machine tool builder can configure the machine data display according to his specific requirements.

If multiple displays have been configured, switch between them as follows:



► Press the **triple-arrow key**

### Elements of machine data display



**Position display X, Y, Z, W:** Distance between tool tip and workpiece datum

- Axis letter:
  - Black: Axis enable granted
  - White = No axis enable



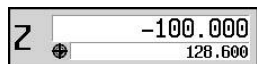
Handwheel active (panel-mounted handwheel)



Handwheel active (portable serial handwheel)



Clamping active



**Position display with current datum shift**



**Position display C:** Position of the C axis

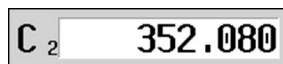
- Empty field: C axis is not active
- Axis letter:
  - Black: Axis enable granted
  - White = No axis enable



**Display settings of the position display:** Can be set via the **axesDisplay-Mode** (604803) machine parameter.

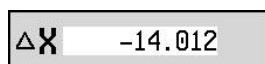
The setting is shown by a letter next to the position window.

- **A:** Actual value (setting: **RFACTL**)
- **N:** Nominal value (setting: **REF NOML**)
- **L:** Servo lag (setting: **LAG**)
- **D:** Distance to go (setting: **DIST.**)



**Display of the C axis with the associated spindle number:** The index of the axis letter C indicates the spindle number

The numeral is only displayed if an axis was configured multiple times, e.g. a second C-axis is configured as a counter spindle.



**Distance-to-go display X, Y, Z, W:** The distance remaining from the current position to the target position of the active traversing command



**Distance-to-go and protection zone status:** Distance-to-go display and display of status of protection zone monitoring

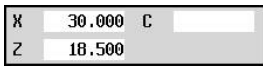
## Elements of machine data display



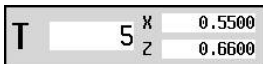
Protection zone monitoring active



Protection zone monitoring not active



**Position display for four axes:** Display of position values for up to four axes  
The displayed axes depend on the machine configuration.

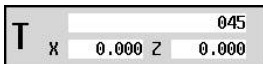


### Tool number display:

- Tool number of the inserted tool
- Tool compensation values

### For all of the T displays:

- **T** highlighted in color: Driven tool
- Tool number or **ID** highlighted in color: Mirrored tool holder
- Tool number with index: Multipoint tool
- The letter **X/Z** of the compensation highlighted in color: Special compensation is active in the X and Z direction



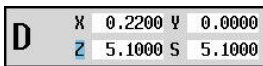
### T ID display:

- **ID** of the inserted tool
- Tool compensation values



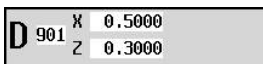
### T ID display without compensation values:

- **ID** of the inserted tool



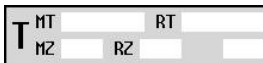
### Tool compensation:

- Special compensation only for recessing tools or button tools
- Special compensation value in gray: Special compensation is not active
- The letter **X/Z** of the compensation highlighted in color: Special compensation is active in the X and Z direction



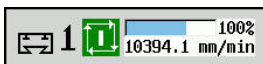
### Additive compensation:

- Compensation values in gray: D compensation is not active
- Compensation values in black: D compensation is active



### Tool life information:

- **T**:
  - Black = global tool life monitoring is on
  - White = global tool life monitoring is off
- **MT, RT** active: Monitoring according to tool life
- **MZ, RZ** active: Monitoring according to part quantity
- All fields empty: Tool without tool-life monitoring



### Slide display and cycle status:

- Upper field: Setting of the override control
- Lower field with white background: Actual feed rate
- Lower field with gray background: Programmed feed rate with stationary slide



### Slide display and cycle status:

- Upper field: Programmed feed rate
- Lower field: Actual feed rate

## Elements of machine data display



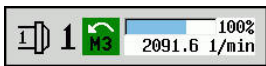
### Slide display and cycle status:

- Upper field: Setting of the override control
- Middle field: Programmed feed rate
- Lower field: Actual feed rate



### Slide display with rear-face machining :

- If rear-face machining is enabled, the slide icon is highlighted in blue



### Spindle display with spindle number, gear range and spindle status:

- Upper field: Setting of the override control
- Lower field: Actual speed or spindle position

### For all of the spindle displays:

- Spindle symbol:
  - Black: Spindle enable granted
  - White = No spindle enable
- Numeral in spindle symbol: Gear range
- Numeral at right next to the spindle symbol: Spindle number
- If a spindle key exists, the number of the selected spindle is highlighted in color
- Spindle status: see "Spindle", Page 107
- Display of the programmed speed in **rpm** or **m/min**
- Display of the actual speed in **rpm**
- If **M19** is active and the machine tool builder has made the setting, when the spindle is not turning, the display shows the spindle position instead of the actual spindle speed
- If a spindle is in slave mode during synchronous operation, the value **0** is displayed instead of the programmed speed
- In synchronous mode, the spindle symbols for both the master and the slave spindle are highlighted in color



### Spindle display with spindle number, gear range and spindle status:

- Upper field: Programmed speed
- Lower field: Actual speed or spindle position

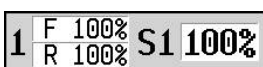
If the programmed spindle speed is displayed in red, a limitation is active and the programmed nominal value will not be reached.



### Spindle display with spindle number, gear range and spindle status:

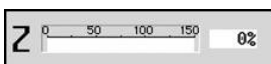
- Upper field: Setting of the override control
- Middle field: Programmed speed
- Lower field: Actual speed or spindle position

If the programmed spindle speed is displayed in red, a limitation is active and the programmed nominal value will not be reached.



### Override display of the active spindle:

- **F**: Feed rate
- **R**: Rapid traverse
- **S**: Spindle

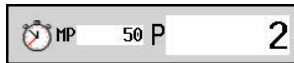


### Motor utilization: Utilization of the servo drive with respect to the rated torque

- Digital axis and spindle motors
- Analog axis and spindle motors, if set up by the machine tool builder

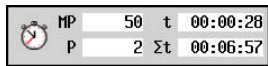


### Elements of machine data display



**Display of quantity:** The quantity is incremented after each **M30**, **M99** or **M18** programmed counter pulse

- **MP:** Defined quantity
- **P:** Number of finished parts



**Display of quantity and job time:** The quantity is incremented after each **M30**, **M99** or **M18** programmed counter pulse

- **MP:** Defined quantity
- **P:** Number of finished parts
- **t:** Run time of the current program
- **Sum t:** Total time



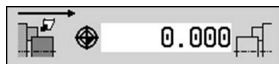
**Display of skip levels and M01 conditional stop:**

- Defined skip levels (upper row) and set or activated skip levels (lower row)
- Setting for **M01**: M01 is not executed in **Continuous run** mode (yellow display)



**Load monitoring display:**

- Left field: zone number (here: 345)
- Right fields: monitored axes (max. 4)



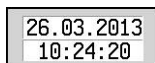
**Display of rear-face machining:** Information about rear-face machining is shown in the RSM display (RSM: Rear Side Machining)

- RSM status
- Active datum shift of the configured RSM axis



**B-axis display:** The information displayed about the status of the tilted plane varies depending on the setting of the machine parameters

- Programmed angular value of the B axis
- Display of the current values **I**, **K**, **U** and **W**
  - **I:** Plane reference in X
  - **K:** Plane reference in Z
  - **U:** Shift in X
  - **W:** Shift in Z



**Date and time display**



**Display of an integrated logo**

## Cycle states

The control shows the current cycle status with the cycle symbol.

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### Cycle symbols

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#### Cycle ON status

Cycle or program execution is active



#### Cycle OFF status

Cycle or program execution is not active

## Axis feed rate

**F** is the identification letter for feed data.

Depending on the setting of the **Minute feed** soft key, data is entered in:

- Millimeters per spindle revolution (feed per revolution)
- Millimeters per minute (feed per minute)

On the screen, you can tell the type of feed rate from the unit of measure in the input field.

You can change the feed value with the **feed compensation controller** (feed override) (range: 0 % to 150 %).

## Spindle

**S** is the identification letter for spindle data.

Depending on the setting of the **Constant speed** soft key, data is entered in:

- Revolutions per minute (constant speed)
- Meters per minute (constant surface speed)

The input range is limited by the maximum spindle speed. You define the speed limitation in the **TSF** dialog window or in DIN programming with the **G26** code. The speed limit remains in effect until a new speed limit value is programmed.

You can change the spindle speed with the speed compensation controller (speed override) (range: 50 % to 150 %).



- If you are machining at a constant cutting speed, the control calculates the spindle speed from the position of the tool tip. The smaller the diameter of the tip, the higher the spindle speed. The maximum spindle speed, however, is never exceeded
- The spindle symbols indicate the direction of spindle rotation as seen from the point of view of the machinist
- The spindle designation is set by the machine tool builder

### Spindle symbols (S display)



Direction of spindle rotation **M3**



Direction of spindle rotation **M4**



Spindle stop **M5**



Spindle is position-locked **M19**



C axis on spindle motor is active

### Spindle designations

H	0	1	Main spindle
1	1	2	Driven tool

## 4.4 Pocket table setup

Tool data such as length and radius, as well as further tool-specific information required by the control for executing diverse functions, are saved in the **toolturn.htt** tool table (in the **TNC:\table\** directory). In the control this tool table is designated a **tool list**.

Tools equipped in your tool carriers are saved in the **ToolAllo.tch** pocket table (in the **TNC:\table\** directory). This pocket table is made available depending on the machine and designated a turret list or magazine list.

### Machine with tool holder (Multifix)

You do not need to manage a pocket table for machines with multifix tool holders because the tool carrier only has one pocket:

- **T: Tool number** – Turret pocket number (always **T1**)
- **ID: ID no.** – Tool name (max. 16 characters)  
Select the tool ID number from the tool list.



- ▶ Press the **Tool list** soft key
- > The control opens the list.



Refer to your machine manual.

The turret, magazine and multifix tool systems can be used together on one machine.

The machine tool builder defines the number of the multifix pocket.

## Machine with turret

Press the Turret list soft key to open the list of the current turret assignment. There is a place in the table for every tool holder of the turret (and possibly Multifix). During setup, each tool (ID number) is assigned to a tool holder. In the turret list, multipoint tools are displayed with all cutting edges.

The turret list can be set up through the **TSF** menu or directly from the cycle dialogs in **Teach-in** submode:

- **T: Tool number** – Turret pocket number
- **ID: ID no.** – Tool name (max. 16 characters)  
The tool name is entered automatically.

Cursor in the **TSF** menu in the **T** input field:



- ▶ Press the **Turret list** soft key
- > After opening, the turret list can be edited.

Cursor in the **TSF** menu in the **ID** input field:



- ▶ Press the **Tool list** soft key
- > The tool list is also opened in addition to the turret list.
- > The turret can be populated with tools from the list.

In the Teach-in cycle, you program the turret pocket as a **T number**. The tool ID number is automatically entered in **ID** if a tool is assigned to the pocket.



Refer to your machine manual.  
The turret, magazine and multifix tool systems can be used together on one machine.  
The machine tool builder defines the number of the multifix pocket.

## Machine with magazine

Press the **Magazine list** soft key to open the list of the current tool carrier assignments. There is a place in the table for every tool holder. During setup, each tool (ID number) is assigned to a tool holder.

On machines with a magazine, the tool is also changed via the **TSF** menu:

- **T: Tool number** – Turret pocket number (always **T1**)
- **ID: ID no.** – Tool name (max. 16 characters)  
The tool name is entered automatically.



- ▶ Press the **Magazine list** soft key

The tools used are listed in the magazine list. The magazine can be loaded and unloaded via the **TSF** menu.



Refer to your machine manual.

The turret, magazine and multifix tool systems can be used together on one machine.

The machine tool builder defines the number of the multifix pocket.

## Filling the turret list with contents from the tool list

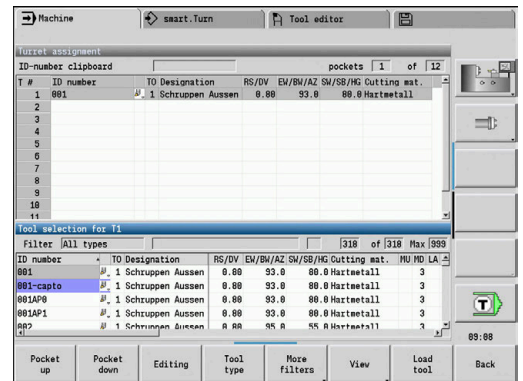
The turret list indicates the current assignments of the tool carrier. The turret list can be set up through the **TSF** menu or directly from the cycle dialogs in **Teach-in** submode.

Display the entries in the tool list in order to transfer entries from the list into the turret assignment list. The control displays the tool list in the lower area of the screen. The arrow keys are active in this list. You can move the cursor directly to a tool ID number by entering the first few letters or digits of the ID number.

Opening the turret list:



- ▶ Select **Set T, S, F** (is only selectable in **Machine** mode of operation)
- ▶ Alternative: Open the cycle dialog
- ▶ Press the **Tool list** soft key to activate the turret assignment list and the tool list
- ▶ Adapt the turret assignment list



Transferring tools from the database:

Pocket down	▶ Select the position in the turret assignment list
↓	▶ Select and sort the entries in the tool database ▶ Use the arrow keys to select the entry in the tool database
Load tool	▶ Load the selected tool into the turret assignment list

### Selecting and sorting the entries in the tool database

Tool type	The control opens the soft-key menu to select the desired tool type
More filters	The control opens the soft-key menu containing additional filter options
View	The control opens the soft-key menu containing various sorting options
Sort by ID / Type	<p>This soft key is available once you press the <b>View</b> soft key.</p> <p>Sort the tools in the displayed list as desired according to:</p> <ul style="list-style-type: none"> <li>■ Tool type</li> <li>■ Tool ID number</li> <li>■ Tool orientation</li> </ul> <p>Each time you press the soft key, it changes to the next sorting mode.</p>
Reverse sorting	<p>This soft key is available once you press the <b>View</b> soft key.</p> <p>Toggle between ascending and descending sorting</p>
Edit the tool	<p>This soft key is displayed once you press the <b>Turret list</b> soft key.</p> <p>Not active here</p>
Back	Close the tool list



## Editing the turret list

The turret assignment list indicates the current assignment of the tool carrier. When you set up a turret list, you enter the ID numbers of the tools.

The turret list can be set up through the **TSF** menu or directly from the cycle dialogs in **Teach-in** submode. You can use the arrow keys to select the desired turret pocket.

You can also set up manual changing systems in the turret assignment list.

**Further information:** "Setting up the holder for manual change systems", Page 583

Setting up the turret list:



- ▶ Select **Set T, S, F** (is only selectable in **Machine** mode of operation)



- ▶ Alternative: Initiate the cycle dialog
- ▶ Press the **Turret list** soft key to activate the turret assignment list and the tool list



- ▶ Use the arrow keys to select a turret pocket
- ▶ Adapt the turret assignment list with the soft keys
- ▶ Alternative: Enter the tool ID number directly

Entering the tool ID number directly:



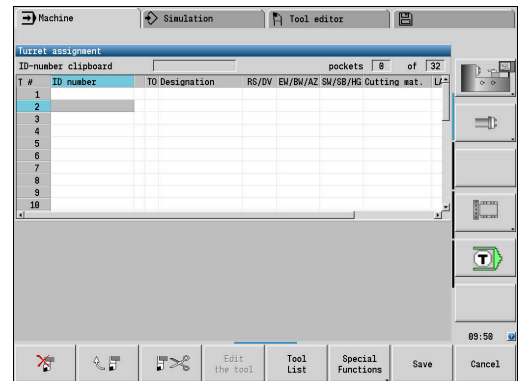
- ▶ Press the **ENT** key to activate direct input



- ▶ Enter the tool ID number
- ▶ Press the **INS** key to conclude input
















- ▶ Alternative: Press the **ESC** key to cancel input



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**Soft keys in turret list**


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	Delete entry
	Paste entry from clipboard
	Cut out entry and save it in the clipboard
	Show entries in the tool database
	Switch to next menu
	This soft key is available once you press the <b>Special functions</b> soft key. Delete the complete turret list
	This soft key is available once you press the <b>Special functions</b> soft key. Reset tool life
	This soft key is available once you press the <b>Special functions</b> soft key. Switches the tool parameter view
	This soft key is available once you press the <b>Special functions</b> soft key. Open the <b>Table of the tool holder</b>
	This soft key is available once you press the <b>Special functions</b> soft key. Deletes the tool holder from the turret assignment list
	Back by one menu level
	Load the tool number and the tool ID number into the TSF or cycle dialog
	Close the turret list without loading the tool number and tool ID number into the dialog. Changes to the turret list are retained

## Editing the magazine list

For machines with tool magazines, the magazine list indicates the current assignment of the existing magazines and tool carriers in the working space. The magazine list can be edited via the **TSF menu**.

Loading the magazine:



- ▶ Select **Set T, S, F** (is only selectable in **Machine** mode of operation)



- ▶ Select **Load magazine**



- ▶ Activate the tool list with the **Load the pocket** soft key

- ▶ Select the tool



- ▶ Select the tool with the **Load tool** soft key



- ▶ Transfer the tool to the magazine list with the **Save** soft key

Changing the tool:



- ▶ Select **Set T, S, F** (is only selectable in **Machine** mode of operation)



- ▶ Select **Tool change**



- ▶ Select the tool with the **Magazine list** soft key

- ▶ Alternative: Enter the tool ID number directly

- ▶ Change the tool with the **Save** soft key



Returning the tool to the magazine:



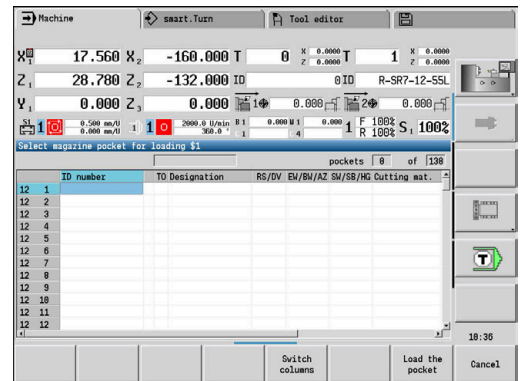
- ▶ Select **Set T, S, F** (is only selectable in **Machine** mode of operation)



- ▶ Select **Return tool to the magazine**



- ▶ Return the tool to the magazine with the **Save** soft key



Unloading the magazine:



- ▶ Select **Set T, S, F** (is only selectable in **Machine** mode of operation)



- ▶ Select **Unload magazine**



- ▶ Select the tool
- ▶ Press the **UnLoad** soft key



- ▶ Remove the tool from the magazine list with the **Save** soft key

## Tool call



Refer to your machine manual.

This function is also available on machines with a tool magazine.

The control will then use the magazine list instead of the turret list.

### Parameters for calling the tool

**T** is the identification letter for the tool holder.



Refer to your machine manual.

The designation of the tool pockets may vary depending on the machine.

Each tool holder of a tool carrier has a unique **T** number in the working space.

**ID** designates the tool ID number.



The ID number of a tool is defined when you create a tool in **Tool editor** mode of operation. Each tool has a unique **ID**.

### Variants of the tool call

- A tool holder, e.g. Multifix

The tool is called by its **ID**. The tool pocket number **T** is always **1**. The control does not maintain a turret list.

- Multiple tool holders, e.g. turret

The tool is called with **T** (turret pocket number). The ID number **ID** is shown and automatically entered in the dialogs. The control maintains a turret list.

In the turret list, multipoint tools are displayed with all cutting edges.

The parameters for calling the tool can be entered in the **TSF** dialog in **Machine** mode of operation. In **Teach-in** submode and **smart.Turn** mode of operation, **T** and **ID** are cycle parameters.



If a **T** number is entered in the **TSF** dialog with an **ID** number that is not defined in the turret list, then the turret list will be changed accordingly. The existing turret list will be overwritten.

## Driven tools

- Driven tools are defined in the tool description
- The driven tool can be operated with feed per revolution if the tool spindle drive is equipped with a rotary encoder
- If driven tools are used at a constant cutting speed, the spindle speed is calculated from the tool diameter

## Tools in different quadrants

### Example

The **principal tool carrier** of your lathe is in front of the workpiece (standard quadrant). An additional tool holder is behind the workpiece.

When the control is configured, it is defined for each tool holder whether the X dimensions and the direction of rotation of circular arcs are mirrored. In the above-mentioned example the additional tool holder is assigned the attribute **mirrored**.

If this method is used, all machining operations are programmed **as usual**—regardless of which tool holder is used for machining. The **Simulation** submode also shows all machining operations in the **standard quadrant**.

The tools are also described and dimensioned for the **standard quadrant**—even if they are inserted in the additional tool holder.

Mirroring does not become effective until the machining of the workpiece, i.e. when the additional tool holder is executing the machining operation.

## Tool life monitoring

If desired, you can have the control monitor tool life or the number of parts that are produced with a specific tool.

The tool life monitoring function adds the time a tool is used at **feed rate**. The quantity monitoring counts the number of finished parts. The count is compared with the entry in the tool data.

As soon as the tool life expires or the programmed quantity is reached, the control sets the diagnostic bit 1. This causes an error message to be issued the next time the tool is called. If no replacement tool is available, the program will be stopped.

- For teach-in programs, simple tool life monitoring is available. Here, the control informs you when a tool is worn out.
- With smart.Turn and DIN PLUS programs, you can choose between simple tool life monitoring feature or tool life monitoring with replacement tools (option 10).

If you use replacement tools, the control automatically inserts the **sister tool** as soon as the tool is worn out. The control does not stop the program run until the last tool of the tool sequence of exchange is worn out.

You can activate / deactivate the tool life management in the **lifeTime** (601801) user parameter.

The control manages the type of monitoring, the tool life/remaining tool life and the maximum number of pieces/remaining number of pieces in the diagnostic bits of the tool data. You can manage and display the diagnostic bits and the tool life in **Tool editor** mode of operation.

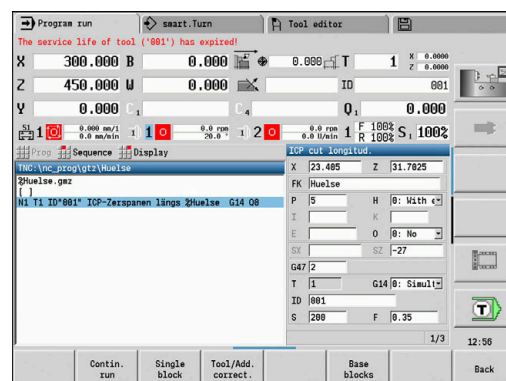
**Further information:** "Editing tool life data", Page 578



If a tool is renewed (e.g. replacement of indexable inserts), the tool life and the number of pieces must be reset in **Tool editor** mode of operation.

You can define replacement tools when setting up the tool carrier in **smart.Turn** mode of operation. The **sequence of exchange** can contain more than one sister tool. The sequence of exchange is a part of the NC program.

**Further information:** smart.Turn and DIN Programming User's Manual



### Resetting the tool life in the turret list

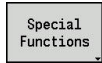
Resetting the tool life:



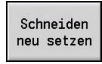
- ▶ Select **Set T, S, F** (is only selectable in **Machine** mode of operation)



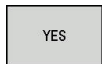
- ▶ Press the **Turret list** soft key



- ▶ Press the **Special functions** soft key



- ▶ Press the **Set teeth to new** soft key



- ▶ Press the **YES** soft key to confirm the confirmation prompt



- ▶ Press the **Back** soft key

### Resetting the tool life in the magazine list

Resetting the tool life:



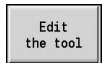
- ▶ Select **Set T, S, F** (is only selectable in **Machine** mode of operation)



- ▶ Select **Tool change**



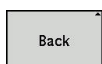
- ▶ Press the **Magazine list** soft key
- ▶ Select the tool



- ▶ Press the **Edit the tool** soft key



- ▶ Press the **New tooth** soft key



- ▶ Press the **Back** soft key



## 4.5 Machine setup

The machine always requires a few preparations, regardless of whether you are machining a workpiece manually or automatically.

In **Machine** mode of operation, you can call the following functions through the **Setup** menu item:

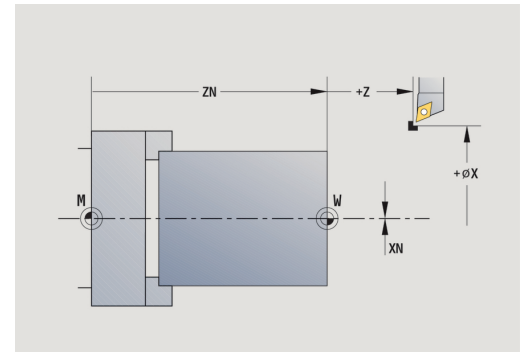
- **Set axis value** (define workpiece datum)
  - **Machine reference** (homing the axes)
- **Set protection zone**
- **Set tool change point**
- **Set C-axis values**
- **Set machine dimensions**
- **Display operating times**
- **Service**
  - **Display operating times**
  - **Tastsysteme einrichten**
  - **Adjust the system time**
  - **HEROS menu**
- **Probing**

## Defining the workpiece datum

In the dialog, the distance between the machine datum and the workpiece datum (also known as **offset**) is shown as **XN** and **ZN**. If the workpiece datum is changed, the display values will be changed accordingly.



The workpiece datum can also be set in the Z axis using a touch probe. When setting the datum, the control checks which type of tool is currently active. If you select the Workpiece datum setup function and a touch probe is inserted, the control automatically adjusts the input form. Press **NC start** to start the measuring process.



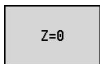
Setting the workpiece datum:



- ▶ Select **Setup**



- ▶ Select **Set axis value**



- ▶ Touch the workpiece datum (end face)
- ▶ Define this point as the workpiece datum **Z = 0**



- ▶ Alternative: Enter the distance between the tool and the workpiece datum as **Measuring pt. coordinate Z**
- ▶ The control will calculate the workpiece datum **Z**
- ▶ Alternative: Machine datum Z = workpiece datum Z (offset = 0)



- ▶ Alternative: This makes it possible to enter the datum shift directly in **ZN**



- ▶ Press the **Save** soft key

## Defining offsets

Before using datum shifts with **G53**, **G54** and **G55**, you need to define the offset values in setup mode.

Setting an offset:



- ▶ Select **Setup**



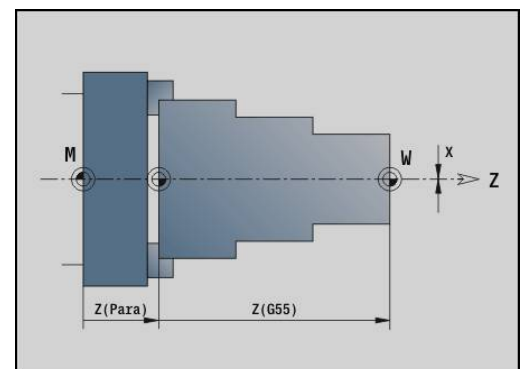
- ▶ Select **Set axis value**



- ▶ Press the **Displacement** soft key




- ▶ Press the **G53**, **G54** or **G55** soft key
- ▶ Press the **Save** soft key
- ▶ The control saves the values to a table. In this way, you can activate the offsets in the program by entering the respective **G** codes

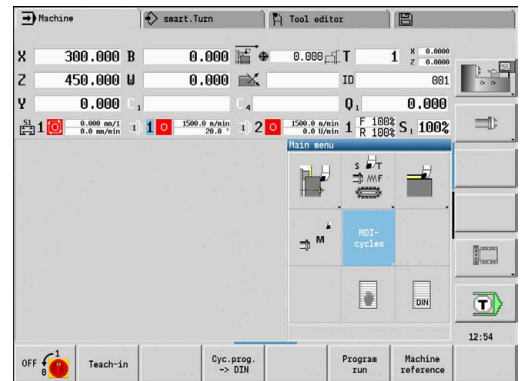


## Axis reference run

It is possible to home axes that have already been homed. Here you can select individual axes or all axes simultaneously.

Homing:

- |                   |  |
|-------------------|--|
| Machine reference | ▶ Press the <b>Machine reference</b> soft key                  |
| X                 | ▶ Press the <b>Z</b> reference and <b>X</b> reference soft key |
| All               | ▶ Alternative: Press the <b>All</b> soft key                   |
- 
- |   |                                 |
|---|---------------------------------|
|  | ▶ Press the <b>NC start</b> key |
|---|---------------------------------|
- > The control automatically traverses the reference marks.
  - > The control refreshes the position display.



## Setting the protection zone

With active protection zone monitoring, the control checks for every movement whether the **protection zone in -Z direction** would be violated. If it detects such a violation, it stops the axis movement and generates an error message.

The **Set protection zone** setup dialog shows the distance between the machine datum and the protection zone in **-ZS**.

The status of the protection zone monitoring is shown in the machine display if it has been configured by the machine manufacturer.

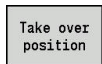
Setting the protection zone and switching off the monitoring function:



- ▶ Select **Setup**



- ▶ Select **Set protection zone**



- ▶ Move the tool with the axis keys or the handwheel until it reaches the **protection zone**
- ▶ Use the **Take over position** soft key to load this position as protection zone
- ▶ Alternative: Enter the position of the protection zone relative to the workpiece datum (**Measuring pt. coordinate -Z** field)



- ▶ Use the **Save** soft key to load the entered position as protection zone



- ▶ Alternative: Switch off protection zone monitoring



- If the **Set protection zone** input window is open, protection zone monitoring is inactive
- In DIN programming, you deactivate protection zone monitoring with **G60 Q1** and reactivate it with **G60**

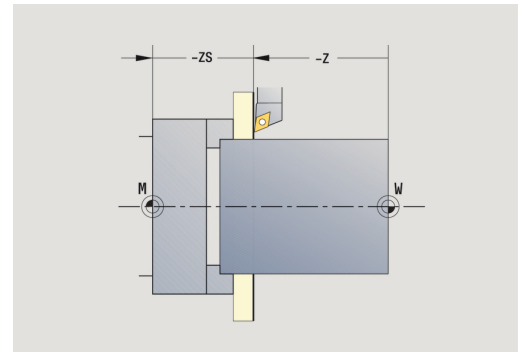
### Protection zone status



Protection zone monitoring active



Protection zone monitoring not active



## Defining the tool change position

With the cycle **Move to tool change position** or the DIN command **G14**, the slide moves to the **tool change position**. Program the tool change position far enough away from the workpiece so that the turret can rotate without collision and the tools do not damage the workpiece during tool change.

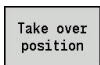
Defining the tool change position:



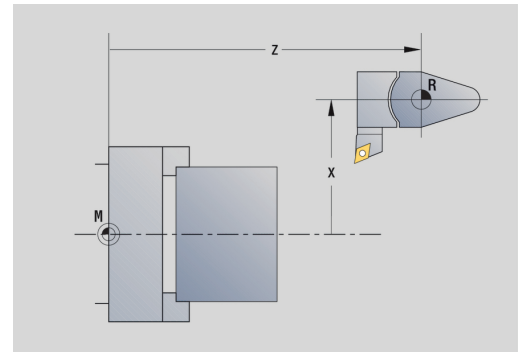
- ▶ Select **Setup**



- ▶ Select **Tool change point**



- ▶ Move to the tool change position
  - ▶ Use the axis keys or the handwheel to move the tool to the tool change position and load this position as tool change point
  - ▶ Alternative: Enter the tool change position directly
  - ▶ Enter the desired tool change position in the **X** and **Z** input fields in machine coordinates (**X** = radius dimension)



The coordinates of the tool change position are entered and displayed as the distance between the machine datum and the point of reference on the tool carrier. It is recommended that you move to the tool change position and load the position with the **Take over position** soft key.

## Setting C-axis values

The **Set C-axis values** function enables you to define a datum shift for the workpiece spindle:

- **CN: Datum shift in C axis** – Position value of the workpiece spindle
- **C: Datum shift in C axis**
- **CM: Measuring pt. coordinate** – Set current position to the defined value

Setting the datum of the C axis:



- ▶ Select **Setup**

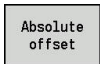


- ▶ Select **Set C-axis values**



- ▶ Position the C axis

- ▶ Define the position as the C-axis datum
- ▶ Alternative: Set the current position to the defined value



- ▶ Press the **Absolute offset** soft key

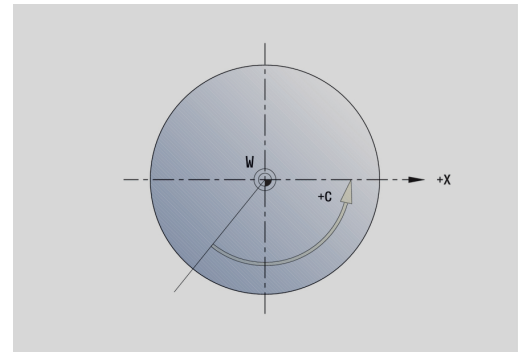
- ▶ Enter the value in the **CM** input field
- ▶ Enter the datum shift of the C axis



- ▶ Confirm your input
- ▶ The control calculates the datum of the C axis.



- ▶ Alternative: Delete the datum shift of the C axis



### Expanded form view for machines with counter spindle

If your machine is equipped with a counter spindle, the **CA** parameter is shown. The **CA** parameter enables you to specify for which workpiece spindle (main spindle or counter spindle) entries for the **Set C-axis values** function will be effective.

The active angle offset is shown in the **CV** parameter. An angle offset is activated with **G905** to match the position of main and counter spindle to each other. This may be necessary if both spindles need to be synchronized for a part transfer. The **Delete CV offset** soft key enables you to reset an active angle offset.

Additional parameters for machines with counter spindle:

- **CV: Datum shift in C axis** – active angular offset
- **CA: No. of C axis** – Selection of C axis (main spindle or counter spindle)

## Setting up machine dimensions

The **Set machine dimensions** function allows you to save any positions for use in NC programs.

Setting up machine dimensions:



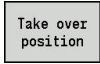
- ▶ Select **Setup**



- ▶ Select **Set machine dimensions**



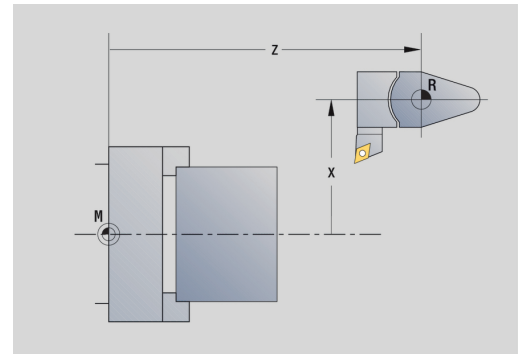
- ▶ Enter the number for the machine dimensions
- ▶ Transfer the position of a single axis as machine dimension



- ▶ Alternative: Transfer the position of all axes as machine dimensions



- ▶ Save the machine dimensions



## Setting up touch probes

For configuring and managing touch probes, the **Tastsysteme einrichten** menu is available.

To open the **Tastsysteme einrichten** menu, proceed as follows:



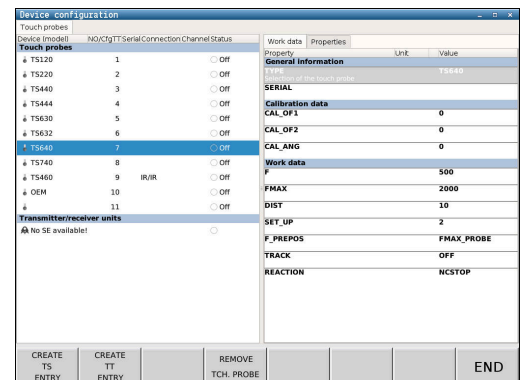
- ▶ Select **Setup**



- ▶ Select **Service**



- ▶ Select **Tastsysteme einrichten**
- ▶ The control opens the **Device configuration** window in the **Tastsysteme einrichten** menu.



The **Tastsysteme einrichten** menu includes the following items:

- **Touch probes**
- **Transmitter/receiver units**
- **Work data tab**
  - **General information**
  - **Calibration data**
  - **Work data**
- **Properties tab**
  - **Connection settings**
  - **Functions**
  - **Current IR touch probe data**

### Touch probes

Under **Touch probes**, the system displays all touch probes configured for the control.

The **Touch probes** menu item is structured as follows:

Contents	Explanation
Device (model)	Name of the touch probe
NO/CfgTT	Number in the touch probe table
Serial	Serial number of the touch probe
Connection	Connection type of the touch probe, e.g. <b>radio/IR</b>
Channel	Number of the radio channel
Status	Status of the touch probe, e.g. <b>Off</b>

### Transmitter/receiver units

Under **Transmitter/receiver units**, the system displays all transmitter/receiver units configured for the control.

### Work data tabWork data

On the **Work data** tab, you can configure default values for use with the selected touch probe.

The **Work data** tab contains the following items:

- **General information**
- **Calibration data**
- **Work data**

To open the **Work data** tab, proceed as follows:

- ▶ Open the **Tastsysteme einrichten** menu
- ▶ Select the **Work data** tab
- > The control opens the **Work data** tab.

### General information

The **General information** menu item shows information on the currently selected touch probe:

Contents	Explanation
TYPE	Selected touch probe
SERIAL	Serial number of the selected touch probe

### Calibration data

You will find the calibration data in your tool database.

**Further information:** "Length Gauges", Page 603



### Work data

The **Work data** menu item displays default values for the selected touch probe. When you program touch probe cycles, the control will use these default values.

Contents	Explanation
F	Feed rate for probing mode
FMAX	Rapid traverse in probing cycle
DIST	Maximum measuring range
SET_UP	Set-up clearance
F_PREPOS	Feed rate for pre-positioning
TRACK	Orientation of the touch probe
REACTION	Behavior in case of collision with the touch probe

### Properties tab Properties

The **Properties** tab contains further information on the status of the selected touch probe.

The **Properties** tab contains the following menu items:

- **Connection settings**
- **Functions**
- **Current IR touch probe data**

To open the **Properties** tab, proceed as follows:

- ▶ Open the **Tastsysteme einrichten** menu
- ▶ Select the **Properties** tab
- ▶ The control opens the **Properties** tab.

#### Connection settings

Under **Connection settings**, you can select the type of triggering in case of deflection or when switching the touch probe on or off:

#### Connection setting

Switching on/off	<input type="radio"/> IR	<input type="radio"/> Radio	<input type="radio"/> Mechanical
Deflection	<input checked="" type="radio"/> IR	<input type="radio"/> Radio	<input type="radio"/> Mechanical

#### Functions

Under **Functions**, you can select the transmitter unit to be triggered.

The screenshot shows the 'Properties' tab with the following settings:

- Connection settings:**
  - Switching on/off:  IR,  Radio,  Mechanical
  - Deflection:  IR,  Radio,  Radio + IR
- Functions:**
  - SE: [Dropdown menu]
  - Buttons: Touch probe on, Touch probe off, Remove the touch probe
- Current IR touch probe data:**
  - NO.: 9
  - Model: TS460
  - Status:  Off
  - Signal strength: [Text input field]
  - Deflection:  Not deflected
  - Collision:  No collision detected
  - Battery warning:  Unknown

### Current IR touch probe data

Select the **Current IR touch probe data** menu item to display an overview of the current status of the touch probe.

Under **Current IR touch probe data**, the following items are displayed:

Contents	Explanation
NO.	Number in the touch probe table
Model	Type of touch probe
Status	Touch probe active or inactive
Signal strength	Display of the signal strength in the bar chart. A full bar indicates an optimum connection.
Deflection	Stylus deflected or not deflected
Collision	Collision or no collision detected
Battery warning	Indicates the battery status; if the charge falls below the limit indicated by the vertical bar, the control displays a warning.

### Creating a new touch probe

To create a new touch probe, proceed as follows:

- ▶ Open the **Tastsysteme einrichten** menu



- ▶ Press the **CREATE TS ENTRY** soft key
- > The control creates a new touch probe entry that will be displayed under **Touch probes**.
- ▶ Add the data for the new touch probe in the menu items explained above:
  - **General information**
  - **Calibration data**
  - **Work data**
- > The touch probe will be connected.

### Removing a touch probe

To delete an existing touch probe, proceed as follows:

- ▶ Open the **Tastsysteme einrichten** menu



- ▶ Press the **Remove the touch probe** soft key
- > The control opens the **Remove touch probe?** dialog.



- ▶ Press the **Ok** soft key
- > The touch probe will be deleted.

## Suppressing touch probe monitoring

While you are using a touch probe, the **Touch probe not ready** error message might be displayed. This can have various causes.

These are the situations that may cause the **Touch probe not ready** error message to display:

- The touch probe is not connected
- The battery in the touch probe is dead
- No connection between the IR touch probe and the receiver unit

The error message immediately stops any machining operation and disables the manual axis keys. If you want to position the touch probe anyway, make sure to disable touch-probe monitoring.

### NOTICE

#### Danger of collision!

The **TCH PROBE MONITOR OFF** function suppresses the corresponding error message. In addition, the control does not perform an automatic collision check with the stylus. Because of this behavior, you must check whether the touch probe can retract safely. There is a risk of collision if you choose the wrong direction for retraction!

- ▶ Carefully move the axes in the **Machine** mode of operation

To suppress touch-probe monitoring, proceed as follows:



- ▶ Select **Setup**
- ▶ Press the **TCH PROBE MONITOR OFF** soft key
- ▶ The control disables touch-probe monitoring for 30 seconds.
- ▶ The control issues the error message **The touch probe monitor is deactivated for 30 seconds.**
- ▶ You can now position the touch probe within the working space during a period of 30 seconds.

## Calibrating the tool touch probe

The **Touch probe calibration** function enables you to determine the exact position values of the tool touch probe.

Measuring the touch probe position:



- ▶ Select **Setup**

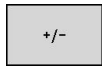


- ▶ Select **Touch Probe**

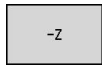


- ▶ Select **Touch probe calibration**

- ▶ Pre-position the tool for the first measuring direction



- ▶ Set the positive or negative traverse direction



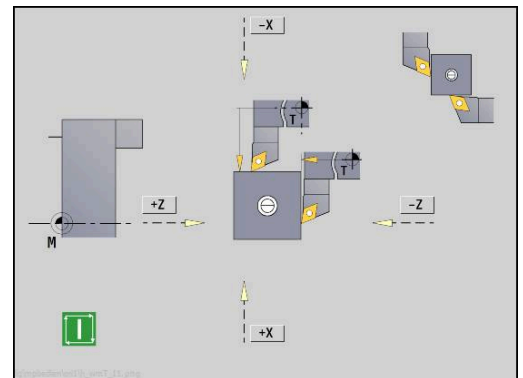
- ▶ Press the soft key for this direction (e.g. -Z direction)



- ▶ Press the **NC start** key
- ▶ The tool moves in the measuring direction.
- ▶ The position of the touch probe is measured and saved when the tool touch probe releases a trigger signal.
- ▶ The tool returns to the starting point.



- ▶ Press the **Back** soft key to terminate the calibration process
- ▶ The calibration values measured are saved.
- ▶ Pre-position the tool for the next measuring direction and repeat the procedure (max. 4 measuring directions)



## Displaying operating times

In the **Service** menu, you can view different operating times.

Operating time	Meaning
<b>Control on</b>	Operating time of the control since being put into service
<b>Machine on</b>	Operating time of the machine tool since being put into service
<b>Program run</b>	Duration of controlled operation since being put into service



Refer to your machine manual.  
Your machine tool builder can provide further operating time displays.

Displaying operating times:



- ▶ Select **Setup**



- ▶ Select **Service**



- ▶ Select **Display operating times**

## Configuring the HR 550 FS wireless handwheel

### Application

Select the **Set up wireless handwheel** menu item to configure the HR 550 FS wireless handwheel. The following functions are available:

- Assigning the handwheel to a specific handwheel holder
- Setting the transmission channel
- Analyzing the frequency spectrum for determining the optimum transmission channel
- Select transmitter power
- Statistical information on the transmission quality

### Set up wireless handwheel:



- ▶ Select **Setup**



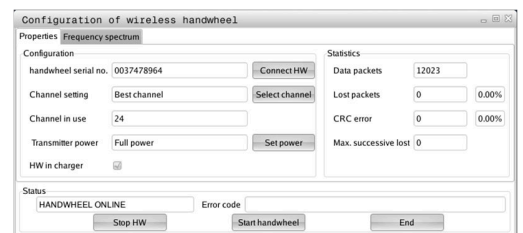
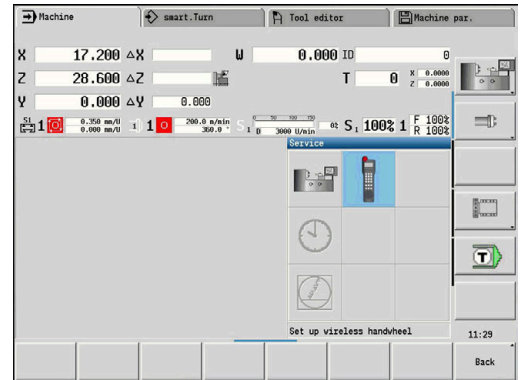
- ▶ Select **Service**



- ▶ Select **Set up wireless handwheel**

### Assigning the handwheel to a specific handwheel holder

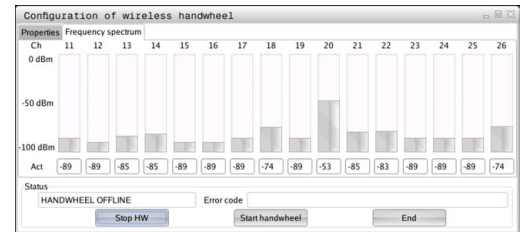
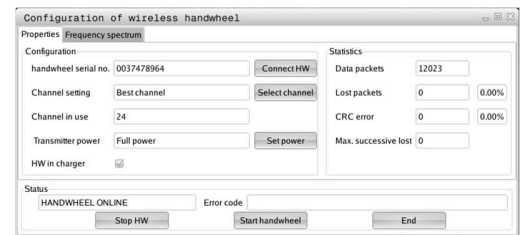
- ▶ Make sure that the handwheel holder is connected to the control hardware.
- ▶ Place the wireless handwheel you want to assign to the handwheel holder in the handwheel holder
- ▶ Select the **Setup** menu item
- ▶ Select the **Service** menu item
- ▶ Select the **Set up wireless handwheel** menu item
- ▶ Click the **Connect HW** button
- ▶ The control saves serial number of the inserted wireless handwheel and shows it in the configuration window on the left next to the **Connect HW** button.
- ▶ To save the configuration and exit the configuration menu, press the **END** button



### Setting the transmission channel

If the wireless handwheel is started automatically, then the control tries to select the transmission channel providing the best transmission signal. If you want to set the transmission channel manually, proceed as follows:

- ▶ Select the **Setup** menu item
- ▶ Select the **Service** menu item
- ▶ Select the **Set up wireless handwheel** menu item
- ▶ Click the **Frequency spectrum** tab
- ▶ Click the **Stop HW** button
- ▶ The control stops the connection to the wireless handwheel and determines the current frequency spectrum for all 16 available channels.
- ▶ Note the number of the channel with the least amount of radio traffic (smallest bar)
- ▶ Click the **Start handwheel** button to reactivate the wireless handwheel
- ▶ Click the **Properties** tab
- ▶ Click the **Select channel** button
- ▶ The controls shows all available channel numbers
- ▶ Click the number of the channel that the control has found to have the least amount of radio traffic
- ▶ To save the configuration and exit the configuration menu, press the **END** button

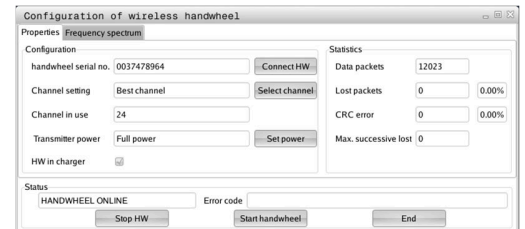


### Selecting the transmitter power



A reduction in transmission power decreases the range of the wireless handwheel.

- ▶ Select the **Setup** menu item
- ▶ Select the **Service** menu item
- ▶ Select the **Set up wireless handwheel** menu item
- ▶ Click the **Set power** button
- ▶ The control displays the three available power settings. Click the desired setting.
- ▶ To save the configuration and exit the configuration menu, press the **END** button



### Statistical data

To display the statistical data, proceed as follows:

- ▶ Select the **Setup** menu item
- ▶ Select the **Service** menu item
- ▶ Select the **Set up wireless handwheel** menu item
- > The control displays the configuration menu with the statistical data.

Under **Statistics**, the control displays information about the transmission quality.

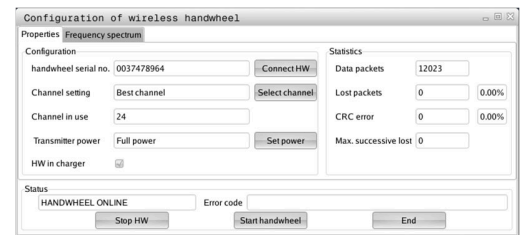
If the received signal quality is impaired and no longer ensures a perfect, safe stop of the axes, the wireless handwheel will perform an emergency stop.

The displayed value **Max. successive lost** indicates whether reception quality is poor. If the control repeatedly displays values greater than 2 during normal operation of the wireless handwheel within the desired range of use, then there is a high risk of an undesired disconnection. This can be corrected by increasing the transmitter power or by changing to another channel with less radio traffic.

If this occurs, try to improve the transmission quality by selecting another channel or by increasing the transmitter power.

**Further information:** "Setting the transmission channel",  
Page 135

**Further information:** "Selecting the transmitter power",  
Page 135





## Setting the system time

With the **Adjust the system time** function, you can set the time on your control.



You will need a mouse to navigate the **System time** input form.

Use the **Month** and **Year** soft keys to increment or decrement the respective settings.

To use an NTP server for setting the time, select a server from the server list first.

Setting the system time:



- ▶ Select **Setup**



- ▶ Select **Service**



- ▶ Select **Adjust the system time**

- ▶ Select **Synchronize the time over NTP server** (if available)

- ▶ Select **Set the time manually**

- ▶ Select **Date**

- ▶ Enter the **Time**

- ▶ Select **Time zone**

- ▶ Press the **OK** soft key



## 4.6 Tool measurement

The control supports tool calibration.

- By touch-off: The setup dimensions are determined by comparing a tool with an already measured tool
- By touch probe: Stationary or swiveling in the working space (installed by the machine tool builder)
- By optical gauge (installed by the machine tool builder)

Calibration by touch-off is always available. If a touch probe or an optical gauge is installed, select these measuring methods by soft key.

If the tool dimensions are already known, you can enter the setup dimensions directly in **Tool editor** mode of operation.



- The compensation values are deleted during tool measurement.
- Please note that for drilling and milling tools the center is measured.
- The tools' type and orientation determine how they are measured. Note the help graphics

## Touch-off

You measure the dimensions relative to a calibrated tool by touching the tool off.

Finding the tool dimensions by touch-off with the tool:

- ▶ In the tool table, enter the tool you want to measure



- ▶ Insert the reference tool and enter the tool number in the **TSF** dialog



- ▶ Turn an end face and define this coordinate as the workpiece datum

- ▶ Return to the **TSF** dialog and insert the tool to be measured

Measure tool

- ▶ Press the **Measure tool** soft key

Transfer Z

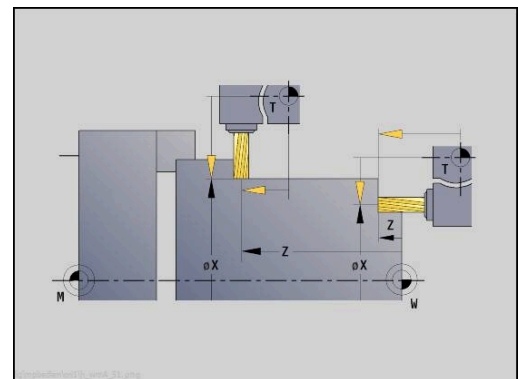
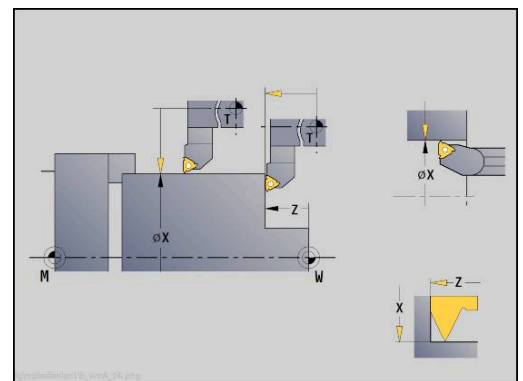
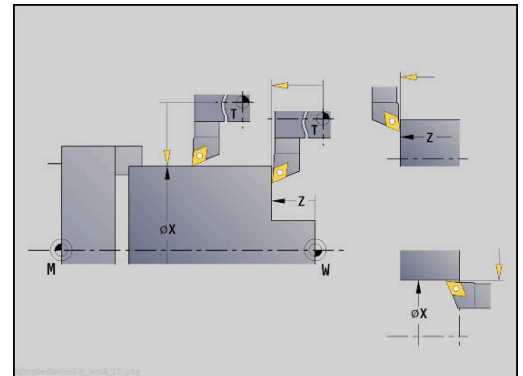
- ▶ Touch the face with the tool
- ▶ Enter the value **0** for **Measuring pt. coordinate Z** (workpiece datum) and save it

Transfer X

- ▶ Turn the measuring diameter
- ▶ Enter the diameter value as **Measuring pt. coordinate X** and save it

Save radius

- ▶ For turning tools, enter the cutting edge radius and load it into the tool table



## Touch probe (tool touch probe)



Refer to your machine manual.  
Your machine manufacturer enables this function.

Finding the tool dimensions by using a touch probe:

- ▶ In the tool table, enter the tool you want to measure



- ▶ Insert the tool and enter the tool number in the **TSF** dialog

Measure tool

- ▶ Press the **Measure tool** soft key

Measure probe

- ▶ Press the **Measure probe** soft key

+/-

- ▶ Pre-position the tool for the first measuring direction
- ▶ Set the positive or negative traverse direction

-Z

- ▶ Press the soft key for this direction (e.g. -Z direction)



- ▶ Press the **NC start** key
- > The tool moves in the measuring direction.
- > When it contacts the touch probe, the control calculates and saves the set-up dimensions.

- > The tool returns to the starting point.

- ▶ Pre-position the tool for the second measuring direction

-X

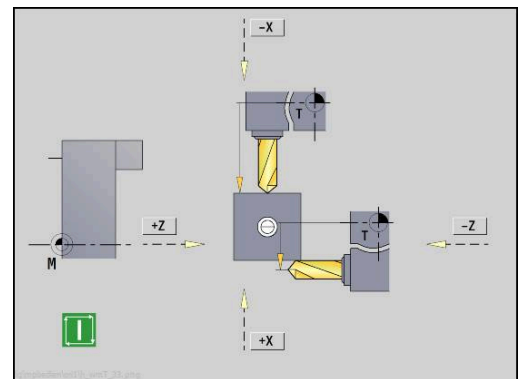
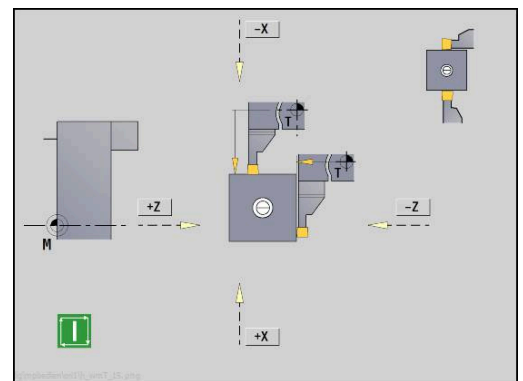
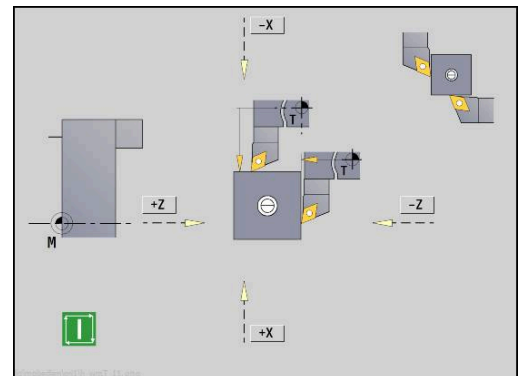
- ▶ Press the soft key for this direction (e.g. -X direction)



- ▶ Press the **NC start** key
- > The tool moves in the measuring direction.
- > When it contacts the touch probe, the control calculates and saves the set-up dimensions.

Save radius

- ▶ For turning tools, enter the cutting edge radius and load it into the tool table



## Optical gauge



Refer to your machine manual.  
Your machine manufacturer enables this function.

Finding the tool dimensions by using an optical gauge:

- ▶ In the tool table, enter the tool you want to measure



- ▶ Insert the tool and enter the tool number in the **TSP** dialog

Measure tool

- ▶ Press the **Measure tool** soft key

Measure optical

- ▶ Press the **Measure optical** soft key

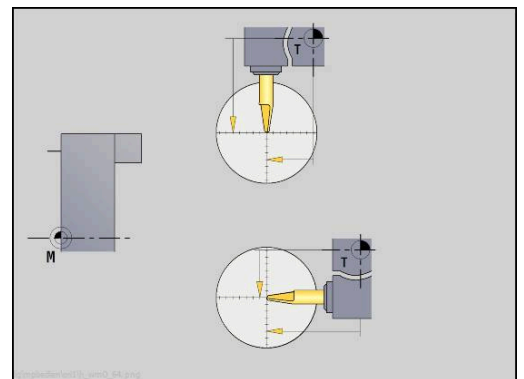
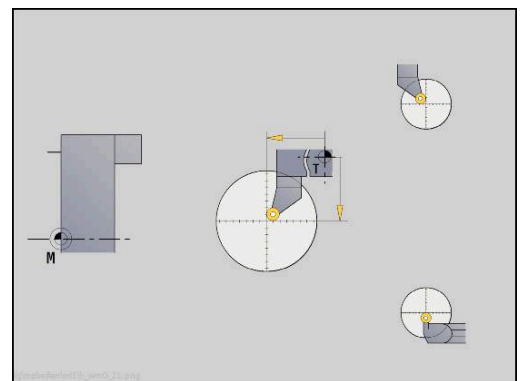
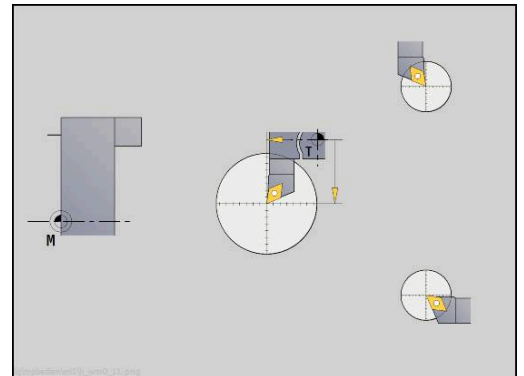
Transfer Z

- ▶ Position the tool at the cross hairs of the optical gauge by using the axis keys or the handwheel
- ▶ Save the tool dimension in Z
- ▶ Save the tool dimension in X

Transfer X

Save radius

- ▶ For turning tools, enter the cutting edge radius and load it into the tool table



## Tool compensation

The tool compensation in X and Z as well as the special compensation for recessing tools and button tools compensate for wear of the cutting edge.



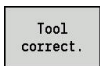
A compensation value must not exceed  $\pm 10$  mm.

You can set tool compensations with the handwheel or enter them into a dialog field.

Setting tool compensation with the handwheel:



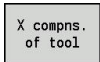
- ▶ Select **Set T, S, F** (is only selectable in **Machine** mode of operation)



- ▶ Press the **Tool correct.** soft key



- ▶ Press the **Set by handwheel** soft key if required



- ▶ Press the **X comps. of tool** (or **Z comps.**) soft key
- ▶ Determine the compensation value with the handwheel
- ▶ The value will be displayed in the distance-to-go display.

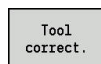


- ▶ Transfer the compensation value to the tool table
- ▶ The T display shows the new compensation value.
- ▶ The distance-to-go display is cleared.

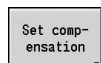
Defining tool compensation:



- ▶ Select **Set T, S, F** (is only selectable in **Machine** mode of operation)



- ▶ Press the **Tool correct.** soft key



- ▶ Press the **Set compensation** soft key if required

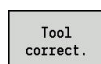


- ▶ Transfer the compensation value to the tool table
- ▶ The T display shows the new compensation value.
- ▶ The distance-to-go display is cleared.

Deleting tool compensation values:



- ▶ Select **Set T, S, F** (is only selectable in **Machine** mode of operation)



- ▶ Press the **Tool correct.** soft key



- ▶ Press the **Delete** soft key



- ▶ Delete compensation value in X (or Z)

## 4.7 Manual operation

When **machining a workpiece manually**, you move the axes with the handwheel or manual direction keys. You can also use Teach-in cycles for machining more complex contours (semi-automatic mode). The paths of traverse and the cycles, however, are not **stored**.

After switch-on and homing, the control is in **Machine** mode of operation. This mode remains active until you select the **Teach-in** submode or the **Program run** submode. "Machine" displayed in the header indicates that you are in **Manual mode**.



Define the workpiece datum and enter the machine data before you start machining.

### Tool change

Enter the tool number of the tool ID number in the **TSF** dialog. Check the tool parameters.

**T0** does not define a tool. This also means that it does not contain any data on tool length, cutting radius, etc.

### Spindle

Enter the spindle speed in the **TSF** dialog. To start and stop spindle rotation, press the spindle keys on the machine operating panel. The **Stopping angle A** in the **TSF** dialog makes the spindle always stop at this position.



Refer to your machine manual.

The maximum executable spindle speed varies depending on the machine. It may differ significantly from the maximum programmable spindle speed.

The machine tool builder defines the maximum executable spindle speed in the machine parameters.



## Handwheel operation



**Further information:** Refer to your machine manual

## Manual direction keys

With the manual direction keys, you can move the axes at the programmed feed rate or at rapid traverse. Enter the feed rate in the **TSF** dialog.



- **Feed rate**
  - If the **spindle is rotating**: Feed per revolution [mm/rev]
  - If the **spindle is not rotating**: Feed per minute [m/min]
  - Feed rate at **rapid traverse** : Feed per minute [m/min]

## Teach-in cycles in Machine mode of operation

- ▶ Set the spindle speed
- ▶ Set the feed rate
- ▶ Insert the tool, define the tool number and check the tool data (**T0** is not permitted)
- ▶ Approach the cycle start point
- ▶ Select the cycle and enter the cycle parameters
- ▶ Graphically check the cycle run
- ▶ Run the cycle



The entries last made in a cycle dialog remain in memory until a new cycle is selected.

## 4.8 Teach-in submode

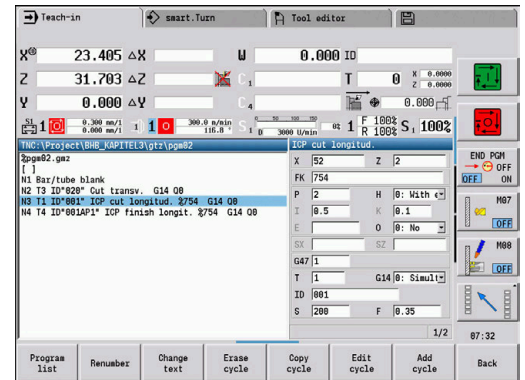
### Teach-in submode

In **Teach-in** submode, you machine a workpiece step by step with the help of teach-in cycles. The control **memorizes** how the workpiece was machined and stores the machining steps in a cycle program, which you can call up again at any time. The **Teach-in** submode can be switched on with the **Teach-in** soft key; the header informs you that it is active.

Each Teach-in program is given a name and a short description. The individual cycles of a cycle program are listed as blocks and are numbered in ascending order. The block number has no meaning for the program run. The cycles are run after each other. When the cursor is located on a cycle block, the control displays the cycle parameters.

The cycle block contains:

- Block number
- Tool used (number and tool ID number)
- Cycle name
- Number of the ICP contour or of the DIN subprogram (after the % character)



## Programming Teach-in cycles

When creating a new Teach-in program, you program each cycle in the following sequence of actions **Enter – Simulate – Execute – Save**. The individual cycles form the cycle program.

You can change Teach-in programs by simply editing the necessary cycle parameters, and delete or add cycles as required.

When you exit the **Teach-in** submode or switch off the machine, the Teach-in program is kept. When you call an ICP cycle, the control displays a soft key for switching to the ICP contour editor.

**Further information:** "ICP editor submode in Teach-in", Page 427

You can program DIN subprograms in the smart.Turn editor and then integrate them into a DIN cycle. To open the smart.Turn editor, either use the **Edit DIN** soft key when you select the DIN cycle, or using the operating-mode key.

---

### Soft keys

---

Program list	Switch to the <b>select cycle programs</b> function
Renumber	Renumber the block numbers of the cycles
Change text	Enter / edit the program description
Erase cycle	Delete the selected cycle
Copy cycle	Copy the cycle parameters into a buffer memory Example: Copy the parameters of the roughing cycle to the finishing cycle
Insert	This soft key is available once you press the <b>Copy cycle</b> soft key. Insert copied data from the buffer
Edit cycle	Change the cycle parameter or cycle mode. The cycle type, however, cannot be changed.
Add cycle	Insert a new cycle below the highlighted block

## 4.9 Program run submode

### Loading a program

In **Program run** submode, you use teach-in programs, DIN programs or automatic jobs for parts production. You cannot change the programs in this mode. The **Simulation** submode, however, allows you to check the programs before you run them. The control also offers the Single block and the Continuous run modes with which you can **machine step by step** the first workpiece of a whole batch.

The smart.Turn programs are saved as DIN programs (\*.nc). Automatic jobs (\*.job) are also generated in **smart.Turn** mode of operation.

By default, **Program run** submode automatically loads the most recently used program. Use machine parameter 601814 to specify that the program will not be selected automatically.

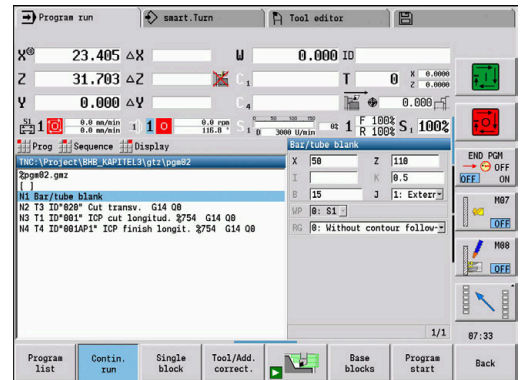
To load another program, proceed as follows:

- |              |   |
|--------------|---|
| Program list | ▶ Press the <b>Program list</b> soft key      |
| DIN          | ▶ The control displays the teach-in programs. |
| Open         | ▶ Alternative: Display the <b>DIN</b> program |
|              | ▶ Select the Teach-in program or DIN program  |
|              | ▶ Press the <b>Open</b> soft key              |

You can start a Teach-in or smart.Turn program at any desired block to resume a machining operation after an interruption (Start blk search).

The **Program run** submode can be switched on by soft key; the header informs you that it is active.

**Further information:** "Program management", Page 170



Programs selected in **Program run** submode are protected from deletion.

To enable the file for deletion, exit the program block display by pressing the **Back** soft key.

## Comparing tool lists

While a program is being loaded, the control compares the current turret assignment list with the tool list of the program. If tools are used in the program that are not in the current turret list or are located in another pocket, an error message is displayed.

After the error message has been confirmed, the program-dependent tool list is shown for checking.

You can overwrite the current turret assignment list with the **Load tool** soft key. If you press the **Cancel** soft key, the program cannot be started. The tool list of the program must match the current turret assignment list.

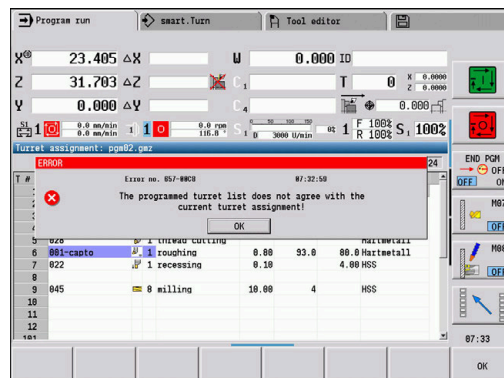
### NOTICE

#### Danger of collision!

If you press the **Load tool** soft key, the current turret assignment list will be overwritten completely and irreversibly with the tool list of the program. The lists will then not be compared again for whether they match. There is a danger of collision during subsequent machining operations!

- Check the turret assignment list manually after it has been overwritten

**i** This function is also available on machines with a tool magazine. The control uses the magazine list instead of the turret list.



## Before executing a program

### Faulty programs

The control checks the programs during loading up to the **MACHINING** section. If it detects an error (for example, an error in the contour description), it displays the error symbol in the header. You can then press the **Info** key for detailed information on the error. The machining section of a program, and therefore all traverse, is not interpreted until after **NC start**. If there is an error here, the machine stops with an error message.



Checking the NC programs in **Simulation** submode helps you to find programming errors or syntax errors in time before actual machining.

- **Checking the cycles and cycle parameters:** The control displays the Teach-in/DIN program in the list window. With Teach-in programs, the parameters of the cycle that is highlighted are displayed.
- **Graphic verification:** The program run can be verified in **Simulation** submode

**Further information:** "Simulation submode", Page 538

## Block scan



Refer to your machine manual.  
This function must be set up by your machine manufacturer.



Block scan (mid-program startup) is not available for **Reference machining** operations required during **load monitoring** (option 151).



Block scan (mid-program startup) is not available for non-circular turning with a coupled spindle (option 135, Synchronizing Funct.). Select an NC block before or after the non-circular turning program section.

Mid-program startup means starting an NC program at a selected point. In smart.Turn programs, you can start the program at any NC block.

The control starts program run from the cursor position. The starting position is not changed by a previous graphic simulation.



In the **execNextStartBlock** machine parameter (601810), you can define whether program run after a block scan will start at the selected NC block or at the subsequent NC block.

**NOTICE****Danger of collision!**

The control brings the machine into the situation in which it would be in a normal program run just before the startup block (e.g. previous tool or previous tilting situation). There is a danger of collision during the tilting movement and the rotation!

- ▶ Pre-position the slide so that the tool carrier (e.g. turret) can tilt without collision
- ▶ Pre-position the slide so that the axes are able to move to the last programmed position before reentry without collision

HEIDENHAIN recommends starting at an NC block immediately after a **T** command.

The control restores the previous machine situation by proceeding in the following sequence:

- Insert the tool
- Position the axes in the configured or selected sequence
- Switch the spindle on

Soft key	Function
Search backwards	Search backward for soft key information, e.g. <b>Next T</b> Backward search will remain enabled until you disable it.
Next UNIT	Jump to the next UNIT
Next T	Jump to the next tool call
Next L	Jump to the next subprogram call
Find text	Jump to the next occurrence of the text entered
Program start	Jump to the machining start at the beginning of the program




## Program execution

The selected Teach-in or DIN program is executed as soon as you press **NC start**. You can interrupt machining at any time by pressing **NC stop**.

During program run, the cycle (or DIN block) that is currently being run is highlighted. With Teach-in programs, the parameters of the cycle currently being run are displayed in the input window.

You can influence the program run with the soft keys listed in this table.

### Soft keys

Program list	Select the Teach-in program or smart.Turn-program
Contin. run	Teach-in program: <ul style="list-style-type: none"> <li>■ <b>On</b>: Cycles are run continuously, one after the other, up to the next tool change to be acknowledged</li> <li>■ <b>Off</b>: Stop after every cycle. Start the following cycle with <b>NC start</b></li> </ul> smart.Turn program: <ul style="list-style-type: none"> <li>■ <b>On</b>: Program execution without any interruption</li> <li>■ <b>Off</b>: Stop before <b>M01</b> command</li> </ul>
Single block	<ul style="list-style-type: none"> <li>■ <b>On</b>: Stop after every traverse path (basic block). Start the next path with <b>NC start</b> (Recommendation: Single block should be used together with the basic-block display)</li> <li>■ <b>Off</b>: Cycles / DIN commands are executed without any interruption</li> </ul>
Tool/Add. correct.	Input of tool compensation values or additive compensation values <b>Further information:</b> "Entering compensation values during program run", Page 158
	Activate the <b>Simulation</b> submenu
Base blocks	<ul style="list-style-type: none"> <li>■ <b>On</b>: The traversing and switching commands are shown in <b>DIN format</b> (basic blocks)</li> <li>■ <b>Off</b>: Teach-in or DIN program is displayed</li> </ul>
Program start	For DIN programs, the soft key will be available once you pressed the <b>Start blk search</b> soft key. The cursor goes to the first block of the Teach-in program or DIN program
Start blk search	Enables you to enter into an NC program at a selected point <b>Further information:</b> "Block scan", Page 151

### No.pieces



Refer to your machine manual.

This function must be enabled and adapted by the machine tool builder.

You can predefine the number of pieces to be machined. The control will then run the program until the specified quantity is reached.

Defining the value for No.pieces:



- ▶ Select the **Flow** menu item



- ▶ Select the **No.pieces** menu item
- ▶ The control opens the **No.pieces** form.

Cycle parameters:

- **MP: Default unit quantity**
- **P: Actual unit quantity**

With the **Delete qty. parts** soft key, you can reset the workpiece counter.

### Skip level

Before you can set and activate skip levels, you need to define them in the program.

**Further information:** smart.Turn and DIN Programming User's Manual

Setting a Skip level:



- ▶ Select the **Flow** menu item



- ▶ Select the **Skip level** menu item
- ▶ The control opens the **Set the skip level** form.

Cycle parameters:

- **NR: Skip levels**

If you enter the value **2** in the **NR** parameter and press the **Save** soft key, the control sets and activates the skip level 2 and refreshes the display field. Furthermore, the next time the program is run, the NC blocks defined by the set or active skip level will not be executed by the control.

**Further information:** "Machine data display", Page 102



You can set and activate more than one skip level at a time by entering a string of numerals in the **NR** parameter. The entry **159** sets/activates the skip levels 1, 5 and 9.

To deactivate the skip levels, program the **NR** parameter without a value and press Save.

When setting and activating skip levels during program run, please remember that the control will respond with a delay due to the block scan.

## Variables



Refer to your machine manual.

This function must be enabled and adapted by the machine tool builder.

In **Program run** submenu, it is possible to display and edit the variables defined in the **PROGRAM HEAD** program section.

**Further information:** smart.Turn and DIN Programming User's Manual

Displaying or hiding Variables:



- ▶ Select the **Flow** menu item



- ▶ Select the **Variables** menu item



- ▶ Select the **Output on** menu item
- > The **Variables** pop-up window is displayed.



- ▶ Alternative: Select the **Output off** menu item
- > The **Variables** pop-up window is hidden.

Changing Variables:



- ▶ Select the **Flow** menu item



- ▶ Select the **Variables** menu item



- ▶ Select the **Change** menu item
- > If the **Variables** pop-up window has not been visible, it will be displayed now.
- > You can now change the variables as desired.



Please note that you can only change variables while the program is not running (not started yet or stopped).

## Automatic job

### Automatic job

In **Program run** submode, the control can execute several main programs in succession without you needing to reselect and start these programs. For this purpose, create a program list (automatic job) in **smart.Turn** operating mode that is then run in **Program run** submode.

Specify a quantity for each main program in the list that defines how often this program is carried out before the next NC program is started. With job selection, you can specify an NC program from which the job is to be processed.

If the automatic job was interrupted under the following conditions, the control will save the interrupted program and the number of pieces already machined:

- **NC stop**
- Emergency stop
- Power failure



Programming notes:

- Automatic jobs (\*.job) can only be created in the default directory. The NC programs used for the job, however, can be stored in any project directories.
- If the program list should be processed without intervention, the listed main programs must be exited with **M99**.
- **M30** stops the automatic job. With the **NC start** key, you can resume the automatic job.

Selecting a job:



- ▶ Select the **Prog** menu item



- ▶ Select the **Job selection** menu item



- ▶ Select **Automatic job**
- ▶ Press the **Open** soft key



- ▶ Select the start program with the cursor if necessary



- ▶ Confirm with the **Take over job** soft key

Resuming a job after an interruption:

- ▶ Select the interrupted job



- ▶ Press the **Interrupt program** soft key
- > The control marks the interrupted program.
- > The control sets the workpiece counter to the number of pieces already machined.



- ▶ Press the **NC start** key

Changing the job display:

- ▶ The desired job must have been selected
- ▶ The cursor is located at the selected program to be started



- ▶ Select the **Display** menu item



- ▶ Select the **Switch off job list** menu item
- > This menu item switches to the NC program display.



- ▶ Alternative: Select the **Switch on job list** menu item
- > This menu item switches to the job display.

## Entering compensation values during program run

### Tool compensation

Entering tool compensation:

Tool/Add.  
correct.

- ▶ Press the **Tool/Add. correct.** soft key

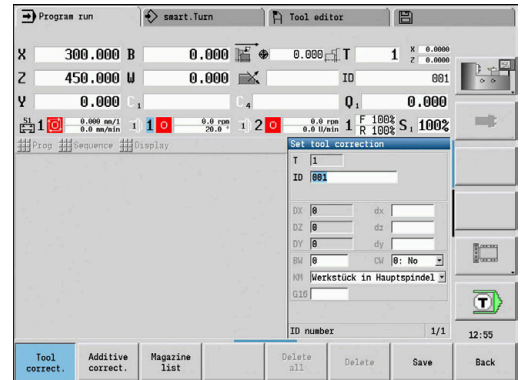
Tool  
correct.

- ▶ Press the **Tool correct.** soft key
- ▶ Enter the tool number or select a tool from the tool list
- ▶ Enter the compensation values
- ▶ Press the **Save** soft key
- ▶ The valid compensation values are displayed in the input window and adopted

Save






- Entered values are added to the existing compensation values and are immediately effective in the display. The control moves in the compensation direction by the compensation value in the following traverse block
- To delete a compensation, enter the current compensation value with the opposite algebraic sign






### Additive compensation

The control manages 16 additive compensation values. You can edit the compensation values in **Program run** submenu and activate them with **G149** in a smart.Turn program or in ICP finishing cycles.





Entering additive compensation:

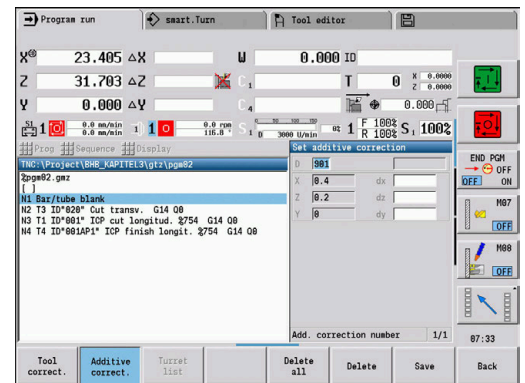
-  ▶ Press the **Tool/Add. correct.** soft key
-  ▶ Press the **Additive correct.** soft key
- ▶ Enter the number of the additive compensation
- ▶ Enter the compensation values
-  ▶ Press the **Save** soft key
- ▶ The valid compensation values are displayed in the input window and adopted

Reading additive compensation:

-  ▶ Press the **Tool/Add. correct.** soft key
-  ▶ Press the **Additive correct.** soft key
- ▶ Enter the number of the additive compensation
- ▶ Place the cursor in the next input field
-  ▶ The control displays the valid compensation values

Deleting additive compensation:

-  ▶ Press the **Tool/Add. correct.** soft key
-  ▶ Press the **Additive correct.** soft key
- ▶ Enter the number of the additive compensation
-  ▶ Press the **Delete** soft key
- ▶ Press the Delete soft key—the values of this compensation are deleted
-  ▶ Alternative: Press the **Delete all** soft key
- ▶ All compensation values will be deleted



- Entered values are added to the existing compensation values and are immediately effective in the display. The control moves in the compensation direction by the compensation value in the following traverse block
- The compensation values are saved in an internal table and are available in any program
- Delete all additive compensation values when you set up the machine again

## Program execution in dry run mode

The dry run mode is used for fast program execution up to a point at which machining is to resume.

The following requirements must be met before starting a dry run:

- The control must be prepared by the machine tool builder for dry run. (The function is usually activated with a keylock switch or a key)
- The **Program run** submode must be activated

When dry run is activated, the spindle status and the spindle speed are **frozen**.

### NOTICE

#### Danger of collision!

In dry run mode, the control performs all movements (except thread cuts) at rapid traverse. There is an increased danger of collision during dry run mode!

- ▶ Use the dry run mode only for **air cuts**
- ▶ Reduce the feed rate with the override potentiometer if necessary

After deactivation of dry run mode, the control returns to the programmed feed rates and the programmed spindle speed.



## 4.10 Load monitoring (option 151)



Refer to your machine manual.  
This function must be set up by your machine manufacturer.



The following steps are required before you can use the load monitoring feature in **Program run** submode:

- Define the respective machine parameters in the System section  
**Further information:** "List of machine parameters", Page 616
- In **smart.Turn** operating mode, define the type of load monitoring with **G996** and the monitoring zone with **G995** in your program  
**Further information:** smart.Turn and DIN Programming User's Manual

During a machining operation with active load monitoring, the control compares the current utilization of the drives specified by **G995** with the respective limit values. To calculate the limit values for a monitoring zone defined with **G995**, the control uses reference values determined during reference machining as well as predefined factors specified in the machine parameters.

If the utilization limit 1 or the utilization sum limit is exceeded, the control issues a warning and sets the corresponding diagnostic bits in **Tool editor** mode of operation in order to identify the active tool as **worn-out**.

If the utilization limit 2 is exceeded, the control issues an error message, stops the machining operation and sets the corresponding diagnostic bits in **Tool editor** mode of operation in order to identify the active tool as **broken**.

You can manage the diagnostic bits in **Tool editor** mode of operation.

**Further information:** "Diagnostic bits", Page 579



If tool life monitoring is active, the control will automatically insert a predefined replacement tool during the next tool call in order to replace the tool that has been flagged as **worn-out** or **broken**. As an alternative to the automatic evaluation of the diagnostic bits by the tool life monitoring function, you can also evaluate the diagnostic bits in your program.



Keep in mind that load monitoring is not possible for hanging axes without counterweight!



Note that load monitoring only works to a limited extent if the load changes are small. Therefore, monitor the drives that are subjected to significant loads, such as the main spindle.



When face turning with a constant surface speed, remember that the load monitoring feature will monitor the spindle up to a maximum of 15 % of the nominal acceleration defined in the machine parameters. Since acceleration increases as a result of the change in rotational speed, the control only monitors the period after the first cut!



The load monitoring function compares current utilization values with maximum limit values. For proper comparison, the utilization values must not be too low. Since the utilization depends on the cutting conditions, the following example is provided for your guidance. It illustrates the required values for the machining of steel:

- **Longitudinal turning:** Cutting depth > 1 mm
- **Recessing:** Cutting depth > 1 mm
- **Drilling into solid material:** Hole diameter > 10 mm

## Reference machining

During reference machining, the control determines the maximum utilization and the total utilization (utilization sum) for each monitoring zone. The determined values are used as reference values. To calculate the limit values for a monitoring zone, the control uses the determined reference values and the predefined factors specified in the machine parameters.










During reference machining, the block scan feature is not available.



Perform reference machining under the conditions in which the parts will later be produced, for example, with respect to feed rates, spindle speeds, and the type and quality of the tools you will be using.

Reference machining:

- 
  - ▶ Select the **Program run** submode and open the NC program
- 
  - ▶ Activate load monitoring: Select the **Sequence** menu item
- 
  - ▶ Select the **Load monitoring ON** menu item
- 
  - ▶ Select reference machining: **Sequence** menu
- 
  - ▶ Select the **Reference machining** menu item
  - ▶ The control shows the title bar with a green background.
- 
  - ▶ Start reference machining: Press the **NC start** key
  - ▶ The control executes the machining operation and saves the reference data to a separate file.
  - ▶ After the successful completion of reference machining, the control displays an information message.
- 
  - ▶ Press the **OK** soft key



Program **M30** or **M99** to conclude reference machining. If the program is aborted during machining, no reference data is saved. In this case you need to execute reference machining again.



Reference machining must be repeated if you make any changes to your program; for example:

- Defining new zones
- Deleting existing zones
- Changing zone numbers
- Changing, adding or removing axes within a zone
- Changing feed rates or spindle speeds
- Changing tools
- Changing cutting depth values

## Checking the reference values

After the successful completion of reference machining, check the determined reference values.



The load monitoring function compares current utilization values with limit values. For proper comparison, the reference values for utilization must not be too low. Check the determined values and, if required, remove monitored axes with a utilization rate of less than 5 % from the monitoring zone.

Meanings of the values:

- **Utilization:** Determined drive torque relative to the rated torque of the drive in [%]
- **Utilization sum:** Sum of the utilization values in the monitoring zone in [%\*ms]

Opening the reference values:



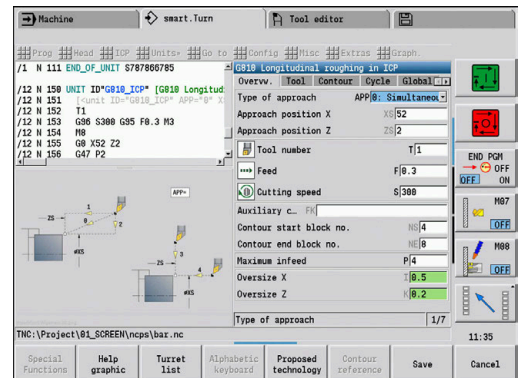
- ▶ Select the **Display** menu item



- ▶ Select the **Edit load data** menu item
- ▶ The control opens the **Set load data** form containing the parameters listed below. In addition, the determined values are displayed as a bar graph

Cycle parameters:

- **ZO: Zone number** – Number of the monitoring zone
- **AX: Axis name** – Monitored axis
- **CH: Channel no.** – selected channel
- **T: Tool pocket** of the active tool in the monitoring zone
- **ID: ID no.** – Name of the active tool in the monitoring zone
- **P: Utilization** – Maximum utilization during reference machining
- **PA: Utilization** – Maximum utilization during the current machining operation
- **PG1: Limit value** – Utilization limit 1
- **PG2: Limit value** – Utilization limit 2
- **W: Utilization sum** during reference machining
- **WA: Utilization sum** during the current machining operation
- **WGF: Limit value factor** – Factor for the limit of the utilization sum



Bar graph:

- Thick upper bar (display in %):
  - **green**: Range up to maximum **UtilizationP** during reference machining
  - **Yellow**: Range up to utilization limit-1 (**PG1**)
  - **Red**: Range up to utilization limit 2 (**PG2**)
  - **Magenta**: Maximum utilization during last machining operation (**PA**)
- Thin lower bar (display standardized to reference value 1):
  - **Green**: Range up to maximum utilization sum during reference machining (**W**)
  - **Yellow**: Range up to limit of the utilization sum (**WGF**)
  - **Magenta**: Maximum utilization sum during last machining operation (**WA**)



After reference machining, the value **W** equals **WA** and the value **P** equals **PA**. They are used as the reference values for calculating the limit values.

## Adapting the limit values

After successful reference machining, the control uses the reference values and the predefined factors specified in the machine parameters to calculate the limit values.

You can adapt the calculated limit values as required for the subsequent production.

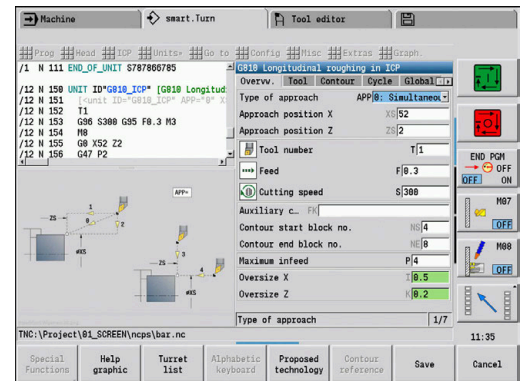
Adapting the limit values:



- ▶ Display the limit values: Select the **Display** menu item



- ▶ Select the **Edit load data** menu item
- ▶ The control opens the **Set load data** form
- ▶ Check the limit values
- ▶ If required, adapt the parameters **PG1**, **PG2** or **WGF**



Be sure to adapt the correct limit values. First, press the **Next zone** and **Next axis** soft keys to select the form containing the limit values you want to change! As an alternative, you can use the selection lists of the **ZO** and **AX** parameters to select the correct form. Save the changes separately for each axis by pressing the **Save** soft key!



Reference machining does not have to be repeated after adapting the limit values. You can continue production with the adapted limit values.

## Using load monitoring during production



Keep in mind that you cannot adapt the limit values during machining. Adapt the limit values before starting a machining operation.

During **Program run** submode, the control monitors the utilization and the utilization sum in each interpolator cycle. In parallel with machining, you can display a graph of the current utilization values for all monitored axes of the active zone.

Opening the graph during machining:



Displaying the utilization values:

- ▶ Select the **Display** menu item
- ▶ Select the **Edit load data** menu item
- ▶ The control opens the **Set load data** form and additionally displays the determined values as a bar graph



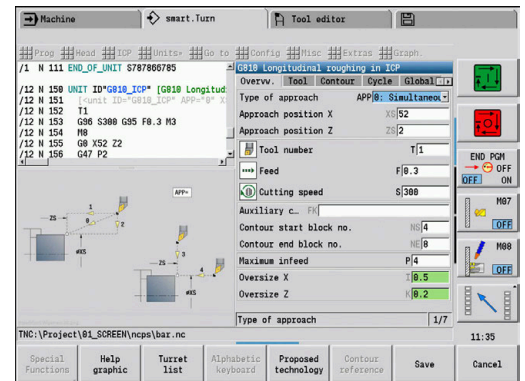
Displaying the current utilization values:

- ▶ Press the **Show active zone** soft key
- ▶ The control automatically switches to the current monitoring zone and displays the current utilization values as a bar graph

Show active zone

Bar graph:

- Thick upper bar (display in %):
  - **Green**: Current utilization (**PA**)
- Thin lower bar (display standardized to reference value 1):
  - **Green**: Current peak value between 0 and limit value 1 (**P**)
  - **Yellow**: Current peak value between P and limit value 1 (**PG1**)
  - **Red**: Current peak value between PG1 and limit value 2 (**PG1**)
- Thin lower bar (display standardized to reference value 1):
  - **Green**: Current utilization sum (**WA**)
  - **Yellow**: Current utilization sum up to the limit value (**WGF**)





## 4.11 Graphic simulation

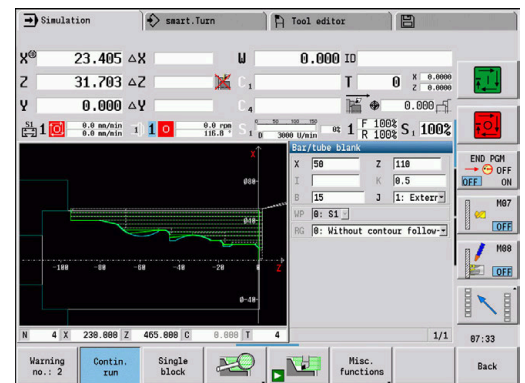
The **Simulation** submode enables you to check the machining sequence, the proportioning of cuts and the finished contour before actual machining.

In **Machine** mode of operation and **Teach-in** submode, this function simulates the execution of a single teach-in cycle—in **Program Run** submode it simulates a complete teach-in program or DIN program.

A programmed workpiece blank is displayed in **Simulation** submode. The control also simulates machining operations that are executed with a traversable spindle or the C axis on the face or lateral surface. This allows you to check the complete machining process.

In **Machine** operating mode and **Teach-in** submode, the teach-in cycle you are currently processing is simulated. In **Program run** submode the simulation starts from the cursor position. smart.Turn and DIN programs are simulated from the beginning of the program.

**Further information:** "Simulation submode", Page 538



## 4.12 Program management

### Program selection

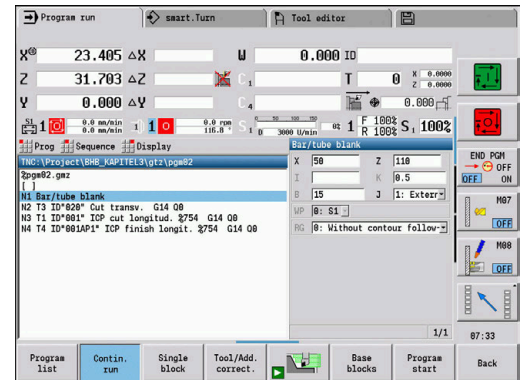
By default, **Program run** submode automatically loads the most recently used program. Use machine parameter 601814 to specify that the program will not be selected automatically.

In the program selection, the programs available in the control are listed. Select the desired program or use the **ENT** key to go to the **File name** input field. In this input field, you limit the selection or enter the program name directly.

- Program list** ▶ Press the **Program list** soft key: Use the soft keys for selecting and sorting the programs

### Soft keys in the program selection dialog

<b>DETAILS</b>	Display the file attributes: <ul style="list-style-type: none"> <li>■ Size</li> <li>■ Date</li> <li>■ Time</li> </ul>
<b>DIN</b>	Switch between Teach-in and DIN/smart.Turn programs
<b>File manager</b>	Open the file management soft-key menu <b>Further information:</b> "File manager", Page 172
<b>Sorting</b>	Open the sorting functions soft-key menu
<b>Project</b>	Open the project management soft-key menu <b>Further information:</b> "Project management", Page 173
<b>Alphabetic keyboard</b>	Open the alphabetic keyboard <b>Further information:</b> "Alphabetic keyboard", Page 63
<b>Open</b>	Open the program for the automatic start
<b>Cancel</b>	Close the program selection dialog. The program previously active in <b>Program run</b> submode remains effective



---

**Soft keys for sorting functions**

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DETAILS	Display the file attributes: <ul style="list-style-type: none"><li>■ Size</li><li>■ Date</li><li>■ Time</li></ul>
Sort by file name	Sort the programs by file name
Sort by size	Sort the programs by file size
Sort by date	Sort the programs by change date
Update	Update the marked program
Reverse sorting	Reverse the sorting direction
Open	Open the program for the automatic start
Back	Return to program selection dialog

## File manager

With the file management functions, you can copy, delete and otherwise manipulate files. You can select the program type (teach-in, smart.Turn or DIN program) before calling the program organization.

### File manager soft keys

Paths / files	Switch between directory and file window
Cut out	Cut marked file
Copy	Copy marked file
Insert	Insert the file stored in the buffer memory
Rename	Rename marked file
DELETE	Delete the marked file following confirmation prompt; program block display must not be open in any operating mode
Back	Return to the program selection dialog

### Other soft keys

DETAILS	Display details
Mark all	Mark all files
Update	Update the marked program
Write protection	Activate/deactivate write protection for the marked program
Alphabetic keyboard	Open the alphabetic keyboard
Back	Return to the program selection dialog

## Project management

You can make your own project folder in the project management so that you can centrally manage associated files. When you create a project, a new folder is set up with the corresponding subfolder structure in the **TNC:\Project\** directory. You can save your programs, contours and drawings to the subfolders.

The **Project** soft key activates the project management. The control shows you all existing projects in a tree structure. In program management, the control also opens a soft-key menu that allows you to create, select and manage projects. To reselect the standard directory of the control, select the **TNC:\nc\_prog** folder and press the **Select std. directory** soft key.

### Soft keys project

New project	Create new project
Copy project	Copy marked project
Delete project	Delete marked project following confirmation prompt
Rename project	Rename marked project
Selection of standard	Open standard directory
Selection of PLC:	Open machine tool builder programs
Select project	Select marked project
Select std. directory	Select standard directory



You can select any project names. The subfolders (**dx**, **gti**, **gtz**, **ncps** and **Pictures**) have predefined names that must not be changed.

All existing project folders are displayed in the project management. Use the file manager to switch between subfolders.

## 4.13 Conversion into DIN format

The "Convert to DIN" function enables you to convert a Teach-in program to a smart.Turn program with the same functionality. You can then optimize, expand such a smart.Turn program, etc.

### Making a conversion

Converting into DIN format:

Cyc. prog.  
-> DIN

- ▶ Press the **Cycle program --> DIN** soft key (**main menu**)
- ▶ Select the program to be converted

Cyc. prog.  
-> DIN

- ▶ Press the **Cycle program --> DIN** soft key (**program selection menu**)

The generated DIN program has the same program name as the Teach-in program.

Should the control encounter any errors during conversion, it generates an error message and cancels conversion.

If a program with the name used is open in the smart.Turn editor, the conversion must be confirmed with the **Overwrite** soft key.

The control overwrites the program that is open in the smart.Turn editor.

## 4.14 Units of measure

The control is operating in either the **metric** or **inch** system. Depending on the unit of measure, the units and decimal places listed in the tables are used in the display values and entries.

### Units

	Metric	Inches
Coordinates, lengths, path data	mm	inch
Feed rate	mm/rev or mm/min	in./rev or in./min
Cutting speed	m/min	ft/min (feet/min)

### Number of decimal places in display values and entries

	Metric	Inches
Coordinate data and path data	3	4
Compensation values	3	5

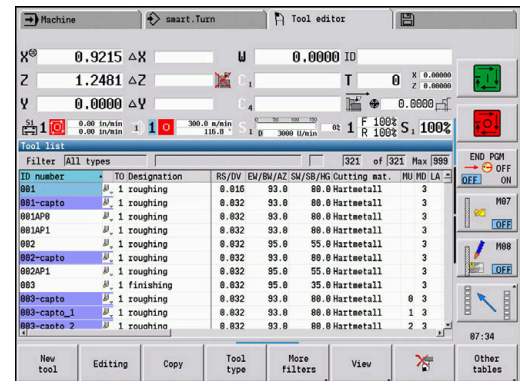
The inch/metric setting is also evaluated for the display values and entries in the tool management.

Use the **unitOfMeasure** machine parameter (101101) to set the unit of measure to metric/inches. Changed metric/inch settings become effective immediately, with no need for a restart.

The basic block display also switches to inches.



- The unit is defined in all NC programs; metric programs can be run while inch mode is active and vice versa
- New programs are created in the selected unit
- Refer to your machine manual if you want to know whether and how the handwheel resolution can be set to inches







# 5

**Teach-in**

## 5.1 Working with cycles

Before you can use the cycles, you must set the workpiece datum and ensure that the tools you are going to use have been described. You enter the machine data (tool, feed rate, spindle speed) in **Teach-in** submode together with the other cycle parameters. In **Machine** mode, you must program this machine data before calling a cycle.



The cutting data can be taken from the technology database using the **Proposed technology** soft key. For this database access, a machining type is permanently assigned to every cycle.

Define the individual cycles as follows:

- Position the tool tip with the handwheel or the jog buttons at the starting point of the cycle (only in **Machine** mode)
- Select and program a cycle
- Graphically test the cycle
- Execute the cycle
- Save the cycle (only in **Teach-in** submode)

### Cycle starting point

In **Machine** mode, cycles will be executed from the current tool position.

In **Teach-in** submode, you enter the starting point as one of the parameters. The control moves to this position in rapid traverse using the shortest path (diagonal) before executing the cycle.

### NOTICE

#### Danger of collision!

The control does not automatically check whether collisions can occur between the tool and the workpiece. There is danger of collision during the approach movement!

- ▶ If necessary, program an additional rapid traverse path to a safe auxiliary position

## Help graphics

The functions and parameters of the Teach-in cycles are illustrated in the graphic support window. These graphics usually show an external machining operation.



- ▶ The triple-arrow key allows you to switch between the help graphics for internal and external machining

Elements used in the graphic support window:

- Broken line: Rapid traverse path
- Continuous line: Feed path
- Dimension line with arrow head on one side: Directional dimension—the algebraic sign defines the direction
- Dimension line with arrow head on both sides: Absolute dimension—the algebraic sign has no effect

## DIN macros

DIN macros (DIN cycles) are DIN subprograms.

**Further information:** "DIN cycles", Page 421

You can integrate DIN macros in Teach-in programs. Make sure that the DIN macros do not contain any datum shifts.

### NOTICE

#### **Danger of collision!**

In **Teach-in** submode, all datum shifts contained in a DIN cycle (DIN macro) will be reset after the cycle has been executed. Danger of collision during subsequent machining operations!

- ▶ Use DIN cycles without datum shifts

## Graphical test run (simulation)

Before executing a cycle, you can graphically test the contour details and the machining sequence.

**Further information:** "Simulation submode", Page 538

## Contour follow-up in Teach-in submode Teach-in

The contour follow-up function updates the originally defined workpiece blank with every machining step. The turning cycles take the current contour of the workpiece blank into account for the calculation of infeed and machining paths. Air cuts are avoided and approach paths optimized.

To activate contour follow-up in **Teach-in** submode, program a workpiece blank and select "With contour follow-up" in the **RG** parameter.

**Further information:** "Workpiece blank cycles", Page 187



When contour follow-up is active, you can also use modal functions, such as interrupted feed or datum shift. Contour follow-up can only be used for turning operations and centric drilling.

Cycle run with active contour follow-up (**RG**: 1):

- Pressing the **NC start** key initiates a search for the selected cycle for mid-program startup
- The next **NC start** executes the **M** commands (e.g. direction of rotation)
- The next **NC start** positions the tool to the last programmed coordinates (e.g. tool change point)
- The next **NC start** runs the selected cycle

## Cycle keys

You can execute a programmed teach-in cycle by pressing the **NC start** key. **NC stop** interrupts a running cycle. If you press **NC stop** during thread cutting, the tool is lifted off the contour and then stopped. The cycle has to be restarted.

During a cycle interruption you can:

- Resume cycle execution with the **NC start** key. The control will always resume execution of the cycle at the point of interruption, even if you have moved the axes in the meantime
- Move the axes with the manual direction keys or the handwheel
- Terminate the machining process with the **BACK** soft key

## Switching functions (M functions)

The control generates all switching functions that are necessary for running a cycle.

The direction of spindle rotation must be defined in the tool parameters. Using the tool parameters, the cycles generate spindle trigger functions (**M3** or **M4**).



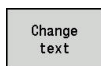
Refer to your machine manual.  
On your lathe, other or additional M commands may apply to the automatically triggered switching functions.

## Comments

You can assign a comment to an existing Teach-in cycle. The comment is inserted in brackets [...] below the cycle.

Adding or editing comments:

- ▶ Create and select a cycle



- ▶ Press the **Change text** soft key



- ▶ Press the **GOTO** key to show the alphabetic keyboard
- ▶ Enter the comment with the on-screen alphabetic keyboard
- ▶ Apply the comment



## Cycle menu

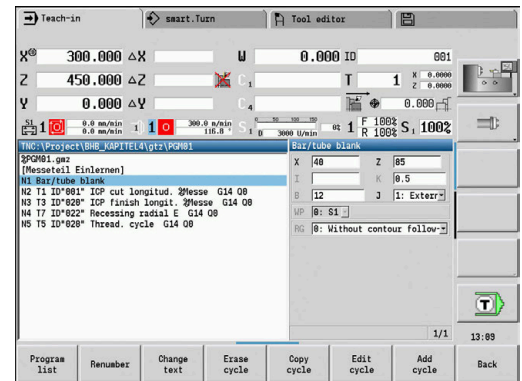
The main menu shows the cycle groups. Once a group has been selected, the menu items for the individual cycles appear.









You can use ICP cycles for complex contours, and DIN macros for technologically sophisticated machining operations. In cycle programs, the names of the ICP contours and DIN macros are at the end of the line of the cycle.

Some cycles offer optional parameters. That means, specific contour elements will only be machined if you set the corresponding parameters. The identification letters for optional parameters and parameters that are preassigned default values are displayed in gray.

The following parameters are only used in **Teach-in** submode:

- Start point **X, Z**
- Machine data **S, F, T** and **ID**



Menu item	Cycle groups
	<b>Define workpiece blank</b> Defining standard workpiece blanks or workpiece blanks with ICP
	<b>Single cuts</b> Positioning in rapid traverse, linear and circular single cuts, chamfers, and rounding arcs
	<b>Roughing cycles lon/trans</b> Roughing and finishing cycles for longitudinal and transverse machining
	<b>Recessing cycle</b> Cycles for recessing, contour recessing, undercuts and parting
	<b>Thread cutting</b> Thread cycles, relief turns and thread repair
	<b>Drilling</b> Drilling cycles and patterns for face and lateral-surface machining
	<b>Millg</b> Milling cycles and patterns for face and lateral-surface machining
	<b>DIN cycle</b> Including DIN macros

Soft keys in cycle programming: Depending on the type of cycle, you define the variants of the cycle by soft key.

---

**Soft keys in cycle programming**


---









Edit ICP	Call the interactive contour input
T-Change approach	Move to the tool change position
Spindle Stop M19	Activate spindle positioning ( <b>M19</b> )
With return	<ul style="list-style-type: none"> <li>■ <b>On:</b> Tool returns to starting point</li> <li>■ <b>Off:</b> Tool remains at cycle end position</li> </ul>
Finishing run	Switch to the finishing operation
Expanded	Switch to the expanded mode
Tool list	Open the turret list and tool list. You can load the tool from the list.
Take over position	Take over the actual X and Z positions in <b>Teach-in</b> submode
Proposed technology	Accept the proposed values for feed rate and cutting velocity from the database
Constant speed	<ul style="list-style-type: none"> <li>■ <b>On:</b> Constant speed (rpm)</li> <li>■ <b>Off:</b> Constant surface speed (m/min)</li> </ul>
Pattern linear	Linear drilling and milling patterns on face or lateral surface
Pattern circular	Circular drilling and milling patterns on face or lateral surface
Input finished	Apply entered or changed values
Back	Cancel the current dialog

If you have confirmed the cycle with the **Input finished** soft key, a further soft-key row is displayed.

---

**Soft keys in cycle programming**

---

 Tool correct.	Tool compensation <b>Further information:</b> "Tool compensation in Teach-in submode", Page 185
 Single block	Initiate cycle in Program Run, Single Block
 Base blocks	Display basic blocks
 	Display simulation
 Save	Save the cycle (only with <b>Add cycle</b> )
 Overwrite	Overwrite the cycle (only with <b>Edit cycle</b> )
 Back	Return to cycle description



## Tool compensation in Teach-in submode

### Tool compensation in Teach-in submode

You can set tool compensations with the handwheel or enter them into a dialog field.

Defining tool compensation:

- ▶ Define the cycle

Input finished	▶ Press the <b>Input finished</b> soft key
Tool correct.	▶ Press the <b>Tool compensation</b> soft key
Set by handwheel	▶ Press the <b>Set by handwheel</b> soft key
Set comp- ensation	▶ Alternative: Press the <b>Set compensation</b> soft key
X comps. of tool	<ul style="list-style-type: none"> <li>▶ Press the <b>X comps. of tool</b> (or Z comps.) soft key</li> <li>▶ Determine the compensation value by handwheel; the value is shown in the distance-to-go display</li> <li>▶ Alternative: Enter the compensation value <b>dx</b> (or <b>dz, dy</b>)</li> </ul>
Save	▶ Press the <b>Save</b> or <b>Overwrite</b> soft key

## Addresses used in many cycles

### Safety clearance G47

Safety clearances are used for approach and departure paths. If the cycle run takes a safety clearance into account during execution you will find the address **G47** in the dialog.

Proposed value:

**Further information:** "List of machine parameters", Page 616

### Safety clearances SCI and SCK

The safety clearances **SCI** and **SCK** are considered for approach and departure paths in drilling and milling cycles.

- **SCI:** Safety clearance in the working plane
- **SCK:** Safety clearance in infeed direction

Proposed value:

**Further information:** "List of machine parameters", Page 616

### Tool change point G14

With the address **G14**, you program a movement of the slide to the saved tool change position at the end of the cycle.

**Further information:** "Defining the tool change position", Page 125

You can influence the approach to the tool change point as follows:

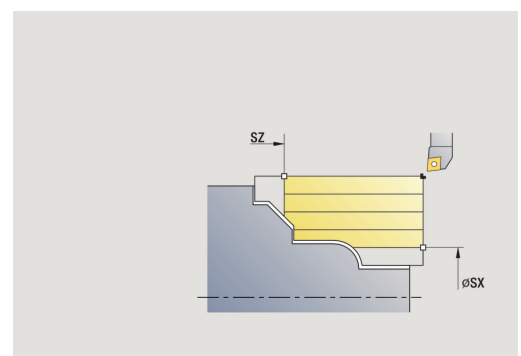
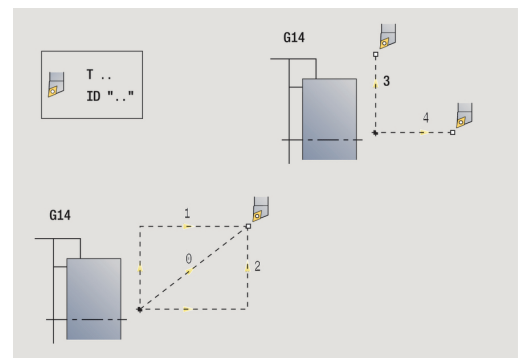
- No axis (do not approach the tool change position)
- 0: Simultaneously (default)
- 1: First X, then Z
- 2: First Z, then X
- 3: Only X
- 4: Only Z
- 5: Only Y (machine-dependent)
- 6: Simultaneous w/ Y (machine-dependent)

### Cutting limits SX, SZ




With the addresses **SX** and **SZ** you limit the contour area to be machined in the X and Z directions. Seen from the tool position at the beginning of the cycle, the contour to be machined is truncated at these positions.

### Additive compensation Dxx



With the address **Dxx** you activate an additive compensation for the entire cycle run. The xx stands for the compensation numbers 1 to 16. The additive compensation is switched off again at the end of the cycle.



## 5.2 Workpiece blank cycles

Menu item	Meaning
	With the workpiece blank cycles you can describe the workpiece blank and the setup used. The workpiece blank cycles do not influence the machining process.  The contours of workpiece blanks are shown during the simulation of the machining process.
Menu item	Workpiece blank cycles
	<b>Bar/tube blank</b> Defining a standard workpiece blank
	<b>ICP workpiece blank contour</b> Free workpiece blank description with ICP

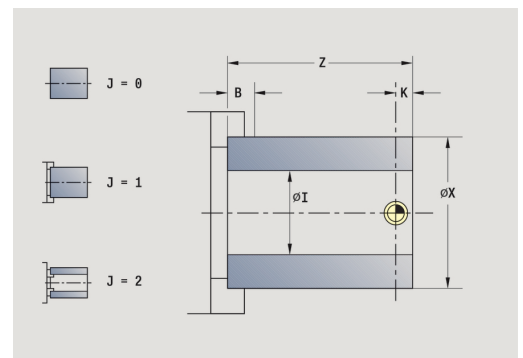
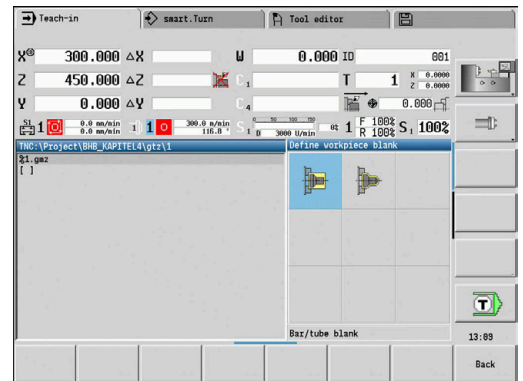
### Bar/tube blank

-  ▶ Select **Define workpiece blank**
-  ▶ Select **Bar/tube blank**

The cycle describes the workpiece blank and the setup used. This information is evaluated in the **Simulation** submodule.

Cycle parameters:

- **X: Outside diameter**
- **Z: Length** – Including transverse oversize and clamping range
- **I: Inside diameter**
- **K: Righthnd edge** – Transverse oversize
- **B: Clamp range**
- **J: Clamp type**
  - **0: Not clamped**
  - **1: Externally clamped**
  - **2: Internally clamped**
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **RG: Activate contour follow-up** – Contour follow-up for **Teach-in** submodule  
**Further information:** "Contour follow-up in Teach-in submodule Teach-in", Page 180
  - **0: Without contour follow-up**
  - **1: With contour follow-up**



## ICP workpiece blank contour



- ▶ Select **Define workpiece blank**

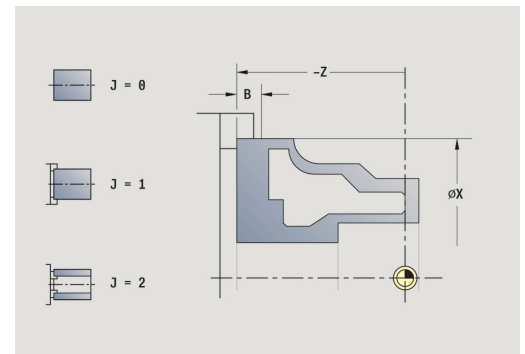


- ▶ Select **ICP workpiece blank contour**




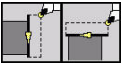





The cycle describes the workpiece blank and the setup used. This information is evaluated in the **Simulation** submode.

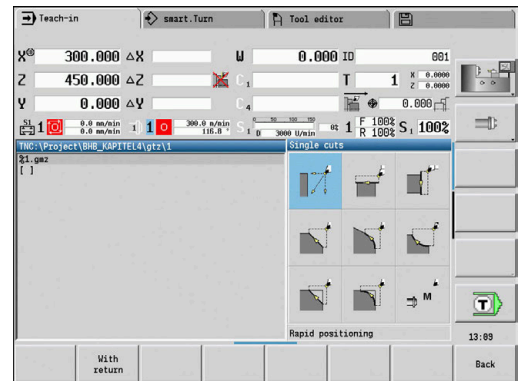
Cycle parameters:

- **X: Chuck diameter**
  - **Z: Chuck position in Z**
  - **B: Clamp range**
  - **J: Clamp type**
    - **0: Not clamped**
    - **1: Externally clamped**
    - **2: Internally clamped**
  - **RK: ICP contour number**
  - **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
    - Main drive
    - Opposing spindle for rear-face machining
  - **RG: Activate contour follow-up** – Contour follow-up for **Teach-in** submode
- Further information:** "Contour follow-up in Teach-in submode Teach-in", Page 180
- **0: Without contour follow-up**
  - **1: With contour follow-up**



### 5.3 Single cut cycles

Menu item	Meaning
	In the single cut cycles you position the tool in rapid traverse, perform linear or circular cuts, machine chamfers or rounding arcs, and enter M functions.
Menu item	Single cut cycles
	<b>Rapid positioning</b>
	<b>Tool change point</b>
	<b>Linear mach. longit./Linear mach. transv.</b> Single longitudinal/transverse cut
	<b>Linear machining in angle</b> Single oblique cut
	<b>Circular machining</b> Single circular cut (cutting direction depends on the selected menu item)
	<b>Cham</b> Machine a chamfer
	<b>Round.</b> Machine a rounding
	Call an <b>M function</b>



## Rap. trav. positioning



- ▶ Select **Single cuts**

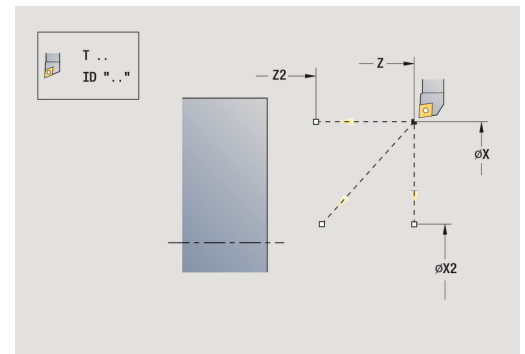


- ▶ Select **Rap. trav. positioning**

The tool moves at rapid traverse from the **Start point** to the **Target point**.

Cycle parameters:

- **X, Z: Start point**
- **X2, Z2: Target point**
- **T: Tool number** – Turret pocket number
- **ID: ID no.**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



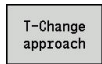
## Approaching the tool change position



- ▶ Select **Single cuts**



- ▶ Select **Rap. trav. positioning**



- ▶ Press the **T-Change approach** soft key

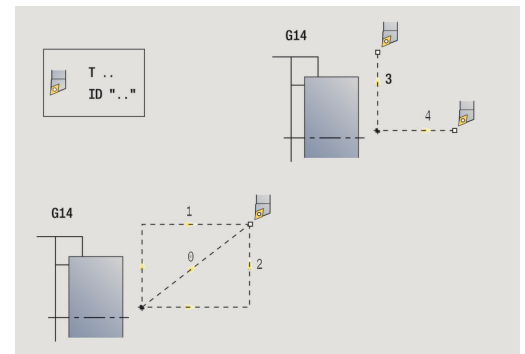
The tool moves at rapid traverse from the current position to the **Tool change point**.

**Further information:** "Tool change point G14", Page 186

After reaching the tool change point, the control switches to the tool indicated in **T**.

Cycle parameters:

- **G14: Tool change point** – Sequence (default: 0)
  - **0: Simultaneously** (diagonal path of traverse)
  - **1: First X, then Z**
  - **2: First Z, then X**
  - **3: Only X**
  - **4: Only Z**
  - **5: Only Y** (machine-dependent)
  - **6: Simultaneous w/ Y** (machine-dependent)
- **T: Tool number** – Turret pocket number
- **ID: ID no.**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



## Linear mach. longit.



- ▶ Select **Single cuts**



- ▶ Select **Linear mach. longit.**



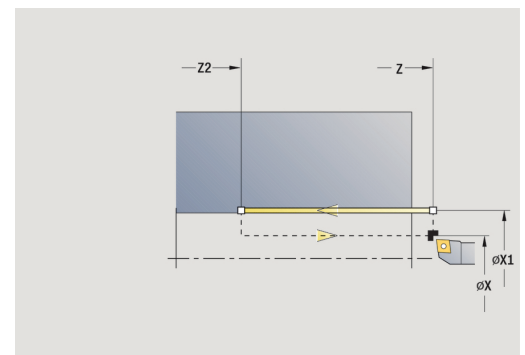
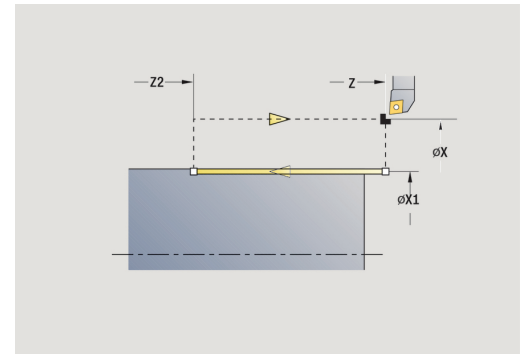
- ▶ Select the scope of the cycle:
  - **Off**: When the cycle is completed, the tool remains at the cycle end position
  - **On**: The tool returns to the starting point

**Linear mach. longit.:** The tool moves from the **Start point** to the **End point contour Z2** at the programmed feed rate and remains at the cycle end position.

**Linear mach. longit. (With return):** The tool approaches the workpiece, executes the longitudinal cut and returns to the **Start point** at the end of cycle.

Cycle parameters:

- **X, Z: Start point**
- **X1: Start point contour** (if **With return** is active)
- **Z2: End point contour**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point** (if **With return** is active)
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T:** **M** function that is executed after the tool call **T**
- **MFS: M at beginning:** **M** function that is executed at the beginning of the machining step
- **MFE: M at end:** **M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**

Cycle execution if **With return** is active:

- 1 Move from **Start point** to **Start point contour X1**
- 2 Move to **End point contour Z2** at programmed feed rate
- 3 Retract and return to **Start point** on paraxial path



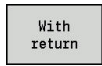
## Transv. linear machining



- ▶ Select **Single cuts**



- ▶ Select **Transv. linear machining**



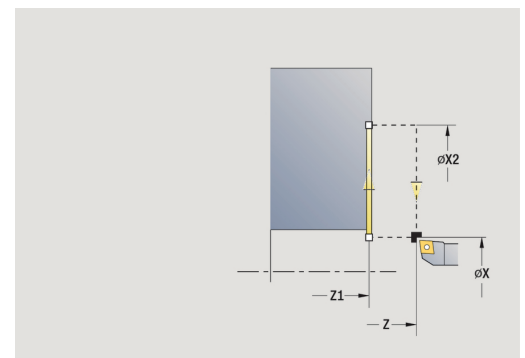
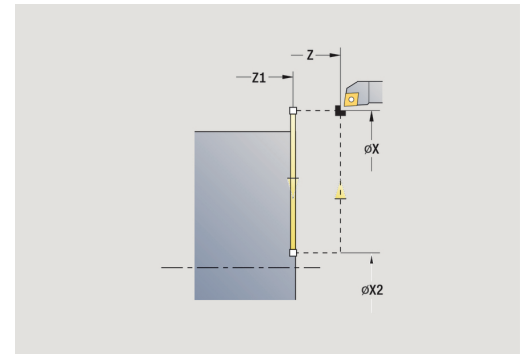
- ▶ Select the scope of the cycle:
  - **Off**: When the cycle is completed, the tool remains at the cycle end position
  - **On**: The tool returns to the starting point

**Transv. linear machining:** The tool moves from the **Start point** to the **End point contour X2** at the programmed feed rate and remains at the cycle end position.

**Transv. linear machining (With return):** The tool approaches the workpiece, executes the transverse cut and returns to the **Start point** at the end of cycle.

Cycle parameters:

- **X, Z: Start point**
- **Z1: Start point contour** (if **With return** is active)
- **X2: End point contour**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point** (if **With return** is active)
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**

Cycle execution if **With return** is active:

- 1 Move from **Start point** to **Start point contour Z1**
- 2 Move to **End point contour X2** at programmed feed rate
- 3 Retract and return to **Start point** on paraxial path

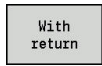
## Linear machining in angle



- ▶ Select **Single cuts**



- ▶ Select **Linear machining in angle**



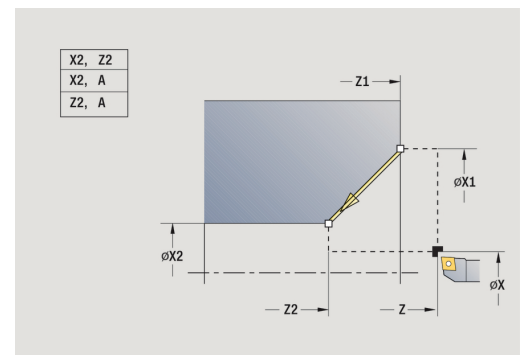
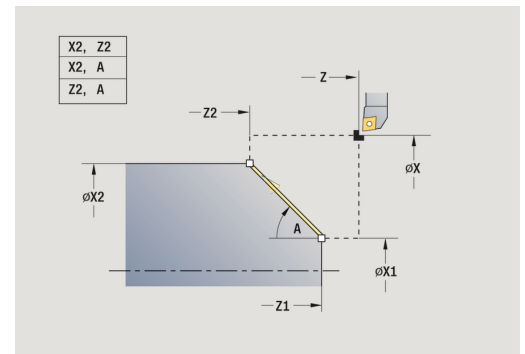
- ▶ Select the scope of the cycle:
  - **Off**: When the cycle is completed, the tool remains at the cycle end position
  - **On**: The tool returns to the starting point

**Linear machining at angle:** The control calculates the **Target position** and moves the tool on a straight line from the **Start point** to the **Target position** at the programmed feed rate. When the cycle is completed, the tool remains at the cycle end position.

**Linear machining at angle (With return):** The control calculates the **Target position**. The tool then approaches the workpiece, executes the linear cut and returns to the **Start point** at the end of cycle. Tool-tip radius compensation is taken into account.

Cycle parameters:

- **X, Z**: Start point
- **X1, Z1**: Start point contour (if **With return** is active)
- **X2, Z2**: End point contour
- **A**: Start angle (range:  $-180^\circ < A < 180^\circ$ )
- **G47**: Safety clearance (if **With return** is active)
- **T**: Tool number – Turret pocket number
- **G14**: Tool change point (if **With return** is active)
- **ID**: ID no.
- **S**: Cutting speed or Constant speed
- **F**: Feed per revolution
- **MT**: M after T: M function that is executed after the tool call T
- **MFS**: M at beginning: M function that is executed at the beginning of the machining step
- **MFE**: M at end: M function that is executed at the end of the machining step
- **WP**: No. of spindle – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW**: Angle in the B axis (machine-dependent)
- **CW**: Reverse the tool (machine-dependent)
- **HC**: Shoe brake (machine-dependent)
- **DF**: Miscellaneous function (machine-dependent)



Type of machining for technology database access:  
**Finishing**



Parameter combinations for defining the target point:  
see help graphic

Cycle execution if **With return** is active:

- 1 Calculate **Target position**
- 2 Move on linear path from **Start point** to **Start point contour X1, Z1**
- 3 Move to **Target position** at programmed feed rate
- 4 Retract and return to **Start point** on paraxial path

## Circular machining



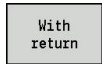
- ▶ Select **Single cuts**



- ▶ Select **Circular machining** (counterclockwise)



- ▶ Alternative: Select **Circular machining** (clockwise)



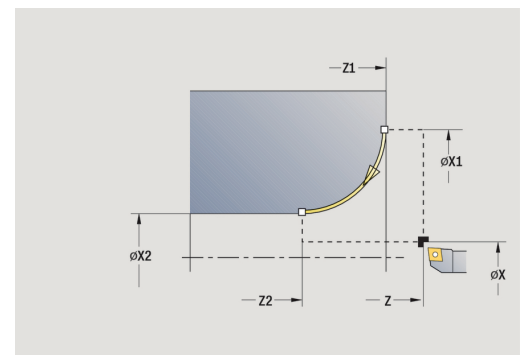
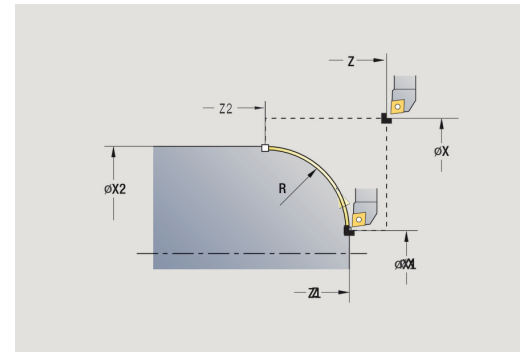
- ▶ Select the scope of the cycle:
  - **Off**: When the cycle is completed, the tool remains at the cycle end position
  - **On**: The tool returns to the starting point

**Circular machining:** The tool moves in a circular arc from the **Start point X, Z** to the **End point contour X2, Z2** at the programmed feed rate and remains at the cycle end position.

**Circular machining (With return):** The tool approaches the workpiece, executes the circular cut and returns to the **Start point** at the end of cycle. Tool-tip radius compensation is taken into account.

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour** (if **With return** is active)
- **X2, Z2: End point contour**
- **R: Radius**
- **G47: Safety clearance** (if **With return** is active)
- **T: Tool number** – Turret pocket number
- **G14: Tool change point** (if **With return** is active)
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T:** **M** function that is executed after the tool call **T**
- **MFS: M at beginning:** **M** function that is executed at the beginning of the machining step
- **MFE: M at end:** **M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**

Cycle execution if **With return** is active:

- 1 Move on paraxial path from **Start point** to **Start point contour X1, Z1**
- 2 Move in circular arc to **End point contour X2, Z2** at programmed feed rate
- 3 Retract and return to **Start point** on paraxial path

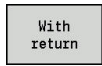
## Chamfer



- ▶ Select **Single cuts**



- ▶ Select **Chamfer**



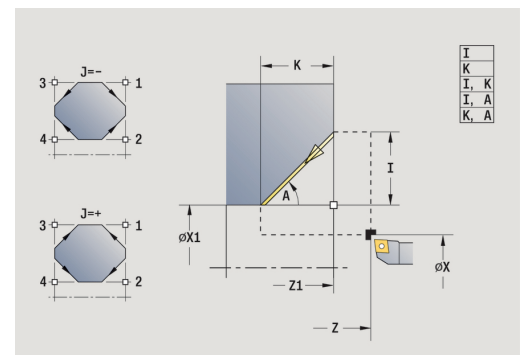
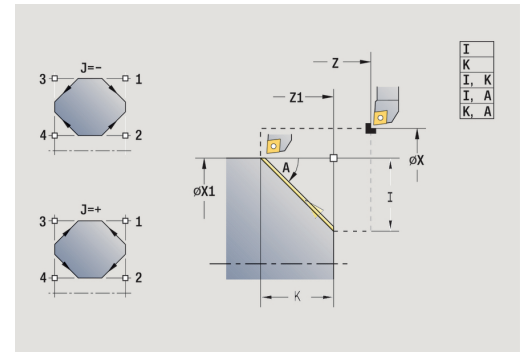
- ▶ Select the scope of the cycle:
  - **Off**: When the cycle is completed, the tool remains at the cycle end position
  - **On**: The tool returns to the starting point

**Chamfer**: The cycle produces a chamfer with dimensions relative to the corner of the workpiece contour. When the cycle is completed, the tool remains at the cycle end position.

**Chamfer (With return)**: The tool approaches the workpiece, machines the chamfer with dimensions relative to the corner of the workpiece contour and returns to the **Start point** at the end of cycle. Tool-tip radius compensation is taken into account.

Cycle parameters:

- **X, Z**: **Start point**
- **X1, Z1**: **Contour corner**
- **A**: **Start angle** – Angle of the chamfer (range:  $0^\circ < A < 90^\circ$ )
- **I, K**: **Chamfer width** in X and Z
- **J**: **Position** (default: 1)  
The algebraic sign determines the cutting direction (see help graphics).
- **G47**: **Safety clearance** (if **With return** is active)
- **T**: **Tool number** – Turret pocket number
- **G14**: **Tool change point** (if **With return** is active)
- **ID**: **ID no.**
- **S**: **Cutting speed** or **Constant speed**
- **F**: **Feed per revolution**
- **MT**: **M after T**: **M** function that is executed after the tool call **T**
- **MFS**: **M at beginning**: **M** function that is executed at the beginning of the machining step
- **MFE**: **M at end**: **M** function that is executed at the end of the machining step
- **WP**: **No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW**: **Angle in the B axis** (machine-dependent)
- **CW**: **Reverse the tool** (machine-dependent)
- **HC**: **Shoe brake** (machine-dependent)
- **DF**: **Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**

Parameter combinations for defining the chamfer:

- **I** or **K** (45° chamfer)
- **I, K**
- **I, A** or **K, A**

Cycle execution if **With return** is active:

- 1 Calculate chamfer **starting point** and chamfer **end point**
- 2 Move on paraxial path from **Start point** to chamfer **start point**
- 3 Move to chamfer **end point** at programmed feed rate
- 4 Retract and return to **Start point** on paraxial path

## Rounding



- ▶ Select **Single cuts**



- ▶ Select **Rounding**



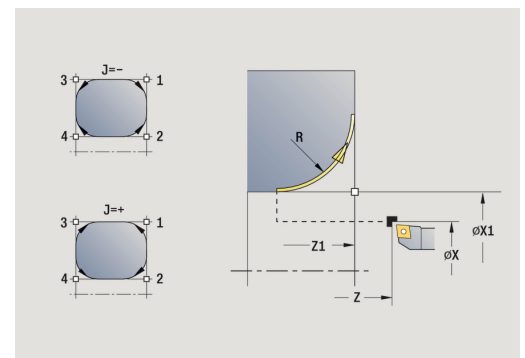
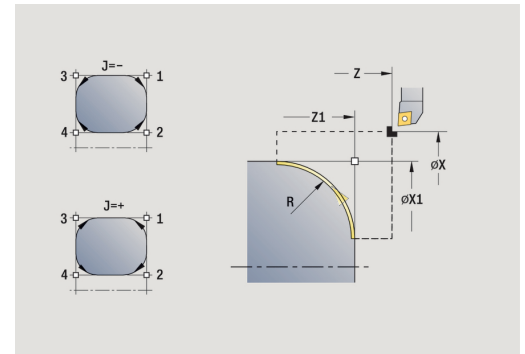
- ▶ Select the scope of the cycle:
  - **Off**: When the cycle is completed, the tool remains at the cycle end position
  - **On**: The tool returns to the starting point

**Rounding**: The cycle produces a rounding with dimensions relative to the corner of the workpiece contour. When the cycle is completed, the tool remains at the cycle end position.

**Rounding (With return)**: The tool approaches the workpiece, machines the rounding with dimensions relative to the corner of the workpiece contour and returns to the **Start point** at the end of cycle. Tool-tip radius compensation is taken into account.

Cycle parameters:

- **X, Z**: Start point
- **X1, Z1**: Contour corner
- **R**: Rounding
- **J**: Position (default: 1)  
The algebraic sign determines the cutting direction (see help graphics).
- **G47**: Safety clearance (if **With return** is active)
- **T**: Tool number – Turret pocket number
- **G14**: Tool change point (if **With return** is active)
- **ID**: ID no.
- **S**: Cutting speed or Constant speed
- **F**: Feed per revolution
- **MT**: M after T: M function that is executed after the tool call T
- **MFS**: M at beginning: M function that is executed at the beginning of the machining step
- **MFE**: M at end: M function that is executed at the end of the machining step
- **WP**: No. of spindle – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW**: Angle in the B axis (machine-dependent)
- **CW**: Reverse the tool (machine-dependent)
- **HC**: Shoe brake (machine-dependent)
- **DF**: Miscellaneous function (machine-dependent)



Type of machining for technology database access:  
**Finishing**



Cycle execution if **With return** is active:

- 1 Calculate **starting point** and **end point** of rounding
- 2 Move on paraxial path from **Start point** to rounding **starting point**
- 3 Move in circular arc to **end point** of rounding at programmed feed rate.
- 4 Retract and return to **Start point** on paraxial path

## M functions

Machine commands (**M** functions) are only executed after **NC start** has been pressed. With the **M list** soft key you can display an overview of the available **M** functions. For the meaning of the **M** functions, refer to your machine manual.

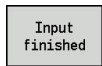
**M** function:



- ▶ Select **Single cuts**



- ▶ Select **M function**



- ▶ Enter the number of the **M** function
- ▶ Confirm your input



- ▶ Press the **NC start** key

Spindle stop **M19** (spindle positioning):



- ▶ Select **Single cuts**



- ▶ Select **M function**



- ▶ Activate **M19**




- ▶ Enter the stopping angle
- ▶ Confirm your input



- ▶ Press the **NC start** key

## 5.4 Turning cycles

Menu item	Meaning
	Turning cycles can be used for roughing and finishing of simple contours in <b>basic mode</b> and complex contours in <b>expanded mode</b>

**Further information:** "ICP contours", Page 424

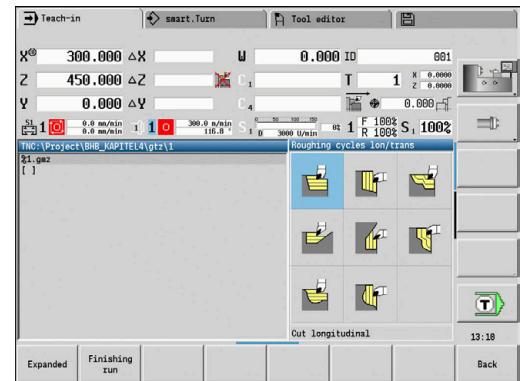










- **Proportioning of cuts:** The control calculates an infeed that is  $\leq$  **Feed depth P**. **Abrasive cuts** are thus avoided
  - **Oversizes** are considered in **expanded mode**
  - **Tool-tip radius compensation** is active
  - **Safety clearance** after each cut:
    - Basic mode: 1 mm
    - Expanded mode: The safety clearance is set separately for inside and outside machining
- Further information:** "List of machine parameters", Page 616

**Cutting and infeed directions for turning cycles:** The control determines the cutting and infeed directions from the cycle parameters.

The decisive ones are:

- **Basic mode:** The parameters for **Starting point X, Z** (in **Machine** operating mode: current tool position) and **Start point contour X1 / End point contour Z2**
- **Expanded mode:** The parameters for **Start point contour X1, Z1** and **End point contour X2, Z2**
- **ICP cycles:** The parameters for **Starting point X, Z** (in **Machine** operating mode: current tool position) and starting point of ICP contour



Menu item	Turning cycles
 	<p><b>Cut longitud./Cut transv.</b> Roughing and finishing cycle for simple contours</p>
 	<p><b>Plunge longitud./Plunge transv.</b> Roughing and finishing cycle for simple plunge-cut contours</p>
 	<p><b>ICP-long.parallel contour/ICP-transv.parallel contour</b> Roughing and finishing cycle for any type of contour (cutting paths parallel to finished part)</p>
 	<p><b>ICP cut longitud./ICP cut transv.</b> Roughing and finishing cycle for any type of contour</p>

### Tool position

It is important that you observe the **Start point X, Z** tool position before executing any of the turning cycles in expanded mode.













The rules apply for all cutting and infeed directions as well as for roughing and finishing:

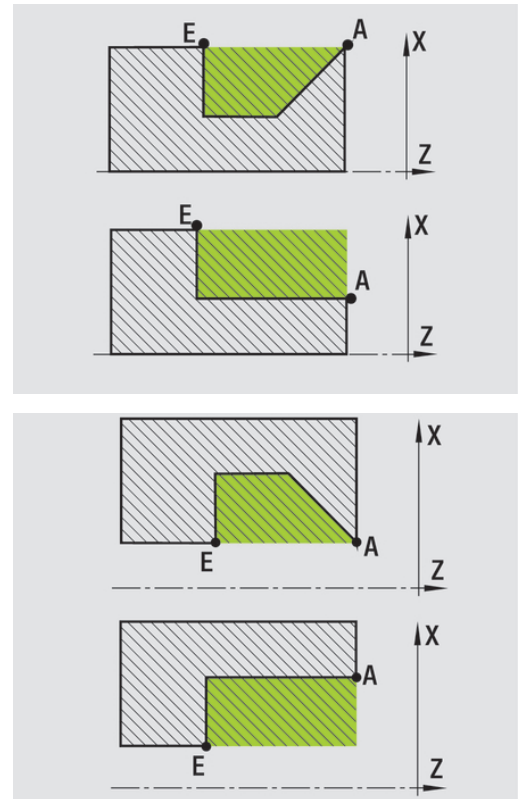
- The starting point must not be located in the shaded area
- The area to be machined starts at the **Start point X, Z** if the tool is positioned **before** the contour area. The control will otherwise only machine the contour area defined
- If the **Start point X, Z** for inside machining is located above the turning center, only the contour area defined will be machined

(A = Start point contour X1, Z1; E = End point contour X2, Z2)

### Contour elements

#### Contour elements in turning cycles

	<b>Basic mode</b> Machining a rectangular area
	<b>Expanded mode</b> Oblique cut at contour start
	<b>Expanded mode</b> Oblique cut at contour end
	<b>Expanded mode</b> Oblique cuts at contour start and end with angles > 45°
	<b>Expanded mode</b> <b>One</b> oblique cut (by entering the starting point of contour, end point of contour and starting angle)
	<b>Expanded mode</b> Rounding arc
	<b>Expanded mode</b> Chamfer (or rounding) at contour end
	<b>Basic mode</b> Machining with descending contour
	<b>Basic mode</b> Oblique cut at contour end
	<b>Expanded mode</b> Rounding in contour valley (in both corners)
	<b>Expanded mode</b> Chamfer (or rounding) at contour start
	<b>Expanded mode</b> Chamfer (or rounding) at contour end



## Cut longitud.



- ▶ Select **Roughing cycles lon/trans**

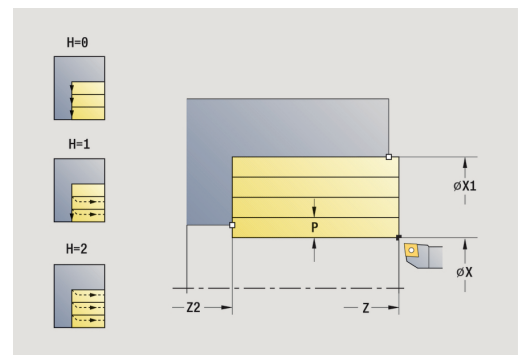
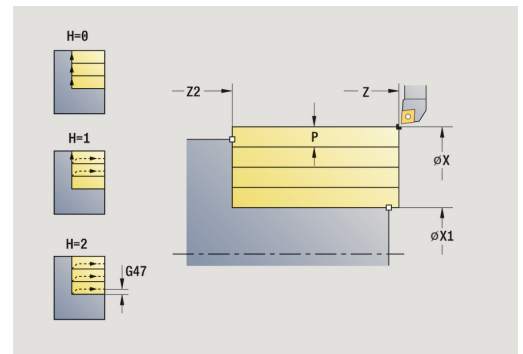


- ▶ Select **Cut longitud.**

The cycle roughs the rectangle described by the **Start point** and the **Start point contour X1/End point contour Z2**.

Cycle parameters:

- **X, Z: Start point**
- **X1: Start point contour**
- **Z2: End point contour**
- **P: Feed depth** – Maximum infeed depth
- **H: Contour smoothing**
  - **0: With each cut**
  - **1: With the last cut**
  - **2: No smoothing**
- **G47: Safety clearance**  
Further information: "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
Further information: "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Roughing**

Cycle run:

- 1 Calculate the proportioning of cuts (infeed)
- 2 Approach the workpiece from the **Start point** for the first pass
- 3 Move to the **End point contour Z2** at the programmed feed rate
- 4 The contour is machined according to the setting in **Contour smoothing H**
- 5 Retract and approach for the next pass
- 6 Repeat 3 to 5 until the **Start point contour X1** is reached
- 7 Return to the **Start point** on a diagonal path
- 8 Move to the **Tool change point** according to the setting in **G14**

## Cut transv.



- ▶ Select **Roughing cycles lon/trans**

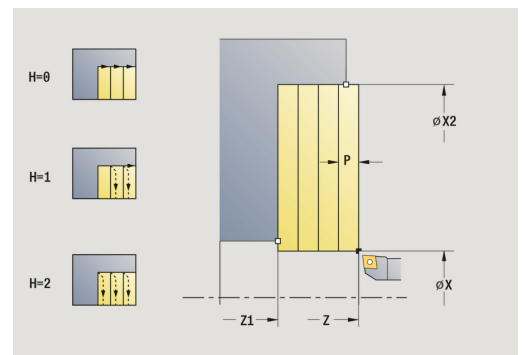
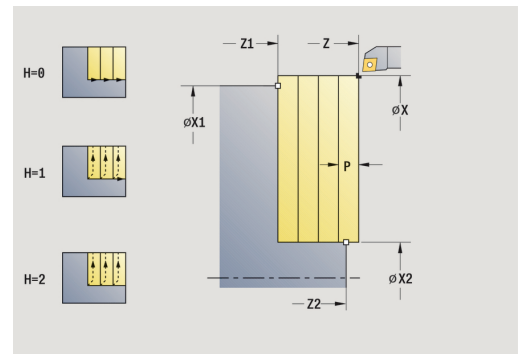


- ▶ Select **Cut transv.**

The cycle roughs the rectangle described by the **Start point** and the **Start point contour Z1/End point contour X2**.

Cycle parameters:

- **X, Z: Start point**
- **Z1: Start point contour**
- **X2: End point contour**
- **P: Feed depth** – Maximum infeed depth
- **H: Contour smoothing**
  - **0: With each cut**
  - **1: With the last cut**
  - **2: No smoothing**
- **G47: Safety clearance**  
Further information: "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
Further information: "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Roughing**



Cycle run:

- 1 Calculate the proportioning of cuts (infeed)
- 2 Approach the workpiece from the **Start point** for the first pass
- 3 Move to the **End point contour X2** at the programmed feed rate
- 4 The contour is machined according to the setting in **Contour smoothing H**
- 5 Retract and approach for the next pass
- 6 Repeat 3 to 5 until the **Start point contour Z1** is reached
- 7 Return to the **Start point** on a diagonal path
- 8 Move to the **Tool change point** according to the setting in **G14**

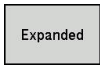
## Cut longitud. — Expanded



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **Cut longitud.**

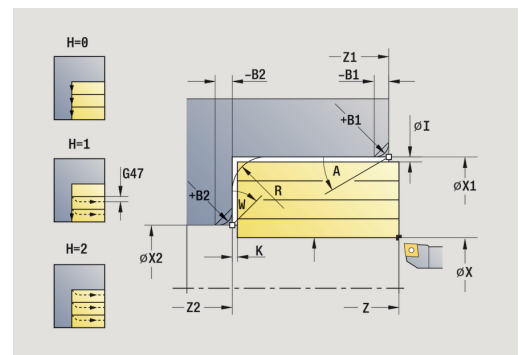
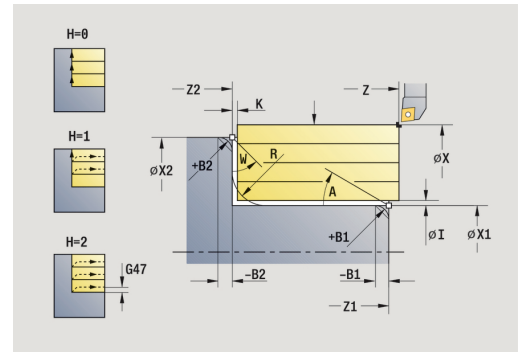


- ▶ Select the **Expanded** soft key

Taking the oversizes into account, the cycle roughs the area described by the **Start point** and the **Start point contour X1/End point contour Z2**.

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **P: Feed depth** – Maximum infeed depth
- **H: Contour smoothing**
  - **0: With each cut**
  - **1: With the last cut**
  - **2: No smoothing**
- **I, K: O-size X and Z**
- **A: Start angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **R: Rounding**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **B1, B2: -B chamf./+B round.** (**B1** at contour start and **B2** at contour end)
  - **B > 0:** Radius of rounding
  - **B < 0:** Width of chamfer
- **BP: Interval time** – time during which the feed motion will be interrupted  
 The chip is broken by the intermittent feed.
- **BF: Feed period** – time interval until the next break  
 The chip is broken by the intermittent feed.
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step



- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Roughing**

Cycle run:

- 1 Calculate the proportioning of cuts (infeed)
- 2 Approach the workpiece from the **Start point** for the first pass
- 3 Move at the programmed feed rate to the **End point contour Z2** or, if defined, to one of the optional contour elements
- 4 The contour is machined according to the setting in **Contour smoothing H**
- 5 Retract and approach for the next pass
- 6 Repeat 3 to 5 until the **Start point contour X1** is reached
- 7 Return to the **Start point** on a paraxial path
- 8 Move to the **Tool change point** according to the setting in **G14**

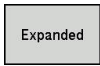
## Cut transv.—Expanded



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **Cut transv.**

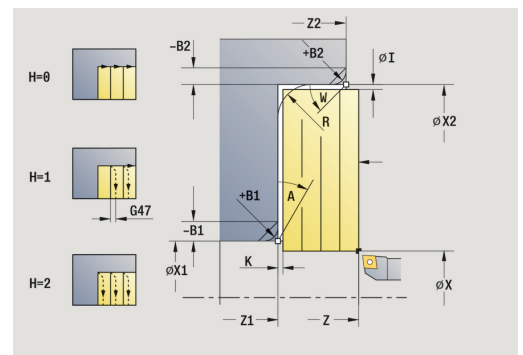
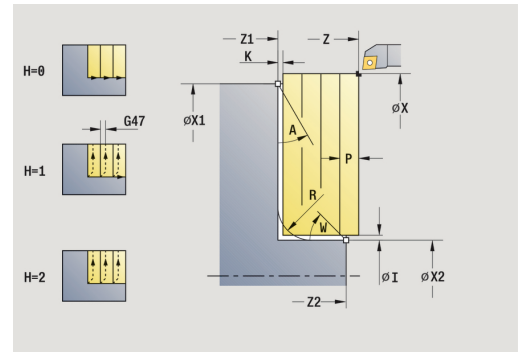


- ▶ Select the **Expanded** soft key

Taking the oversizes into account, the cycle roughs the area described by the **Start point** and the **Start point contour Z1/End point contour X2**.

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **P: Feed depth** – Maximum infeed depth
- **H: Contour smoothing**
  - **0: With each cut**
  - **1: With the last cut**
  - **2: No smoothing**
- **I, K: O-size X and Z**
- **A: Start angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **R: Rounding**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **B1, B2: -B chamf./+B round.** (**B1** at contour start and **B2** at contour end)
  - **B > 0:** Radius of rounding
  - **B < 0:** Width of chamfer
- **BP: Interval time** – time during which the feed motion will be interrupted  
 The chip is broken by the intermittent feed.
- **BF: Feed period** – time interval until the next break  
 The chip is broken by the intermittent feed.
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step



- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Roughing**

Cycle run:

- 1 Calculate the proportioning of cuts (infeed)
- 2 Approach the workpiece from the **Start point** for the first pass
- 3 Move at the programmed feed rate to the **End point contour X2** or, if defined, to one of the optional contour elements
- 4 The contour is machined according to the setting in **Contour smoothing H**
- 5 Retract and approach for the next pass
- 6 Repeat 3 to 5 until the **Start point contour Z1** is reached
- 7 Return to the **Start point** on a paraxial path
- 8 Move to the **Tool change point** according to the setting in **G14**

## Finishing cut longitud.



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **Cut longitud.**



- ▶ Press the **Finishing run** soft key

The cycle finishes the contour area from **Start point contour X1** to **End point contour Z2**.



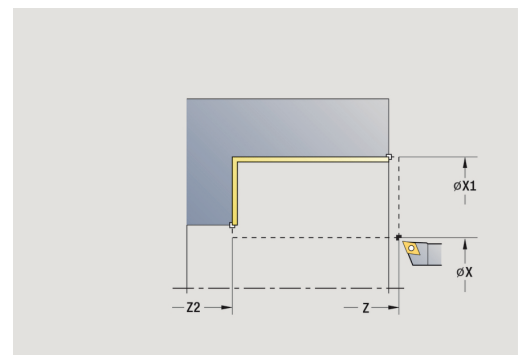
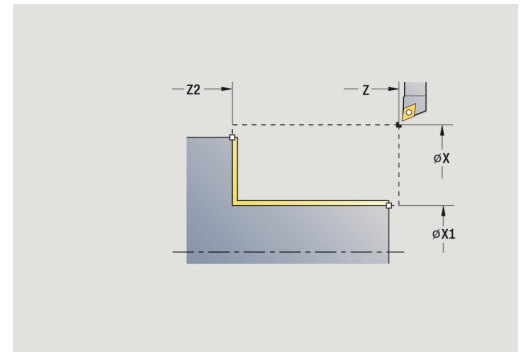
At the end of the cycle, the tool returns to the **Start point**.

Cycle parameters:

- **X, Z: Start point**
- **X1: Start point contour**
- **Z2: End point contour**
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**



Cycle run:

- 1 Move in transverse direction from the **Start point** to the **Start point contour X1**
- 2 Finish first in longitudinal direction, then in transverse direction
- 3 Return in longitudinal direction to the **Start point**
- 4 Move to the **Tool change point** according to the setting in **G14**

### Finishing cut transv.



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **Cut transv.**



- ▶ Press the **Finishing run** soft key

The cycle finishes the contour area from **Start point contour Z1** to **End point contour X2**.



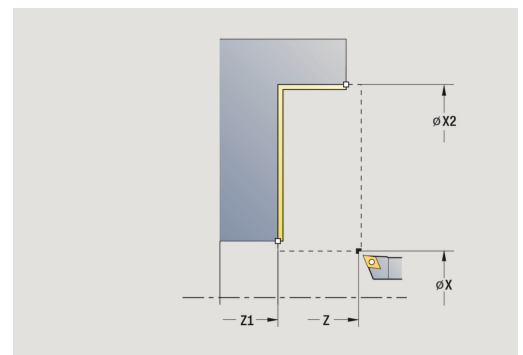
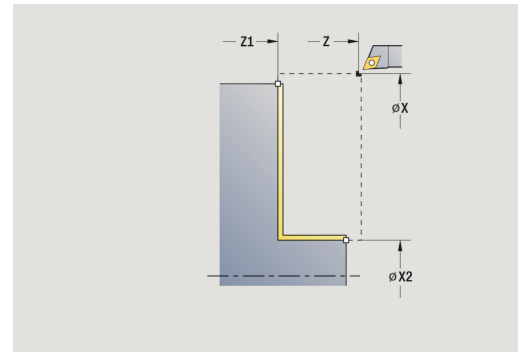
At the end of the cycle, the tool returns to the **Start point**.

Cycle parameters:

- **X, Z: Start point**
- **Z1: Start point contour**
- **X2: End point contour**
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**





Cycle run:

- 1 Move in longitudinal direction from the **Start point** to the **Start point contour Z1**
- 2 Finish first in transverse direction, then in longitudinal direction
- 3 Return in transverse direction to the **Start point**
- 4 Move to the **Tool change point** according to the setting in **G14**

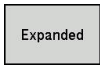
## Finishing cut longitud. — Expanded



- ▶ Select **Roughing cycles lon/trans**



- ▶ **Select Cut longitud.**



- ▶ Select the **Expanded** soft key



- ▶ Press the **Finishing run** soft key

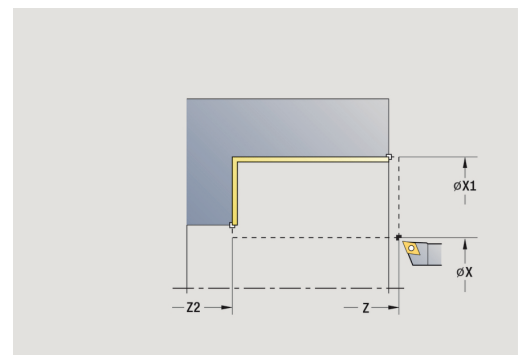
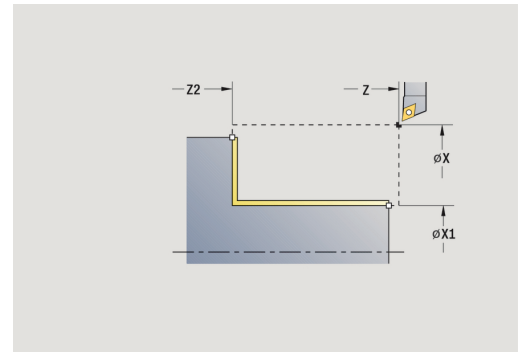
The cycle finishes the contour area from **Start point contour** to **End point contour**.



When the cycle is completed, the tool remains at the cycle end position.

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **DXX: Add. correction number** (range: 1-16)  
**Further information:** "Additive compensation Dxx", Page 186
- **G58: Contour-parallel oversize**
- **A: Start angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **R: Rounding**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **B1, B2: -B cham./+B round.** (**B1** at contour start and **B2** at contour end)
  - **B > 0:** Radius of rounding
  - **B < 0:** Width of chamfer
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T:** **M** function that is executed after the tool call **T**
- **MFS: M at beginning:** **M** function that is executed at the beginning of the machining step
- **MFE: M at end:** **M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)



- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**

Cycle run:

- 1 Move in transverse direction from the **Start point** to the **Start point contour X1, Z1**
- 2 Finish the contour area from the **Start point contour X1, Z1** to the **End point contour X2, Z2**, taking the optional contour elements into account
- 3 Move to the **Tool change point** according to the setting in **G14**

## Finishing cut transv.—Expanded



- ▶ Select **Roughing cycles lon/trans**



- ▶ **Select Cut transv.**



- ▶ Select the **Expanded** soft key



- ▶ Press the **Finishing run** soft key

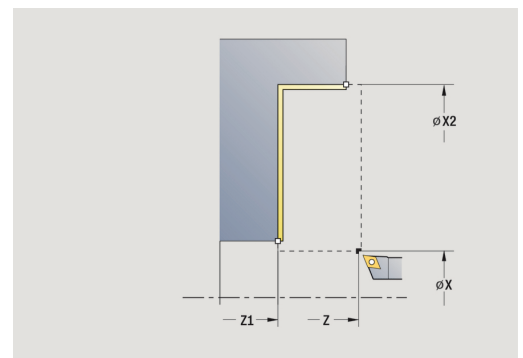
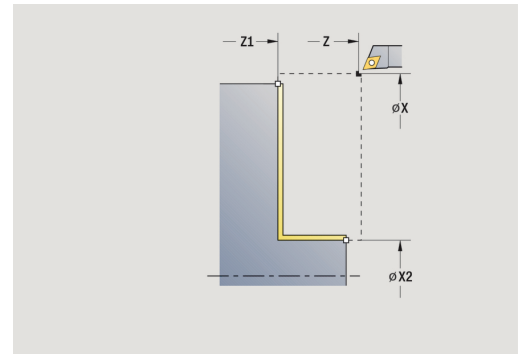
The cycle finishes the contour area from **Start point contour** to **End point contour**.



When the cycle is completed, the tool remains at the cycle end position.

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **DXX: Add. correction number** (range: 1-16)  
**Further information:** "Additive compensation Dxx", Page 186
- **G58: Contour-parallel oversize**
- **A: Start angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **R: Rounding**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **B1, B2: -B cham./+B round.** (**B1** at contour start and **B2** at contour end)
  - **B > 0:** Radius of rounding
  - **B < 0:** Width of chamfer
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T:** **M** function that is executed after the tool call **T**
- **MFS: M at beginning:** **M** function that is executed at the beginning of the machining step
- **MFE: M at end:** **M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)



- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**

Cycle run:

- 1 Move in longitudinal direction from the **Start point** to the **Start point contour X1, Z1**
- 2 Finish the contour area from the **Start point contour X1, Z1** to the **End point contour X2, Z2**, taking the optional contour elements into account
- 3 Move to the **Tool change point** according to the setting in **G14**

## Cutting, longitudinal plunge



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **Plunge longit.**

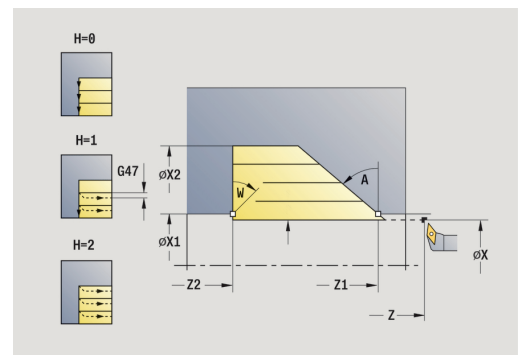
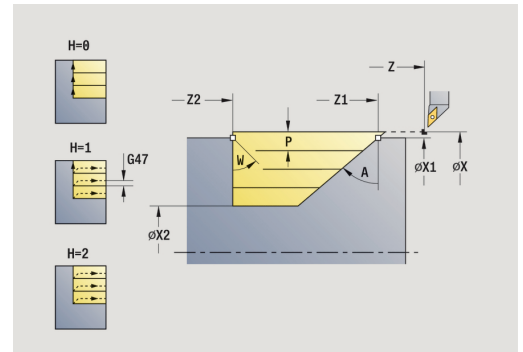
The cycle roughs the area described by the **Start point contour**, **End point contour** and **Plunging angle**.



- The tool plunges with the maximum possible angle, leaving material remaining
- The steeper the tool plunges into the material, the greater the feed rate decrease (max. 50 %)

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **P: Feed depth** – Maximum infeed depth
- **H: Contour smoothing**
  - **0: With each cut**
  - **1: With the last cut**
  - **2: No smoothing**
- **A: Plunging angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **G47: Safety clearance**  
Further information: "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
Further information: "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)





Type of machining for technology database access:  
**Roughing**

Cycle run:

- 1 Calculate the proportioning of cuts (infeed)
- 2 Approach the workpiece from the **Start point** on a paraxial path for the first pass
- 3 Plunge-cut at **Plunging angle A** with reduced feed
- 4 Move at the programmed feed rate to the **End point contour Z2** or to the oblique surface defined by the **Final angle W**
- 5 The contour is machined according to the setting in **Contour smoothing H**
- 6 Return and approach again for the next pass
- 7 Repeat 3 to 6 until the **End point contour X2** is reached
- 8 Return to the **Start point** on a paraxial path
- 9 Move to the **Tool change point** according to the setting in **G14**

## Cutting, transverse plunge



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **Plunge transv.**

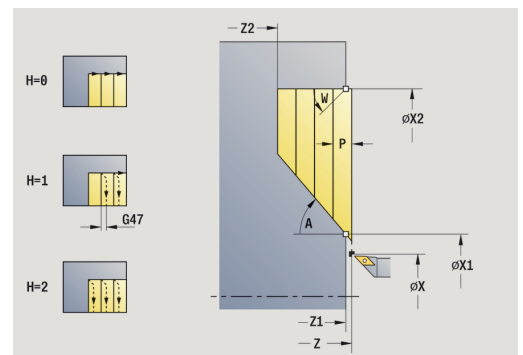
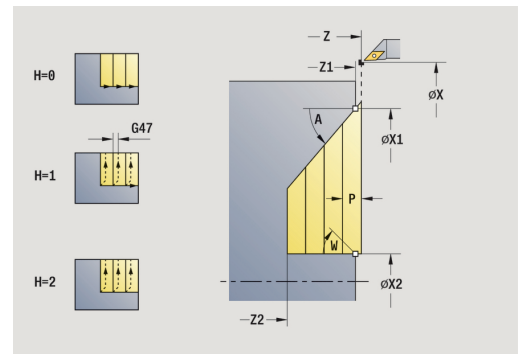
The cycle roughs the area described by the **Start point contour**, **End point contour** and **Plunging angle**.



- The tool plunges with the maximum possible angle, leaving material remaining
- The steeper the tool plunges into the material, the greater the feed rate decrease (max. 50 %)

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **P: Feed depth** – Maximum infeed depth
- **H: Contour smoothing**
  - **0: With each cut**
  - **1: With the last cut**
  - **2: No smoothing**
- **A: Plunging angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **G47: Safety clearance**  
Further information: "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
Further information: "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)







Type of machining for technology database access:  
**Roughing**

Cycle run:

- 1 Calculate the proportioning of cuts (infeed)
- 2 Approach the workpiece from the **Start point** on a paraxial path for the first pass
- 3 Plunge-cut at **Plunging angle A** with reduced feed
- 4 Move at the programmed feed rate to the **End point contour X2** or to the oblique surface defined by the **Final angle W**
- 5 The contour is machined according to the setting in **Contour smoothing H**
- 6 Return and approach again for the next pass
- 7 Repeat 3 to 6 until the **End point contour Z2** is reached
- 8 Return to the **Start point** on a paraxial path
- 9 Move to the **Tool change point** according to the setting in **G14**

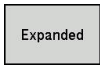
## Cutting, longitudinal plunge—Expanded



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **Plunge longit.**



- ▶ Select the **Expanded** soft key

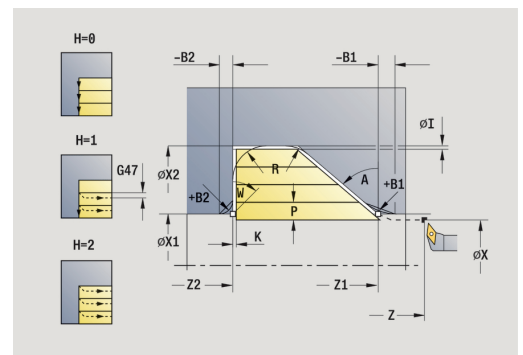
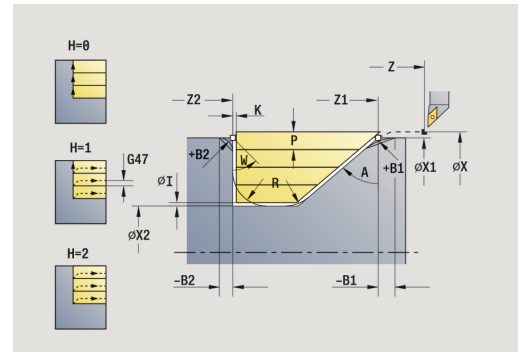
The cycle roughs the area described by the **Start point contour**, **End point contour** and **Plunging angle**, taking the oversizes into account.



- The tool plunges with the maximum possible angle, leaving material remaining
- The steeper the tool plunges into the material, the greater the feed rate decrease (max. 50 %)

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **P: Feed depth** – Maximum infeed depth
- **H: Contour smoothing**
  - **0: With each cut**
  - **1: With the last cut**
  - **2: No smoothing**
- **I, K: O-size X and Z**
- **A: Plunging angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **R: Rounding**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **B1, B2: -B cham./+B round.** (**B1** at contour start and **B2** at contour end)
- **BP: Interval time** – time during which the feed motion will be interrupted  
The chip is broken by the intermittent feed.
- **BF: Feed period** – time interval until the next break  
The chip is broken by the intermittent feed.
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step



- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Roughing**

Cycle run:

- 1 Calculate the proportioning of cuts (infeed)
- 2 Approach the workpiece from the **Start point** on a paraxial path for the first pass
- 3 Plunge-cut at **Plunging angle A** with reduced feed
- 4 Move at the programmed feed rate to the **End point contour Z2** or, if defined, to one of the optional contour elements
- 5 The contour is machined according to the setting in **Contour smoothing H**
- 6 Return and approach for the next pass
- 7 Repeat 3 to 6 until the **End point contour X2** is reached
- 8 Return to the **Start point** on a paraxial path
- 9 Move to the **Tool change point** according to the setting in **G14**

## Transverse cutting, plunge—Expanded



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **Plunge transv.**



- ▶ Select the **Expanded** soft key

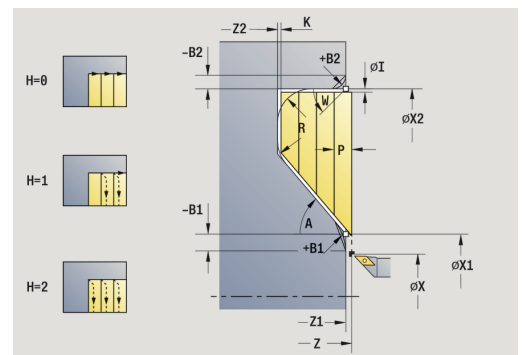
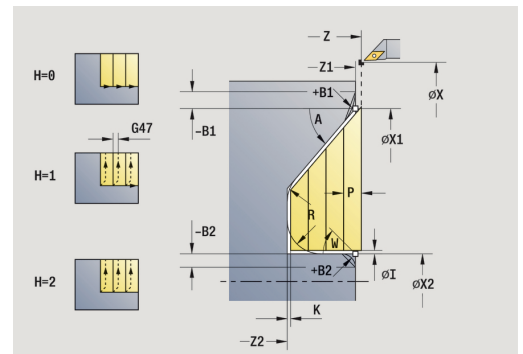
The cycle roughs the area described by the **Start point contour**, **End point contour** and **Plunging angle**, taking the oversizes into account.



- The tool plunges with the maximum possible angle, leaving material remaining
- The steeper the tool plunges into the material, the greater the feed rate decrease (max. 50 %)

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **P: Feed depth** – Maximum infeed depth
- **H: Contour smoothing**
  - **0: With each cut**
  - **1: With the last cut**
  - **2: No smoothing**
- **I, K: O-size X and Z**
- **A: Plunging angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **R: Rounding**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **B1, B2: -B cham./+B round.** (**B1** at contour start and **B2** at contour end)
- **BP: Interval time** – time during which the feed motion will be interrupted  
The chip is broken by the intermittent feed.
- **BF: Feed period** – time interval until the next break  
The chip is broken by the intermittent feed.
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step



- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Roughing**

Cycle run:

- 1 Calculate the proportioning of cuts (infeed)
- 2 Approach the workpiece from the **Start point** on a paraxial path for the first pass
- 3 Plunge-cut at **Plunging angle A** with reduced feed
- 4 Move at the programmed feed rate to the **End point contour X2** or, if defined, to one of the optional contour elements
- 5 The contour is machined according to the setting in **Contour smoothing H**
- 6 Retract and approach for the next pass
- 7 Repeat 3 to 6 until the **End point contour Z2** is reached
- 8 Return to the **Start point** on a paraxial path
- 9 Move to the **Tool change point** according to the setting in **G14**

## Longitudinal cutting, finishing plunge



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **Plunge longit.**



- ▶ Press the **Finishing run** soft key

The cycle finishes the contour area from **Start point contour** to **End point contour**. At the end of the cycle, the tool returns to the **Start point**.



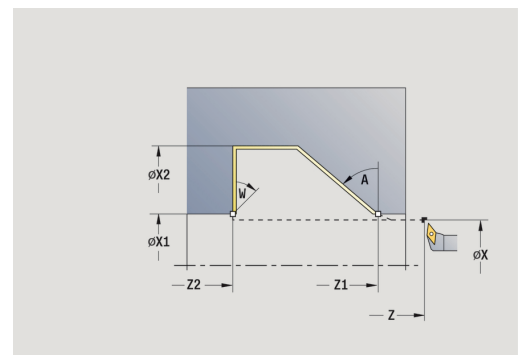
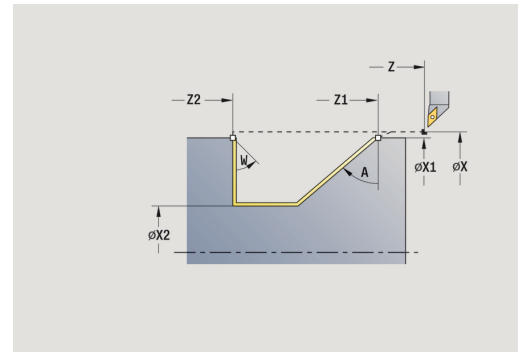
- The tool plunges with the maximum possible angle, leaving material remaining
- The steeper the tool plunges into the material, the greater the feed rate decrease (max. 50 %)

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **A: Plunging angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T:** M function that is executed after the tool call T
- **MFS: M at beginning:** M function that is executed at the beginning of the machining step
- **MFE: M at end:** M function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**



Cycle run:

- 1 Move in transverse direction from the **Start point** to the **Start point contour X1, Z1**
- 2 Finish the defined contour area
- 3 Return to the **Start point** on a paraxial path
- 4 Move to the **Tool change point** according to the setting in **G14**

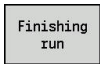
## Traverse cutting, finishing plunge



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **Plunge transv.**



- ▶ Press the **Finishing run** soft key

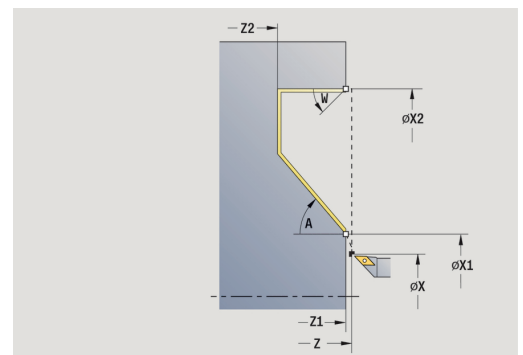
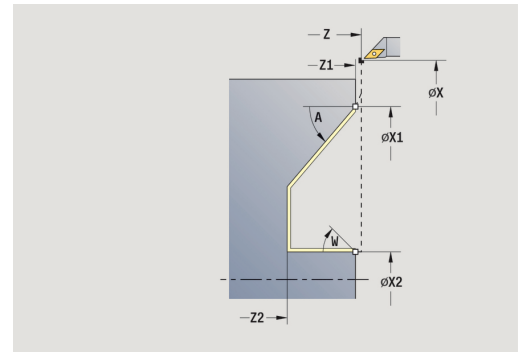
The cycle finishes the contour area from **Start point contour** to **End point contour**. At the end of the cycle, the tool returns to the **Start point**.



- The tool plunges with the maximum possible angle, leaving material remaining
- The steeper the tool plunges into the material, the greater the feed rate decrease (max. 50 %)

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **A: Plunging angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T:** M function that is executed after the tool call T
- **MFS: M at beginning:** M function that is executed at the beginning of the machining step
- **MFE: M at end:** M function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**



Cycle run:

- 1 Move in transverse direction from the **Start point** to the **Start point contour X1, Z1**
- 2 Finish the defined contour area
- 3 Return to the **Start point** on a paraxial path
- 4 Move to the **Tool change point** according to the setting in **G14**

## Longitudinal cutting, finishing plunge—Expanded



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **Plunge longit.**



- ▶ Select the **Expanded** soft key



- ▶ Press the **Finishing run** soft key

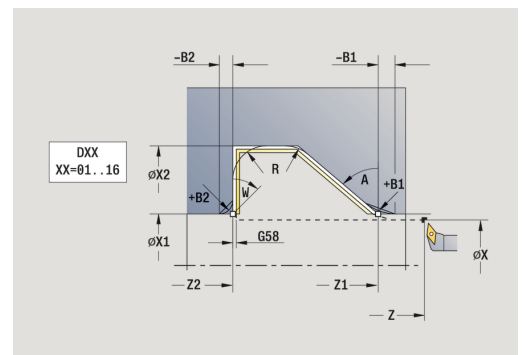
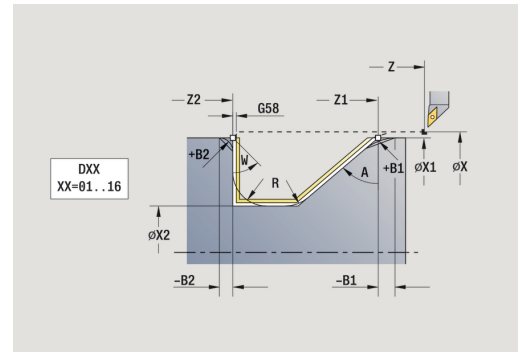
The cycle finishes the contour area from **Start point contour** to **End point contour**. When the cycle is completed, the tool remains at the cycle end position.



- The tool plunges with the maximum possible angle, leaving material remaining
- The steeper the tool plunges into the material, the greater the feed rate decrease (max. 50 %)

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **DXX: Add. correction number** (range: 1-16)  
**Further information:** "Additive compensation Dxx", Page 186
- **G58: Contour-parallel oversize**
- **A: Plunging angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **R: Rounding**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **B1, B2: -B cham./+B round.** (**B1** at contour start and **B2** at contour end)
  - **B > 0:** Radius of rounding
  - **B < 0:** Width of chamfer
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T:** M function that is executed after the tool call **T**
- **MFS: M at beginning:** M function that is executed at the beginning of the machining step
- **MFE: M at end:** M function that is executed at the end of the machining step



- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**

Cycle run:

- 1 Move on paraxial path from **Start point** to **Start point contour X1, Z1**
- 2 Finish the defined contour area, taking the optional contour elements into account
- 3 Move to the **Tool change point** according to the setting in **G14**

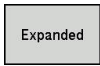
## Transverse cutting, finishing plunge—Expanded



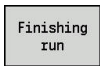
- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **Plunge transv.**



- ▶ Select the **Expanded** soft key



- ▶ Press the **Finishing run** soft key

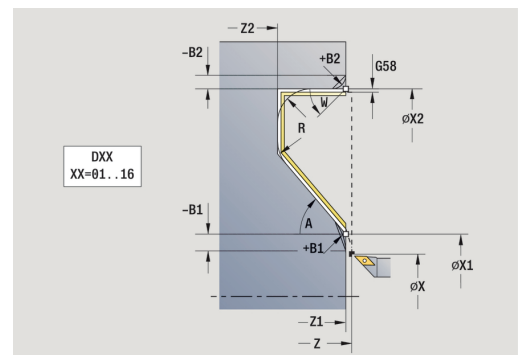
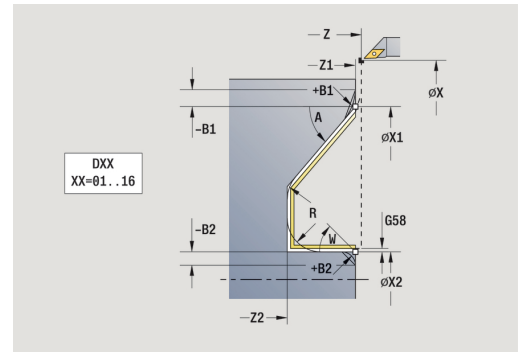
The cycle finishes the contour area from **Start point contour** to **End point contour**. When the cycle is completed, the tool remains at the cycle end position.



- The tool plunges with the maximum possible angle, leaving material remaining
- The steeper the tool plunges into the material, the greater the feed rate decrease (max. 50 %)

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **DXX: Add. correction number** (range: 1-16)  
**Further information:** "Additive compensation Dxx", Page 186
- **G58: Contour-parallel oversize**
- **A: Plunging angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **R: Rounding**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **B1, B2: -B cham./+B round.** (**B1** at contour start and **B2** at contour end)
  - **B > 0:** Radius of rounding
  - **B < 0:** Width of chamfer
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T:** **M** function that is executed after the tool call **T**
- **MFS: M at beginning:** **M** function that is executed at the beginning of the machining step
- **MFE: M at end:** **M** function that is executed at the end of the machining step



- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**

Cycle run:

- 1 Move on paraxial path from **Start point** to **Start point contour X1, Z1**
- 2 Finish the defined contour area, taking the optional contour elements into account
- 3 Move to the **Tool change point** according to the setting in **G14**

## Cutting, longitudinal, ICP contour-parallel



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **ICP-long.parallel contour**

The cycle roughs the defined area on contour-parallel paths.



- In this cycle, the workpiece will be roughed in a contour-parallel manner, depending on the **Workpiece blank oversize J** and **Type of cut lines H**:
  - **J = 0**: the area defined by **X, Z**, and the ICP contour, taking the oversizes into account
  - **J > 0**: the area defined by the ICP contour (plus oversizes) and the **Workpiece blank oversize J**
  - The tool plunges with the maximum possible angle, leaving material remaining

### NOTICE

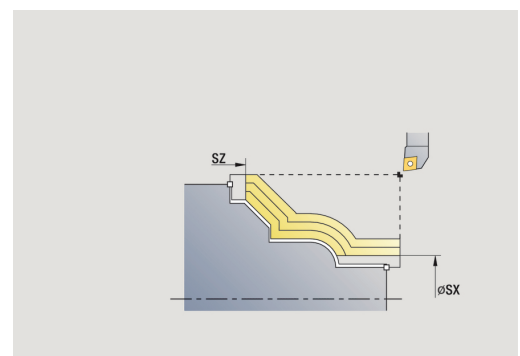
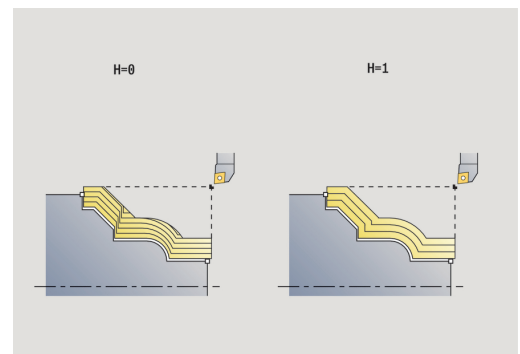
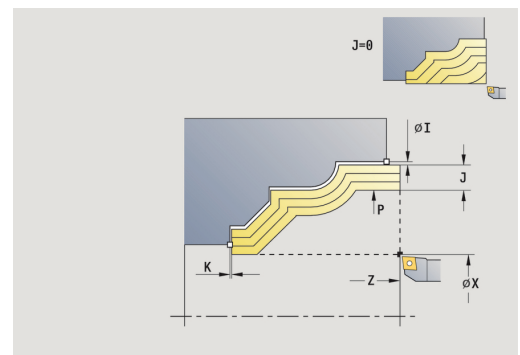
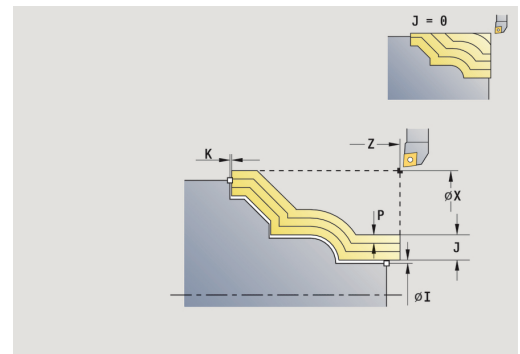
#### Danger of collision!

If **Workpiece blank oversize J > 0**, the control will not check whether the programmed **Feed depth P** is possible with the current cutting geometry in the transverse and longitudinal directions. Danger of collision during machining!

- ▶ Select a **Feed depth P** that fits the current cutting geometry

Cycle parameters:

- **X, Z**: **Start point**
- **FK**: **No. of ICP finished part** – Name of the contour to be machined
- **P**: **Feed depth** (is evaluated depending on **J**)
  - **J = 0**: **P** is the maximum infeed depth. The cycle reduces the infeed depth if the programmed infeed is not possible in the transverse or longitudinal direction due to the cutting geometry.
  - **J > 0**: **P** is the infeed depth. This infeed is used in the longitudinal and transverse directions.
- **H**: **Type of cut lines** – machining will be done as follows
  - **0**: **Constant mach.depth**
  - **1**: **Equidistant cut lines**
- **I, K**: **O-size X and Z**
- **J**: **Workpiece blank oversize**
  - **J = 0**: The cycle machines from the current tool position
  - **J > 0**: The cycle machines the area defined by the workpiece blank oversize
- **HR**: **Main machining direction**



- **SX, SZ: Cutting limit in X and Z**  
Further information: "Cutting limits SX, SZ", Page 186
- **G47: Safety clearance**  
Further information: "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
Further information: "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **BP: Interval time** – time during which the feed motion will be interrupted  
The chip is broken by the intermittent feed.
- **BF: Feed period** – time interval until the next break  
The chip is broken by the intermittent feed.
- **A: Start angle** (reference: Z axis; default: parallel to Z axis)
- **W: Depart. angle** (reference: Z axis; default: orthogonal to Z axis)
- **XA, ZA: Start point blank** (Definition of the corner point of the workpiece blank contour—an evaluation will only take place if no workpiece blank has been defined beforehand)
  - **XA, ZA** not programmed: The workpiece blank contour is calculated from the tool position and the ICP contour
  - **XA, ZA** programmed: Definition of the corner point of the workpiece blank
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Roughing**

Cycle run:

- 1 Calculate the proportioning of cuts (infeed), taking the **Workpiece blank oversize J** and the **Type of cut lines H** into account
  - **J = 0**: The cutting geometry is taken into account. This may result in the use of different infeeds for the longitudinal and transverse directions
  - **J > 0**: The same infeed is used for both the longitudinal and the transverse directions.
- 2 Approach the workpiece from the **Start point** on a paraxial path for the first pass
- 3 Machine the workpiece according to the calculated proportioning of cuts
- 4 Retract and approach for the next pass
- 5 Repeat 3 to 4 until the defined area has been machined
- 6 Return to the **Start point** on a paraxial path
- 7 Move to the **Tool change point** according to the setting in **G14**



### Cutting, transverse, ICP contour-parallel



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **ICP transv. parallel contour**

The cycle roughs the defined area on contour-parallel paths.



- In this cycle, the workpiece will be roughed in a contour-parallel manner, depending on the **Workpiece blank oversize J** and **Type of cut lines H**:
  - **J = 0**: the area defined by **X**, **Z**, and the ICP contour, taking the oversizes into account
  - **J > 0**: the area defined by the ICP contour (plus oversizes) and the **Workpiece blank oversize J**
  - The tool plunges with the maximum possible angle, leaving material remaining

### NOTICE

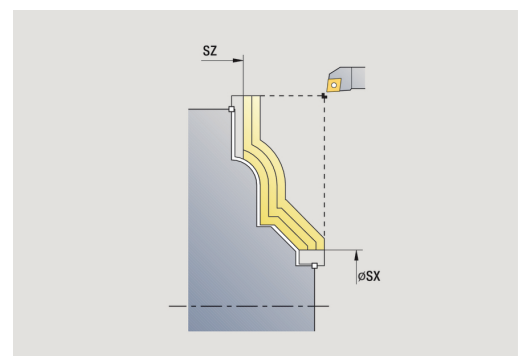
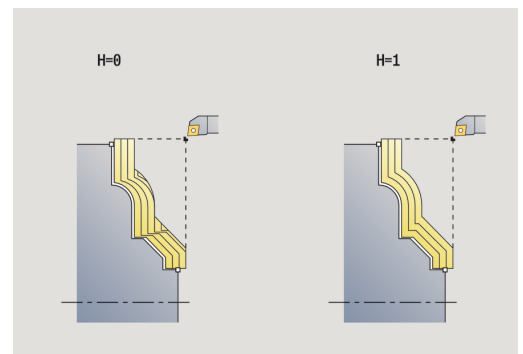
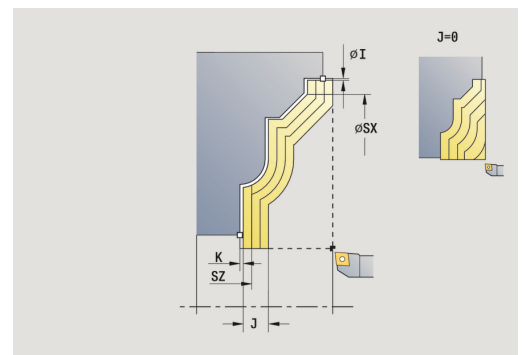
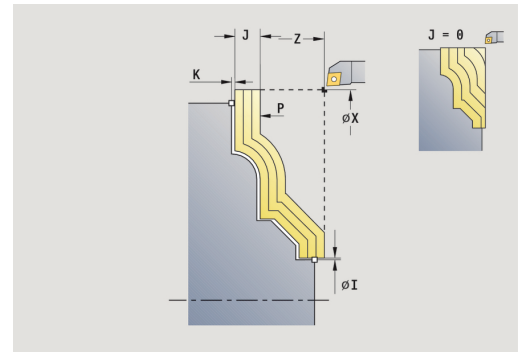
#### Danger of collision!

If **Workpiece blank oversize J > 0**, the control will not check whether the programmed **Feed depth P** is possible with the current cutting geometry in the transverse and longitudinal directions. Danger of collision during machining!

- ▶ Select a **Feed depth P** that fits the current cutting geometry

Cycle parameters:

- **X, Z**: **Start point**
- **FK**: **No. of ICP finished part** – Name of the contour to be machined
- **P**: **Feed depth** (is evaluated depending on **J**)
  - **J = 0**: **P** is the maximum infeed depth. The cycle reduces the infeed depth if the programmed infeed is not possible in the transverse or longitudinal direction due to the cutting geometry.
  - **J > 0**: **P** is the infeed depth. This infeed is used in the longitudinal and transverse directions.
- **H**: **Type of cut lines** – machining will be done as follows
  - **0**: **Constant mach.depth**
  - **1**: **Equidistant cut lines**
- **I, K**: **O-size X and Z**
- **J**: **Workpiece blank oversize**
  - **J = 0**: The cycle machines from the current tool position
  - **J > 0**: The cycle machines the area defined by the workpiece blank oversize
- **HR**: **Main machining direction**



- **SX, SZ: Cutting limit in X and Z**  
Further information: "Cutting limits SX, SZ", Page 186
- **G47: Safety clearance**  
Further information: "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
Further information: "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **BP: Interval time** – time during which the feed motion will be interrupted  
The chip is broken by the intermittent feed.
- **BF: Feed period** – time interval until the next break  
The chip is broken by the intermittent feed.
- **A: Start angle** (reference: Z axis; default: orthogonal to Z axis)
- **W: Depart. angle** (reference: Z axis; default: parallel to Z axis)
- **XA, ZA: Start point blank** (Definition of the corner point of the workpiece blank contour—an evaluation will only take place if no workpiece blank has been defined beforehand)
  - **XA, ZA** not programmed: The workpiece blank contour is calculated from the tool position and the ICP contour
  - **XA, ZA** programmed: Definition of the corner point of the workpiece blank
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Roughing**

Cycle run:

- 1 Calculate the proportioning of cuts (infeed), taking the **Workpiece blank oversize J** and the **Type of cut lines H** into account
  - **J = 0**: The cutting geometry is taken into account. This may result in the use of different infeeds for the longitudinal and transverse directions
  - **J > 0**: The same infeed is used for both the longitudinal and the transverse direction
- 2 Approach the workpiece from the **Start point** on a paraxial path for the first pass
- 3 Machine the workpiece according to the calculated proportioning of cuts
- 4 Return and approach for the next pass
- 5 Repeat 3 to 4 until the defined area has been machined
- 6 Return to the **Start point** on a paraxial path
- 7 Move to the **Tool change point** according to the setting in **G14**

## Cutting, longitudinal, ICP contour-parallel, finishing



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **ICP-long.parallel contour**



- ▶ Press the **Finishing run** soft key

The cycle finishes the contour area defined by the ICP contour. When the cycle is completed, the tool remains at the cycle end position.



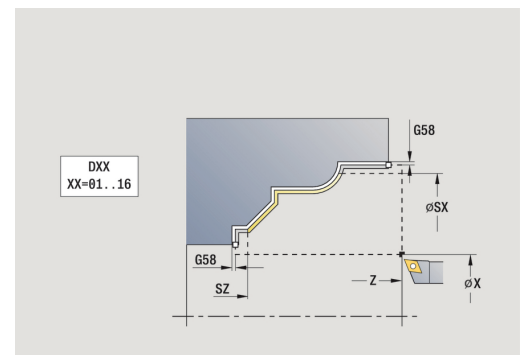
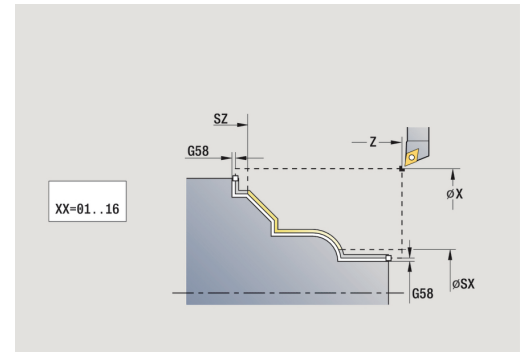
The tool plunges with the maximum possible angle, leaving material remaining.

Cycle parameters:

- **X, Z: Start point**
- **FK: No. of ICP finished part** – Name of the contour to be machined
- **DXX: Add. correction number** (range: 1-16)  
**Further information:** "Additive compensation Dxx", Page 186
- **G58: Contour-parallel oversize**
- **DI, DK: Oversize X and Z** paraxial
- **SX, SZ: Cutting limit in X and Z**  
**Further information:** "Cutting limits SX, SZ", Page 186
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**



Cycle run:

- 1 Move on a paraxial path from the **Start point** to the ICP contour starting point
- 2 Finish the defined contour area
- 3 Move to the **Tool change point** according to the setting in **G14**

## Cutting, transverse, ICP contour-parallel, finishing



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **ICP transv. parallel contour**



- ▶ Press the **Finishing run** soft key

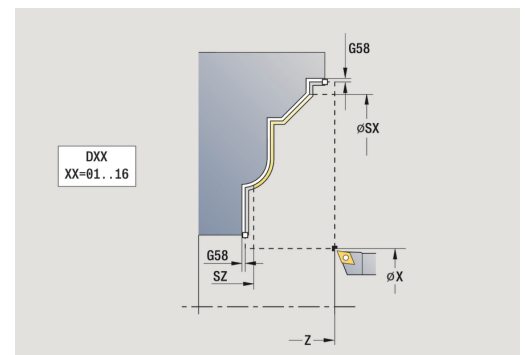
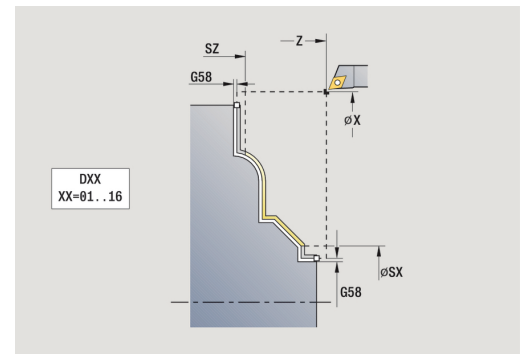
The cycle finishes the contour area defined by the ICP contour. When the cycle is completed, the tool remains at the cycle end position.



The tool plunges with the maximum possible angle, leaving material remaining.

Cycle parameters:

- **X, Z: Start point**
- **FK: No. of ICP finished part** – Name of the contour to be machined
- **DXX: Add. correction number** (range: 1-16)  
**Further information:** "Additive compensation Dxx", Page 186
- **G58: Contour-parallel oversize**
- **DI, DK: Oversize X and Z** paraxial
- **SX, SZ: Cutting limit in X and Z**  
**Further information:** "Cutting limits SX, SZ", Page 186
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**

Cycle run:

- 1 Move on a paraxial path from the **Start point** to the ICP contour starting point
- 2 Finish the defined contour area
- 3 Move to the **Tool change point** according to the setting in **G14**

## ICP cut longitud.



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **ICP cutting longitudinal**

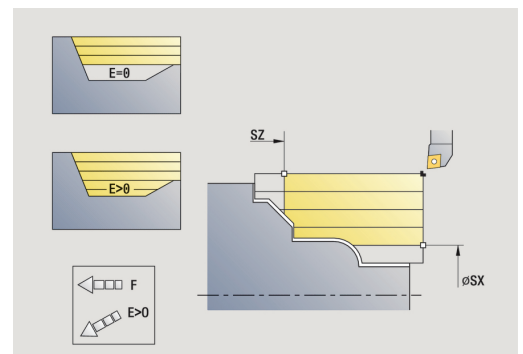
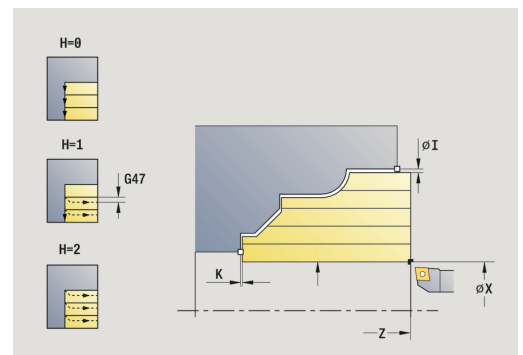
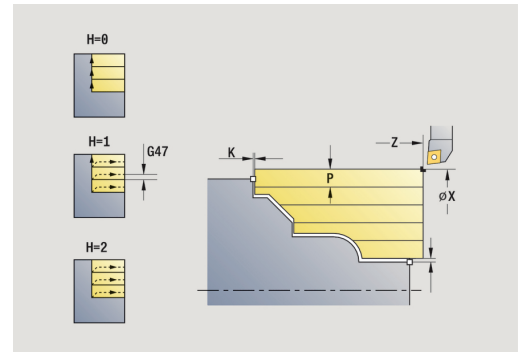
The cycle roughs the area defined by the **Start point** and the ICP contour, taking the oversizes into account.



- The tool plunges with the maximum possible angle, leaving material remaining
- The steeper the tool plunges into the material, the greater the feed rate decrease (max. 50 %)

Cycle parameters:

- **X, Z: Start point**
- **FK: No. of ICP finished part** – Name of the contour to be machined
- **P: Feed depth** – Maximum infeed depth
- **H: Contour smoothing**
  - **0: With each cut**
  - **1: With the last cut**
  - **2: No smoothing**
- **I, K: O-size X and Z**
- **E: Plunging behavior**
  - No input: Automatic feed-rate reduction
  - **E = 0:** No plunging
  - **E > 0:** Plunging feed rate in use
- **O: Hide undercutting**
- **SX, SZ: Cutting limit in X and Z**  
**Further information:** "Cutting limits SX, SZ", Page 186
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **BP: Interval time** – time during which the feed motion will be interrupted  
 The chip is broken by the intermittent feed.
- **BF: Feed period** – time interval until the next break  
 The chip is broken by the intermittent feed.
- **A: Start angle** (reference: Z axis; default: parallel to Z axis)
- **W: Depart.angle** (reference: Z axis; default: orthogonal to Z axis)





- **XA, ZA: Start point blank** (Definition of the corner point of the workpiece blank contour—an evaluation will only take place if no workpiece blank has been defined beforehand)
  - **XA, ZA** not programmed: The workpiece blank contour is calculated from the tool position and the ICP contour
  - **XA, ZA** programmed: Definition of the corner point of the workpiece blank
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Roughing**

Cycle run:

- 1 Calculate the proportioning of cuts (infeed)
- 2 Approach the workpiece from the **Start point** on a paraxial path for the first pass
- 3 For descending contours, plunge into the material at a reduced feed rate
- 4 Machine the workpiece according to the calculated proportioning of cuts
- 5 The contour is machined according to the setting in **Contour smoothing H**
- 6 Retract and approach for the next pass
- 7 Repeat 3 to 6 until the defined area has been machined
- 8 Return to the **Start point** on a paraxial path
- 9 Move to the **Tool change point** according to the setting in **G14**

## ICP cutting transverse



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **ICP cutting transverse**

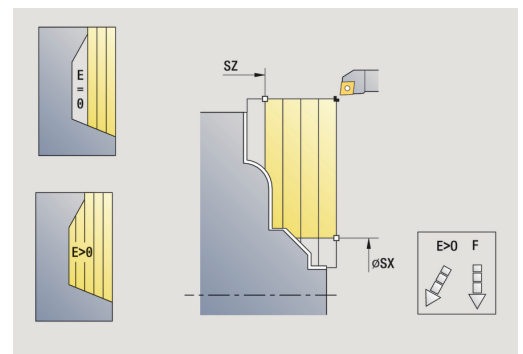
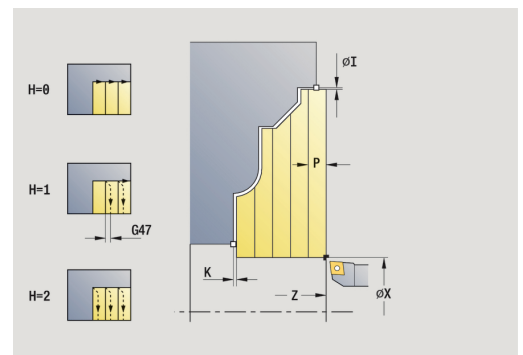
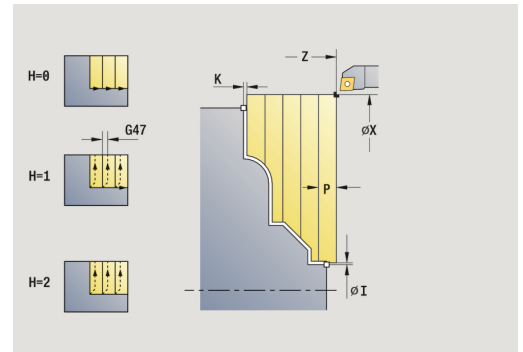
The cycle roughs the area defined by the start point and the ICP contour, taking the oversizes into account.



- The tool plunges with the maximum possible angle, leaving material remaining
- The steeper the tool plunges into the material, the greater the feed rate decrease (max. 50 %)

Cycle parameters:

- **X, Z: Start point**
- **FK: No. of ICP finished part** – Name of the contour to be machined
- **P: Feed depth** – Maximum infeed depth
- **H: Contour smoothing**
  - **0: With each cut**
  - **1: With the last cut**
  - **2: No smoothing**
- **I, K: O-size X and Z**
- **E: Plunging behavior**
  - No input: Automatic feed-rate reduction
  - **E = 0:** No plunging
  - **E > 0:** Plunging feed rate in use
- **O: Hide undercutting**
- **SX, SZ: Cutting limit in X and Z**  
**Further information:** "Cutting limits SX, SZ", Page 186
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **BP: Interval time** – time during which the feed motion will be interrupted  
 The chip is broken by the intermittent feed.
- **BF: Feed period** – time interval until the next break  
 The chip is broken by the intermittent feed.
- **A: Start angle** (reference: Z axis; default: parallel to Z axis)
- **W: Depart.angle** (reference: Z axis; default: orthogonal to Z axis)



- **XA, ZA: Start point blank** (Definition of the corner point of the workpiece blank contour—an evaluation will only take place if no workpiece blank has been defined beforehand)
  - **XA, ZA** not programmed: The workpiece blank contour is calculated from the tool position and the ICP contour
  - **XA, ZA** programmed: Definition of the corner point of the workpiece blank
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Roughing**

Cycle run:

- 1 Calculate the proportioning of cuts (infeed)
- 2 Approach the workpiece from the **Start point** on a paraxial path for the first pass
- 3 For descending contours, plunge into the material at a reduced feed rate
- 4 Machine the workpiece according to the calculated proportioning of cuts
- 5 The contour is machined according to the setting in **Contour smoothing H**
- 6 Return and approach for the next pass
- 7 Repeat 3 to 6 until the defined area has been machined
- 8 Return to the **Start point** on a paraxial path
- 9 Move to the **Tool change point** according to the setting in **G14**

## Longitudinal ICP cutting, finishing



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **ICP cutting longitudinal**



- ▶ Press the **Finishing run** soft key

The cycle finishes the contour area defined by the ICP contour. When the cycle is completed, the tool remains at the cycle end position.



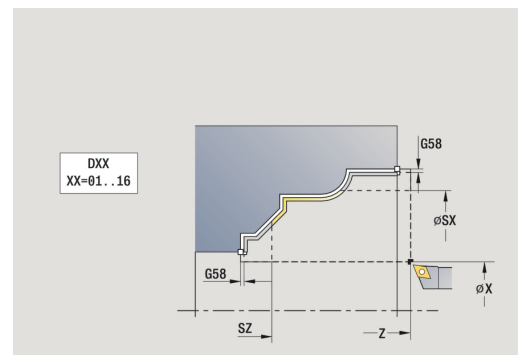
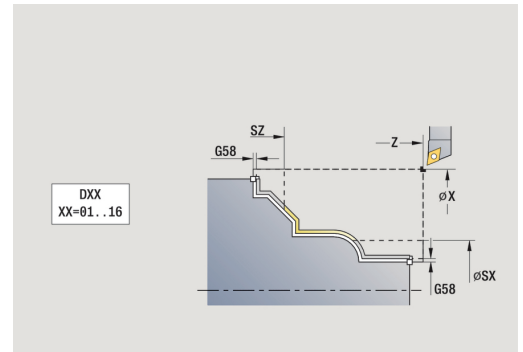
The tool plunges with the maximum possible angle, leaving material remaining.

Cycle parameters:

- **X, Z: Start point**
- **FK: No. of ICP finished part** – Name of the contour to be machined
- **DXX: Add. correction number** (range: 1-16)  
**Further information:** "Additive compensation Dxx", Page 186
- **G58: Contour-parallel oversize**
- **DI, DK: Oversize X and Z** paraxial
- **SX, SZ: Cutting limit in X and Z**  
**Further information:** "Cutting limits SX, SZ", Page 186
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**



Cycle run:

- 1 Move on a paraxial path from the **Start point** to the ICP contour starting point
- 2 Finish the defined contour area
- 3 Move to the **Tool change point** according to the setting in **G14**

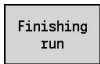
## Transverse ICP cutting, finishing



- ▶ Select **Roughing cycles lon/trans**



- ▶ Select **ICP cutting transverse**



- ▶ Press the **Finishing run** soft key

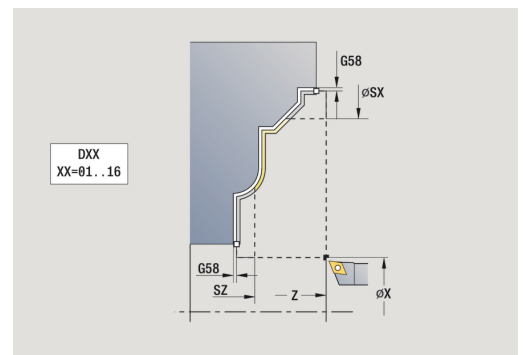
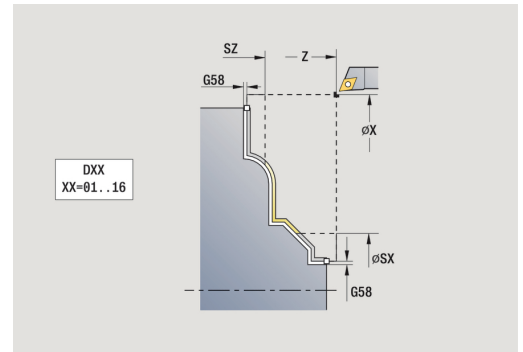
The cycle finishes the contour area defined by the ICP contour. When the cycle is completed, the tool remains at the cycle end position.



The tool plunges with the maximum possible angle, leaving material remaining.

Cycle parameters:

- **X, Z: Start point**
- **FK: No. of ICP finished part** – Name of the contour to be machined
- **DXX: Add. correction number** (range: 1-16)  
**Further information:** "Additive compensation Dxx", Page 186
- **G58: Contour-parallel oversize**
- **DI, DK: Oversize X and Z** paraxial
- **SX, SZ: Cutting limit in X and Z**  
**Further information:** "Cutting limits SX, SZ", Page 186
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**

Cycle run:

- 1 Move on a paraxial path from the **Start point** to the ICP contour starting point
- 2 Finish the defined contour area
- 3 Move to the **Tool change point** according to the setting in **G14**

## Examples of turning cycles

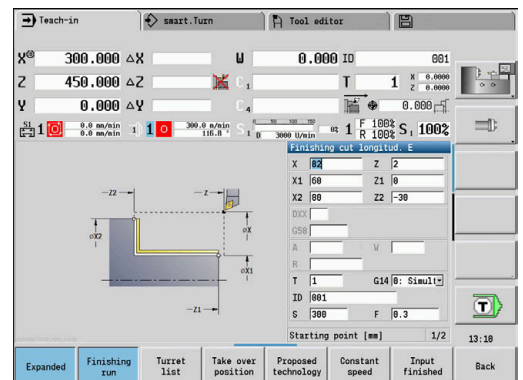
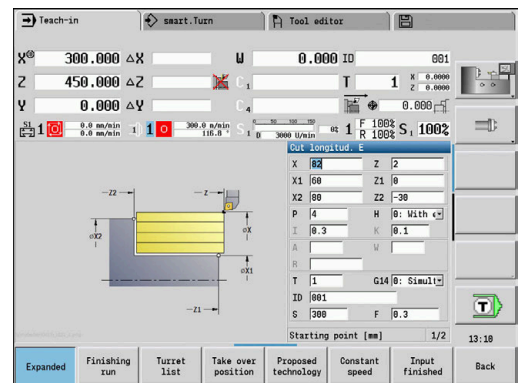
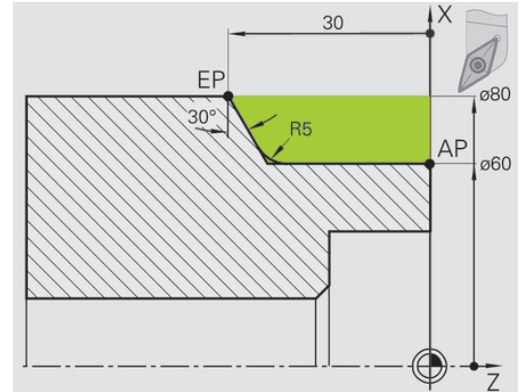
### Roughing and finishing an outside contour

The shaded area from **AP (Start point contour)** to **EP (End point contour)** is roughed with the "Cut longitudinal—expanded" cycle, taking oversizes into account. This contour area will be finished subsequently with the "Finishing cut longitudinal—expanded" cycle. The rounding arc and the oblique cut at the contour end are both machined in **expanded mode**.

The **Start point contour X1, Z1** and **End point contour X2, Z2** parameters determine the cutting and infeed directions—in this example, outside machining and infeed in negative X-axis direction.

Tool data:

- Turning tool (for external machining)
- **TO** = 1 – Tool orientation
- **A** = 93° – Tool angle
- **B** = 55° – Point angle





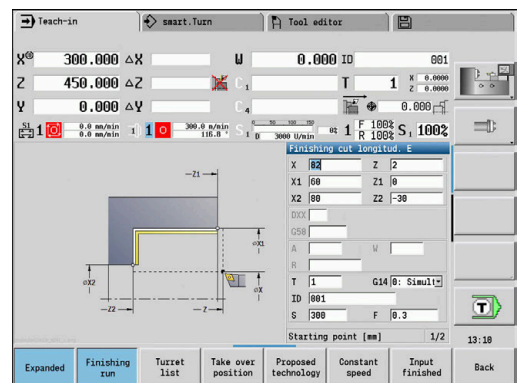
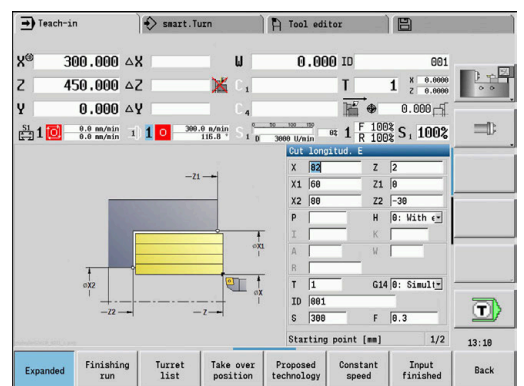
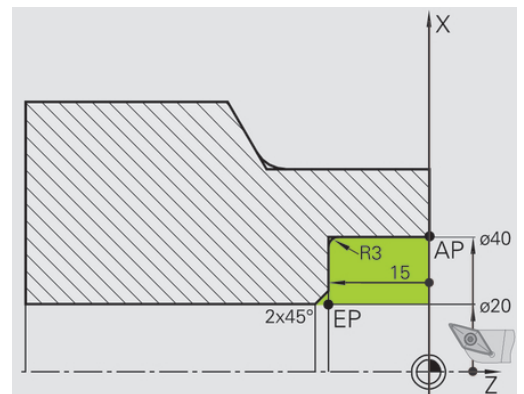
### Roughing and finishing an inside contour

The shaded area from **AP (Start point contour)** to **EP (End point contour)** is roughed with the "Cut longitudinal—expanded" cycle, taking oversizes into account. This contour area will be finished subsequently with the "Finishing cut longitudinal—expanded" cycle. The rounding arc and the chamfer at the contour end are both machined in **expanded mode**.

The **Start point contour X1, Z1** and **End point contour X2, Z2** parameters determine the cutting and infeed directions—in this example, inside machining and infeed in positive X-axis direction.

Tool data:

- Turning tool (for internal machining)
- **TO** = 7 – Tool orientation
- **A** = 93° – Tool angle
- **B** = 55° – Point angle



### Roughing (hollowing) with the plunge cycle

The tool to be used cannot plunge at the required angle of 15°. The roughing process for the area therefore requires two steps.

#### 1st step

The shaded area from **AP (Start point contour)** to **EP (End point contour)** is roughed with the **Plunge longit. E** cycle, taking oversizes into account.

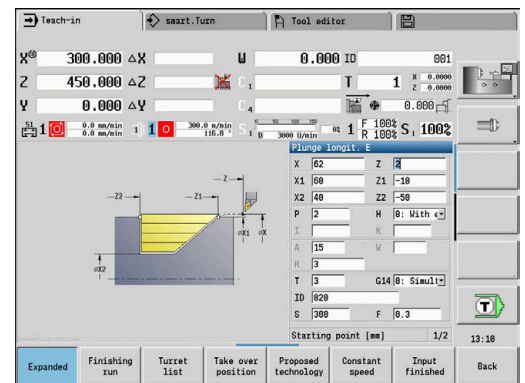
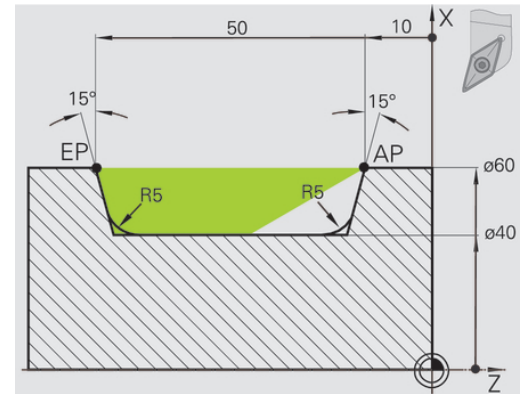
The **Start. angle A** is defined with 15°, as dimensioned in the workpiece drawing. Based on the tool parameters, the control calculates the maximum plunge angle that can be achieved with the programmed tool. The residual material will be cut off in the second step.

The **expanded mode** is used to machine the rounding arcs in the contour valley.

Be sure to enter the correct values for the **Start point contour X1, Z1** and **End point contour X2, Z2** parameters. These parameters determine the cutting and infeed directions—in this example, outside machining and infeed in negative X-axis direction.

Tool data:

- Turning tool (for external machining)
- **TO** = 1 – Tool orientation
- **A** = 93° – Tool angle
- **B** = 55° – Point angle



### 2nd step

The area that was left out in the first step (shaded area in the figure) is machined with the **Plunge longit. E** cycle. Before executing this step, you must change tools.

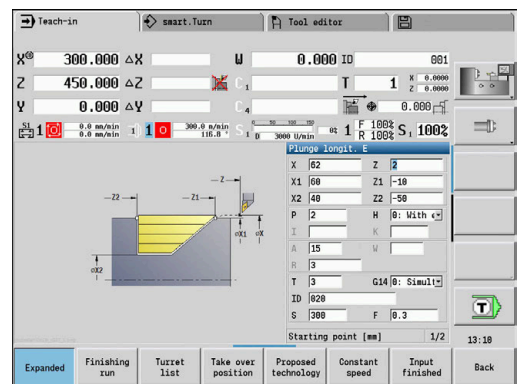
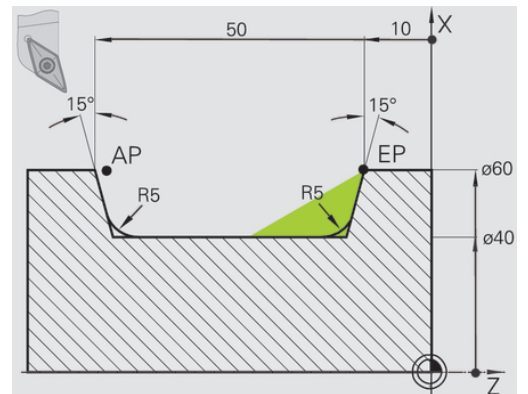
The **expanded mode** is used to machine the rounding arcs in the contour valley.

The **Start point contour X1, Z1** and **End point contour X2, Z2** parameters determine the cutting and infeed directions—in this example, outside machining and infeed in negative X-axis direction.


The **Start point contour Z1** parameter was determined during simulation of the first step.

Tool data:

- Turning tool (for external machining)
- **TO** = 3 – Tool orientation
- **A** = 93° – Tool angle
- **B** = 55° – Point angle



## 5.5 Recessing cycles

Menu item	Meaning
	The recessing cycle group comprises recessing, recess turning, undercut and parting cycles. Simple contours can be machined in <b>basic mode</b> , complex contours in <b>expanded mode</b> .

ICP recessing cycles machine contours defined with ICP.

**Further information:** "ICP contours", Page 424







- i**
- **Proportioning of cuts:** The control calculates a constant recessing width that is  $\leq P$
  - Oversizes are considered in **expanded mode**
  - Tool-tip radius compensation is conducted (exception: **Undercut type K**)

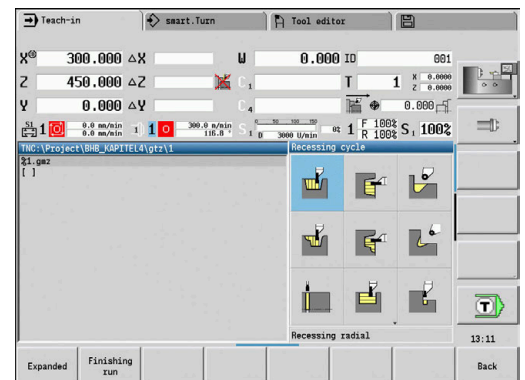
### Cutting and infeed directions for recessing cycles:




The control determines the cutting and infeed directions from the cycle parameters.

The decisive ones are:

- **Basic mode:** The parameters for **Starting point X, Z** (in **Machine** operating mode: current tool position) and **Start point contour X1 / End point contour Z2**
- **Expanded mode:** The parameters for **Start point contour X1, Z1** and **End point contour X2, Z2**
- **ICP cycles:** The parameters for **Starting point X, Z** (in **Machine** operating mode: current tool position) and starting point of ICP contour

Menu item	Recessing cycles
 	<b>Recessing radial/Recessing axial</b> Recessing and finishing cycles for simple contours
 	<b>ICP recessing radial/ICP recessing axial</b> Recessing and finishing cycles for any contour
	<b>Recess turning radial/Recess turning axial</b> Recess-turning and finishing cycles for simple contours and any type of contour
	<b>Undercut. Form H</b> Undercut type H









Menu item	Recessing cycles
	<b>Undercut. Form K</b> Undercut type K
	<b>Undercut. Form U</b> Undercut type U
	<b>Cut-off</b> Cycle for parting the workpiece

### Undercut position

The control determines the position of an undercut from the cycle parameters for **Start point X, Z** (in **Machine** mode: current tool position) and **Start point contour X1, Z1**.

### Contour forms

#### Contour elements in recessing cycles

	<b>Basic mode</b> Machining a rectangular area
	<b>Expanded mode</b> Oblique cut at contour start
	<b>Expanded mode</b> Oblique cut at contour end
	<b>Expanded mode</b> Rounding arc in both corners of contour valley
	<b>Expanded mode</b> Chamfer or rounding arc at contour start
	<b>Expanded mode</b> Chamfer or rounding arc at contour end

## Recessing radial



- ▶ Select **Recessing cycle**

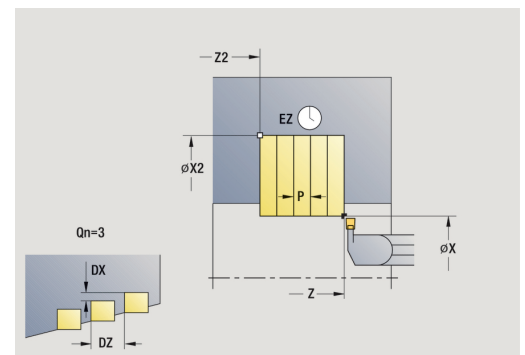
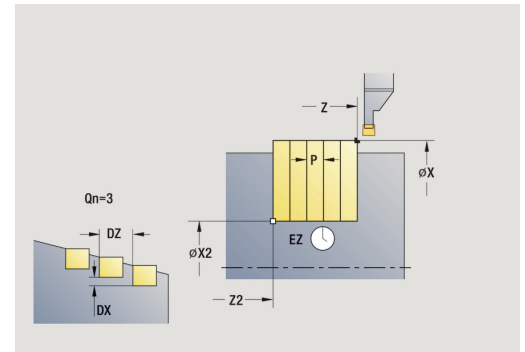


- ▶ Select **Recessing radial**

The cycle machines the number of recesses defined in **Number of recess cycles Qn**. The **Start point** and **End point contour** parameters define the first recess (position, recess depth and recess width).

Cycle parameters:

- **X, Z: Start point**
- **X2, Z2: End point contour**
- **P: Cut. width** – Infeeds  $\leq P$  (no input:  $P = 0.8 * \text{cutting width of the tool}$ )
- **EZ: Delay** – Dwell time for chip breaking (default: length of time for two revolutions)
- **Qn: Number of recess cycles** (default: 1)
- **DX, DZ: Dist. to subsequent recess** relative to the preceding recess
- **G47: Safety clearance**  
Further information: "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
Further information: "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Contour recessing**



In this cycle you can specify how the floor element is machined during the finishing process.

The control evaluates the **recessFinishing** (602414) machining parameter for this purpose. If this parameter is not defined, the floor element is divided in the center.

Cycle run:

- 1 Calculate the recess positions and the proportioning of cuts
- 2 Approach the workpiece for the next recess on a paraxial path from the **Start point** or from the last recess
- 3 Move to the **End point contour X2** at the programmed feed rate
- 4 Remain at this position for the dwell time **Delay EZ**
- 5 Retract and approach for the next pass
- 6 Repeat 3 to 5 until the complete recess has been machined
- 7 Repeat 2 to 6 until all recesses have been machined
- 8 Return to the **Start point** on a paraxial path
- 9 Move to the **Tool change point** according to the setting in **G14**

## Recessing axial



- ▶ Select **Recessing cycle**

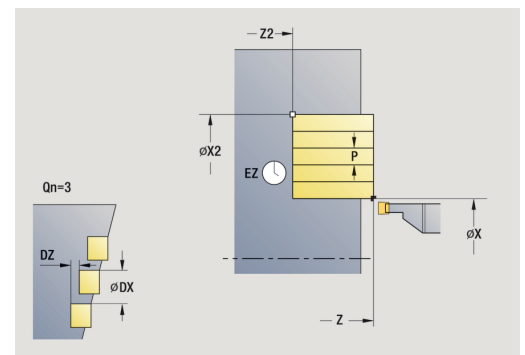
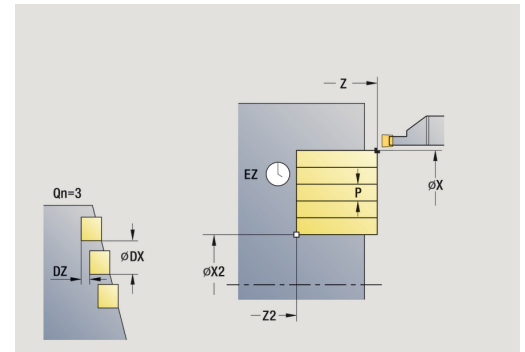


- ▶ Select **Recessing axial**

The cycle machines the number of recesses defined in **Number of recess cycles Qn**. The **Start point** and **End point contour** parameters define the first recess (position, recess depth and recess width).

Cycle parameters:

- **X, Z: Start point**
- **X2, Z2: End point contour**
- **P: Cut. width** – Infeeds  $\leq P$  (no input:  $P = 0.8 \cdot$  cutting width of the tool)
- **EZ: Delay** – Dwell time for chip breaking (default: length of time for two revolutions)
- **Qn: Number of recess cycles** (default: 1)
- **DX, DZ: Dist. to subsequent recess** relative to the preceding recess
- **G47: Safety clearance**  
Further information: "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
Further information: "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Contour recessing**





In this cycle you can specify how the floor element is machined during the finishing process.

The control evaluates the **recessFinishing** (602414) machining parameter for this purpose. If this parameter is not defined, the floor element is divided in the center.

Cycle run:

- 1 Calculate the recess positions and the proportioning of cuts
- 2 Approach the workpiece for the next recess on a paraxial path from the **Start point** or from the last recess
- 3 Move to the **End point contour Z2** at the programmed feed rate
- 4 Remain at this position for the dwell time **Delay EZ**
- 5 Retract and approach for the next pass
- 6 Repeat 3 to 5 until the complete recess has been machined
- 7 Repeat 2 to 6 until all recesses have been machined
- 8 Return to the **Start point** on a paraxial path
- 9 Move to the **Tool change point** according to the setting in **G14**

## Recessing radial—Expanded



- ▶ Select **Recessing cycle**



- ▶ Select **Recessing radial**

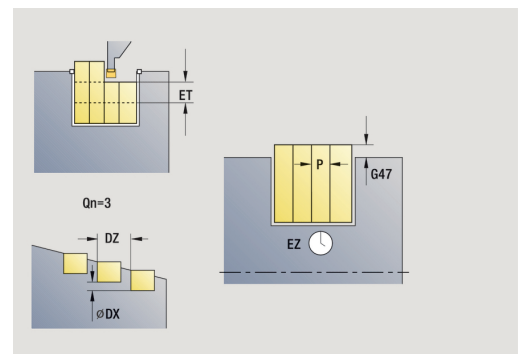
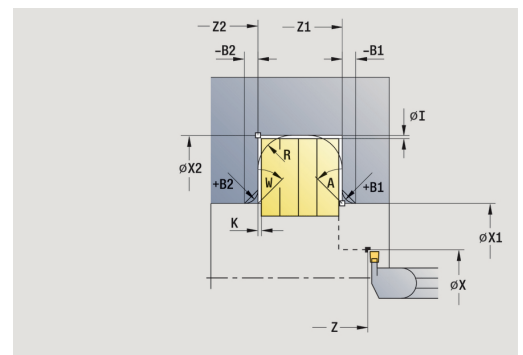
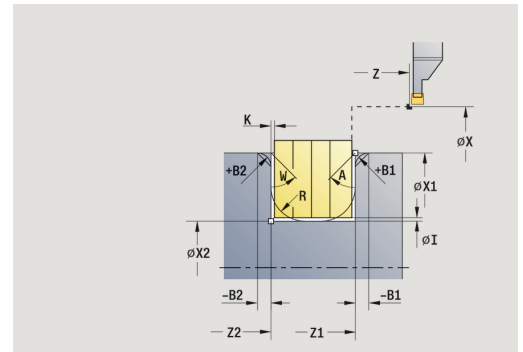


- ▶ Select the **Expanded** soft key

The cycle machines the number of recesses defined in **Number of recess cycles Qn**. The **Start point** and **End point contour** parameters define the first recess (position, recess depth and recess width).

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **B1, B2: -B chamf./+B round.** (**B1** at contour start and **B2** at contour end)
  - **B > 0:** Radius of rounding
  - **B < 0:** Width of chamfer
- **A: Start angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **R: Rounding**
- **I, K: O-size X and Z**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **P: Cut. width** – Infeeds  $\leq P$  (no input:  $P = 0.8 \cdot$  cutting width of the tool)
- **ET: Recess depth** per infeed
- **EZ: Delay** – Dwell time for chip breaking (default: length of time for two revolutions)
- **Qn: Number of recess cycles** (default: 1)
- **DX, DZ: Dist.to subsequent recess** relative to the preceding recess
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T:** M function that is executed after the tool call **T**
- **MFS: M at beginning:** M function that is executed at the beginning of the machining step
- **MFE: M at end:** M function that is executed at the end of the machining step



- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Contour recessing**



In this cycle you can specify how the floor element is machined during the finishing process.  
The control evaluates the **recessFinishing** (602414) machining parameter for this purpose. If this parameter is not defined, the floor element is divided in the center.

Cycle run:

- 1 Calculate the recess positions and the proportioning of cuts
- 2 Approach the workpiece for the next recess on a paraxial path from the **Start point** or from the last recess
- 3 Move at the programmed feed rate to the **End point contour X2** or, if defined, to one of the optional contour elements
- 4 Remain at this position for the dwell time **Delay EZ**
- 5 Retract and approach for the next pass
- 6 Repeat 3 to 5 until the complete recess has been machined
- 7 Repeat 2 to 6 until all recesses have been machined
- 8 Return to the **Start point** on a paraxial path
- 9 Move to the **Tool change point** according to the setting in **G14**

## Recessing axial—Expanded



- ▶ Select **Recessing cycle**



- ▶ Select **Recessing axial**

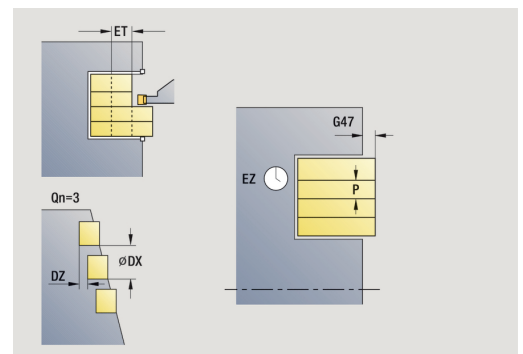
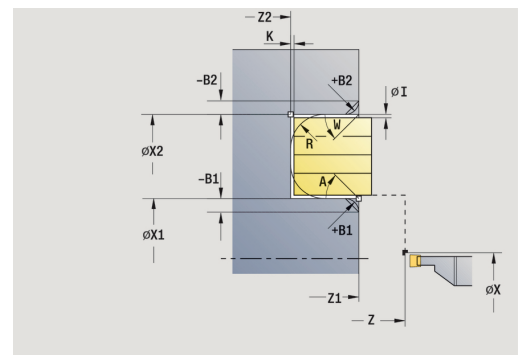
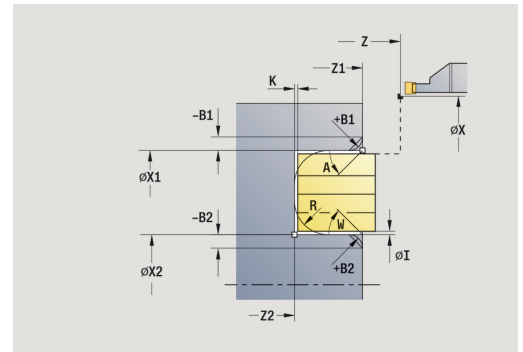


- ▶ Select the **Expanded** soft key

The cycle machines the number of recesses defined in **Number of recess cycles Qn**. The **Start point** and **End point contour** parameters define the first recess (position, recess depth and recess width).

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **B1, B2: -B chamf./+B round.** (**B1** at contour start and **B2** at contour end)
  - **B > 0:** Radius of rounding
  - **B < 0:** Width of chamfer
- **A: Start angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **R: Rounding**
- **I, K: O-size X and Z**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **P: Cut. width** – Infeeds  $\leq P$  (no input:  $P = 0.8 \cdot$  cutting width of the tool)
- **ET: Recess depth** per infeed
- **EZ: Delay** – Dwell time for chip breaking (default: length of time for two revolutions)
- **Qn: Number of recess cycles** (default: 1)
- **DX, DZ: Dist.to subsequent recess** relative to the preceding recess
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T:** M function that is executed after the tool call **T**
- **MFS: M at beginning:** M function that is executed at the beginning of the machining step
- **MFE: M at end:** M function that is executed at the end of the machining step



- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Contour recessing**



In this cycle you can specify how the floor element is machined during the finishing process.  
The control evaluates the **recessFinishing** (602414) machining parameter for this purpose. If this parameter is not defined, the floor element is divided in the center.

Cycle run:

- 1 Calculate the recess positions and the proportioning of cuts
- 2 Approach the workpiece for the next recess on a paraxial path from the **Start point** or from the last recess
- 3 Move at the programmed feed rate to the **End point contour Z2** or, if defined, to one of the optional contour elements
- 4 Remain at this position for the dwell time **Delay EZ**
- 5 Retract and approach for the next pass
- 6 Repeat 3 to 5 until the complete recess has been machined
- 7 Repeat 2 to 6 until all recesses have been machined
- 8 Return to the **Start point** on a paraxial path
- 9 Move to the **Tool change point** according to the setting in **G14**

## Recessing radial finishing



- ▶ Select **Recessing cycle**



- ▶ Select **Recessing radial**

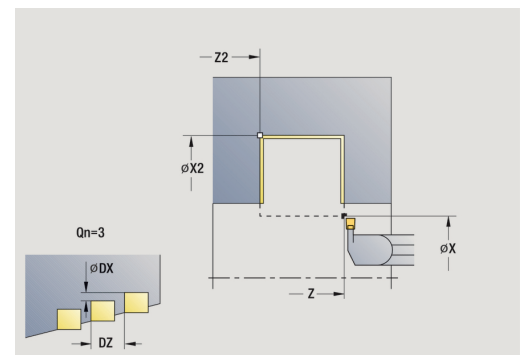
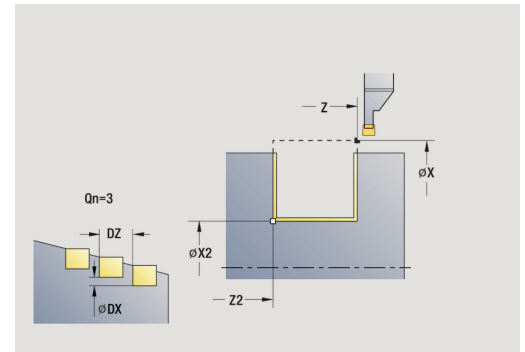


- ▶ Press the **Finishing run** soft key

The cycle machines the number of recesses defined in **Number of recess cycles Qn**. The **Start point** and **End point contour** parameters define the first recess (position, recess depth and recess width).

Cycle parameters:

- **X, Z: Start point**
- **X2, Z2: End point contour**
- **Qn: Number of recess cycles** (default: 1)
- **DX, DZ: Dist.to subsequent recess** relative to the preceding recess
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Contour recessing**



In this cycle you can specify how the floor element is machined during the finishing process.  
The control evaluates the **recessFinishing** (602414) machining parameter for this purpose. If this parameter is not defined, the floor element is divided in the center.

Cycle run:

- 1 Calculate the recess positions
- 2 Approach the workpiece for the next recess on a paraxial path from the **Start point** or from the last recess
- 3 Finish the first side and the contour valley up to a position just before the recess end point
- 4 Approach the workpiece on a paraxial path for finishing the second side
- 5 Finish the second side and the remainder of the contour valley
- 6 Repeat 2 to 5 until all recesses have been machined
- 7 Return to the **Start point** on a paraxial path
- 8 Move to the **Tool change point** according to the setting in **G14**

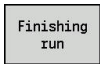
## Recessing axial finishing



- ▶ Select **Recessing cycle**



- ▶ Select **Recessing axial**

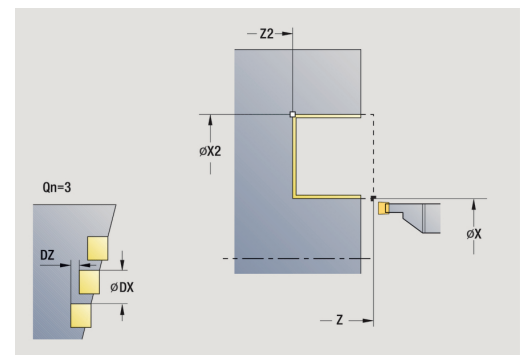
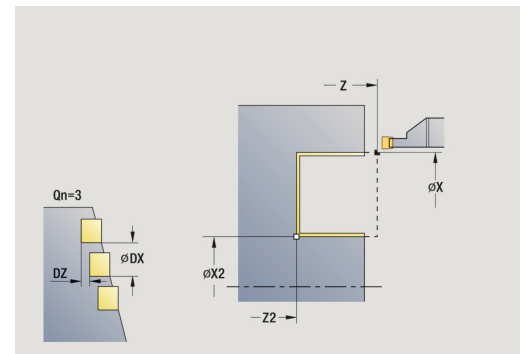


- ▶ Press the **Finishing run** soft key

The cycle machines the number of recesses defined in **Number of recess cycles Qn**. The **Start point** and **End point contour** parameters define the first recess (position, recess depth and recess width).

Cycle parameters:

- **X, Z: Start point**
- **X2, Z2: End point contour**
- **Qn: Number of recess cycles** (default: 1)
- **DX, DZ: Dist.to subsequent recess** relative to the preceding recess
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Contour recessing**



In this cycle you can specify how the floor element is machined during the finishing process.  
The control evaluates the **recessFinishing** (602414) machining parameter for this purpose. If this parameter is not defined, the floor element is divided in the center.



Cycle run:

- 1 Calculate the recess positions
- 2 Approach the workpiece for the next recess on a paraxial path from the **Start point** or from the last recess
- 3 Finish the first side and the contour valley up to a position just before the recess end point
- 4 Approach the workpiece on a paraxial path for finishing the second side
- 5 Finish the second side and the remainder of the contour valley
- 6 Repeat 2 to 5 until all recesses have been machined
- 7 Return to the **Start point** on a paraxial path
- 8 Move to the **Tool change point** according to the setting in **G14**

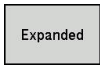
## Recessing radial finishing—Expanded



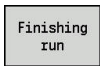
- ▶ Select **Recessing cycle**



- ▶ Select **Recessing radial**



- ▶ Select the **Expanded** soft key

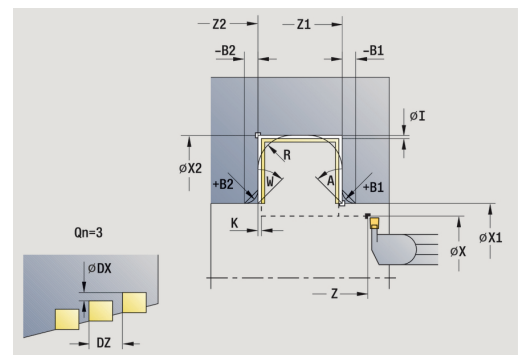
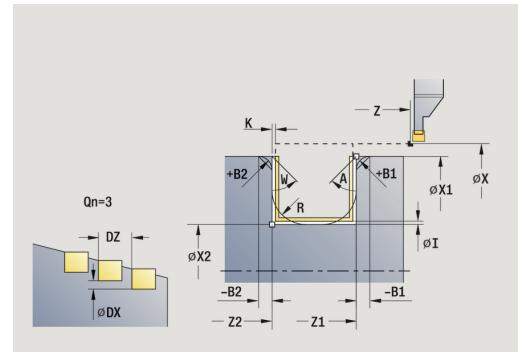


- ▶ Press the **Finishing run** soft key

The cycle machines the number of recesses defined in **Number of recess cycles Qn**. The **Start point** and **End point contour** parameters define the first recess (position, recess depth and recess width).

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **B1, B2: -B chamfer./+B round.** (**B1** at contour start and **B2** at contour end)
  - **B > 0:** Radius of rounding
  - **B < 0:** Width of chamfer
- **A: Start angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **R: Rounding**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **Qn: Number of recess cycles** (default: 1)
- **DX, DZ: Dist.to subsequent recess** relative to the preceding recess
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T:** M function that is executed after the tool call **T**
- **MFS: M at beginning:** M function that is executed at the beginning of the machining step
- **MFE: M at end:** M function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)



- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Contour recessing**



In this cycle you can specify how the floor element is machined during the finishing process.  
The control evaluates the **recessFinishing** (602414) machining parameter for this purpose. If this parameter is not defined, the floor element is divided in the center.

Cycle run:

- 1 Calculate the recess positions and the proportioning of cuts
- 2 Approach the workpiece for the next recess on a paraxial path from the **Start point** or from the last recess
- 3 Finish the first side (taking the optional contour elements into account) and the contour valley up to a position just before the recess end point
- 4 Approach the workpiece on a paraxial path for finishing the second side
- 5 Finish the second side (taking the optional contour elements into account) and the remainder of the contour valley
- 6 Repeat 2 to 5 until all recesses have been finished
- 7 Return to the **Start point** on a paraxial path
- 8 Move to the **Tool change point** according to the setting in **G14**

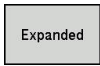
## Recessing axial finishing—Expanded



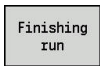
- ▶ Select **Recessing cycle**



- ▶ Select **Recessing axial**



- ▶ Select the **Expanded** soft key

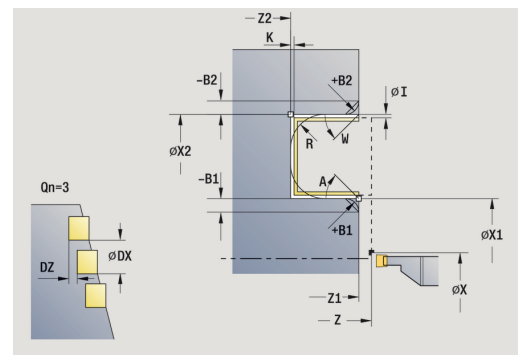
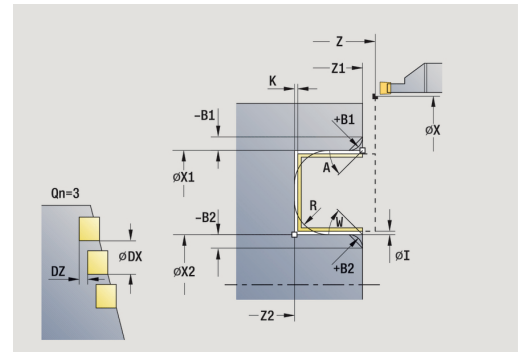


- ▶ Press the **Finishing run** soft key

The cycle machines the number of recesses defined in **Number of recess cycles Qn**. The **Start point** and **End point contour** parameters define the first recess (position, recess depth and recess width).

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **B1, B2: -B cham./+B round.** (**B1** at contour start and **B2** at contour end)
  - **B > 0:** Radius of rounding
  - **B < 0:** Width of chamfer
- **A: Start angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **R: Rounding**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **Qn: Number of recess cycles** (default: 1)
- **DX, DZ: Dist.to subsequent recess** relative to the preceding recess
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)



- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Contour recessing**



In this cycle you can specify how the floor element is machined during the finishing process.  
The control evaluates the **recessFinishing** (602414) machining parameter for this purpose. If this parameter is not defined, the floor element is divided in the center.

Cycle run:

- 1 Calculate the recess positions and the proportioning of cuts
- 2 Approach the workpiece for the next recess on a paraxial path from the **Start point** or from the last recess
- 3 Finish the first side (taking the optional contour elements into account) and the contour valley up to a position just before the recess end point
- 4 Approach the workpiece on a paraxial path for finishing the second side
- 5 Finish the second side (taking the optional contour elements into account) and the remainder of the contour valley
- 6 Repeat 2 to 5 until all recesses have been finished
- 7 Return to the **Start point** on a paraxial path
- 8 Move to the **Tool change point** according to the setting in **G14**

## Radial ICP recessing cycles



- ▶ Select **Recessing cycle**

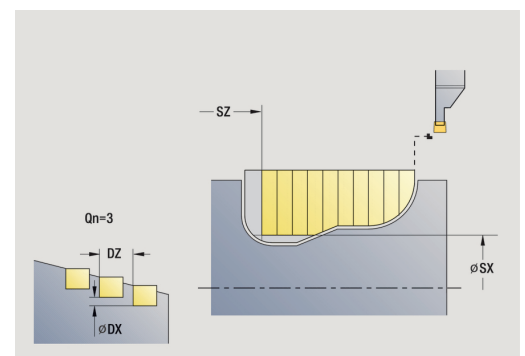
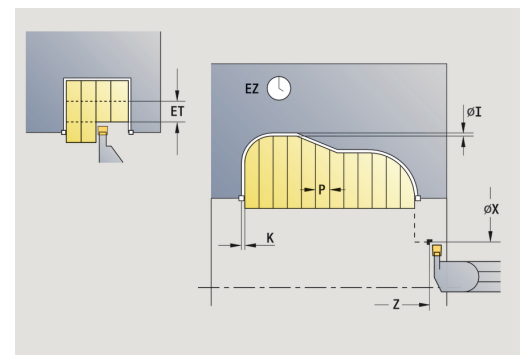
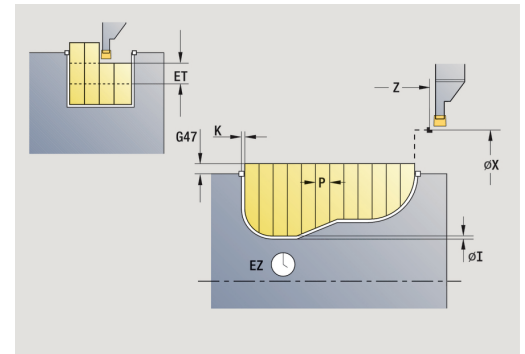


- ▶ Select **Recessing radial ICP**

The cycle machines the number of recesses defined in **Number of recess cycles Qn**. The **Start point** and **End point contour** parameters define the first recess (position, recess depth and recess width).

Cycle parameters:

- **X, Z: Start point**
- **FK: No. of ICP finished part** – Name of the contour to be machined
- **P: Cut. width** – Infeeds  $\leq P$  (no input:  $P = 0.8 * \text{cutting width of the tool}$ )
- **ET: Recess depth** per infeed
- **I, K: O-size X and Z**
- **EZ: Delay** – Dwell time for chip breaking (default: length of time for two revolutions)
- **Qn: Number of recess cycles** (default: 1)
- **DX, DZ: Dist. to subsequent recess** relative to the preceding recess
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **SX, SZ: Cutting limit in X and Z**  
**Further information:** "Cutting limits SX, SZ", Page 186
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Contour recessing**



In this cycle you can specify how the floor element is machined during the finishing process.

The control evaluates the **recessFinishing** (602414) machining parameter for this purpose. If this parameter is not defined, the floor element is divided in the center.

Cycle run:

- 1 Calculate the recess positions and the proportioning of cuts
- 2 Approach the workpiece for the next recess on a paraxial path from the **Start point** or from the last recess
- 3 Machine along the defined contour
- 4 Retract and approach for the next pass
- 5 Repeat 3 to 4 until the complete recess has been machined
- 6 Repeat 2 to 5 until all recesses have been machined
- 7 Return to the **Start point** on a paraxial path
- 8 Move to the **Tool change point** according to the setting in **G14**

## Axial ICP recessing cycles



- ▶ Select **Recessing cycle**

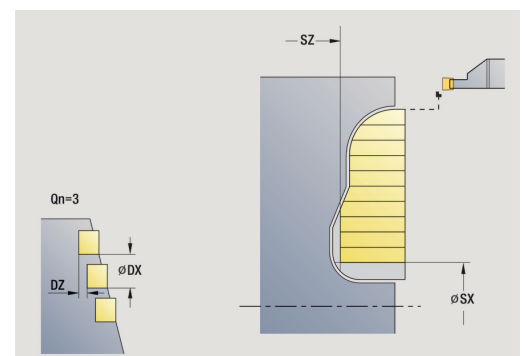
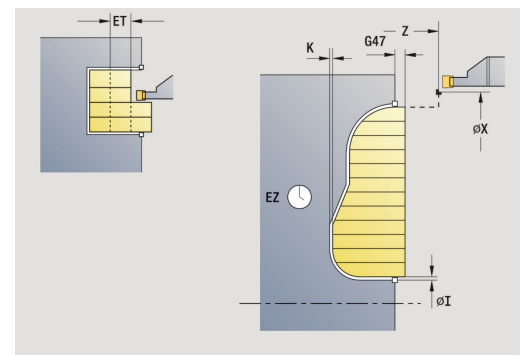
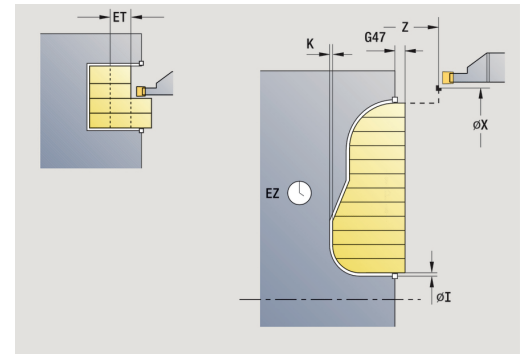


- ▶ Select **Recessing axial ICP**

The cycle machines the number of recesses defined in **Number of recess cycles Qn**. The **Start point** and **End point contour** parameters define the first recess (position, recess depth and recess width).

Cycle parameters:

- **X, Z: Start point**
- **FK: No. of ICP finished part** – Name of the contour to be machined
- **P: Cut. width** – Infeeds  $\leq P$  (no input:  $P = 0.8 * \text{cutting width of the tool}$ )
- **ET: Recess depth** per infeed
- **I, K: O-size X and Z**
- **EZ: Delay** – Dwell time for chip breaking (default: length of time for two revolutions)
- **Qn: Number of recess cycles** (default: 1)
- **DX, DZ: Dist. to subsequent recess** relative to the preceding recess
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **SX, SZ: Cutting limit in X and Z**  
**Further information:** "Cutting limits SX, SZ", Page 186
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Contour recessing**





In this cycle you can specify how the floor element is machined during the finishing process.

The control evaluates the **recessFinishing** (602414) machining parameter for this purpose. If this parameter is not defined, the floor element is divided in the center.

Cycle run:

- 1 Calculate the recess positions and the proportioning of cuts
- 2 Approach the workpiece for the next recess on a paraxial path from the **Start point** or from the last recess
- 3 Machine along the defined contour
- 4 Return and approach for the next pass
- 5 Repeat 3 to 4 until the complete recess has been machined
- 6 Repeat 2 to 5 until all recesses have been machined
- 7 Return to the **Start point** on a paraxial path
- 8 Move to the **Tool change point** according to the setting in **G14**

## Radial ICP recessing, finishing



- ▶ Select **Recessing cycle**



- ▶ Select **Recessing radial ICP**



- ▶ Press the **Finishing run** soft key

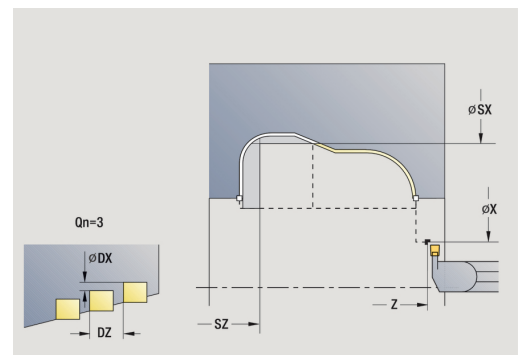
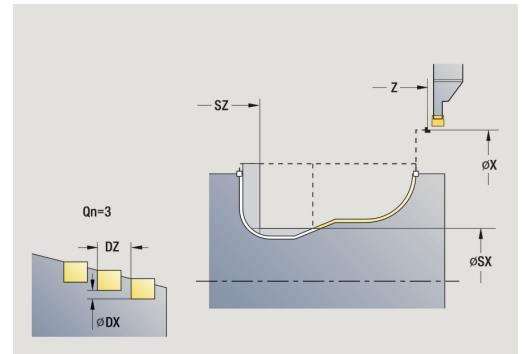
The cycle machines the number of recesses defined in **Number of recess cycles Qn**. The **Start point** and **End point contour** parameters define the first recess (position, recess depth and recess width).



At the end of the cycle, the tool returns to the **Start point**.

Cycle parameters:

- **X, Z: Start point**
- **FK: No. of ICP finished part** – Name of the contour to be machined
- **Qn: Number of recess cycles** (default: 1)
- **DX, DZ: Dist.to subsequent recess** relative to the preceding recess
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **SX, SZ: Cutting limit in X and Z**  
**Further information:** "Cutting limits SX, SZ", Page 186
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Contour recessing**



In this cycle you can specify how the floor element is machined during the finishing process.

The control evaluates the **recessFinishing** (602414) machining parameter for this purpose. If this parameter is not defined, the floor element is divided in the center.

Cycle run:

- 1 Calculate the recess positions
- 2 Approach the workpiece for the next recess on a paraxial path from the **Start point** or from the last recess
- 3 Finish the recess
- 4 Repeat 2 to 3 until all recesses have been machined
- 5 Return to the **Start point** on a paraxial path
- 6 Move to the **Tool change point** according to the setting in **G14**

## Axial ICP recessing, finishing



- ▶ Select **Recessing cycle**



- ▶ Select **Recessing axial ICP**



- ▶ Press the **Finishing run** soft key

The cycle machines the number of recesses defined in **Number of recess cycles Qn**. The **Start point** and **End point contour** parameters define the first recess (position, recess depth and recess width).



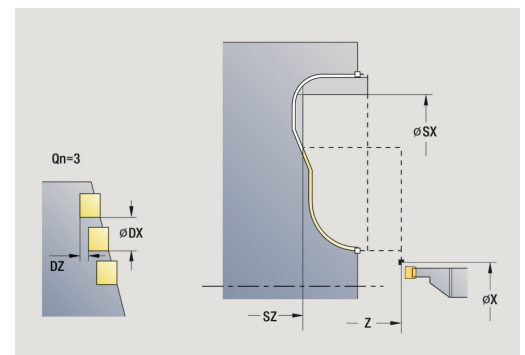
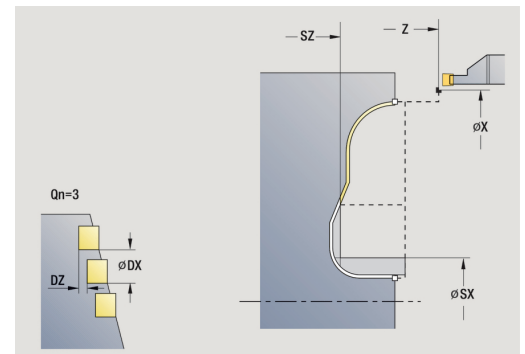
At the end of the cycle, the tool returns to the **Start point**.

Cycle parameters:

- **X, Z: Start point**
- **FK: No. of ICP finished part** – Name of the contour to be machined
- **Qn: Number of recess cycles** (default: 1)
- **DX, DZ: Dist.to subsequent recess** relative to the preceding recess
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **SX, SZ: Cutting limit in X and Z**  
**Further information:** "Cutting limits SX, SZ", Page 186
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Contour recessing**





In this cycle you can specify how the floor element is machined during the finishing process.

The control evaluates the **recessFinishing** (602414) machining parameter for this purpose. If this parameter is not defined, the floor element is divided in the center.

Cycle run:

- 1 Calculate the recess positions
- 2 Approach the workpiece for the next recess on a paraxial path from the **Start point** or from the last recess
- 3 Finish the recess
- 4 Repeat 2 to 3 until all recesses have been machined
- 5 Return to the **Start point** on a paraxial path
- 6 Move to the **Tool change point** according to the setting in **G14**

## Recess turning

The recess turning cycles machine by alternate recessing and roughing movements. The machining process requires a minimum of retraction and infeed movements.

To influence recess-turning operations, use the following parameters:

- **O: Recessing feed** – Feed rate for recessing movement
- **U: Unidir. turning** – You can perform a unidirectional or bidirectional turning operation
- **B: Offset width** – After the second infeed movement, during the transition from turning to recessing, the path to be machined is reduced by the **Offset width**. Each time the system switches from turning to recessing on this side, the path is reduced by the offset width—in addition to the previous offset. The total offset is limited to 80 % of the effective cutting width (effective cutting width = cutting width – 2\*cutting radius). If required, the control reduces the programmed **Offset width**. At the end of precutting, the residual material is removed with a single cut
- **RB: Depth compens.** – Depending on factors such as workpiece material or feed rate, the tool tip is displaced during a turning operation. The resulting infeed error can be compensated with **Depth compens.** during **finishing, expanded**. The **Depth compens.** factor is usually determined empirically



These cycles require the use of **recess-turning tools**.

**Radial recess turning**


- ▶ Select Recessing cycle



- ▶ Select Recess turning

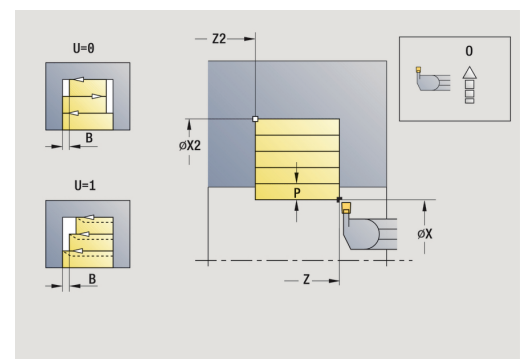
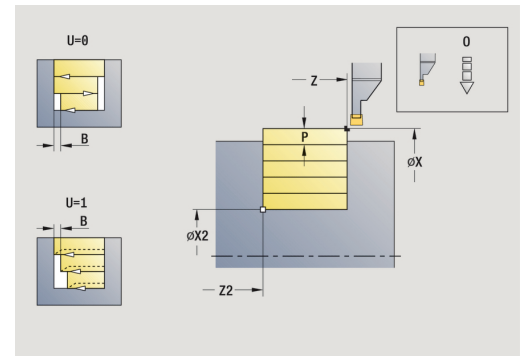


- ▶ Select Radial recess turning

The cycle machines the rectangle described by the **Start point** and the **End point contour**.

Cycle parameters:

- **X, Z: Start point**
- **X2, Z2: End point contour**
- **P: Feed depth** – Maximum infeed depth
- **O: Recessing feed** (default: active feed rate)
- **B: Offset width** (default: 0)
- **U: Unidir. turning** (default: 0)
  - **0: Bidirectional**
  - **1: Unidirectional**
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Recess turning**

Cycle run:

- 1 Calculate the proportioning of cuts
- 2 Approach the workpiece from the **Start point** for the first pass
- 3 Execute the first cut (recessing)
- 4 Machine perpendicularly to the recessing direction (turning)
- 5 Repeat 3 to 4 until the **End point contour X2, Z2** is reached
- 6 Return to the **Start point** on a paraxial path
- 7 Move to the **Tool change point** according to the setting in **G14**



**Axial recess turning**

- ▶ Select Recessing cycle



- ▶ Select Recess turning

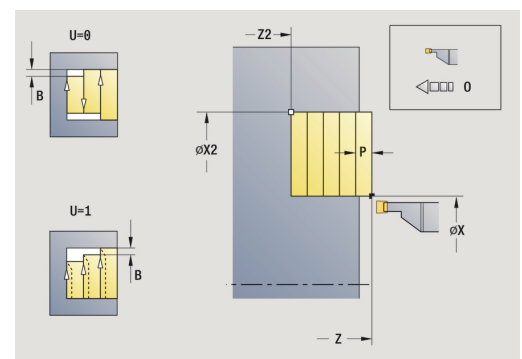
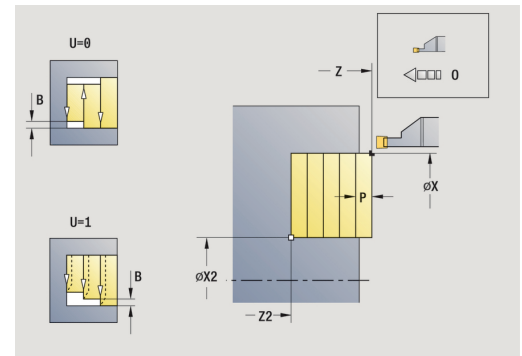


- ▶ Select Axial recess turning

The cycle machines the rectangle described by the **Start point** and the **End point contour**.

Cycle parameters:

- **X, Z: Start point**
- **X2, Z2: End point contour**
- **P: Feed depth** – Maximum infeed depth
- **O: Recessing feed** (default: active feed rate)
- **B: Offset width** (default: 0)
- **U: Unidir. turning** (default: 0)
  - **0: Bidirectional**
  - **1: Unidirectional**
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T:** M function that is executed after the tool call **T**
- **MFS: M at beginning:** M function that is executed at the beginning of the machining step
- **MFE: M at end:** M function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Recess turning**

Cycle run:

- 1 Calculate the proportioning of cuts
- 2 Approach the workpiece from the **Start point** for the first pass
- 3 Execute the first cut (recessing)
- 4 Machine perpendicularly to the recessing direction (turning)
- 5 Repeat 3 to 4 until the **End point contour X2, Z2** is reached
- 6 Return to the **Start point** on a paraxial path
- 7 Move to the **Tool change point** according to the setting in **G14**

**Radial recess turning—Expanded**



▶ Select Recessing cycle



▶ Select Recess turning



▶ Select Radial recess turning



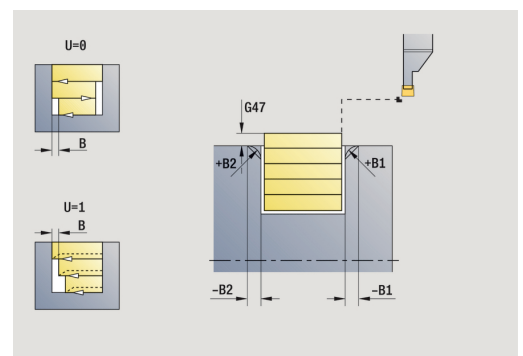
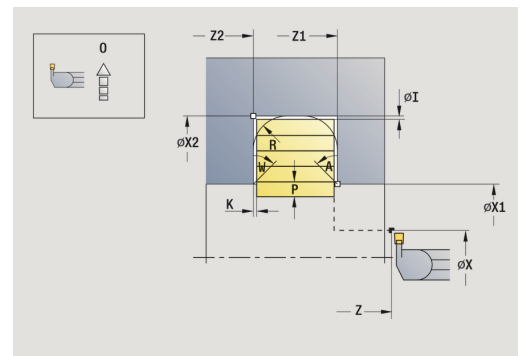
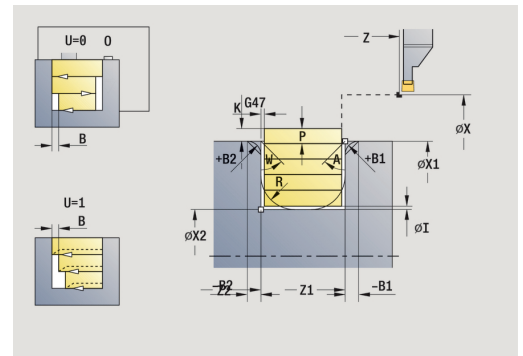
▶ Select the **Expanded** soft key

Taking the oversizes into account, the cycle machines the area described by the **Start point X/Start point contour Z1** and the **End point contour**.

**Further information:** "Recess turning", Page 286

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **P: Feed depth** – Maximum infeed depth
- **O: Recessing feed** (default: active feed rate)
- **I, K: O-size X and Z**
- **A: Start angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **R: Rounding**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **B1, B2: -B cham./+B round.** (**B1** at contour start and **B2** at contour end)
  - **B > 0:** Radius of rounding
  - **B < 0:** Width of chamfer
- **B: Offset width** (default: 0)
- **U: Unidir. turning** (default: 0)
  - **0: Bidirectional**
  - **1: Unidirectional**
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T:** M function that is executed after the tool call **T**
- **MFS: M at beginning:** M function that is executed at the beginning of the machining step
- **MFE: M at end:** M function that is executed at the end of the machining step



- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Recess turning**

Cycle run:

- 1 Calculate the proportioning of cuts
- 2 Approach the workpiece from the **Start point** for the first pass
- 3 Execute the first cut (recessing)
- 4 Machine perpendicularly to the recessing direction (turning)
- 5 Repeat 3 to 4 until the **End point contour X2, Z2** is reached
- 6 Machine a chamfer or rounding at the contour start or contour end, if defined
- 7 Return to the **Start point** on a paraxial path
- 8 Move to the **Tool change point** according to the setting in **G14**

**Axial recess turning—Expanded**



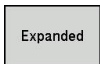
▶ Select Recessing cycle



▶ Select Recess turning



▶ Select Axial recess turning



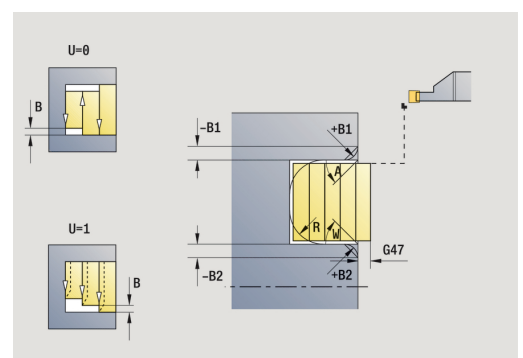
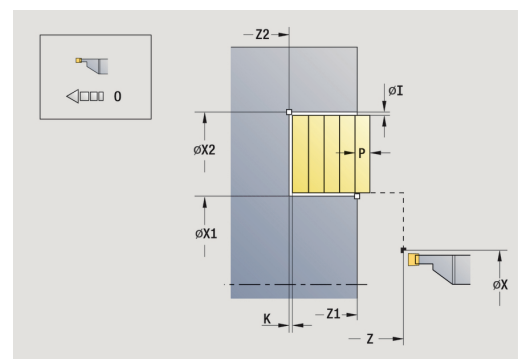
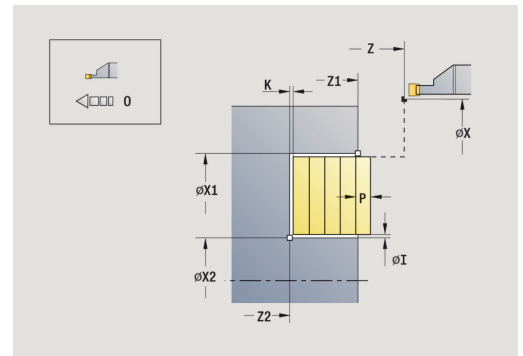
▶ Select the **Expanded** soft key

Taking the oversizes into account, the cycle machines the area described by the **Start point Z/Start point contour X1** and the **End point contour**.

**Further information:** "Recess turning", Page 286

Cycle parameters:

- **X, Z:** Start point
- **X1, Z1:** Start point contour
- **X2, Z2:** End point contour
- **P:** Feed depth – Maximum infeed depth
- **O:** Recessing feed (default: active feed rate)
- **I, K:** O-size X and Z
- **A:** Start angle (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W:** Final angle (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **R:** Rounding
- **T:** Tool number – Turret pocket number
- **G14:** Tool change point  
**Further information:** "Tool change point G14", Page 186
- **ID:** ID no.
- **S:** Cutting speed or Constant speed
- **F:** Feed per revolution
- **B1, B2:** -B cham./+B round. (**B1** at contour start and **B2** at contour end)
  - **B** > 0: Radius of rounding
  - **B** < 0: Width of chamfer
- **B:** Offset width (default: 0)
- **U:** Unidir. turning (default: 0)
  - **0:** Bidirectional
  - **1:** Unidirectional
- **G47:** Safety clearance  
**Further information:** "Safety clearance G47", Page 186
- **MT:** M after T: M function that is executed after the tool call T
- **MFS:** M at beginning: M function that is executed at the beginning of the machining step
- **MFE:** M at end: M function that is executed at the end of the machining step



- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Recess turning**

Cycle run:

- 1 Calculate the proportioning of cuts
- 2 Approach the workpiece from the **Start point** for the first pass
- 3 Execute the first cut (recessing)
- 4 Machine perpendicularly to the recessing direction (turning)
- 5 Repeat 3 to 4 until the **End point contour X2, Z2** is reached
- 6 Machine a chamfer or rounding at the contour start or contour end, if defined
- 7 Return to the **Start point** on a paraxial path
- 8 Move to the **Tool change point** according to the setting in **G14**

**Radial recess turning, finishing**

- ▶ **Select Recessing cycle**



- ▶ **Select Recess turning**



- ▶ **Select Radial recess turning**



- ▶ Press the **Finishing run** soft key

The cycle finishes the contour area defined by the **Start point** and the **End point contour**.

**Further information:** "Recess turning", Page 286



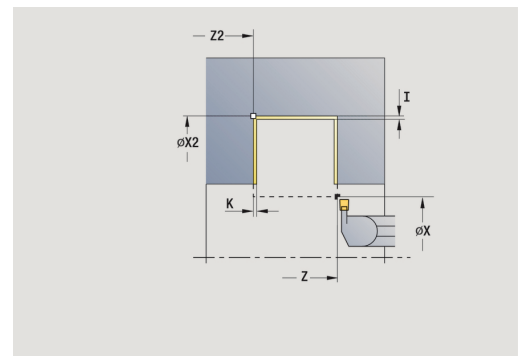
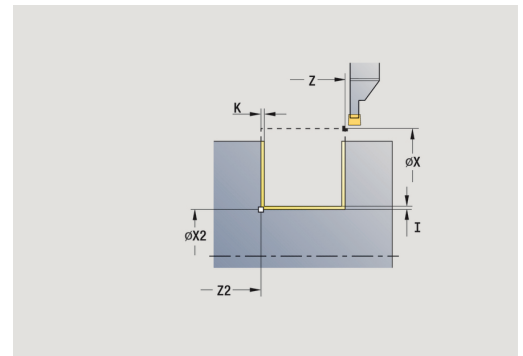
With **oversizes I, K**, you define the material left remaining after the finishing cycle.

Cycle parameters:

- **X, Z: Start point**
- **X2, Z2: End point contour**
- **I, K: Oversize blank X and Z**
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T:** M function that is executed after the tool call T
- **MFS: M at beginning:** M function that is executed at the beginning of the machining step
- **MFE: M at end:** M function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Recess turning**



Cycle run:

- 1 Approach the workpiece from the **Start point** on a paraxial path
- 2 Finish the first side and the contour area up to a position just before the **End point contour X2, Z2**
- 3 Move to the **Start point X/End point contour Z2** on a paraxial path
- 4 Finish the second side, then finish the remainder of the contour valley
- 5 Return to the **Start point** on a paraxial path
- 6 Move to the **Tool change point** according to the setting in **G14**



**Axial recess turning, finishing**


- ▶ Select **Recessing cycle**



- ▶ Select **Recess turning**



- ▶ Select **Axial recess turning**



- ▶ Press the **Finishing run** soft key

The cycle finishes the contour area defined by the **Start point** and the **End point contour**.

**Further information:** "Recess turning", Page 286



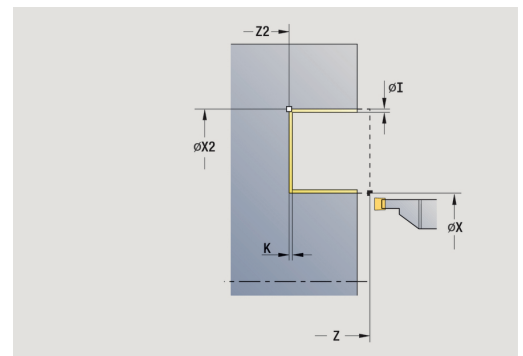
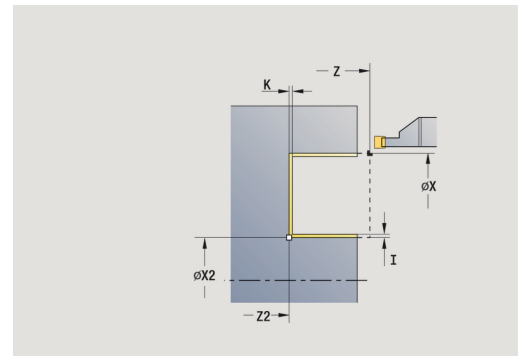
With **oversizes I, K**, you define the material left remaining after the finishing cycle.

Cycle parameters:

- **X, Z: Start point**
- **X2, Z2: End point contour**
- **I, K: Oversize blank X and Z**
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T:** M function that is executed after the tool call **T**
- **MFS: M at beginning:** M function that is executed at the beginning of the machining step
- **MFE: M at end:** M function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Recess turning**



Cycle run:

- 1 Approach the workpiece from the **Start point** on a paraxial path
- 2 Finish the first side and the contour area up to a position just before the **End point contour X2, Z2**
- 3 Move to the **Start point Z/End point contour X2** on a paraxial path
- 4 Finish the second side, then finish the remainder of the contour valley
- 5 Return to the **Start point** on a paraxial path
- 6 Move to the **Tool change point** according to the setting in **G14**

**Radial recess turning, finishing—Expanded**



- ▶ Select Recessing cycle



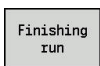
- ▶ Select Recess turning



- ▶ Select Radial recess turning



- ▶ Select the **Expanded** soft key



- ▶ Press the **Finishing run** soft key

The cycle finishes the contour area defined by the **Start point contour** and the **End point contour**.

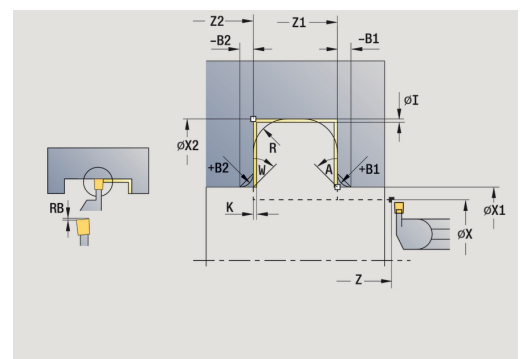
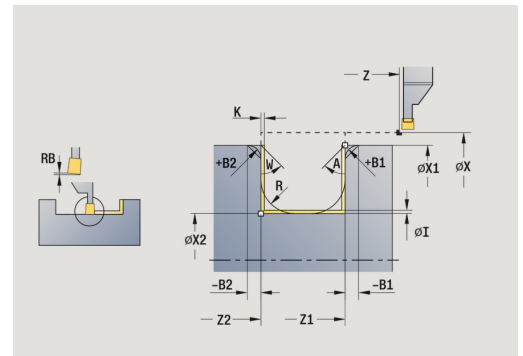
**Further information:** "Recess turning", Page 286

**i**

- With **workpiece-blank oversizes RI, RK**, you define the material to be machined during the finishing cycle. For this purpose, enter the oversizes for recess turning, finishing
- With **oversizes I, K**, you define the material left remaining after the finishing cycle

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **RB: Depth compens.**
- **I, K: O-size X and Z**
- **A: Start angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **R: Rounding**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **B1, B2: -B chamf./+B round.** (**B1** at contour start and **B2** at contour end)
  - **B > 0:** Radius of rounding
  - **B < 0:** Width of chamfer
- **RI, RK: Oversize blank X and Z** – Oversize before the finishing operation for calculating the approach and departure paths and the finishing area
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**



- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Recess turning**

Cycle run:

- 1 Approach the workpiece from the **Start point**
- 2 Finish the first side, taking the optional contour elements into account; then finish the contour valley up to a position just before the **End point contour X2, Z2**
- 3 Approach the workpiece on a paraxial path for finishing the second side
- 4 Finish the second side, taking the optional contour elements into account; then finish the remainder of the contour valley
- 5 Finish the chamfer or rounding at the contour start or contour end, if defined
- 6 Move to the **Tool change point** according to the setting in **G14**

**Axial recess turning, finishing—Expanded**



- ▶ Select Recessing cycle



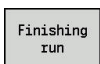
- ▶ Select Recess turning



- ▶ Select Axial recess turning



- ▶ Select the **Expanded** soft key



- ▶ Press the **Finishing run** soft key

The cycle finishes the contour area defined by the **Start point contour** and the **End point contour**.

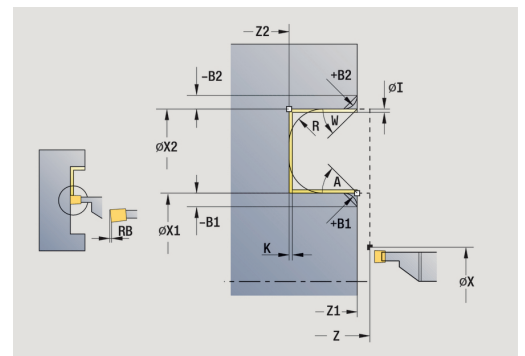
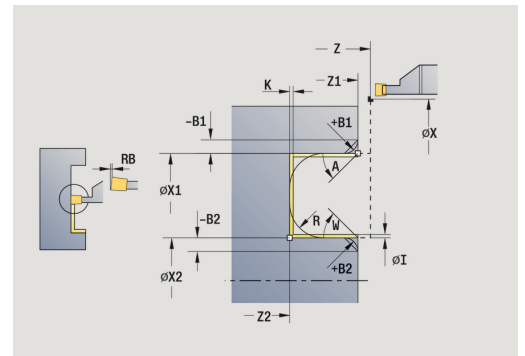
**Further information:** "Recess turning", Page 286

**i**

- With **workpiece-blank oversizes RI, RK**, you define the material to be machined during the finishing cycle. For this purpose, enter the oversizes for recess turning, finishing
- With **oversizes I, K**, you define the material left remaining after the finishing cycle

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point contour**
- **X2, Z2: End point contour**
- **RB: Depth compens.**
- **I, K: O-size X and Z**
- **A: Start angle** (range:  $0^\circ \leq A < 90^\circ$ ; default:  $0^\circ$ )
- **W: Final angle** (range:  $0^\circ \leq W < 90^\circ$ ; default:  $0^\circ$ )
- **R: Rounding**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **B1, B2: -B chamf./+B round.** (**B1** at contour start and **B2** at contour end)
  - **B > 0:** Radius of rounding
  - **B < 0:** Width of chamfer
- **RI, RK: Oversize blank X and Z** – Oversize before the finishing operation for calculating the approach and departure paths and the finishing area
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T:** M function that is executed after the tool call T



- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Recess turning**

Cycle run:

- 1 Approach the workpiece from the **Start point**
- 2 Finish the first side, taking the optional contour elements into account; then finish the contour valley up to a position just before the **End point contour X2, Z2**
- 3 Approach the workpiece on a paraxial path for finishing the second side
- 4 Finish the second side, taking the optional contour elements into account; then finish the remainder of the contour valley
- 5 Finish the chamfer or rounding at the contour start or contour end, if defined
- 6 Move to the **Tool change point** according to the setting in **G14**

**ICP-Recess turning long.**



- ▶ Select Recessing cycle



- ▶ Select Recess turning



- ▶ Select ICP-Recess turning long.

The cycle machines the defined area.

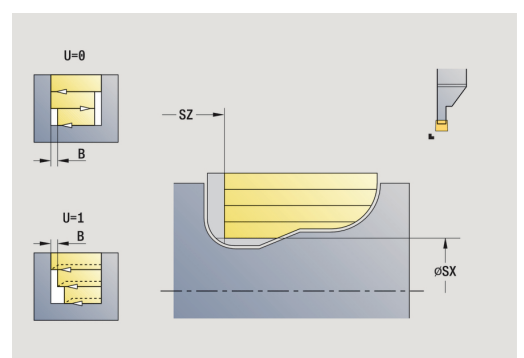
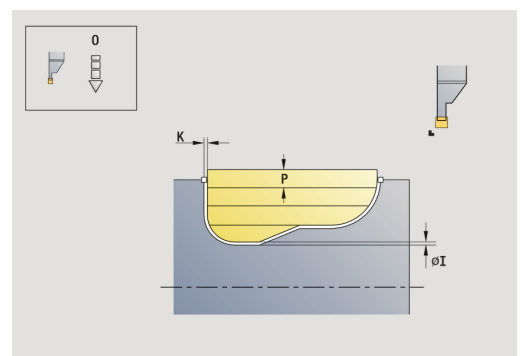
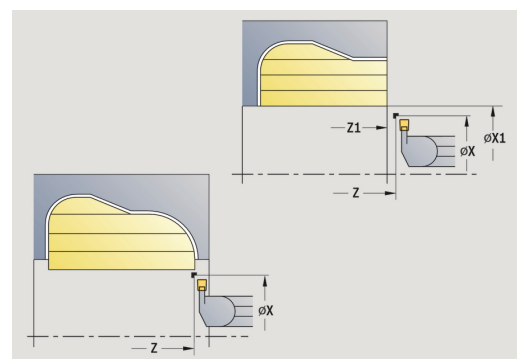
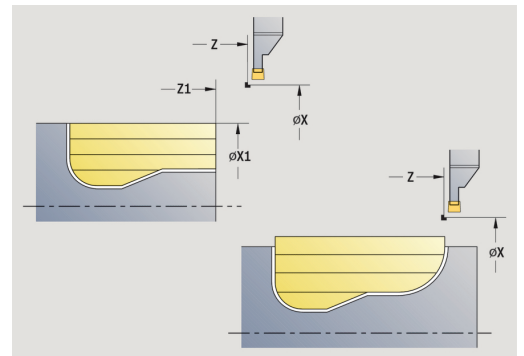
**Further information:** "Recess turning", Page 286

**i**

- If you are machining **descending contours**, define the **Start point**—not the **Start point blank**. The cycle machines the area defined by the **Start point** and the ICP contour, taking the oversizes into account
- If you are machining **ascending contours**, define the **Start point** and the **Start point blank**. The cycle machines the area defined by the **Start point blank** and the ICP contour, taking the oversizes into account

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point blank**
- **FK: No. of ICP finished part** – Name of the contour to be machined
- **P: Feed depth** – Maximum infeed depth
- **O: Recessing feed** (default: active feed rate)
- **I, K: O-size X and Z**
- **SX, SZ: Cutting limit in X and Z**  
**Further information:** "Cutting limits SX, SZ", Page 186
- **B: Offset width** (default: 0)
- **U: Unidir. turning** (default: 0)
  - **0: Bidirectional**
  - **1: Unidirectional**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **A: Start angle** (default: opposite to recessing direction)
- **W: Depart.angle** (default: opposite to recessing direction)
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step



- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Recess turning**

Cycle run:

- 1 Calculate the proportioning of cuts
- 2 Approach the workpiece from the **Start point** for the first pass
- 3 Execute the first cut (recessing)
- 4 Machine perpendicularly to the recessing direction (turning)
- 5 Repeat 3 to 4 until the defined area has been machined
- 6 Return to the **Start point** on a paraxial path
- 7 Move to the **Tool change point** according to the setting in **G14**



**ICP-Recess turning transv.**

- ▶ Select Recessing cycle



- ▶ Select Recess turning



- ▶ Select ICP-Recess turning transv.

The cycle machines the defined area.

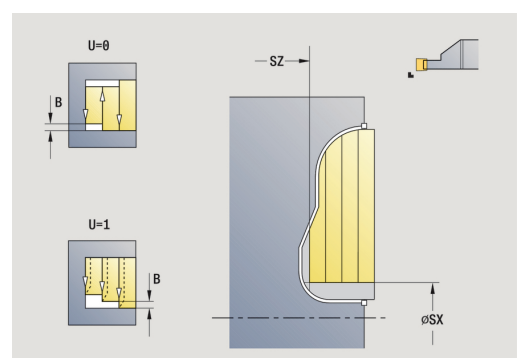
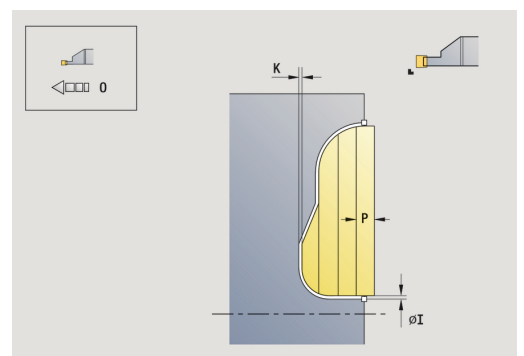
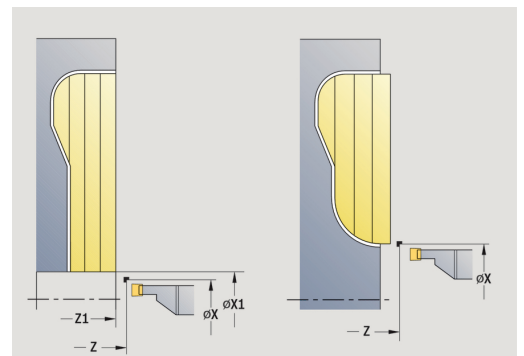
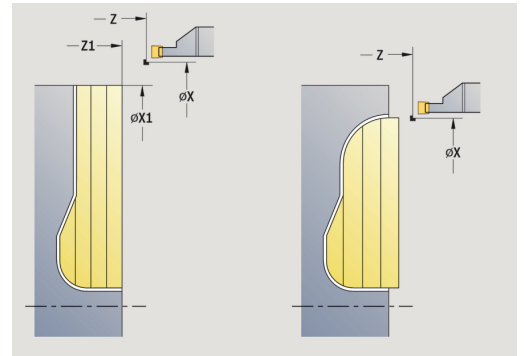
**Further information:** "Recess turning", Page 286



- If you are machining **descending contours**, define the **Start point**—not the **Start point blank**. The cycle machines the area defined by the **Start point** and the ICP contour, taking the oversizes into account
- If you are machining **ascending contours**, define the **Start point** and the **Start point blank**. The cycle machines the area defined by the **Start point blank** and the ICP contour, taking the oversizes into account

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point blank**
- **FK: No. of ICP finished part** – Name of the contour to be machined
- **P: Feed depth** – Maximum infeed depth
- **O: Recessing feed** (default: active feed rate)
- **I, K: O-size X and Z**
- **SX, SZ: Cutting limit in X and Z**  
**Further information:** "Cutting limits SX, SZ", Page 186
- **B: Offset width** (default: 0)
- **U: Unidir. turning** (default: 0)
  - **0: Bidirectional**
  - **1: Unidirectional**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **A: Start angle** (default: opposite to recessing direction)
- **W: Depart.angle** (default: opposite to recessing direction)
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step



- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Recess turning**

Cycle run:

- 1 Calculate the proportioning of cuts
- 2 Approach the workpiece from the **Start point** for the first pass
- 3 Execute the first cut (recessing)
- 4 Machine perpendicularly to the recessing direction (turning)
- 5 Repeat 3 to 4 until the defined area has been machined
- 6 Return to the **Start point** on a paraxial path
- 7 Move to the **Tool change point** according to the setting in **G14**

**Radial ICP recess turning, finishing**

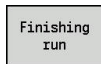

- ▶ Select **Recessing cycle**



- ▶ Select **Recess turning**



- ▶ Select **ICP-Recess turning long.**



- ▶ Press the **Finishing run** soft key

The cycle finishes the contour area defined by the ICP contour. At the end of the cycle, the tool returns to the **Start point**.

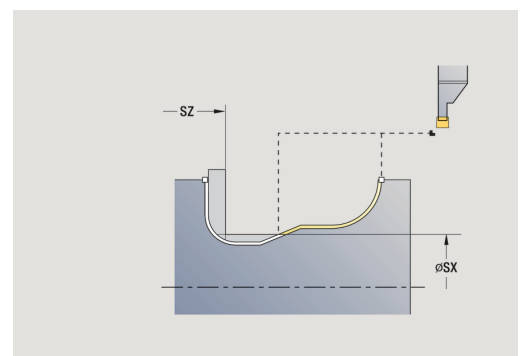
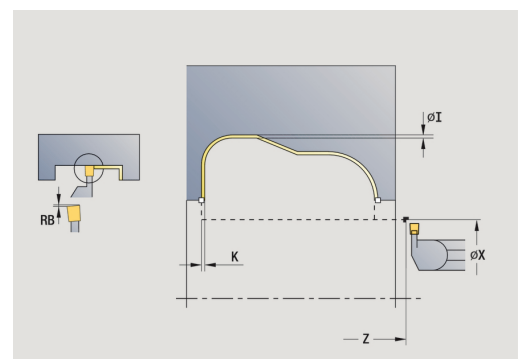
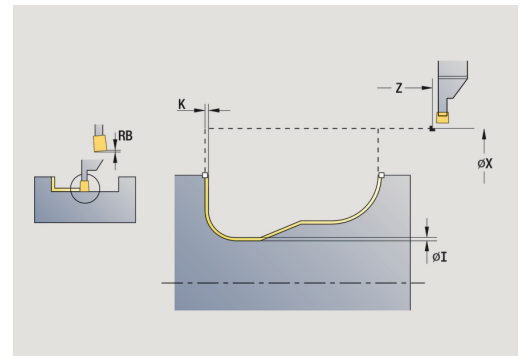
**Further information:** "Recess turning", Page 286



- With **workpiece-blank oversizes RI, RK**, you define the material to be machined during the finishing cycle. For this purpose, enter the oversizes for recess turning, finishing
- With **oversizes I, K**, you define the material left remaining after the finishing cycle

Cycle parameters:

- **X, Z: Start point**
- **FK: No. of ICP finished part** – Name of the contour to be machined
- **RB: Depth compens.**
- **I, K: O-size X and Z**
- **SX, SZ: Cutting limit in X and Z**  
**Further information:** "Cutting limits SX, SZ", Page 186
- **RI, RK: Oversize blank X and Z**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **A: Start angle** (default: opposite to recessing direction)
- **W: Depart.angle** (default: opposite to recessing direction)
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step



- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Recess turning**

Cycle run:

- 1 Pre-position from the **Start point** to the **Safety clearance** above the first side on a paraxial path
- 2 Finish the complete contour in one cut
- 3 Return to the **Start point** on a paraxial path
- 4 Move to the **Tool change point** according to the setting in **G14**

**Axial ICP recess turning, finishing**



- ▶ Select **Recessing cycle**



- ▶ Select **Recess turning**



- ▶ Select **ICP-Recess turning transv.**



- ▶ Press the **Finishing run** soft key

The cycle finishes the contour area defined by the ICP contour. At the end of the cycle, the tool returns to the **Start point**.

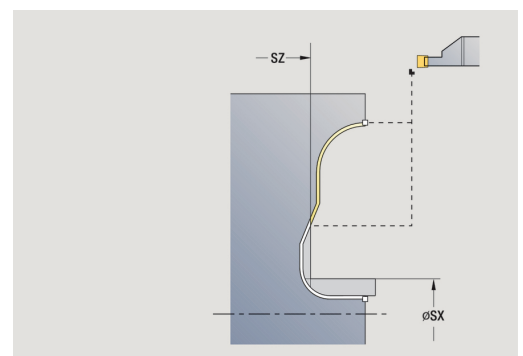
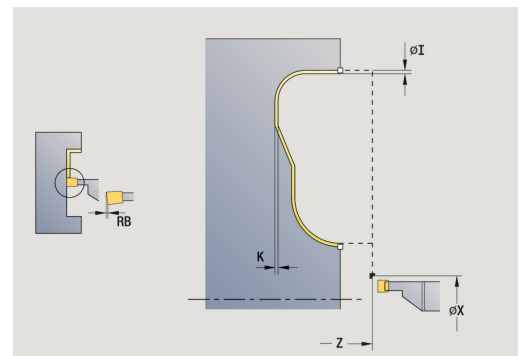
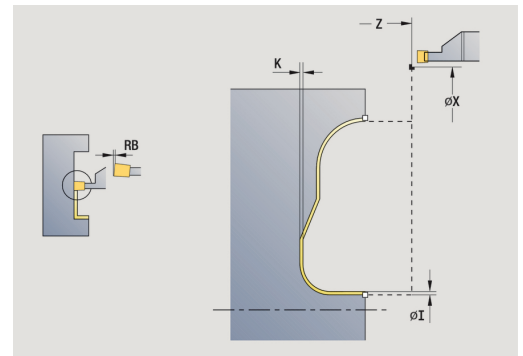
**Further information:** "Recess turning", Page 286

**i**

- With **workpiece-blank oversizes RI, RK**, you define the material to be machined during the finishing cycle. For this purpose, enter the oversizes for recess turning, finishing
- With **oversizes I, K**, you define the material left remaining after the finishing cycle

Cycle parameters:

- **X, Z: Start point**
- **FK: No. of ICP finished part** – Name of the contour to be machined
- **RB: Depth compens.**
- **I, K: O-size X and Z**
- **SX, SZ: Cutting limit in X and Z**  
**Further information:** "Cutting limits SX, SZ", Page 186
- **RI, RK: Oversize blank X and Z**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **A: Start angle** (default: opposite to recessing direction)
- **W: Depart.angle** (default: opposite to recessing direction)
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step



- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Recess turning**

Cycle run:

- 1 Pre-position from the **Start point** to the **Safety clearance** above the first side on a paraxial path
- 2 Finish the complete contour in one cut
- 3 Return to the **Start point** on a paraxial path
- 4 Move to the **Tool change point** according to the setting in **G14**

**Undercut. Form H**

- ▶ Select **Recessing cycle**



- ▶ Select **Undercut H**

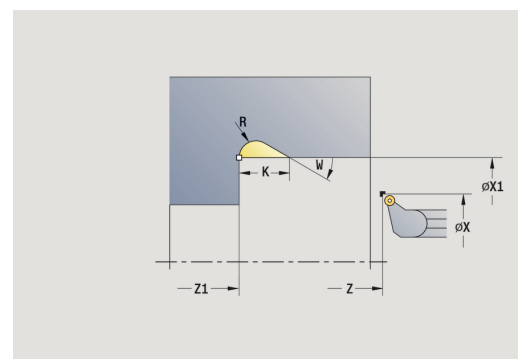
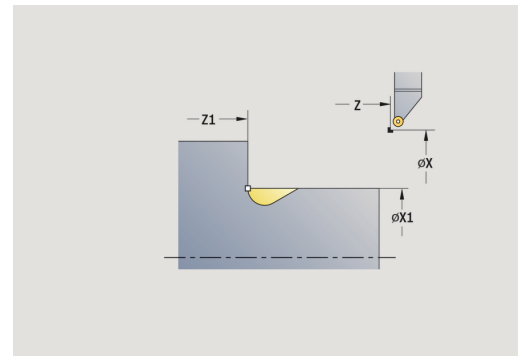
The contour depends on the parameters defined. If you do not define the **Undercut radius**, the oblique cut will be executed up to **Contour corner Z1** (tool radius = **Undercut radius**).

If you do not define the **plunging angle**, it is calculated from the **Undercut lgth.** and **Undercut radius**. The end point of the undercut is then located at the **Contour corner**.

The end point of the undercut is determined from the plunging angle in accordance with **Undercut type H**.

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Contour corner**
- **K: Undercut lgth.**
- **R: Undercut radius** (default: no circular element)
- **W: Plunging angle** (default: **W** is calculated)
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**

Cycle run:

- 1 Approach the workpiece from the **Start point** up to the safety clearance
- 2 Machine the undercut according to the cycle parameters
- 3 Return to the **Start point** on a diagonal path
- 4 Move to the **Tool change point** according to the setting in **G14**



**Undercut. Form K**

▶ Select **Recessing cycle**



▶ Select **Undercut K**

This cycle performs only one linear cut at an angle of 45°. The resulting contour geometry therefore depends on the tool that is used.

Cycle parameters:

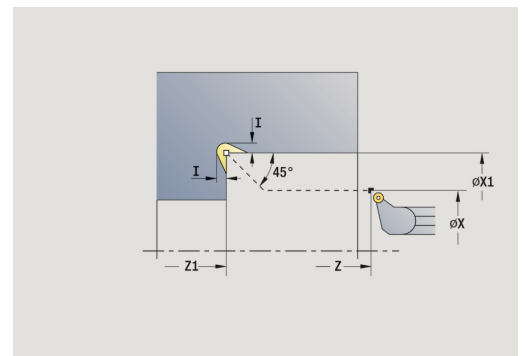
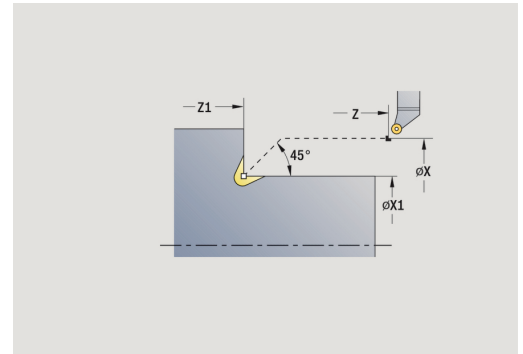
- **X, Z:** Start point
- **X1, Z1:** Contour corner
- **I:** Undercut depth
- **G47:** Safety clearance  
Further information: "Safety clearance G47", Page 186
- **T:** Tool number – Turret pocket number
- **G14:** Tool change point  
Further information: "Tool change point G14", Page 186
- **ID:** ID no.
- **S:** Cutting speed or Constant speed
- **F:** Feed per revolution
- **MT: M after T:** M function that is executed after the tool call **T**
- **MFS: M at beginning:** M function that is executed at the beginning of the machining step
- **MFE: M at end:** M function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**

Cycle run:

- 1 Pre-position at an angle of 45° to the **Safety clearance** above the **Contour corner X1, Z1** at rapid traverse
- 2 Plunge by **Undercut depth I**
- 3 Return the tool to the **Start point** on the same path
- 4 Move to the **Tool change point** according to the setting in **G14**



**Undercut. Form U**

- ▶ Select **Recessing cycle**

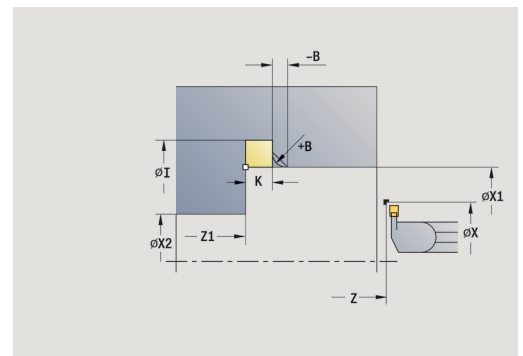
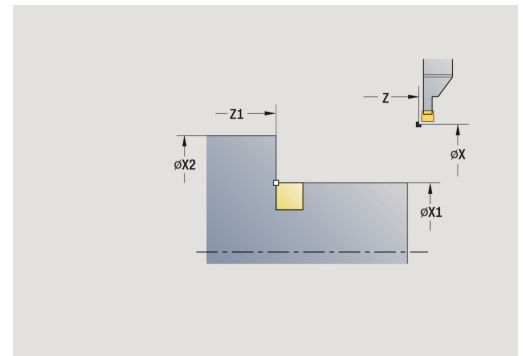


- ▶ Select **Undercut U**

This cycle machines an **Undercut type U** and, if programmed, finishes the adjoining plane surface. The undercut is executed in several passes if the **Undercut width** is greater than the recessing width of the tool. If the cutting width of the tool is not defined, the control assumes that the tool's cutting width equals the **Undercut width**. Either a chamfer or a rounding arc can be machined.

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Contour corner**
- **X2: End point transv.**
- **I: Undercut diameter**
- **K: Undercut width**
- **B: -B cham./+B round.**
  - **B > 0:** Radius of rounding
  - **B < 0:** Width of chamfer
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**

Cycle run:

- 1 Calculate the proportioning of cuts
- 2 Approach the workpiece from the **Start point** up to the safety clearance
- 3 Move at the programmed feed rate to the **Undercut diameter I** and dwell at this position (for two revolutions)
- 4 Retract and approach for the next pass
- 5 Repeat 3 to 4 until the **Contour corner Z1** is reached
- 6 After the last pass, finish the adjoining plane surface, starting from **End point transv. X2**, if defined
- 7 Machine the chamfer or rounding arc, if defined
- 8 Return to the **Start point** on a diagonal path
- 9 Move to the **Tool change point** according to the setting in **G14**

**Cut off**

- ▶ Select **Recessing cycle**

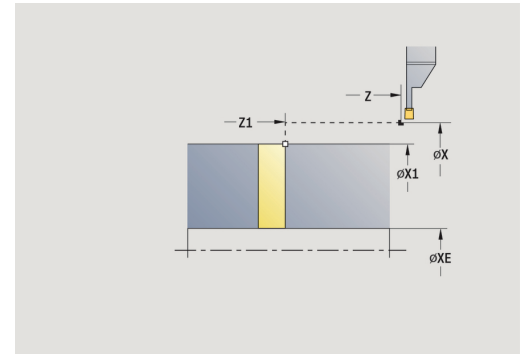


- ▶ Select **Cut off**

The cycle parts the workpiece. If programmed, a chamfer or rounding arc is machined on the outside diameter.

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Contour corner**
- **XE: Inner diameter (pipe)**
- **D: Maximum speed**
- **I: Diam. feed reduction** – Limit diameter over which traverse is at reduced feed rate
- **B: -B cham./+B round.**
  - **B > 0:** Radius of rounding
  - **B < 0:** Width of chamfer
- **E: Reduced feed**
- **K: Retraction distance** after parting – lift off the tool laterally from the plane surface before retraction
- **SD: Speed limit from I up**
- **U: Collector active diameter** (machine-dependent)
- **G47: Safety clearance**  
**Further information:** "Safety clearance G47", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T:** **M** function that is executed after the tool call **T**
- **MFS: M at beginning:** **M** function that is executed at the beginning of the machining step
- **MFE: M at end:** **M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access: **Cut off**

Cycle run:

- 1 Approach the workpiece from the **Start point** up to the **Safety clearance**
- 2 Cut to the depth of the chamfer or rounding and machine the chamfer/rounding if defined
- 3 Depending on the cycle parameters, move at the programmed feed rate to
  - The turning center, or
  - The **Inner diameter (pipe) XE**  
If you have programmed a feed-rate reduction, the control switches to the **Reduced feed E** as soon as the tool reaches the **Diam. feed reduction I**.
- 4 Retract along the plane surface and return to the **Start point**
- 5 Move to the **Tool change point** according to the setting in **G14**



The limit to the **Maximum speed D** is only effective in the cycle. After the cycle ends, the speed limit that was valid before the cycle becomes effective again.

## Examples of recessing cycles

### Recess outside

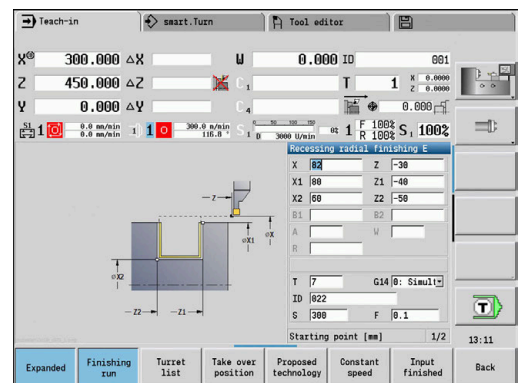
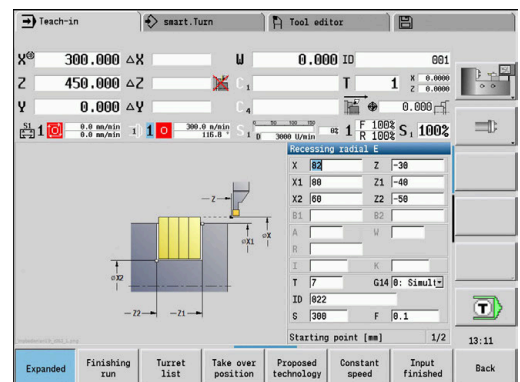
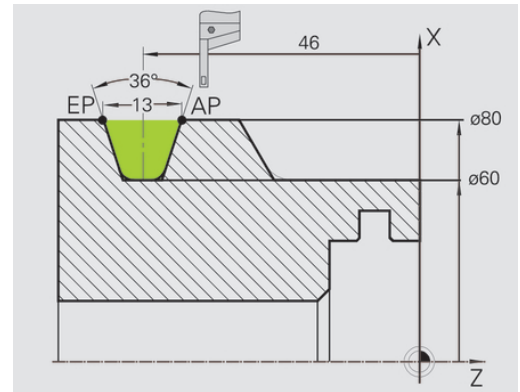
The machining operation is to be executed with the **Recessing radial E** cycle, taking oversizes into account. This contour area will be finished subsequently with **Recessing radial finishing E**.

The rounding arcs in the corners of the contour valley and the oblique surfaces at the contour start and end are also machined in **expanded mode**.

Be sure to enter the correct values for the **Start point contour X1, Z1** and **End point contour X2, Z2** parameters. These parameters determine the cutting and infeed directions—in this example, outside machining and infeed in negative Z-axis direction.

Tool data:

- Turning tool (for external machining)
- **TO** = 1 – Tool orientation
- **SB** = 4 – Cutting width (4 mm)



**Recess inside**

The machining operation will be executed with the **Recessing radial E** cycle, taking oversizes into account. This contour area will be finished subsequently with **Recessing radial finishing E**.

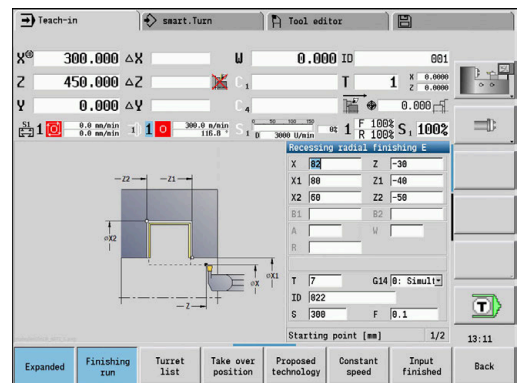
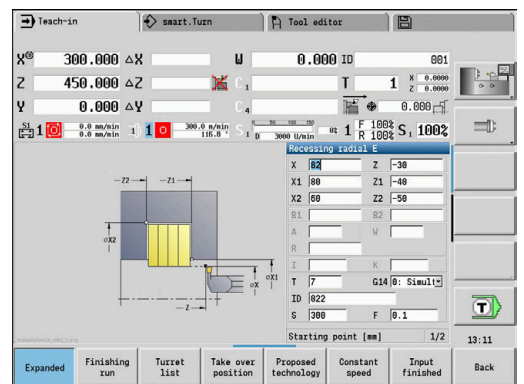
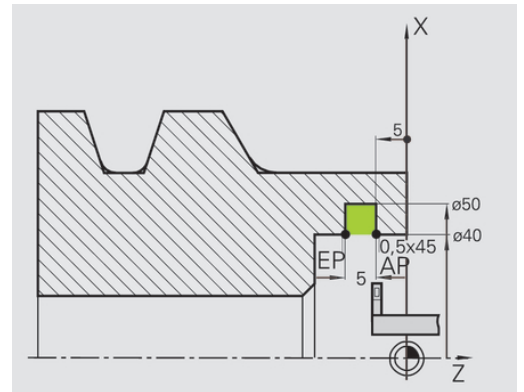
Since the **Cut. width P** is not entered, the control plunge-cuts with 80 % of the cutting width of the tool.

In **expanded mode**, the chamfers are machined at the start/end of the contour.


Be sure to enter the correct values for the **Start point contour X1, Z1** and **End point contour X2, Z2** parameters. These parameters determine the cutting and infeed directions—in this example, inside machining and infeed in negative Z-axis direction.

Tool data:

- Turning tool (for internal machining)
- **TO** = 7 – Tool orientation
- **SB** = 2 – Cutting width (2 mm)



## 5.6 Thread and undercut cycles

Menu item	Meaning
	The thread and undercut cycles machine single or multi-start longitudinal and tapered threads, as well as thread undercuts

In Teach-in mode you can

- Repeat the **last cut** to compensate for tool inaccuracies
- Use the **Recut** function to rework damaged threads (only in **Machine** operating mode)









- Threads are cut with constant rotational speed
- Feed rate override is not effective during cycle execution



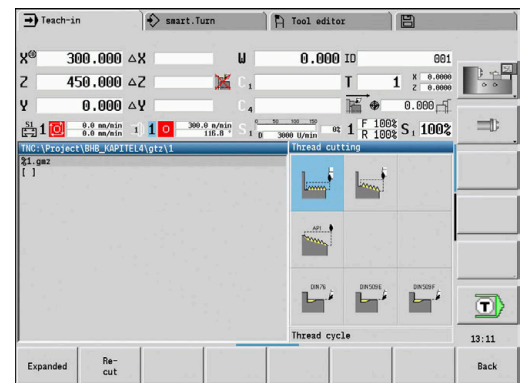
Refer to your machine manual.

The machine manufacturer specifies whether the tool is retracted immediately after **NC stop** or the thread is completed.

Menu item	Thread and undercut cycles
	<b>Thread. cycle</b> Longitudinal single or multi-start thread
	<b>Tapered thr.</b> Tapered single or multi-start thread
	<b>API thread</b> Single or multi-start API thread (API: American Petroleum Institute)
	<b>Undercut DIN 76</b> Thread undercut and thread chamfer
	<b>Undercut DIN 509E</b> Undercut and cylinder chamfer
	<b>Undercut DIN 509F</b> Undercut and cylinder chamfer

### Direction of threads

The control determines the direction of the thread from the parameters for **Starting point Z** (in **Machine** operating mode: current tool position) and **End point thread Z2**. You select internal or external thread by soft key.





## GV parameter: Type of infeed

With the **GV** parameter, you define the type of infeed for thread cutting cycles.

The following infeed types are available:

- **0: Const. mach. X-section** – The control reduces the cutting depth with each infeed so that the chip cross section, and therefore the metal removal rate, remains constant
- **1: Const. infeed** – with each infeed the control uses the same cutting depth without exceeding the **Max. approach I**
- **2: EPL with distrib. of cuts** – the control calculates the cutting depth for constant infeed from the **Thread pitch F1** and **Shaft speed constant S**. If the multiple of the cutting depth does not correspond to the **Thread depth**, the control uses the **Rem. cut depth** for the first infeed. The control proportions the remaining cuts, i.e. it divides the last cutting depth into four partial cuts. The first cut is half the calculated cutting depth, the second is a quarter and the third and fourth each are an eighth
- **3: EPL w/o distrib. of cuts** – the control calculates the cutting depth for constant infeed from the **Thread pitch F1** and **Shaft speed constant S**. If the multiple of the cutting depth does not correspond to the **Thread depth**, the control uses the **Rem. cut depth** for the first infeed. All subsequent infeeds are constant and correspond to the calculated cutting depth
- **4: MANUALplus 4110** – the control executes the first infeed with the **Max. approach I**. To determine the subsequent cutting depths, the control uses the formula  $gt = 2 * I * \text{SQRT "current no. of cuts"}$ , where **gt** is the absolute depth. Since the cutting depth is reduced with each infeed because the current number of cuts is increased accordingly by the value 1, and if the cutting depth falls below the value given in **Rem. cut depth R**, the control uses the value defined here as the new constant cutting depth. If the multiple of the cutting depth does not correspond to the **Thread depth**, the control executes the last cut at the final depth
- **5: Constant infeed (4290)** – with each infeed, the control uses the same cutting depth where the cutting depth corresponds to the **Max. approach I**. If the multiple of the cutting depth does not correspond to the **Thread depth**, the control uses the **Rem. cut depth** for the first infeed
- **6: Const. w/ distrib. (4290)** – with each infeed, the control uses the same cutting depth, where the cutting depth corresponds to the **Max. approach I**. If the multiple of the cutting depth does not correspond to the **Thread depth**, the control uses the **Rem. cut depth** for the first infeed. The control proportions the remaining cuts, i.e. it divides the last cutting depth into four partial cuts. The first cut is half the calculated cutting depth, the second is a quarter and the third and fourth each are an eighth

## Undercut position

The control determines the position of an undercut from the parameters for **Starting point X, Z** (in **Machine** operating mode: current tool position) and **Start point cylinder X1/End point transv. Z2**.



An undercut can only be machined in a right-angled paraxial contour corner in the linear axis.

## Handwheel superimposition

If your machine features handwheel superimposition, you can overlap axis movements during thread cutting in a limited area:

- **X direction:** Maximum programmed thread depth depending on the current cutting depth
- **Z direction:** +/- a fourth of the thread pitch



Refer to your machine manual.  
This function must be set up by your machine manufacturer.

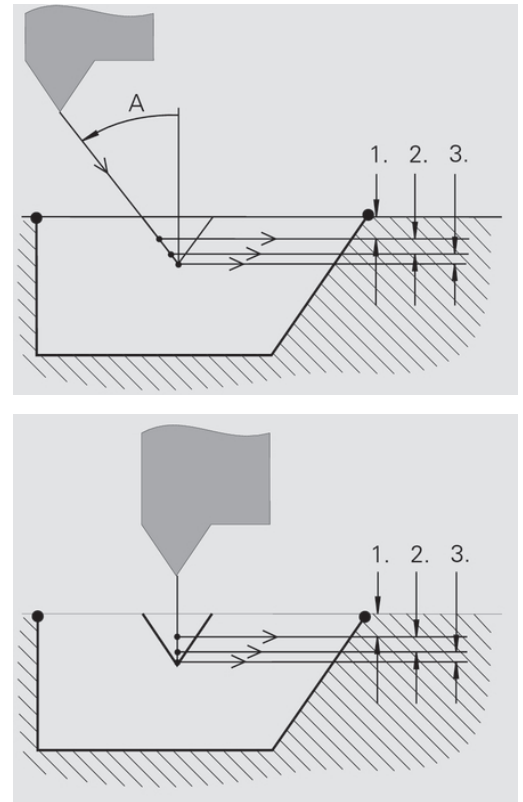


Remember that position changes resulting from handwheel superimposition are no longer effective after the cycle end or the **Last cut** function.

### Angle of infeed, thread depth, proportioning of cuts

With some thread cycles, you can indicate the angle of infeed (thread angle). The figures show the operating sequence at an angle of infeed of  $-30^\circ$  and an angle of infeed of  $0^\circ$ .

The thread depth is programmed for all thread cycles. The control reduces the cutting depth with each cut.



### Thread run-in and thread run-out

The slide requires a run-in distance to accelerate to the programmed feed rate before starting the actual thread, and a run-out distance at the end of the thread to decelerate again.

If the run-in length or run-out length is too short, the thread may not attain the expected quality. In this case, the control displays a warning.

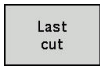
## Last cut

After the cycle is finished, the control presents the **Last cut** option. In this way, you can enter a tool compensation value and repeat the last thread cut.

Sequence of the **Last cut** function:

Initial situation: The thread cut cycle has been run, and the thread depth is not correct.

▶ Perform the tool compensation



▶ Press the **Last cut** soft key



▶ Press the **NC start** key

▶ Check the thread



The tool compensation and the **Last cut** can be repeated as often as necessary until the thread is correct.

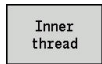
### Thread cycle (longitudinal)



- ▶ Select **Thread cutting**



- ▶ Select **Thread cycle**

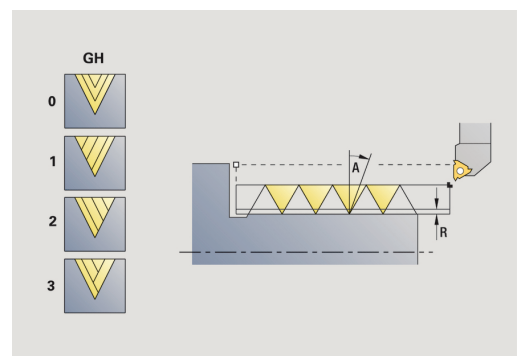
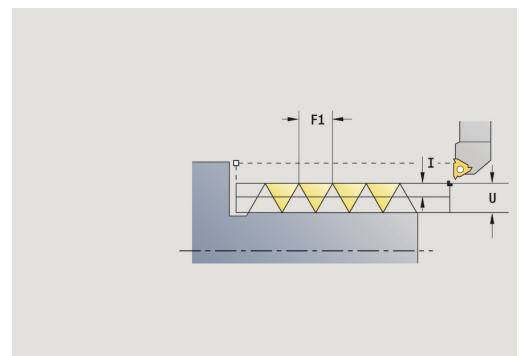
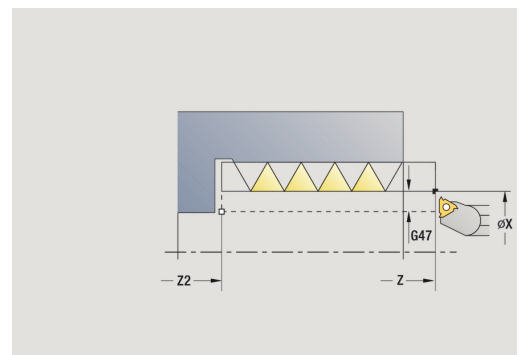
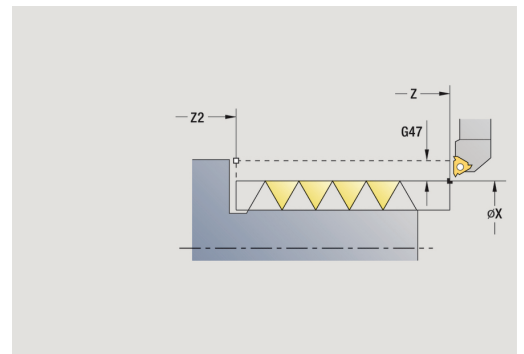


- ▶ Select the type of thread:
  - **On:** Internal thread
  - **Off:** External thread

This cycle cuts a single external or internal thread with a thread angle of 30°. Tool infeed is performed in the X axis only.

Cycle parameters:

- **X, Z:** Start point of thread
- **Z2:** End point thread
- **F1:** Thread pitch (= feed rate)
- **U:** Thread depth (default: no input)
  - Outside thread:  $U = 0.6134 * F1$
  - Inside thread:  $U = -0.5413 * F1$
- **I:** Max. approach
  - $I < U$ : First cut with **I**, all subsequent cuts with cutting-depth reduction
  - $I = U$ : One cut
  - No input: **I** is calculated from **U** and **F1**
- **G47:** Safety clearance  
**Further information:** "Safety clearance G47", Page 186
- **T:** Tool number – Turret pocket number
- **G14:** Tool change point  
**Further information:** "Tool change point G14", Page 186
- **ID:** ID no.
- **S:** Constant spindle speed
- **GV:** Type of infeed  
**Further information:** "GV parameter: Type of infeed", Page 321
  - **0:** Const. mach. X-section
  - **1:** Const. infeed
  - **2:** EPL with distrib. of cuts
  - **3:** EPL w/o distrib. of cuts
  - **4:** MANUALplus 4110
  - **5:** Constant infeed (4290)
  - **6:** Const. w/ distrib. (4290)
- **GH:** Type of offset
  - **0:** Without offset
  - **1:** From left
  - **2:** From right
  - **3:** Alternating left/right



- **A: Approach ang.** (range:  $-60^\circ < \mathbf{A} < 60^\circ$ ; default:  $30^\circ$ )
  - $\mathbf{A} < 0$ : Infeed on left thread flank
  - $\mathbf{A} > 0$ : Infeed on right thread flank
- **R: Rem. cut depth** (only with  $\mathbf{GV} = 4$ ; default:  $1/100$  mm)
- **IC: Number of cuts** – The infeed is calculated from **IC** and **U**  
Usable with:
  - $\mathbf{GV} = 0$ : Constant chip cross section
  - $\mathbf{GV} = 1$ : Constant infeed
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Thread cutting**

Cycle run:

- 1 Calculate the proportioning of cuts
- 2 Start the first pass at the **Start point Z**
- 3 Move to the **End point thread Z2** at the programmed feed rate
- 4 Return on a paraxial path and approach for the next pass
- 5 Repeat 3 to 4 until the **Thread depth U** is reached
- 6 Move to the **Tool change point** according to the setting in **G14**

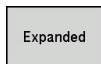
## Thread cycle (longitudinal)—Expanded



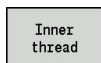
- ▶ Select **Thread cutting**



- ▶ Select **Thread cycle**



- ▶ Select the **Expanded** soft key

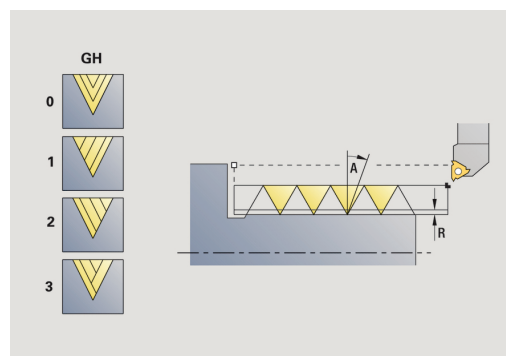
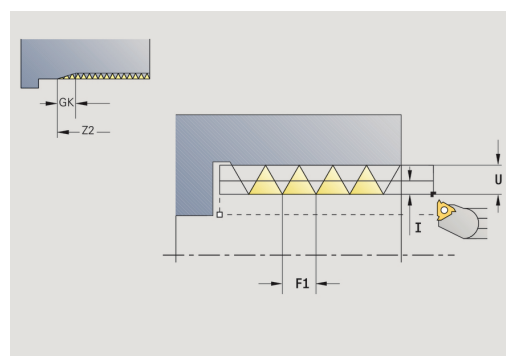
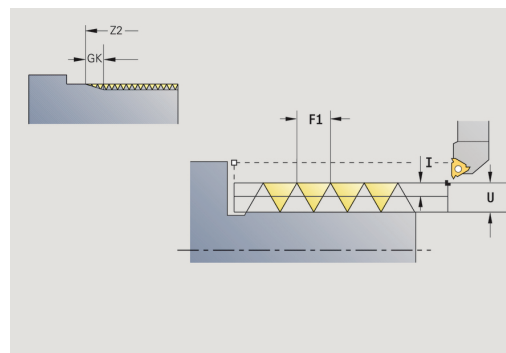


- ▶ Select the type of thread:
  - **On:** Internal thread
  - **Off:** External thread

This cycle cuts a single or multi-start external or internal thread. The thread starts at the **Start point** and ends at the **End point thread** (without a thread run-in or run-out).

Cycle parameters:

- **X, Z:** Start point of thread
- **Z2:** End point thread
- **F1:** Thread pitch (= feed rate)
- **D:** No.gears (default: 1 single-start thread)
- **U:** Thread depth (default: no input)
  - Outside thread:  $U = 0.6134 * F1$
  - Inside thread:  $U = -0.5413 * F1$
- **I:** Max. approach
  - $I < U$ : First cut with **I**, all subsequent cuts with cutting-depth reduction
  - $I = U$ : One cut
  - No input: **I** is calculated from **U** and **F1**
- **GK:** Thread runout length
- **G47:** Safety clearance  
Further information: "Safety clearance G47", Page 186
- **T:** Tool number – Turret pocket number
- **G14:** Tool change point  
Further information: "Tool change point G14", Page 186
- **ID:** ID no.
- **S:** Constant spindle speed
- **GV:** Type of infeed  
Further information: "GV parameter: Type of infeed", Page 321
  - **0:** Const. mach. X-section
  - **1:** Const. infeed
  - **2:** EPL with distrib. of cuts
  - **3:** EPL w/o distrib. of cuts
  - **4:** MANUALplus 4110
  - **5:** Constant infeed (4290)
  - **6:** Const. w/ distrib. (4290)



- **GH: Type of offset**
  - **0: Without offset**
  - **1: From left**
  - **2: From right**
  - **3: Alternating left/right**
- **A: Approach ang.** (range:  $-60^\circ < \mathbf{A} < 60^\circ$ ; default:  $30^\circ$ )
  - $\mathbf{A} < 0$ : Infeed on left thread flank
  - $\mathbf{A} > 0$ : Infeed on right thread flank
- **R: Rem. cut depth** (only with **GV** = 4; default: 1/100 mm)
- **E: Incremental gradient** – Variable thread pitch (e.g. for manufacturing spiral conveyors or extruder shafts)
- **Q: Number no-load.**
- **IC: Number of cuts** – The infeed is calculated from **IC** and **U**  
Usable with:
  - **GV** = 0: Constant chip cross section
  - **GV** = 1: Constant infeed
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Thread cutting**

Cycle run:

- 1 Calculate the proportioning of cuts
- 2 Start the first thread groove at the **Start point Z**
- 3 Move to the **End point thread Z2** at the programmed feed rate
- 4 Return on a paraxial path and approach for the next thread groove
- 5 Repeat 3 to 4 for all thread grooves
- 6 Approach for the next pass, taking the **reduced cutting depth** and the **Approach ang. A** into account
- 7 Repeat 3 to 6 until **No.gears D** and **Thread depth U** are reached
- 8 Move to the **Tool change point** according to the setting in **G14**



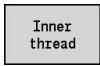
## Taper thread



- ▶ Select **Thread cutting**



- ▶ Select **Taper thread**

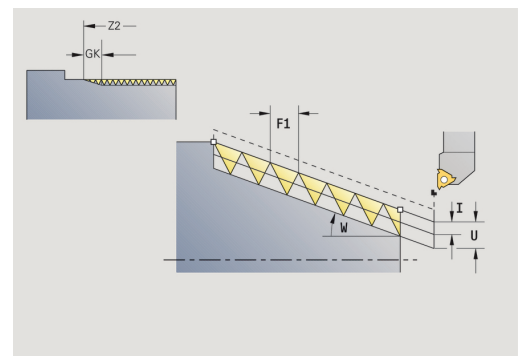
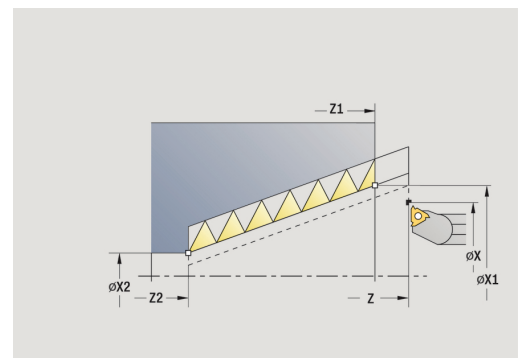
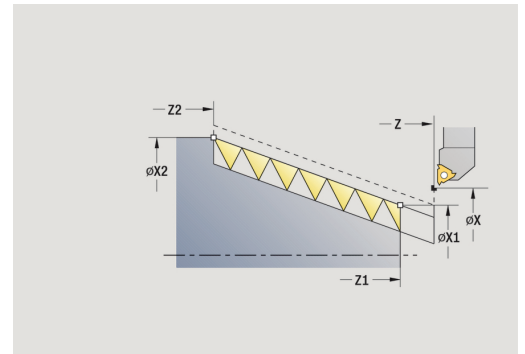


- ▶ Select the type of thread:
  - **On:** Internal thread
  - **Off:** External thread

This cycle cuts a single or multi-start tapered external or internal thread.

Cycle parameters:

- **X, Z:** Start point
- **X1, Z1:** Start point thread
- **X2, Z2:** End point thread
- **F1:** Thread pitch (= feed rate)
- **D:** No.gears (default: 1 single-start thread)
- **U:** Thread depth (default: no input)
  - Outside thread:  $U = 0.6134 * F1$
  - Inside thread:  $U = -0.5413 * F1$
- **I:** Max. approach
  - $I < U$ : First cut with **I**, all subsequent cuts with cutting-depth reduction
  - $I = U$ : One cut
  - No input: **I** is calculated from **U** and **F1**
- **W:** Taper angle (range:  $-60^\circ < W < 60^\circ$ )
- **GK:** Thread runout length
  - $GK < 0$ : Run-out at beginning of thread
  - $GK > 0$ : Run-out at end of thread
- **G47:** Safety clearance  
**Further information:** "Safety clearance G47", Page 186
- **T:** Tool number – Turret pocket number
- **G14:** Tool change point  
**Further information:** "Tool change point G14", Page 186
- **ID:** ID no.
- **S:** Constant spindle speed
- **GV:** Type of infeed  
**Further information:** "GV parameter: Type of infeed", Page 321
  - **0:** Const. mach. X-section
  - **1:** Const. infeed
  - **2:** EPL with distrib. of cuts
  - **3:** EPL w/o distrib. of cuts
  - **4:** MANUALplus 4110
  - **5:** Constant infeed (4290)
  - **6:** Const. w/ distrib. (4290)



- **GH: Type of offset**
  - **0: Without offset**
  - **1: From left**
  - **2: From right**
  - **3: Alternating left/right**
- **A: Approach ang.** (range:  $-60^\circ < \mathbf{A} < 60^\circ$ ; default:  $30^\circ$ )
  - $\mathbf{A} < 0$ : Infeed on left thread flank
  - $\mathbf{A} > 0$ : Infeed on right thread flank
- **R: Rem. cut depth** (only with **GV** = 4; default: 1/100 mm)
- **E: Incremental gradient** – Variable thread pitch (e.g. for manufacturing spiral conveyors or extruder shafts)
- **Q: Number no-load.**
- **IC: Number of cuts** – The infeed is calculated from **IC** and **U**  
Usable with:
  - **GV** = 0: Constant chip cross section
  - **GV** = 1: Constant infeed
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Thread cutting**

Parameter combinations for **Taper angle**:

- **X1/Z1, X2/Z2**
- **X1/Z1, Z2, W**
- **Z1, X2/Z2, W**

Cycle run:

- 1 Calculate the proportioning of cuts
- 2 Move to the **Start point X1, Z1**
- 3 Move to the **End point thread Z2** at the programmed feed rate
- 4 Return on a paraxial path and approach for the next thread groove
- 5 Repeat 3 to 4 for all thread grooves
- 6 Approach for the next pass, taking the **reduced cutting depth** and the **Approach ang. A** into account
- 7 Repeat 3 to 6 until **No.gears D** and **Thread depth U** are reached
- 8 Move to the **Tool change point** according to the setting in **G14**

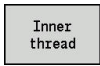
## API thread



- ▶ Select **Thread cutting**



- ▶ Select **API thread**

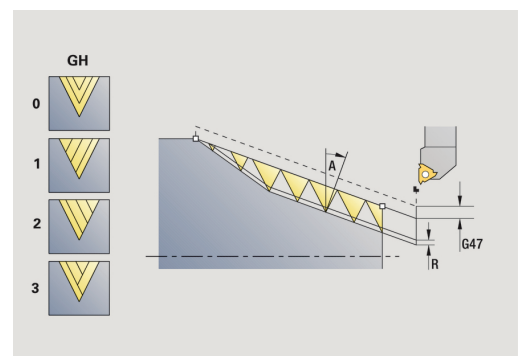
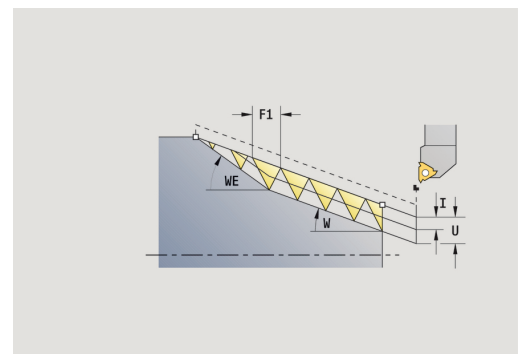
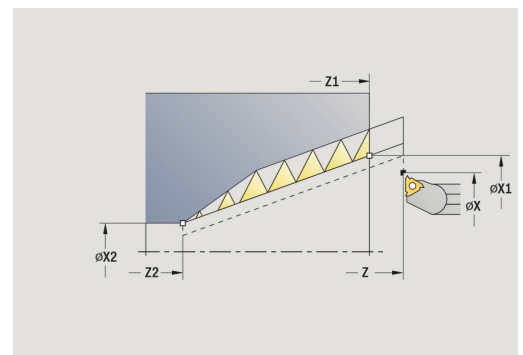
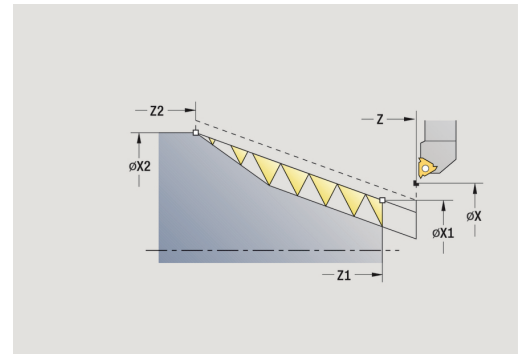


- ▶ Select the type of thread:
  - **On:** Internal thread
  - **Off:** External thread

This cycle cuts a single or multi-start external or internal API thread. The depth of thread decreases at the thread run-out.

Cycle parameters:

- **X, Z:** Start point
- **X1, Z1:** Start point thread
- **X2, Z2:** End point thread
- **F1:** Thread pitch (= feed rate)
- **D:** No.gears (default: 1 single-start thread)
- **U:** Thread depth (default: no input)
  - Outside thread:  $U = 0.6134 * F1$
  - Inside thread:  $U = -0.5413 * F1$
- **I:** Max. approach
  - $I < U$ : First cut with **I**, all subsequent cuts with cutting-depth reduction
  - $I = U$ : One cut
  - No input: **I** is calculated from **U** and **F1**
- **WE:** Run-out angle (range:  $0^\circ < WE < 90^\circ$ )
- **W:** Taper angle (range:  $-60^\circ < W < 60^\circ$ )
- **G47:** Safety clearance  
Further information: "Safety clearance G47", Page 186
- **T:** Tool number – Turret pocket number
- **G14:** Tool change point  
Further information: "Tool change point G14", Page 186
- **ID:** ID no.
- **S:** Constant spindle speed
- **GV:** Type of infeed  
Further information: "GV parameter: Type of infeed", Page 321
  - **0:** Const. mach. X-section
  - **1:** Const. infeed
  - **2:** EPL with distrib. of cuts
  - **3:** EPL w/o distrib. of cuts
  - **4:** MANUALplus 4110
  - **5:** Constant infeed (4290)
  - **6:** Const. w/ distrib. (4290)



- **GH: Type of offset**
  - **0: Without offset**
  - **1: From left**
  - **2: From right**
  - **3: Alternating left/right**
- **A: Approach ang.** (range:  $-60^\circ < \mathbf{A} < 60^\circ$ ; default:  $30^\circ$ )
  - $\mathbf{A} < 0$ : Infeed on left thread flank
  - $\mathbf{A} > 0$ : Infeed on right thread flank
- **R: Rem. cut depth** (only with **GV** = 4; default: 1/100 mm)
- **Q: Number no-load.**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Thread cutting**

Parameter combinations for the taper angle:

- **X1/Z1, X2/Z2**
- **X1/Z1, Z2, W**
- **Z1, X2/Z2, W**

Cycle run:

- 1 Calculate the proportioning of cuts
- 2 Move to the **Start point X1, Z1**
- 3 Move to the **End point thread Z2** at the programmed feed rate, taking the **Run-out angle WE** into account
- 4 Return on a paraxial path and approach for the next thread groove
- 5 Repeat 3 to 4 for all thread grooves
- 6 Approach for the next pass, taking the **reduced cutting depth** and the **Approach ang. A** into account
- 7 Repeat 3 to 6 until **No.gears D** and **Thread depth U** are reached
- 8 Move to the **Tool change point** according to the setting in **G14**

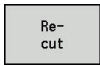
## Recutting threads (longitudinally)



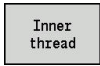
- ▶ Select **Thread cutting**



- ▶ Select **Thread cycle**



- ▶ Press the **Recut** soft key

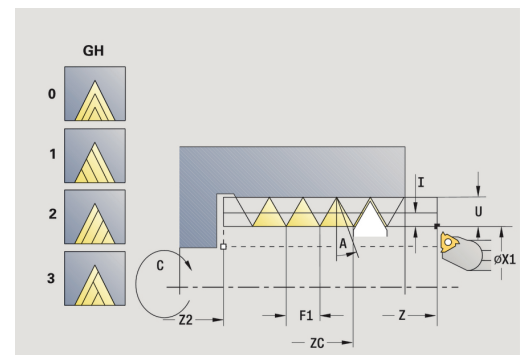
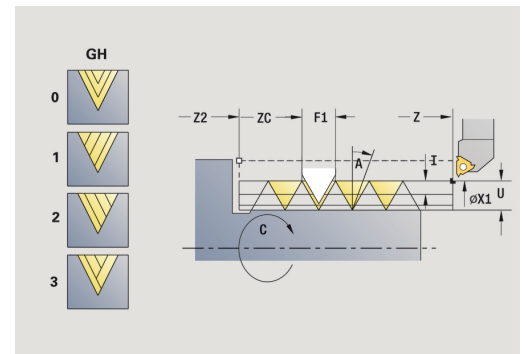


- ▶ Select the type of thread:
  - **On:** Internal thread
  - **Off:** External thread

This optional cycle recuts a single-start thread. Since you have already unclamped the workpiece, the control needs to know the exact position of the thread. Place the cutting tip of the threading tool in the center of a groove and transfer the positions to the **Measured angle C** and **Measured position ZC** parameters by pressing the **Take over position** soft key. From these values, the cycle then calculates the angle of the spindle at the starting point. This function is only available in **Machine** mode of operation.

Cycle parameters:

- **X, Z:** Start point
  - **X1:** Start point thread
  - **Z2:** End point thread
  - **F1:** Thread pitch (= feed rate)
  - **U:** Thread depth (default: no input)
    - Outside thread:  $U = 0.6134 * F1$
    - Inside thread:  $U = -0.5413 * F1$
  - **I:** Max. approach
    - $I < U$ : First cut with I, all subsequent cuts with cutting-depth reduction
    - $I = U$ : One cut
    - No input: I is calculated from U and F1
  - **C:** Measured angle
  - **ZC:** Measured position
  - **T:** Tool number – Turret pocket number
  - **ID:** ID no.
  - **S:** Constant spindle speed
  - **GV:** Type of infeed
- Further information:** "GV parameter: Type of infeed", Page 321
- **0:** Const. mach. X-section
  - **1:** Const. infeed
  - **2:** EPL with distrib. of cuts
  - **3:** EPL w/o distrib. of cuts
  - **4:** MANUALplus 4110
  - **5:** Constant infeed (4290)
  - **6:** Const. w/ distrib. (4290)



- **GH: Type of offset**
  - **0: Without offset**
  - **1: From left**
  - **2: From right**
  - **3: Alternating left/right**
- **A: Approach ang.** (range:  $-60^\circ < \mathbf{A} < 60^\circ$ ; default:  $30^\circ$ )
  - $\mathbf{A} < 0$ : Infeed on left thread flank
  - $\mathbf{A} > 0$ : Infeed on right thread flank
- **R: Rem. cut depth** (only with **GV** = 4; default: 1/100 mm)
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)

Cycle run:

- 1 Pre-position the threading tool to the center of a thread groove
- 2 Use the **Take over position** soft key to transfer the tool position and the spindle angle to the **Measured position ZC** and **Measured angle C** parameters
- 3 Move the tool manually out of the thread groove
- 4 Position the tool to the **Start point**
- 5 Start the cycle with the **Input finished** soft key, then press the **NC start** key

## Recutting threads, Expanded (longitudinally)



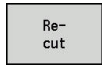
- ▶ Select **Thread cutting**



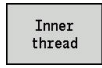
- ▶ Select **Thread cycle**



- ▶ Select the **Expanded** soft key



- ▶ Press the **Recut** soft key

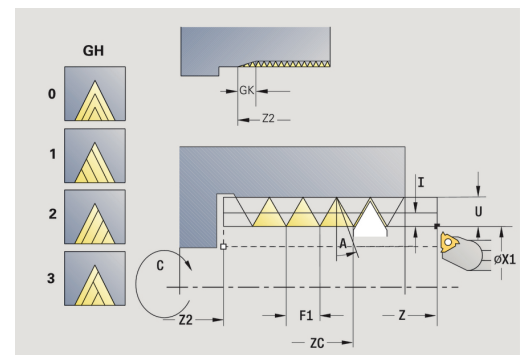
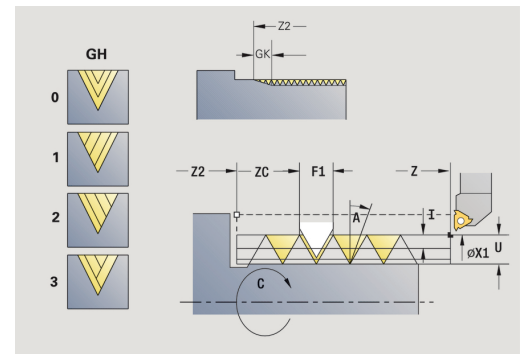


- ▶ Select the type of thread:
  - **On:** Internal thread
  - **Off:** External thread

This optional cycle recuts a single-start thread. Since you have already unclamped the workpiece, the control needs to know the exact position of the thread. Place the cutting tip of the threading tool in the center of a groove and transfer the positions to the **Measured angle C** and **Measured position ZC** parameters by pressing the **Take over position** soft key. From these values, the cycle then calculates the angle of the spindle at the starting point. This function is only available in **Machine** mode of operation.

Cycle parameters:

- **X, Z:** Start point
- **X1:** Start point thread
- **Z2:** End point thread
- **F1:** Thread pitch (= feed rate)
- **D:** No.gears (default: 1 single-start thread)
- **U:** Thread depth (default: no input)
  - Outside thread:  $U = 0.6134 * F1$
  - Inside thread:  $U = -0.5413 * F1$
- **I:** Max. approach
  - $I < U$ : First cut with **I**, all subsequent cuts with cutting-depth reduction
  - $I = U$ : One cut
  - No input: **I** is calculated from **U** and **F1**
- **GK:** Thread runout length
- **C:** Measured angle
- **ZC:** Measured position
- **T:** Tool number – Turret pocket number
- **ID:** ID no.
- **S:** Constant spindle speed





- **GV: Type of infeed**  
**Further information:** "GV parameter: Type of infeed", Page 321
  - **0: Const. mach. X-section**
  - **1: Const. infeed**
  - **2: EPL with distrib. of cuts**
  - **3: EPL w/o distrib. of cuts**
  - **4: MANUALplus 4110**
  - **5: Constant infeed (4290)**
  - **6: Const. w/ distrib. (4290)**
- **GH: Type of offset**
  - **0: Without offset**
  - **1: From left**
  - **2: From right**
  - **3: Alternating left/right**
- **A: Approach ang.** (range:  $-60^\circ < A < 60^\circ$ ; default:  $30^\circ$ )
  - **A < 0:** Infeed on left thread flank
  - **A > 0:** Infeed on right thread flank
- **R: Rem. cut depth** (only with **GV** = 4; default: 1/100 mm)
- **E: Incremental gradient** – Variable thread pitch (e.g. for manufacturing spiral conveyors or extruder shafts)
- **Q: Number no-load.**
- **MT: M after T:** M function that is executed after the tool call **T**
- **MFS: M at beginning:** M function that is executed at the beginning of the machining step
- **MFE: M at end:** M function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)

Cycle run:

- 1 Pre-position the threading tool to the center of a thread groove
- 2 Use the **Take over position** soft key to transfer the tool position and the spindle angle to the **Measured position ZC** and **Measured angle C** parameters
- 3 Move the tool manually out of the thread groove
- 4 Position the tool to the **Start point**
- 5 Start the cycle with the **Input finished** soft key and press the **NC start** key

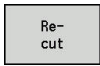
## Recutting taper threads



- ▶ Select **Thread cutting**



- ▶ Select **Taper thread**



- ▶ Press the **Recut** soft key



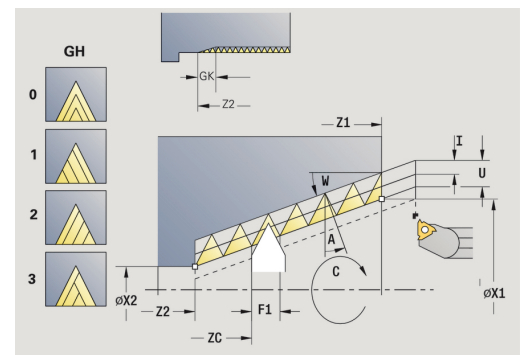
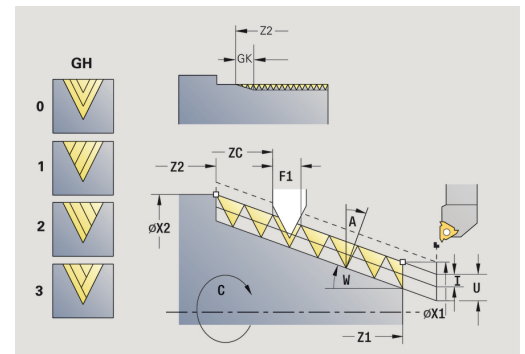
- ▶ Select the type of thread:
  - **On:** Internal thread
  - **Off:** External thread

This optional cycle recuts a single or multi-start tapered external or internal thread. Since you have already unclamped the workpiece, the control needs to know the exact position of the thread. Place the cutting tip of the threading tool in the center of a groove and transfer the positions to the **Measured angle C** and **Measured position ZC** parameters by pressing the **Take over position** soft key. From these values, the cycle then calculates the angle of the spindle at the starting point.

This function is only available in **Machine** mode of operation.

Cycle parameters:

- **X, Z:** Start point
- **X1, Z1:** Start point thread
- **X2, Z2:** End point thread
- **F1:** Thread pitch (= feed rate)
- **D:** No.gears (default: 1 single-start thread)
- **U:** Thread depth (default: no input)
  - Outside thread:  $U = 0.6134 * F1$
  - Inside thread:  $U = -0.5413 * F1$
- **I:** Max. approach
  - $I < U$ : First cut with **I**, all subsequent cuts with cutting-depth reduction
  - $I = U$ : One cut
  - No input: **I** is calculated from **U** and **F1**
- **W:** Taper angle (range:  $-60^\circ < W < 60^\circ$ )
- **GK:** Thread runout length
  - $GK < 0$ : Run-out at beginning of thread
  - $GK > 0$ : Run-out at end of thread
- **C:** Measured angle
- **ZC:** Measured position
- **T:** Tool number – Turret pocket number
- **ID:** ID no.
- **S:** Constant spindle speed



- **GV: Type of infeed**  
**Further information:** "GV parameter: Type of infeed", Page 321
  - **0: Const. mach. X-section**
  - **1: Const. infeed**
  - **2: EPL with distrib. of cuts**
  - **3: EPL w/o distrib. of cuts**
  - **4: MANUALplus 4110**
  - **5: Constant infeed (4290)**
  - **6: Const. w/ distrib. (4290)**
- **GH: Type of offset**
  - **0: Without offset**
  - **1: From left**
  - **2: From right**
  - **3: Alternating left/right**
- **A: Approach ang.** (range:  $-60^\circ < \mathbf{A} < 60^\circ$ ; default:  $30^\circ$ )
  - **A < 0:** Infeed on left thread flank
  - **A > 0:** Infeed on right thread flank
- **R: Rem. cut depth** (only with **GV** = 4; default: 1/100 mm)
- **E: Incremental gradient** – Variable thread pitch (e.g. for manufacturing spiral conveyors or extruder shafts)
- **Q: Number no-load.**
- **MT: M after T:** **M** function that is executed after the tool call **T**
- **MFS: M at beginning:** **M** function that is executed at the beginning of the machining step
- **MFE: M at end:** **M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)

Cycle run:

- 1 Pre-position the threading tool to the center of a thread groove
- 2 Use the **Take over position** soft key to transfer the tool position and the spindle angle to the **Measured position ZC** and **Measured angle C** parameters
- 3 Move the tool manually out of the thread groove
- 4 Position the tool **in front of** the workpiece
- 5 Start the cycle with the **Input finished** soft key and press the **NC start** key

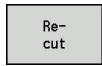
## Recutting API threads



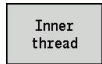
- ▶ Select **Thread cutting**



- ▶ Select **API thread**



- ▶ Press the **Recut** soft key



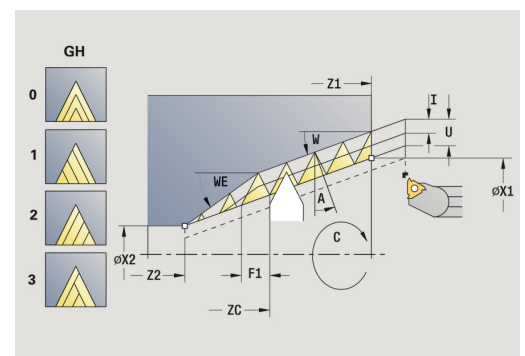
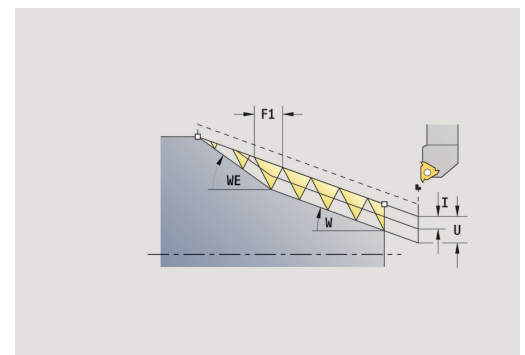
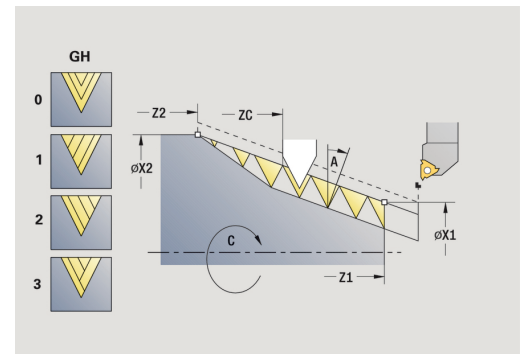
- ▶ Select the type of thread:
  - **On:** Internal thread
  - **Off:** External thread

This optional cycle recuts a single or multi-start external or internal API thread. Since you have already unclamped the workpiece, the control needs to know the exact position of the thread. Place the cutting tip of the threading tool in the center of a groove and transfer the positions to the **Measured angle C** and **Measured position ZC** parameters by pressing the **Take over position** soft key. From these values, the cycle then calculates the angle of the spindle at the starting point.

This function is only available in **Machine** mode of operation.

Cycle parameters:

- **X, Z: Start point**
- **X1, Z1: Start point thread**
- **X2, Z2: End point thread**
- **F1: Thread pitch** (= feed rate)
- **D: No.gears** (default: 1 single-start thread)
- **U: Thread depth** (default: no input)
  - Outside thread:  $U = 0.6134 * F1$
  - Inside thread:  $U = -0.5413 * F1$
- **I: Max. approach**
  - $I < U$ : First cut with **I**, all subsequent cuts with cutting-depth reduction
  - $I = U$ : One cut
  - No input: **I** is calculated from **U** and **F1**
- **WE: Run-out angle** (range:  $0^\circ < WE < 90^\circ$ )
- **W: Taper angle** (range:  $-60^\circ < W < 60^\circ$ )
- **C: Measured angle**
- **ZC: Measured position**
- **T: Tool number** – Turret pocket number
- **ID: ID no.**
- **S: Constant spindle speed**



- **GV: Type of infeed**  
**Further information:** "GV parameter: Type of infeed", Page 321
  - **0: Const. mach. X-section**
  - **1: Const. infeed**
  - **2: EPL with distrib. of cuts**
  - **3: EPL w/o distrib. of cuts**
  - **4: MANUALplus 4110**
  - **5: Constant infeed (4290)**
  - **6: Const. w/ distrib. (4290)**
- **GH: Type of offset**
  - **0: Without offset**
  - **1: From left**
  - **2: From right**
  - **3: Alternating left/right**
- **A: Approach ang.** (range:  $-60^\circ < A < 60^\circ$ ; default:  $30^\circ$ )
  - **A < 0:** Infeed on left thread flank
  - **A > 0:** Infeed on right thread flank
- **R: Rem. cut depth** (only with **GV** = 4; default: 1/100 mm)
- **Q: Number no-load.**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)

Cycle run:

- 1 Pre-position the threading tool to the center of a thread groove
- 2 Use the **Take over position** soft key to transfer the tool position and the spindle angle to the **Measured position ZC** and **Measured angle C** parameters
- 3 Move the tool manually out of the thread groove
- 4 Position the tool **in front of** the workpiece
- 5 Start the cycle with the **Input finished** soft key and press the **NC start** key

## Undercut DIN 76



- ▶ Select **Thread cutting**



- ▶ **Undercut DIN 76**

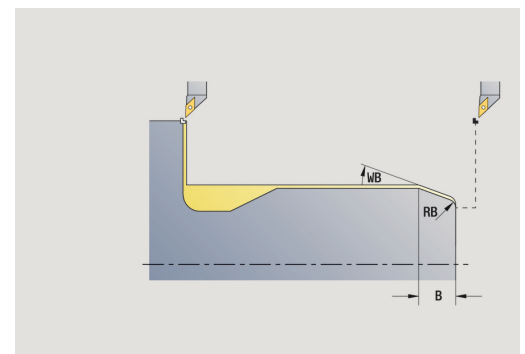
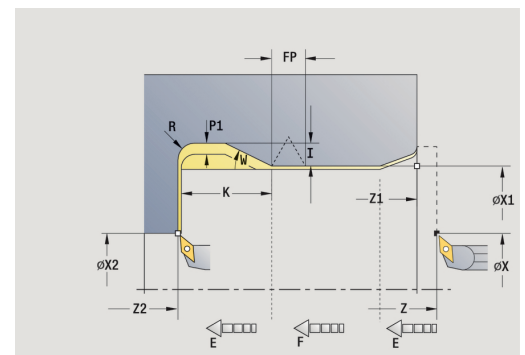
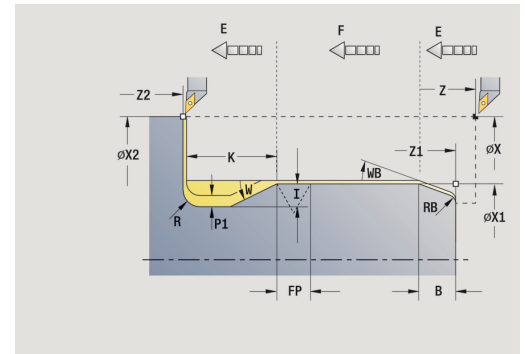


- ▶ Select the scope of the cycle:
  - **Off**: When the cycle is completed, the tool remains at the cycle end position
  - **On**: The tool returns to the starting point

The cycle machines an **Undercut DIN 76**, a thread chamfer, the adjoining cylinder, and then with the plane surface. The thread chamfer is executed when you enter the **Cylinder 1st cut length** or **Cut-in radius** parameters.

Cycle parameters:

- **X, Z**: Start point
- **X1, Z1**: Start point cylinder
- **X2, Z2**: End point transv.
- **FP**: **Thread pitch** (default: value from standard table)
- **E**: **Reduced feed** for the plunge cut and the thread chamfer (default: **Feed per revolution F**)
- **I**: **Undercut depth** (default: value from standard table)
- **K**: **Undercut length** (default: standard table)
- **W**: **Undercut angle** (default: value from standard table)
- **R**: **Undercut radius** on both sides of the undercut (default: value from standard table)
- **P1**: **Undercut oversize**
  - No input: Machining in one cut
  - **P1** > 0: Division into pre-turning and finish-turning. **P1** is longitudinal oversize; the transverse oversize is preset to 0.1 mm
- **T**: **Tool number** – Turret pocket number
- **G14**: **Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID**: **ID no.**
- **S**: **Cutting speed** or **Constant speed**
- **F**: **Feed per revolution**
- **B**: **Cylinder 1st cut length** (default: no start chamfer)
- **WB**: **Cut-in angle** (default: 45°)
- **RB**: **Cut-in radius** (no input: no element; positive value: cut-in radius; negative value: chamfer)
- **G47**: **Safety clearance**  
**Further information:** "Safety clearance G47", Page 186 — evaluated only if "With return" is active
- **MT**: **M after T**: **M** function that is executed after the tool call **T**
- **MFS**: **M at beginning**: **M** function that is executed at the beginning of the machining step
- **MFE**: **M at end**: **M** function that is executed at the end of the machining step



- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**

All parameters that you enter will be accounted for—even if the standard table prescribes other values. If the parameters **I**, **K**, **W** and **R** are not defined, the control determines these parameters from **FP** in the standard table.

**Further information:** "DIN 76 – undercut parameters", Page 757

Cycle run:

- 1 Approach the workpiece from the **Start point**
  - to the **Start point cylinder X1**
  - Alternative:
    - for the **thread chamfer**
- 2 Machine the **thread chamfer**, if defined
- 3 Finish-machine the cylinder up to the beginning of the undercut
- 4 Pre-machine the undercut, if defined
- 5 Machine the undercut
- 6 Finish-machine to the **End point transv. X2**
- 7 Return
  - Without return: Tool remains at the **End point transv.**
  - With return: Retract and return diagonally to the **Start point**
- 8 Move to the **Tool change point** according to the setting in **G14**

## Undercut DIN 509 E



- ▶ Select **Thread cutting**



- ▶ **Undercut DIN 509 E**

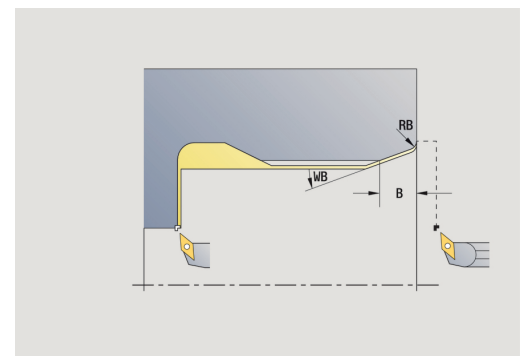
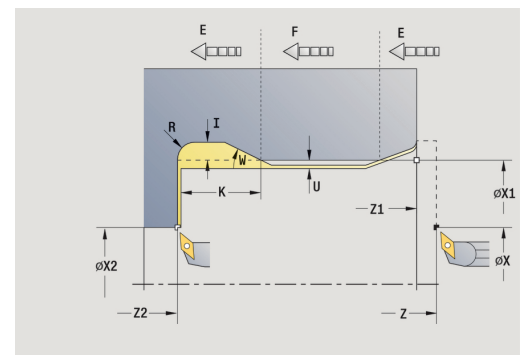
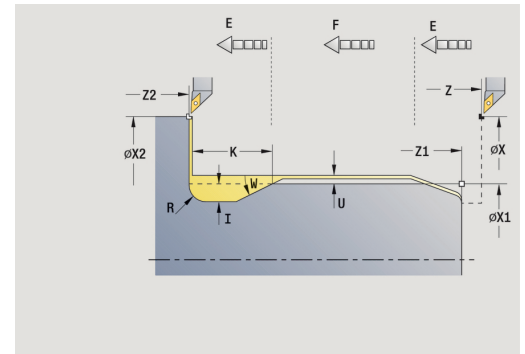


- ▶ Select the scope of the cycle:
  - **Off**: When the cycle is completed, the tool remains at the cycle end position
  - **On**: The tool returns to the starting point

The cycle machines an **Undercut DIN 509 E**, a cylinder start chamfer, the adjoining cylinder, and then the plane surface. You can define a grinding oversize for the area of the cylinder. The cylinder chamfer is executed when you enter the **Cylinder 1st cut length** or **Cut-in radius** parameter.

Cycle parameters:

- **X, Z**: Start point
- **X1, Z1**: Start point cylinder
- **X2, Z2**: End point transv.
- **U**: **Grind. overs.** for the area of the cylinder (default: 0)
- **E**: **Reduced feed** for the plunge cut and the thread chamfer (default: **Feed per revolution F**)
- **I**: **Undercut depth** (default: value from standard table)
- **K**: **Undercut length** (default: standard table)
- **W**: **Undercut angle** (default: value from standard table)
- **R**: **Undercut radius** on both sides of the undercut (default: value from standard table)
- **T**: **Tool number** – Turret pocket number
- **G14**: **Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID**: ID no.
- **S**: **Cutting speed** or **Constant speed**
- **F**: **Feed per revolution**
- **B**: **Cylinder 1st cut length** (default: no start chamfer)
- **WB**: **Cut-in angle** (default: 45°)
- **RB**: **Cut-in radius** (no input: no element; positive value: cut-in radius; negative value: chamfer)
- **G47**: **Safety clearance**  
**Further information:** "Safety clearance G47", Page 186 — evaluated only if "With return" is active
- **MT**: **M after T**: **M** function that is executed after the tool call **T**





- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**

All parameters that you enter will be accounted for—even if the standard table prescribes other values. If the parameters **I**, **K**, **W** and **R** are not defined, the control determines these parameters from **FP** in the standard table.

**Further information:** "DIN 509 E – undercut parameters",  
Page 758

Cycle run:

- 1 Approach the workpiece from the **Start point**
  - to the **Start point cylinder X1**
  - Alternative:
    - for the **thread chamfer**
- 2 Machine the **thread chamfer**, if defined
- 3 Finish-machine the cylinder up to the beginning of the undercut
- 4 Machine the undercut
- 5 Finish-machine to the **End point transv. X2**
- 6 Return
  - Without return: Tool remains at the **End point transv.**
  - With return: Retract and return diagonally to the **Start point**
- 7 Move to the **Tool change point** according to the setting in **G14**

## Undercut DIN 509 F



- ▶ Select **Thread cutting**



- ▶ **Undercut DIN 509 F**

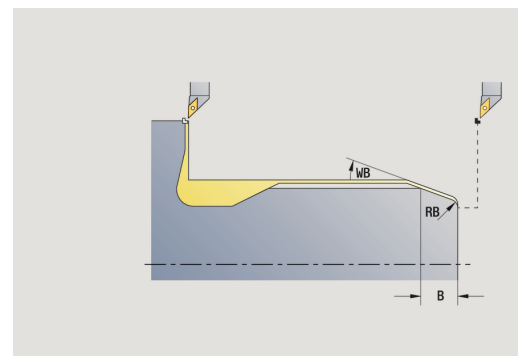
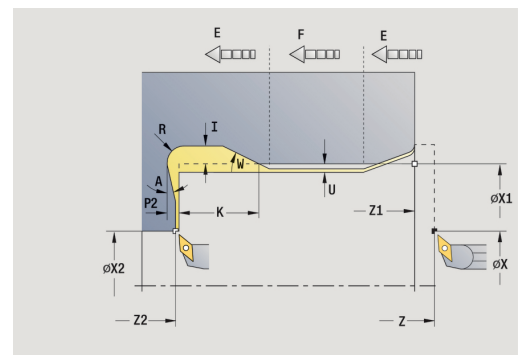
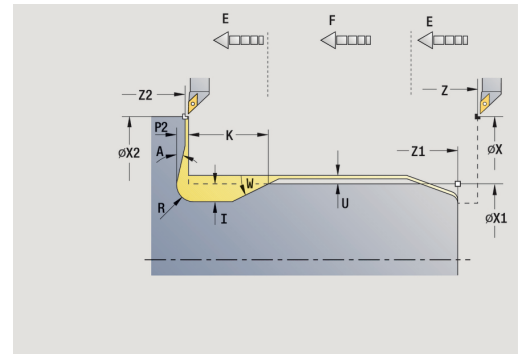


- ▶ Select the scope of the cycle:
  - **Off**: When the cycle is completed, the tool remains at the cycle end position
  - **On**: The tool returns to the starting point

The cycle machines an **Undercut DIN 509 F**, a cylinder start chamfer, the adjoining cylinder, and then the plane surface. You can define a grinding oversize for the area of the cylinder. The cylinder chamfer is executed when you enter the **Cylinder 1st cut length** or **Cut-in radius** parameter.

Cycle parameters:

- **X, Z**: Start point
- **X1, Z1**: Start point cylinder
- **X2, Z2**: End point transv.
- **U**: **Grind. overs.** for the area of the cylinder (default: 0)
- **E**: **Reduced feed** for the plunge cut and the thread chamfer (default: **Feed per revolution F**)
- **I**: **Undercut depth** (default: value from standard table)
- **K**: **Undercut length** (default: standard table)
- **W**: **Undercut angle** (default: value from standard table)
- **R**: **Undercut radius** on both sides of the undercut (default: value from standard table)
- **P2**: **Surf. depth** (default: standard table)
- **A**: **Face angle** (default: standard table)
- **T**: **Tool number** – Turret pocket number
- **G14**: **Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID**: **ID no.**
- **S**: **Cutting speed** or **Constant speed**
- **F**: **Feed per revolution**
- **B**: **Cylinder 1st cut length** (default: no start chamfer)
- **WB**: **Cut-in angle** (default: 45°)
- **RB**: **Cut-in radius** (no input: no element; positive value: cut-in radius; negative value: chamfer)
- **G47**: **Safety clearance**  
**Further information:** "Safety clearance G47", Page 186 — evaluated only if **With return** is active
- **MT**: **M after T**: **M** function that is executed after the tool call **T**



- **MFS: M at beginning:** M function that is executed at the beginning of the machining step
- **MFE: M at end:** M function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Finishing**

All parameters that you enter will be accounted for—even if the standard table prescribes other values. If the parameters **I**, **K**, **W** and **R** are not defined, the control determines these parameters from **FP** in the standard table.

**Further information:** "", Page 758

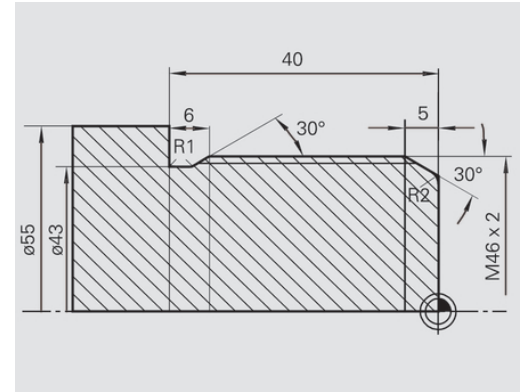
Cycle run:

- 1 Approach the workpiece from the **Start point**
  - to the **Start point cylinder X1**
  - Alternative:
    - for the **thread chamfer**
- 2 Machine the **thread chamfer**, if defined
- 3 Finish-machine the cylinder up to the beginning of the undercut
- 4 Machine the undercut
- 5 Finish-machine to the **End point transv. X2**
- 6 Return
  - Without return: Tool remains at the **End point transv.**
  - With return: Retract and return diagonally to the **Start point**
- 7 Move to the **Tool change point** according to the setting in **G14**

## Example of thread and undercut cycles

### External thread and thread undercut

The machining operation consists of two steps. The **Undercut DIN 76** cycle machines the undercut and thread chamfer. The **thread cycle** then cuts the thread.

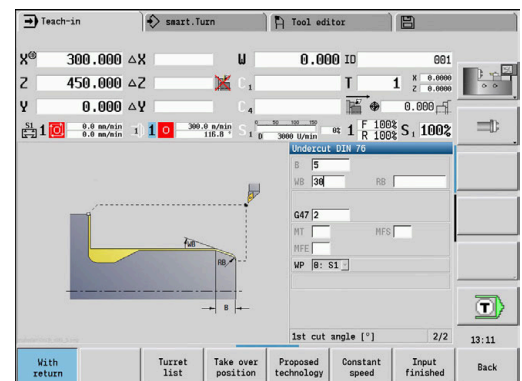
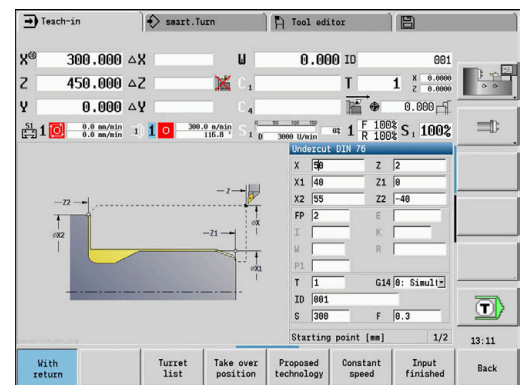


### 1st step

The parameters for the undercut and thread chamfer can be programmed in two superimposed input windows.

Tool data:

- Turning tool (for external machining)
- **TO** = 1 – Tool orientation
- **A** = 93° – Tool angle
- **B** = 55° – Point angle

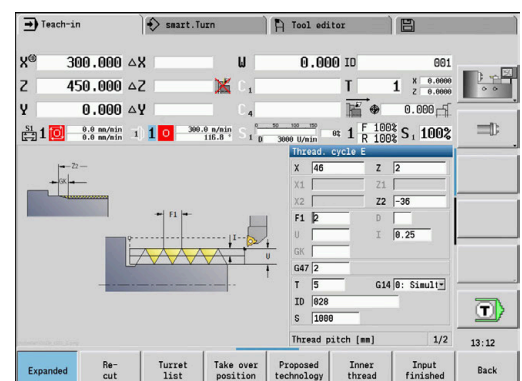


### 2nd step

The **thread cycle (longitudinal)–expanded** cuts the thread. The cycle parameters define the thread depth and the proportioning of cuts.

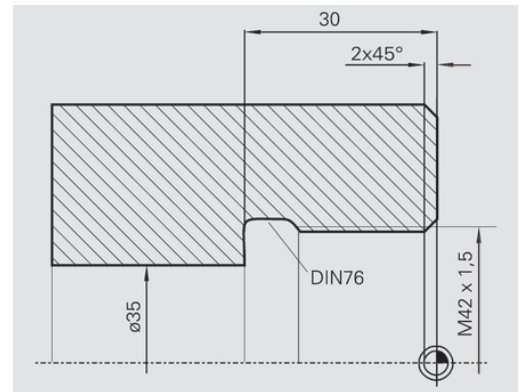
Tool data:

- Turning tool (for external machining)
- **TO** = 1 – Tool orientation



### Internal thread and thread undercut

The machining operation consists of two steps. The **Undercut DIN 76** cycle machines the undercut and thread chamfer. The **thread cycle** then cuts the thread.



#### 1st step

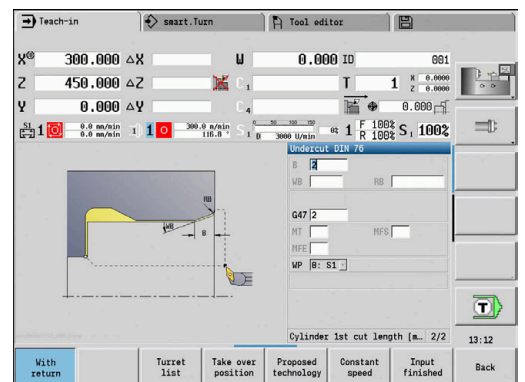
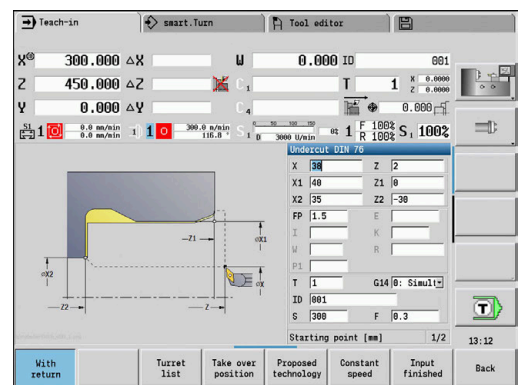
The parameters for the undercut and thread chamfer can be programmed in two superimposed input windows.

The control determines the undercut parameters from the standard table.

For the thread chamfer, you only need to enter the chamfer width. The angle of 45° is the default value for the **Cut-in angle WB**.

Tool data:

- Turning tool (for internal machining)
- **TO** = 7 – Tool orientation
- **A** = 93° – Tool angle
- **B** = 55° – Point angle



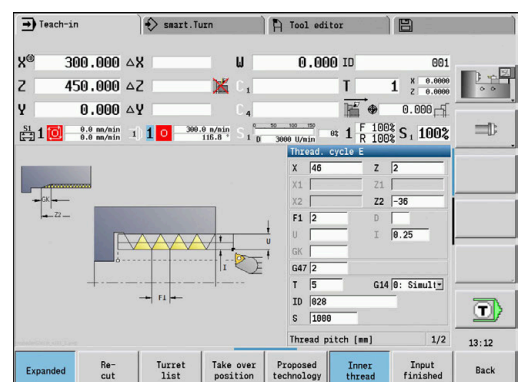
#### 2nd step

The **thread cycle (longitudinal)** cuts the thread. The thread pitch is defined. The control automatically determines all other values from the standard table.


You must pay attention to the setting of the **Inner thread** soft key.

Tool data:

- Turning tool (for internal machining)
- **TO** = 7 – Tool orientation










## 5.7 Drilling cycles



Menu item	Meaning
	The drilling cycles allow you to machine axial and radial holes

Pattern machining:

**Further information:** "Drilling and milling patterns", Page 406

Menu item	Drilling cycles
 	<b>Drill. axial/Drill. radial</b> For drilling single holes and patterns
 	<b>Deep hole ax./Deep hole rad</b> For drilling single holes and patterns
 	<b>Tapping axial/Tapping radial</b> For drilling single holes and patterns
	<b>Thread milling axial</b> For milling threads in existing holes

### Drill. axial

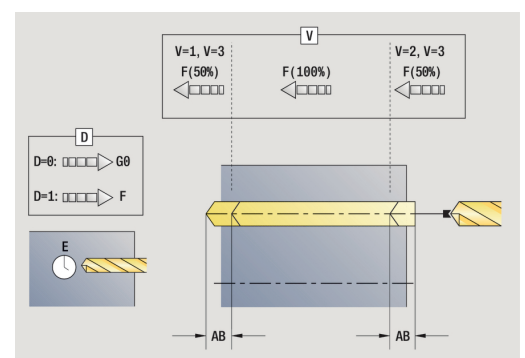
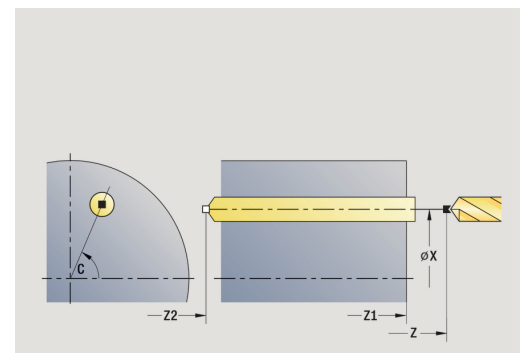
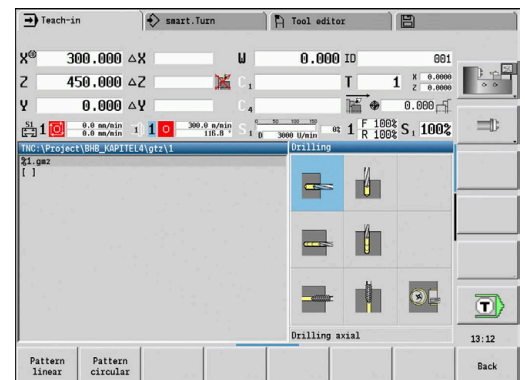
-  ▶ Select **Drilling**
-  ▶ Select **Drilling axial**

This cycle drills a hole on the face of the workpiece.

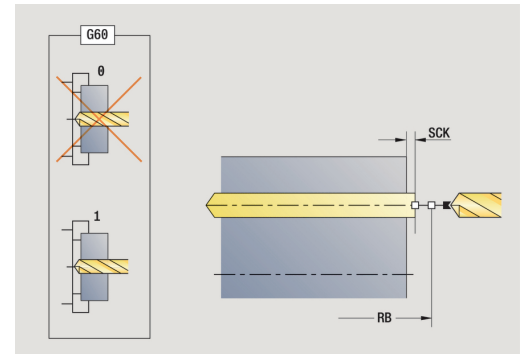
Cycle parameters:

- **X, Z:** Start point
- **C:** Spindle angle – C-axis position
- **Z1:** Start point drill (default: drilling starts from **Z**)
- **Z2:** End point drill
- **E:** Period of dwell for chip breaking at end of hole (default: 0)
- **D:** Retraction type
  - **0:** Rapid traverse
  - **1:** Feed rate
- **AB:** Drilling lengths (default: 0)
- **V:** Drilling variants (default: 0)
  - **0:** Without reduction
  - **1:** At end of the hole
  - **2:** At start of the hole
  - **3:** At start & end of hole
- **CB:** Brake off (1)
- **SCK:** Safety clearance

**Further information:** "Safety clearances SCI and SCK",  
Page 186



- **G60:** Deactivate **Protection zone** for the drilling operation
  - **0: Active**
  - **1: Inactive**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **BP: Interval time** – time during which the feed motion will be interrupted  
 The chip is broken by the intermittent feed.
- **BF: Feed period** – time interval until the next break  
 The chip is broken by the intermittent feed.
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



**i** Type of machining for technology database access depends on the tool type:

- **Drillg** for twist drills
- **Predrilling** with indexable insert drills

- i**
- If **AB** and **V** are programmed, the feed rate is reduced by 50 % during both pre-drilling and through-boring.
  - The control uses the tool parameter **driven tool** to determine whether the programmed spindle speed and feed rate apply to the spindle or the driven tool.

Cycle run:

- 1 Position the spindle to the **Spindle angle C** (in **Machine** mode: machining from current spindle angle)
- 2 If defined, move at rapid traverse to the **Start point drill Z1**
- 3 If defined, spot drill at reduced feed rate
- 4 Depending on **Drilling variants V**:
  - Through-drilling reduction:
    - Drill at programmed feed rate to position **Z2 – AB**
    - Drill at reduced feed rate to **End point drill Z2**
  - No through-drilling reduction:
    - Drill at programmed feed rate to **End point drill Z2**
    - Remain at end of hole for **Period of dwell E**, if defined
- 5 Retract
  - If **Z1** is programmed, to **Start point drill Z1**
  - If **Z1** is not programmed, to **Start point Z**
- 6 Move to the **Tool change point** according to the setting in **G14**



## Drilling radial



- ▶ Select **Drilling**

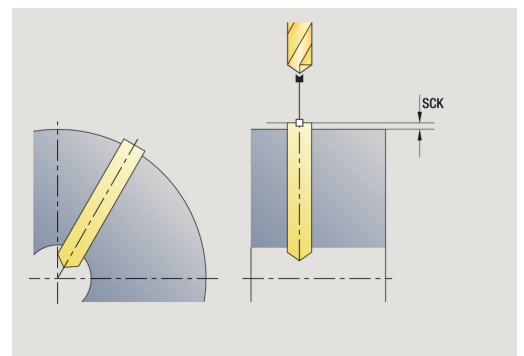
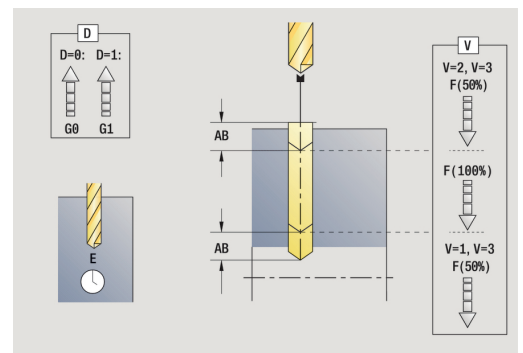
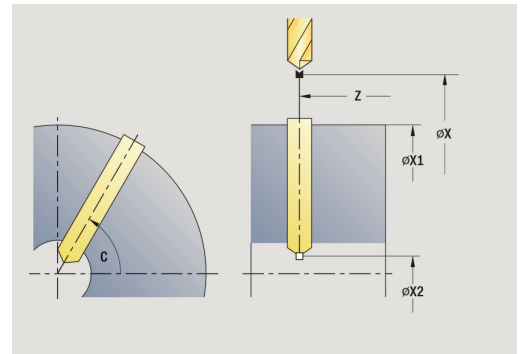


- ▶ Select **Drilling radial**

This cycle drills a hole on the lateral surface of the workpiece.

Cycle parameters:

- **X, Z: Start point**
- **C: Spindle angle** – C-axis position
- **X1: Start point drill** (default: drilling starts from **X**)
- **X2: End point drill**
- **E: Period of dwell** for chip breaking at end of hole (default: 0)
- **D: Retraction type**
  - **0: Rapid traverse**
  - **1: Feed rate**
- **AB: Drilling lengths** (default: 0)
- **V: Drilling variants** (default: 0)
  - **0: Without reduction**
  - **1: At end of the hole**
  - **2: At start of the hole**
  - **3: At start & end of hole**
- **CB: Brake off (1)**
- **SCK: Safety clearance**  
**Further information:** "Safety clearances SCI and SCK", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **BP: Interval time** – time during which the feed motion will be interrupted  
 The chip is broken by the intermittent feed.
- **BF: Feed period** – time interval until the next break  
 The chip is broken by the intermittent feed.
- **MT: M after T: M** function that is executed after the tool call **T**



- **MFS: M at beginning:** M function that is executed at the beginning of the machining step
- **MFE: M at end:** M function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access depends on the tool type:

- **Drillg** for twist drills
- **Predrilling** with indexable insert drills



If **AB** and **V** are programmed, the feed rate is reduced by 50 % during both pre-drilling and through-boring.

Cycle run:

- 1 Position the spindle to the **Spindle angle C** (in **Machine** mode: machining from current spindle angle)
- 2 If defined, move at rapid traverse to the **Start point drill X1**
- 3 If defined, spot drill at reduced feed rate
- 4 Depending on **Drilling variants V**:
  - Through-drilling reduction:
    - Drill at programmed feed rate to position **X2 – AB**
    - Drill at reduced feed rate to **End point drill X2**
  - No through-drilling reduction:
    - Drill at programmed feed rate to **End point drill X2**
    - Remain at end of hole for **Period of dwell E**, if defined
- 5 Retract
  - If **X1** is programmed, to **Start point drill X1**
  - If **X1** is not programmed, to **Start point X**
- 6 Move to the **Tool change point** according to the setting in **G14**

### Deep drilling axial



▶ Select **Drilling**

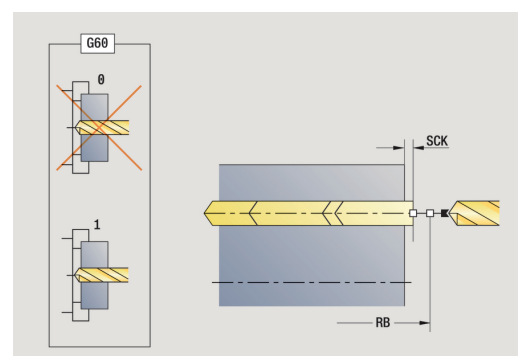
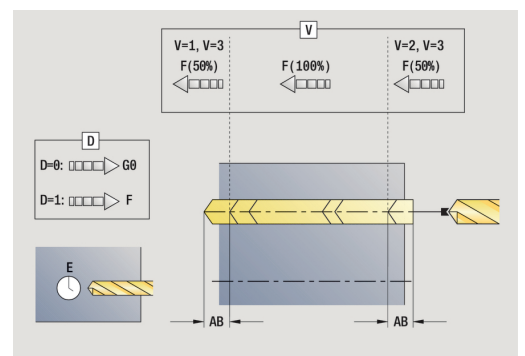
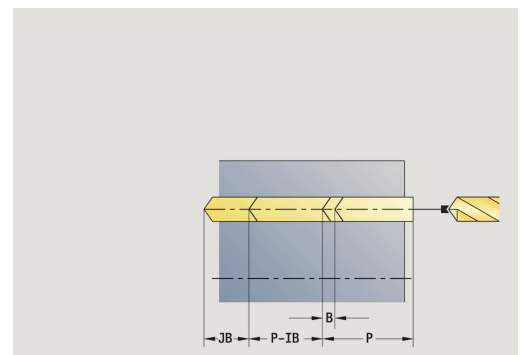
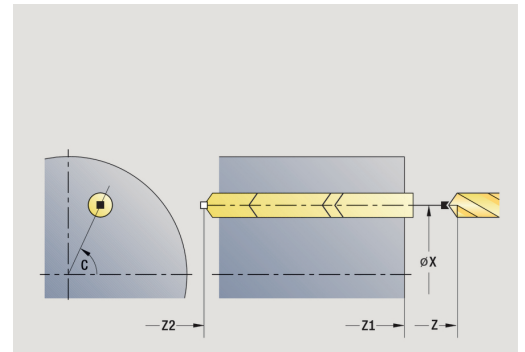


▶ Select **Deep drilling axial**

The cycle produces a hole on a front face in several passes.

Cycle parameters:

- **X, Z: Start point**
- **C: Spindle angle** – C-axis position
- **Z1: Start point drill** (default: drilling starts from **Z**)
- **Z2: End point drill**
- **P: 1st hole dpth** (default: hole will be drilled in one pass)
- **IB: Hole depth reduct. val** (default: 0)
- **JB: Minimum hole depth** (default: 1/10 of **P**)
- **B: Return length** (default: retract to **Start point drill**)
- **E: Period of dwell** for chip breaking at end of hole (default: 0)
- **D: Retraction type** – Retraction speed and infeed within the hole (default: 0)
  - **0: Rapid traverse**
  - **1: Feed rate**
- **AB: Drilling lengths** (default: 0)
- **V: Drilling variants** (default: 0)
  - **0: Without reduction**
  - **1: At end of the hole**
  - **2: At start of the hole**
  - **3: At start & end of hole**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **CB: Brake off (1)**
- **SCK: Safety clearance**  
**Further information:** "Safety clearances SCI and SCK", Page 186
- **G60: Deactivate Protection zone** for the drilling operation
  - **0: Active**
  - **1: Inactive**



- **BP: Interval time** – time during which the feed motion will be interrupted  
The chip is broken by the intermittent feed.
- **BF: Feed period** – time interval until the next break  
The chip is broken by the intermittent feed.
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access depends on the tool type:

- **Drillg** for twist drills
- **Predrilling** with indexable insert drills



- If **AB** and **V** are programmed, the feed rate is reduced by 50 % during both pre-drilling and through-boring.
- The control uses the tool parameter **driven tool** to determine whether the programmed spindle speed and feed rate apply to the spindle or the driven tool.

Cycle run:

- 1 Position the spindle to the **Spindle angle C** (in **Machine** mode: machining from current spindle angle)
- 2 If defined, move at rapid traverse to the **Start point drill Z1**
- 3 First pass (pecking depth: **P**)—spot drill at reduced feed rate, if defined
- 4 Retract by the **Return length B**—or to the **Start point drill** and advance again to the safety clearance inside the hole
- 5 Next pass (pecking depth: last depth – **IB** or **JB**)
- 6 Repeat 4 to 5 until the **End point drill Z2** is reached
- 7 Last drilling pass, depending on **Drilling variants V**:
  - Through-drilling reduction:
    - Drill at programmed feed rate to position **Z2 – AB**
    - Drill at reduced feed rate to **End point drill Z2**
  - No through-drilling reduction:
    - Drill at programmed feed rate to **End point drill Z2**
    - Remain at end of hole for **Period of dwell E**, if defined
- 8 Retract
  - If **Z1** is programmed, to **Start point drill Z1**
  - If **Z1** is not programmed, to **Start point Z**
- 9 Move to the **Tool change point** according to the setting in **G14**

## Deep drilling radial



- ▶ Select **Drilling**

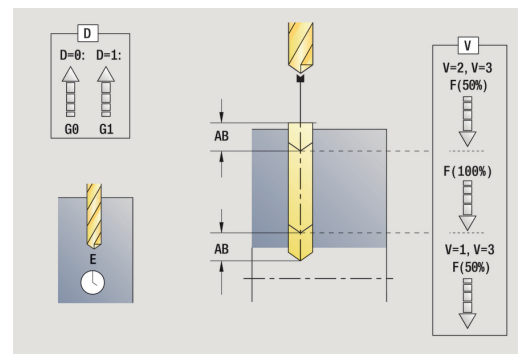
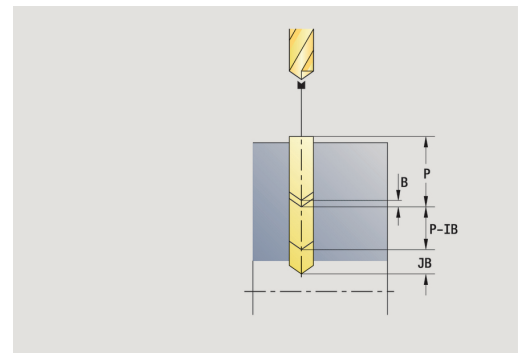
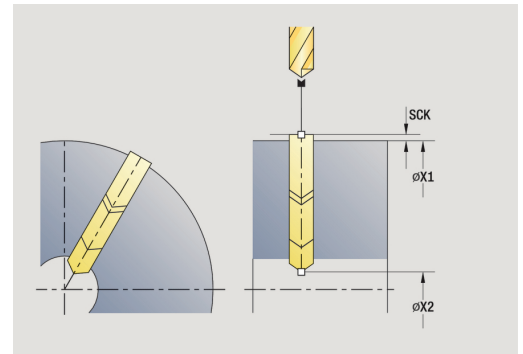


- ▶ Select **Deep drilling radial**

The cycle produces a bore hole on the lateral surface of a workpiece in several passes.

Cycle parameters:

- **X, Z: Start point**
- **C: Spindle angle** – C-axis position
- **X1: Start point drill** (default: drilling starts from **X**)
- **X2: End point drill**
- **P: 1st hole dpth** (default: hole will be drilled in one pass)
- **IB: Hole depth reduct. val** (default: 0)
- **JB: Minimum hole depth** (default: 1/10 of **P**)
- **B: Return length** (default: retract to **Start point drill**)
- **E: Period of dwell** for chip breaking at end of hole (default: 0)
- **D: Retraction type** – Retraction speed and infeed within the hole (default: 0)
  - **0: Rapid traverse**
  - **1: Feed rate**
- **AB: Drilling lengths** (default: 0)
- **V: Drilling variants** (default: 0)
  - **0: Without reduction**
  - **1: At end of the hole**
  - **2: At start of the hole**
  - **3: At start & end of hole**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **CB: Brake off (1)**
- **SCK: Safety clearance**  
**Further information:** "Safety clearances SCI and SCK", Page 186



- **BP: Interval time** – time during which the feed motion will be interrupted  
The chip is broken by the intermittent feed.
- **BF: Feed period** – time interval until the next break  
The chip is broken by the intermittent feed.
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access depends on the tool type:

- **Drillg** for twist drills
- **Predrilling** with indexable insert drills



If **AB** and **V** are programmed, the feed rate is reduced by 50 % during both pre-drilling and through-boring.

Cycle run:

- 1 Position the spindle to the **Spindle angle C** (in **Machine** mode: machining from current spindle angle)
- 2 If defined, move at rapid traverse to the **Start point drill X1**
- 3 First pass (pecking depth: **P**)—spot drill at reduced feed rate, if defined
- 4 Retract by the **Return length B**—or to the **Start point drill** and advance again to the safety clearance inside the hole
- 5 Next pass (pecking depth: last depth – **IB** or **JB**)
- 6 Repeat 4 to 5 until the **End point drill X2** is reached
- 7 Last drilling pass, depending on **Drilling variants V**:
  - Through-drilling reduction:
    - Drill at programmed feed rate to position **X2 – AB**
    - Drill at reduced feed rate to **End point drill X2**
  - No through-drilling reduction:
    - Drill at programmed feed rate to **End point drill X2**
    - Remain at end of hole for **Period of dwell E**, if defined
- 8 Retract
  - If **X1** is programmed, to **Start point drill X1**
  - If **X1** is not programmed, to **Start point X**
- 9 Move to the **Tool change point** according to the setting in **G14**



## Tapping axial



▶ Select **Drilling**



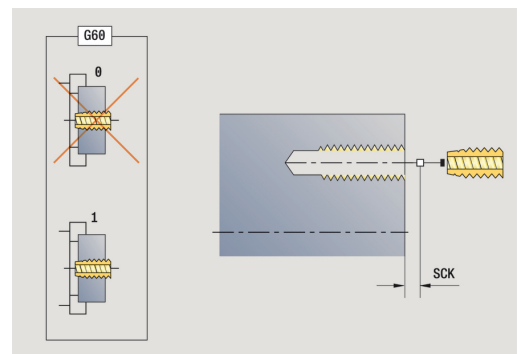
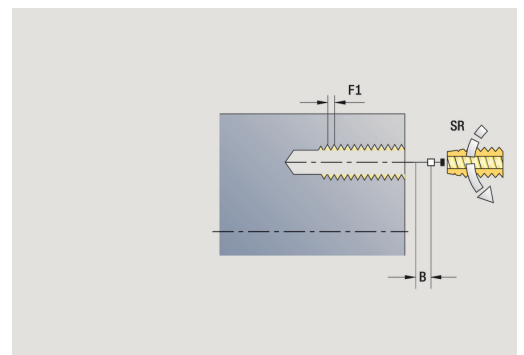
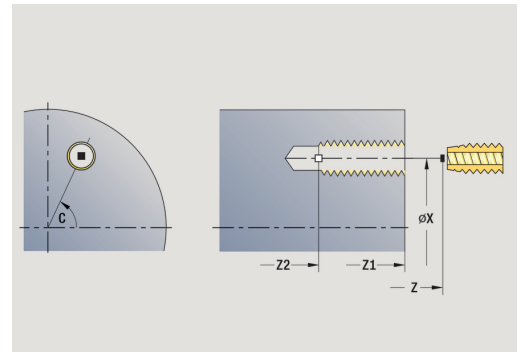
▶ Select **Tapping axial**

This cycle is used to tap a thread on the face of a workpiece.

Meaning of **Retract length**: Use this parameter for floating tap holders. The cycle calculates a new nominal pitch on the basis of the thread depth, the programmed pitch, and the retraction length. The nominal pitch is somewhat smaller than the pitch of the tap. During tapping, the tap is pulled away from the chuck by the retraction length. With this method, you can achieve higher service life of the taps.

Cycle parameters:

- **X, Z: Start point**
- **C: Spindle angle** – C-axis position
- **Z1: Start point drill** (default: drilling starts from **Z**)
- **Z2: End point drill**
- **F1: Thread pitch** (default: feed rate from tool definition)
- **B: Run-in lgth** to obtain the programmed spindle speed and feed rate (default:  $2 * \text{Thread pitch } F1$ )
- **SR: Return speed** for enabling rapid retraction (default: same spindle speed as for tapping)
- **L: Retract length** when using floating tap holders (default: 0)
- **CB: Brake off (1)**
- **SCK: Safety clearance**  
**Further information:** "Safety clearances SCI and SCK", Page 186
- **G60: Deactivate Protection zone** for the drilling operation
  - **0: Active**
  - **1: Inactive**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **SP: Chip breaking depth**
- **SI: Retraction distance**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step



- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Tapping**



The control uses the tool parameter **driven tool** to determine whether the programmed spindle speed and feed rate apply to the spindle or the driven tool.

Cycle run:

- 1 Position the spindle to the **Spindle angle C** (in **Machine** mode: machining from current spindle angle)
- 2 If defined, move at rapid traverse to the **Start point drill Z1**
- 3 Tap the thread to the **End point drill Z2**
- 4 Retract at **Return speed SR**
  - If **Z1** is programmed, to **Start point drill Z1**
  - If **Z1** is not programmed, to **Start point Z**
- 5 Move to the **Tool change point** according to the setting in **G14**

## Tapping radial



- ▶ Select **Drilling**



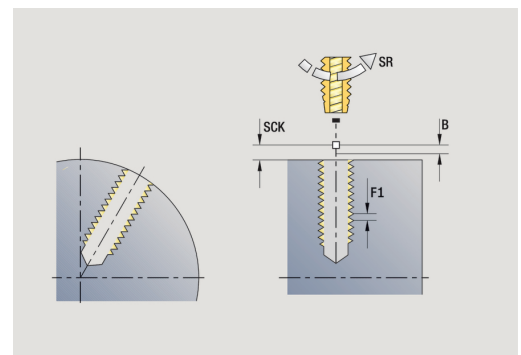
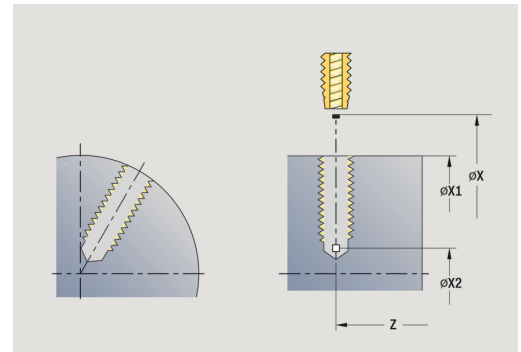
- ▶ Select **Tapping radial**

This cycle is used to tap a thread on the lateral surface of a workpiece.

Meaning of **Retract length**: Use this parameter for floating tap holders. The cycle calculates a new nominal pitch on the basis of the thread depth, the programmed pitch, and the **Retract length**. The nominal pitch is somewhat smaller than the pitch of the tap. During tapping, the drill is pulled away from the chuck by the **Retract length**. With this method, you can achieve higher service life of the taps.

Cycle parameters:

- **X, Z: Start point**
- **C: Spindle angle** – C-axis position
- **X1: Start point drill** (default: drilling starts from **X**)
- **X2: End point drill**
- **F1: Thread pitch** (default: feed rate from tool definition)
- **B: Run-in lgth** to obtain the programmed spindle speed and feed rate (default:  $2 * \text{Thread pitch F1}$ )
- **SR: Return speed** for enabling rapid retraction (default: same spindle speed as for tapping)
- **L: Retract length** when using floating tap holders (default: 0)
- **CB: Brake off (1)**
- **SCK: Safety clearance**  
Further information: "Safety clearances SCI and SCK", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
Further information: "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **SP: Chip breaking depth**
- **SI: Retraction distance**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)



- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Tapping**

Cycle run:

- 1 Position the spindle to the **Spindle angle C** (in **Machine** mode: machining from current spindle angle)
- 2 If defined, move at rapid traverse to the **Start point drill X1**
- 3 Tap the thread to the **End point drill X2**
- 4 Retract at **Return speed SR**
  - If **X1** is programmed, to **Start point drill X1**
  - If **X1** is not programmed, to **Start point X**
- 5 Move to the **Tool change point** according to the setting in **G14**

## Axial thread milling



- ▶ Select **Drilling**



- ▶ Select **Axial thread milling**

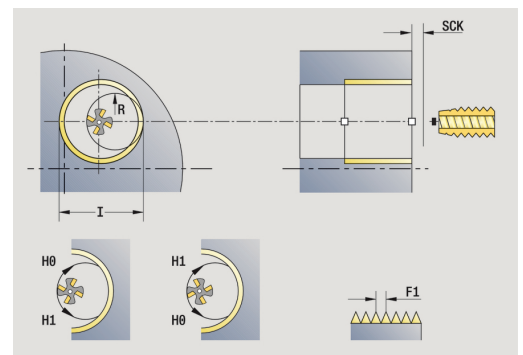
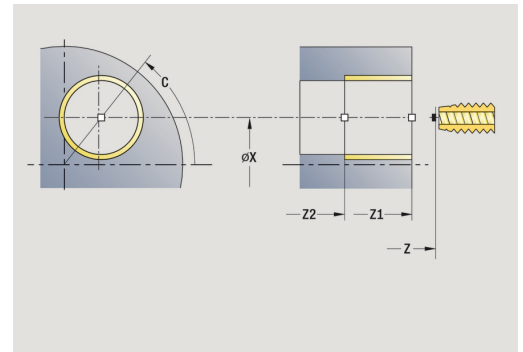
The cycle mills a thread in an existing hole.



Use threading tools for this cycle.

Cycle parameters:

- **X, Z: Start point**
- **C: Spindle angle** – C-axis position (default: current spindle angle)
- **Z1: Start point drill** (default: drilling starts from **Z**)
- **Z2: End point drill**
- **F1: Thread pitch** (= feed rate)
- **J: Direction of thread:**
  - **0: Right-hand thread**
  - **1: Left-hand thread**
- **I: Thread diameter**
- **R: Approach radius** (default:  $(I - \text{milling diameter})/2$ )
- **H: Mill cutting direction**
  - **0: Up-cut**
  - **1: Climb**
- **V: Milling method**
  - **0: One revolution** – the thread is milled in a 360-degree helix
  - **1: Two or more revolutions** – the thread is milled in several helix paths (single-point tool)
- **SCK: Safety clearance**  
**Further information:** "Safety clearances SCI and SCK", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **MT: M after T:** M function that is executed after the tool call **T**
- **MFS: M at beginning:** M function that is executed at the beginning of the machining step
- **MFE: M at end:** M function that is executed at the end of the machining step



- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Milling**

Cycle run:

- 1 Position the spindle to the **Spindle angle C** (in **Machine** mode: machining from current spindle angle)
- 2 Position the tool to the **End point drill Z2** (milling floor) inside the hole
- 3 Approach on **Approach radius R**
- 4 Mill the thread in a rotation of 360°, while advancing by the **Thread pitch F1**
- 5 Retract the tool and return it to the **Start point**
- 6 Move to the **Tool change point** according to the setting in **G14**

## Examples of drilling cycles

### Centric drilling and tapping

The machining operation consists of two steps. In the first step, the **Drilling axial** cycle drills the hole. In the second step, the **Tapping axial** cycle taps the thread.

The drill is positioned at safety clearance to the workpiece surface (**Start point X, Z**). The **Start point drill Z1** is therefore not programmed. A feed-rate reduction for spot drilling is programmed in the **AB** and **V** parameters.

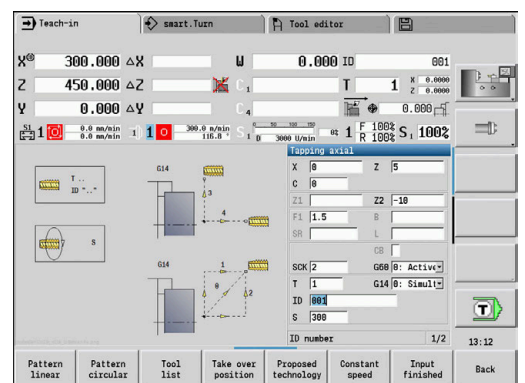
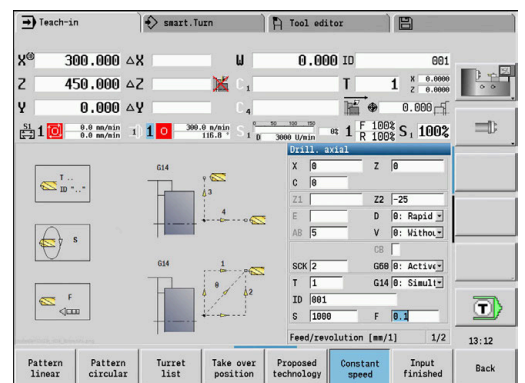
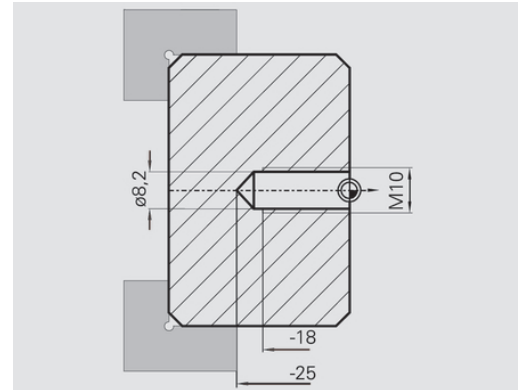
The thread pitch is not programmed. The control uses the thread pitch of the tool. The **Return speed SR** ensures that the tool is retracted quickly.

Tool data (drill)

- **TO** = 8 – Tool orientation
- **I** = 8.2 – Drilling diameter
- **B** = 118 – Point angle
- **H** = 0 – The tool is not a driven tool

Tool data (tap)

- **TO** = 8 – Tool orientation
- **I** = 10 – Thread diameter M10
- **F** = 1.5 – Thread pitch
- **H** = 0 – The tool is not a driven tool



## Deep-hole drilling

A through hole is drilled through the workpiece outside the turning center with the **Deep drilling axial** cycle. This machining operation requires a traversable spindle and driven tools.

The **1st hole dpth P** and **Hole depth reduct. val IB** parameters define the individual passes, and the **Minimum hole depth JB** parameter limits the hole depth reduction.

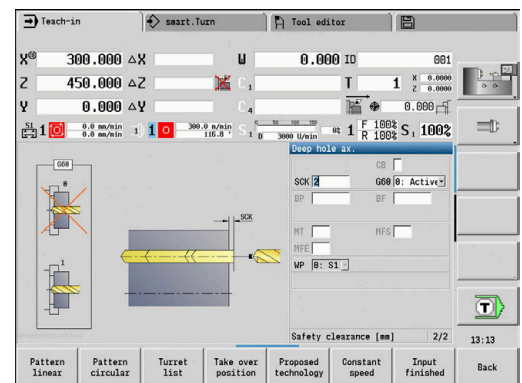
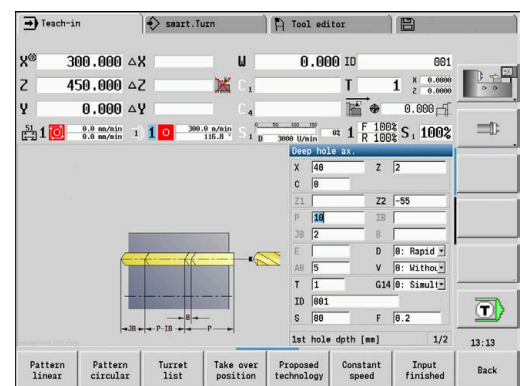
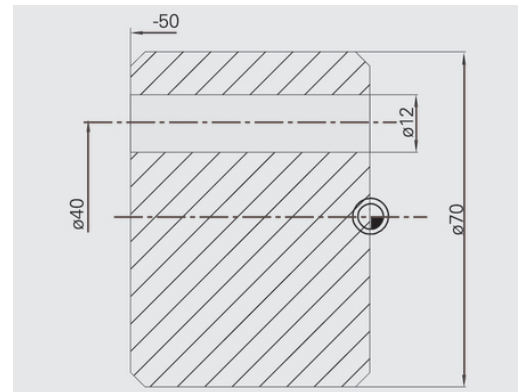
As the **Return length B** is not defined, the drill therefore retracts to the **Start point** after each pass, remains there for the programmed dwell time, and then advances again to the safety clearance for the next pass.

Since this example is to illustrate how you drill a through hole, the **End point drill Z2** is programmed such that the tool has to drill all the way through the workpiece before it reaches the end point.

The parameters **AB** and **V** define a feed-rate reduction for both spot drilling and through-boring.


Tool data

- **TO** = 8 – Tool orientation
- **I** = 12 – Drilling diameter
- **B** = 118 – Point angle
- **H** = 1 – The tool is a driven tool





## 5.8 Milling cycles








Menu item	Meaning
	Milling cycles are used to machine axial and radial slots, contours, pockets, surfaces and polygons.

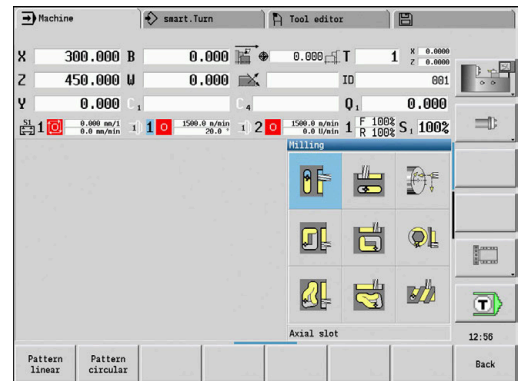
Pattern machining:

**Further information:** "Drilling and milling patterns", Page 406

In **Teach-in** submode, these cycles include activation/deactivation of the C axis and spindle positioning.

In **Machine** mode, activate the C axis with **Rapid positioning** to position the spindle **before** the actual milling cycle. The milling cycles then automatically deactivate the C axis.

Menu item	Milling cycles
	<b>Rapid positioning</b> Activate C axis; position tool and spindle
	<b>Slot axial/Slot radial</b> For milling single slots or slot patterns
	<b>Figure axial/Figure radial</b> For milling a single figure
	<b>ICP contour axial/ICP contour radial</b> For milling single ICP contours or contour patterns
	<b>Face milling</b> For milling surfaces or polygons
	<b>Hel. groove millg. radial</b> Radial milling for machining a helical slot
	<b>Engraving, axial/Engraving, radial</b> Engraves characters and character strings



## Rapid positioning, milling



- ▶ Select **Milling**

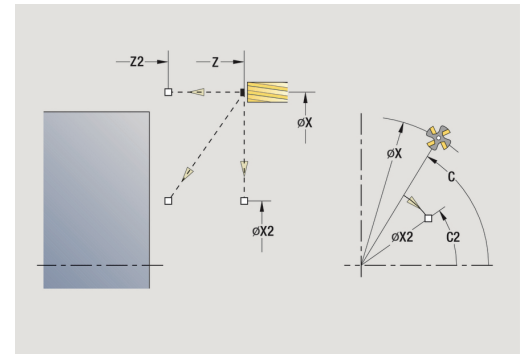


- ▶ Select **Rapid positioning**

The cycle activates the C axis and positions the spindle (C axis) and the tool.



- **Rapid traverse positioning** is only possible in **Machine** mode
- The C axis is deactivated by a subsequent manual milling cycle



Cycle parameters:

- **X2, Z2: Target point**
- **C2: End angle**—C-axis position (default: current spindle angle)
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining

Cycle run:

- 1 Activate the C axis
- 2 Insert the current tool
- 3 Simultaneously position the tool at rapid traverse to the **Target point X2, Z2** and the **End angle C2**

## Axial slot



- ▶ Select **Milling**

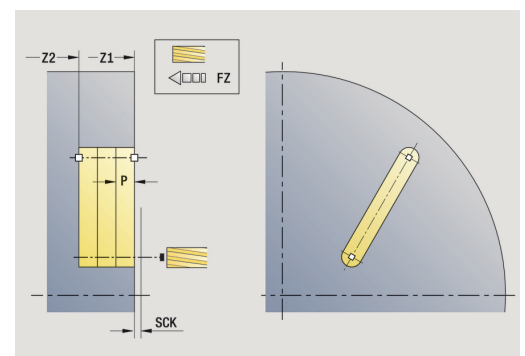
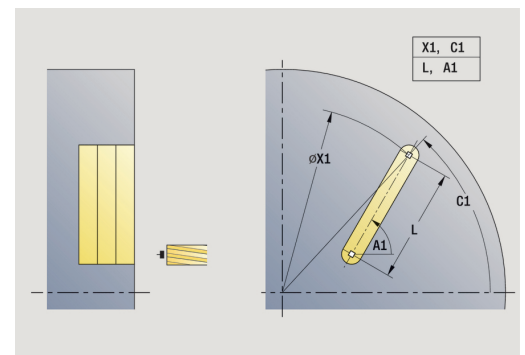
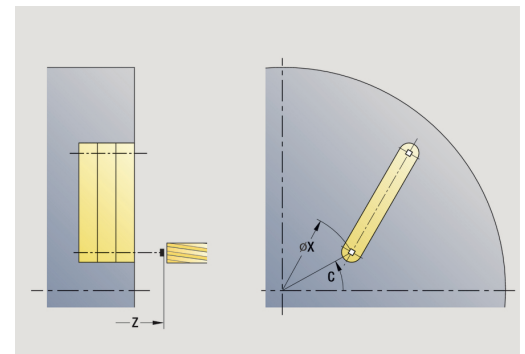


- ▶ Select **Axial slot**

This cycle mills a slot on the face of the workpiece. The slot width equals the diameter of the milling cutter.

Cycle parameters:

- **X, Z: Start point**
- **C: Spindle angle** – C-axis position
- **X1: Slot target point in X** (diameter value)
- **C1: Angle of slot target pt.** (default: spindle angle C)
- **L: Slot length**
- **A1: Angle to X axis** (default: 0°)
- **Z1: Millg. top edge** (default: **Starting point Z**)
- **Z2: Milling floor**
- **P: Feed depth** (default: total depth in one infeed)
- **FZ: Approach feed** (default: active feed rate)
- **SCK: Safety clearance**  
**Further information:** "Safety clearances SCI and SCK", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T:** **M** function that is executed after the tool call **T**
- **MFS: M at beginning:** **M** function that is executed at the beginning of the machining step
- **MFE: M at end:** **M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Milling**

Parameter combinations for the position and orientation of the slot:

- **X1, C1**
- **L, A1**

Cycle run:

- 1 Activate the C axis and position at **Spindle angle C** at rapid traverse (only in **Teach-in** submode)
- 2 Calculate the proportioning of cuts
- 3 Approach at **Approach feed FZ**
- 4 Machine to the **end point of slot**
- 5 Approach at **Approach feed FZ**
- 6 Machine to the **starting point of slot**
- 7 Repeat 3 to 6 until the milling depth is reached
- 8 Position to the **Start point Z** and deactivate the C axis
- 9 Move to the **Tool change point** according to the setting in **G14**

## Radial slot



- ▶ Select **Milling**

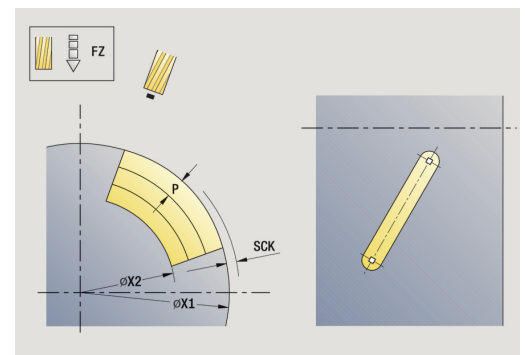
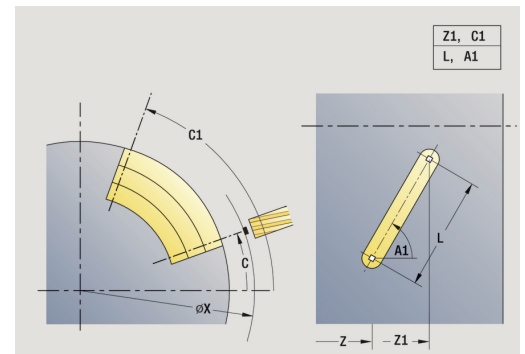


- ▶ Select **Radial slot**

This cycle mills a slot on the lateral surface of the workpiece. The slot width equals the diameter of the milling cutter.

Cycle parameters:

- **X, Z: Start point**
- **C: Spindle angle** – C-axis position
- **Z1: Slot target point**
- **C1: Angle of slot target pt.** (default: spindle angle C)
- **L: Slot length**
- **A1: Angle to Z axis** (default: 0°)
- **X1: Upper edge of milling** (diameter value; default: **Starting point X**)
- **X2: Milling floor**
- **P: Feed depth** (default: total depth in one infeed)
- **FZ: Approach feed** (default: active feed rate)
- **SCK: Safety clearance**  
**Further information:** "Safety clearances SCI and SCK", Page 186
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T:** **M** function that is executed after the tool call **T**
- **MFS: M at beginning:** **M** function that is executed at the beginning of the machining step
- **MFE: M at end:** **M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Milling**

Parameter combinations for the position and orientation of the slot:

- **X1, C1**
- **L, A1**

Cycle run:

- 1 Activate the C axis and position at **Spindle angle C** at rapid traverse (only in **Teach-in** submode)
- 2 Calculate the proportioning of cuts
- 3 Approach at **Approach feed FZ**
- 4 Machine to the **end point of slot**
- 5 Approach at **Approach feed FZ**
- 6 Machine to the **starting point of slot**
- 7 Repeat 3 to 6 until the milling depth is reached
- 8 Position to the **Start point X** and deactivate the C axis
- 9 Move to the **Tool change point** according to the setting in **G14**

### Axial figure



▶ Select **Milling**



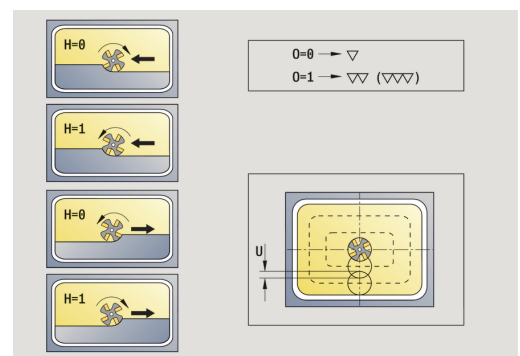
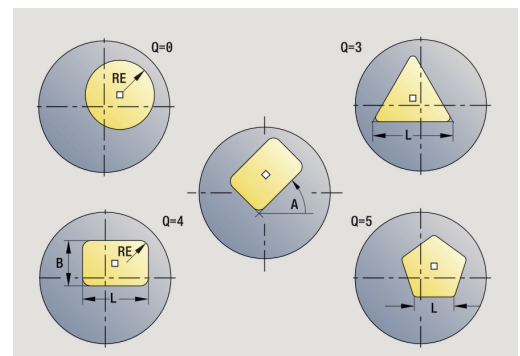
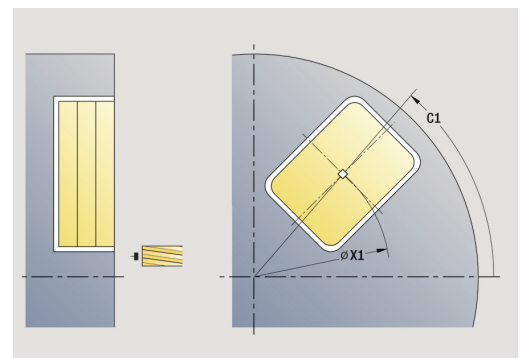
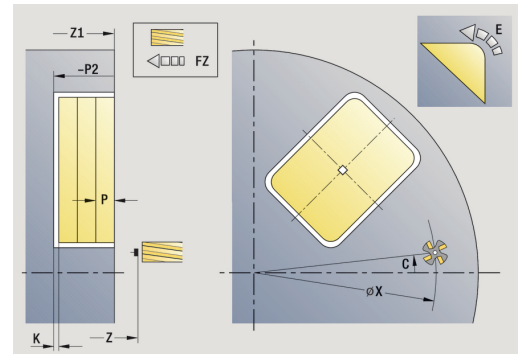
▶ Select **Axial figure**

Depending on the parameters, the cycle mills one of the following contours or roughs/finishes a pocket on the face:

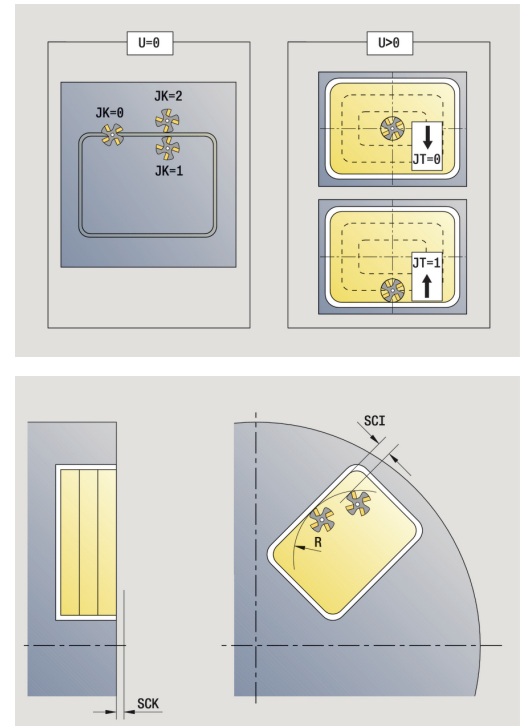
- Rectangle (**Q** = 4, **L** <> **B**)
- Square (**Q** = 4, **L** = **B**)
- Circle (**Q** = 0, **RE** > 0, **L** and **B**: no input)
- Triangle or polygon (**Q** = 3 or **Q** > 4, **L** <> 0)

Cycle parameters:

- **X, Z**: Start point
- **C**: Spindle angle – C-axis position (default: current spindle angle)
- **X1**: Dia. of figure center
- **C1**: Angle of figure center (default: Spindle angle C)
- **Q**: Number edges (default: 0)
  - **Q** = 0: Circle
  - **Q** = 4: Rectangle, square
  - **Q** = 3: Triangle
  - **Q** > 4: Polygon
- **L**: Edge length
  - Rectangle: Rectangle length
  - Square, polygon: Edge length
  - Polygon: **L** < 0 inscribed circle diameter
  - Circle: No input
- **B**: Width of rectangle
  - Rectangle: Rectangle width
  - Square: **L** = **B**
  - Polygon, circle: No input
- **RE**: Rounding radius (default: 0)
  - Rectangle, square, polygon: Rounding radius
  - Circle: Circle radius
- **A**: Angle to X axis (default: 0°)
  - Rectangle, square, polygon: Position of figure
  - Circle: No input
- **Z1**: Millg. top edge (default: Starting point Z)
- **P2**: Milling depth
- **T**: Tool number – Turret pocket number



- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **I: Contour-parallel oversize**
- **K: Infeed-direction oversize**
- **P: Feed depth** (default: total depth in one infeed)
- **FZ: Approach feed** (default: active feed rate)
- **E: Reduced feed** for circular elements (default: active feed rate)
- **O: Roughing/Finish** – Only for pocket milling
  - **0: Roughing**
  - **1: Finishing**
- **H: Mill cutting direction**
  - **0: Up-cut**
  - **1: Climb**
- **U: Overlap factor**—defines the overlap of milling paths (default: 0.5) (range: 0 – 0.99)  
Overlap =  $U \cdot \text{milling diameter}$ 
  - **U = 0** or no input: Contour milling
  - **U > 0:** Pocket milling – Minimum overlap of milling paths =  $U \cdot \text{milling diameter}$
- **JK: Contour milling** – Input is evaluated only for contour milling
  - **0: On the contour**
  - **1: Within the contour**
  - **2: Outside the contour**
- **JT: Pocket milling** – Input is evaluated only for pocket milling
  - **0: From the inside out**
  - **1: From the outside in**
- **R: Approach angle** (default: 0)
  - **R = 0:** Contour element is approached directly; infeed to starting point above the milling plane—then vertical plunge
  - **R > 0:** Tool moves on approaching/departing arc that connects tangentially to the contour element
  - **R < 0** for inside corners: Tool moves on approaching/departing arc that connects tangentially to the contour element
  - **R < 0** for outside corners: Length of linear approaching/departing element; contour element is approached/departed tangentially





- **RB: Return plane**
- **SCI: Safety clearance** in the working plane
- **SCK: Safety clearance** in infeed direction  
**Further information:** "Safety clearances SCI and SCK", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Milling**



Notes on parameters and functions:

- **Machining of contours or pockets:** Defined with **Overlap factor U**
- **Milling direction:** Depends on the definition of **Mill cutting direction H** and the direction of rotation of the milling cutter  
**Further information:** "Milling direction for contour milling", Page 396
- **Milling cutter radius compensation:** Effective (except for contour milling with **J=0**)
- **Approach and departure:** For closed contours, the starting point of the first element (in rectangles, the longer element) is the point of approach and departure. The tool approaches directly or on an arc according to **Approach radius R**
- **Contour milling JK** defines whether the milling cutter will machine on the contour (center of milling cutter on the contour) or inside/outside of the contour
- **Pocket milling—roughing (O=0):** Use **JT** to define whether a pocket is machined from the inside toward the outside, or vice versa
- **Pocket milling—finishing (O=1):** First, the edge of the pocket is machined; then the pocket floor is machined. With **JT** you define whether a pocket floor is to be finished from the inside towards the outside, or vice versa

Cycle run:

**All versions:**

- 1 Activate the C axis and position at **Spindle angle C** at rapid traverse (only in **Teach-in** submode)
- 2 Calculate the proportioning of cuts (infeeds to the milling planes, infeeds in the milling planes)

**Contour milling:**

- 3 Depending on the **Approch angle R**, approach the workpiece and plunge to the first milling plane
- 4 Mill the first plane
- 5 Plunge to the next milling plane
- 6 Repeat 4 to 5 until the milling depth is reached

**Pocket milling—roughing:**

- 3 Move to the **Safety clearance** and plunge to the first milling plane
- 4 Depending on **Pocket milling JT**, machine the milling plane either from the inside towards the outside, or vice versa
- 5 Plunge to the next milling plane
- 6 Repeat 4 to 5 until the milling depth is reached

**Pocket milling—finishing:**

- 3 Depending on the **Approch angle R**, approach the workpiece and plunge to the first milling plane
- 4 Finish-machine the edge of the pocket—one working plane after the other
- 5 Depending on **Pocket milling JT**, finish the pocket floor either from the inside towards the outside, or vice versa
- 6 Finish-machine the pocket at the programmed feed rate

**All versions:**

- 7 Position to the **Start point Z** and deactivate the C axis
- 8 Move to the **Tool change point** according to the setting in **G14**

## Radial figure



▶ Select **Milling**



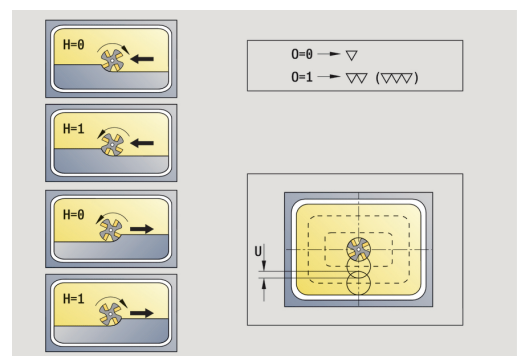
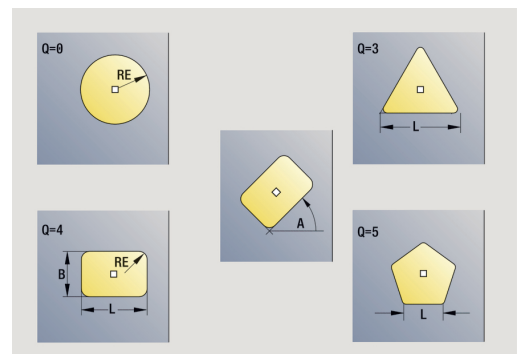
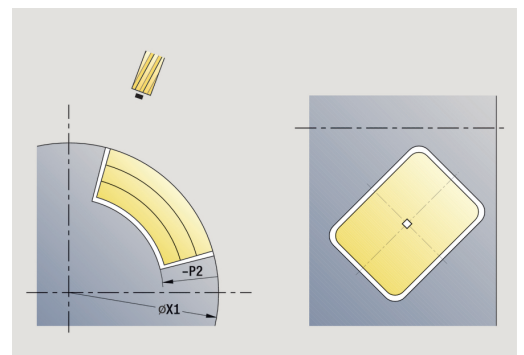
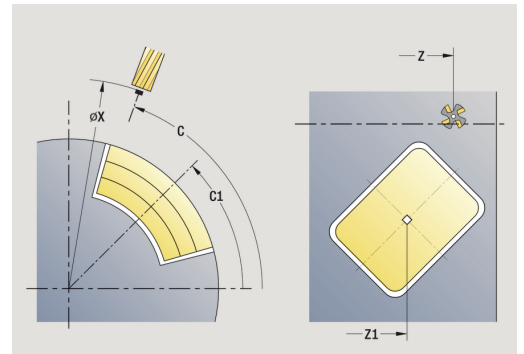
▶ Select **Radial figure**

Depending on the parameters, the cycle mills one of the following contours or roughs/finishes a pocket on the lateral surface:

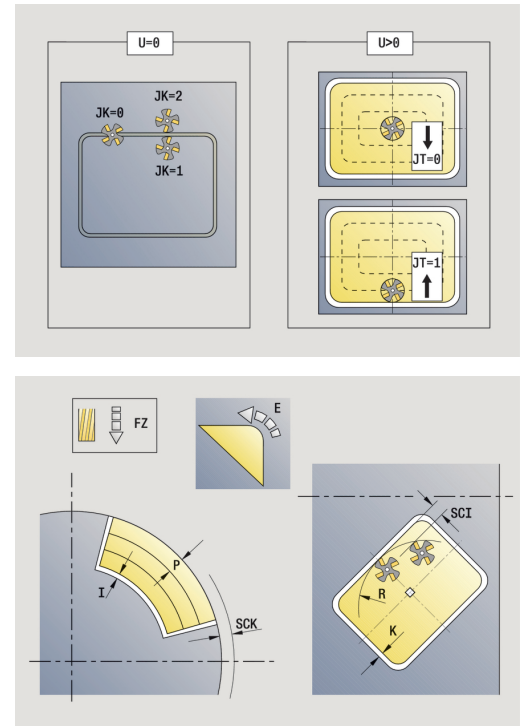
- Rectangle (**Q=4**, **L<>B**)
- Square (**Q=4**, **L=B**)
- Circle (**Q=0**, **RE>0**, **L** and **B**: no input)
- Triangle or polygon (**Q=3** or **Q>4**, **L<>0**)

Cycle parameters:

- **X, Z**: Start point
- **C**: Spindle angle – C-axis position (default: current spindle angle)
- **Z1**: Figure center
- **C1**: Angle of figure center (default: Spindle angle C)
- **Q**: Number edges (default: 0)
  - Q = 0: Circle
  - Q = 4: Rectangle, square
  - Q = 3: Triangle
  - Q > 4: Polygon
- **L**: Edge length
  - Rectangle: Rectangle length
  - Square, polygon: Edge length
  - Polygon: **L < 0** inscribed circle diameter
  - Circle: No input
- **B**: Width of rectangle
  - Rectangle: Rectangle width
  - Square: **L = B**
  - Polygon, circle: No input
- **RE**: Rounding radius (default: 0)
  - Rectangle, square, polygon: Rounding radius
  - Circle: Circle radius
- **A**: Angle to Z axis (default: 0°)
  - Rectangle, square, polygon: Position of figure
  - Circle: No input
- **X1**: Upper edge of milling (diameter value; default: Starting point X)
- **P2**: Milling depth
- **T**: Tool number – Turret pocket number
- **ID**: ID no.
- **S**: Cutting speed or Constant speed
- **F**: Feed per revolution
- **I**: Infeed-direction oversize
- **K**: Contour-parallel oversize



- **P: Feed depth** (default: total depth in one infeed)
- **FZ: Approach feed** (default: active feed rate)
- **E: Reduced feed** for circular elements (default: active feed rate)
- **O: Roughing/Finish** – Only for pocket milling
  - **0: Roughing**
  - **1: Finishing**
- **H: Mill cutting direction**
  - **0: Up-cut**
  - **1: Climb**
- **U: Overlap factor**—defines the overlap of milling paths (default: 0.5) (range: 0 – 0.99)  
Overlap =  $U \cdot \text{milling diameter}$ 
  - $U = 0$  or no input: Contour milling
  - $U > 0$ : Pocket milling – Minimum overlap of milling paths =  $U \cdot \text{milling diameter}$
- **JK: Contour milling** – Input is evaluated only for contour milling
  - **0: On the contour**
  - **1: Within the contour**
  - **2: Outside the contour**
- **JT: Pocket milling** – Input is evaluated only for pocket milling
  - **0: From the inside out**
  - **1: From the outside in**
- **R: Approach angle** (default: 0)
  - $R = 0$ : Contour element is approached directly; infeed to starting point above the milling plane—then vertical plunge
  - $R > 0$ : Tool moves on approaching/departing arc that connects tangentially to the contour element
  - $R < 0$  for inside corners: Tool moves on approaching/departing arc that connects tangentially to the contour element
  - $R < 0$  for outside corners: Length of linear approaching/departing element; contour element is approached/departed tangentially
- **RB: Return plane**
- **SCI: Safety clearance** in the working plane
- **SCK: Safety clearance** in infeed direction  
**Further information:** "Safety clearances SCI and SCK", Page 186
- **MT: M after T:** M function that is executed after the tool call T
- **MFS: M at beginning:** M function that is executed at the beginning of the machining step
- **MFE: M at end:** M function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)



- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Milling**



Notes on parameters and functions:

- **Machining of contours or pockets:** Defined with **Overlap factor U**
- **Milling direction:** Depends on the definition of **Mill cutting direction H** and the direction of rotation of the milling cutter  
**Further information:** "Milling direction for contour milling", Page 396
- **Milling cutter radius compensation:** Effective (except for contour milling with **J=0**)
- **Approach and departure:** For closed contours, the starting point of the first element (in rectangles, the longer element) is the point of approach and departure. The tool approaches directly or on an arc according to **Approach radius R**
- **Contour milling JK** defines whether the milling cutter will machine on the contour (center of milling cutter on the contour) or inside/outside of the contour
- **Pocket milling—roughing (O=0):** Use **JT** to define whether a pocket is machined from the inside toward the outside, or vice versa
- **Pocket milling—finishing (O=1):** First, the edge of the pocket is machined; then the pocket floor is machined. With **JT** you define whether a pocket floor is to be finished from the inside towards the outside, or vice versa

Cycle run:

**All versions:**

- 1 Activate the C axis and position at **Spindle angle C** at rapid traverse (only in **Teach-in** submode)
- 2 Calculate the proportioning of cuts (infeeds to the milling planes, infeeds in the milling planes)

**Contour milling:**

- 3 Depending on the **Approch angle R**, approach the workpiece and plunge to the first milling plane
- 4 Mill the first plane
- 5 Plunge to the next milling plane
- 6 Repeat 4 to 5 until the milling depth is reached

**Pocket milling—roughing:**

- 3 Move to the **Safety clearance** and plunge to the first milling plane
- 4 Depending on **Pocket milling JT**, machine the milling plane either from the inside towards the outside, or vice versa
- 5 Plunge to the next milling plane
- 6 Repeat 4 to 5 until the milling depth is reached

**Pocket milling—finishing:**

- 3 Depending on the **Approch angle R**, approach the workpiece and plunge to the first milling plane
- 4 Finish-machine the edge of the pocket—one working plane after the other
- 5 Depending on **Pocket milling JT**, finish the pocket floor either from the inside towards the outside, or vice versa
- 6 Finish-machine the pocket at the programmed feed rate

**All versions:**

- 7 Position to the **Start point Z** and deactivate the C axis
- 8 Move to the **Tool change point** according to the setting in **G14**

### ICP contour axial



▶ Select **Milling**

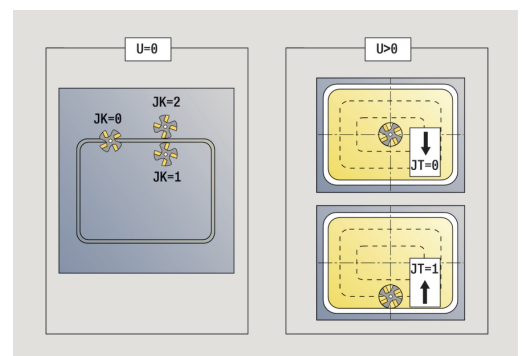
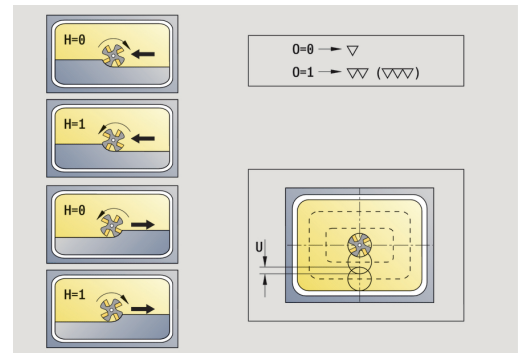
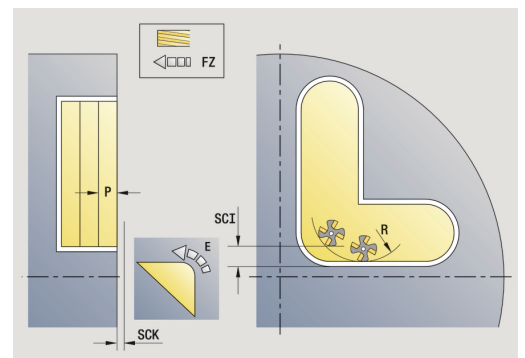
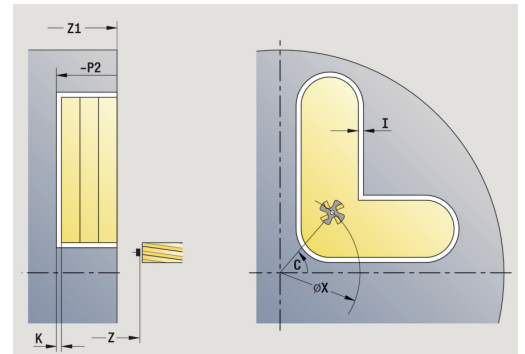


▶ Select **ICP contour axial**

Depending on the parameters, the cycle mills one of the following contours or roughs/finishes a pocket on the face.

Cycle parameters:

- **X, Z: Start point**
- **C: Spindle angle** – C-axis position
- **Z1: Millg. top edge** (default: **Starting point Z**)
- **P2: Milling depth**
- **I: Contour-parallel oversize**
- **K: Infeed-direction oversize**
- **P: Feed depth** (default: total depth in one infeed)
- **FZ: Approach feed** (default: active feed rate)
- **E: Reduced feed** for circular elements (default: active feed rate)
- **FK: ICP contour number**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **O: Roughing/Finish** – Only for pocket milling
  - **0: Roughing**
  - **1: Finishing**
- **H: Mill cutting direction**
  - **0: Up-cut**
  - **1: Climb**
- **U: Overlap factor**—defines the overlap of milling paths (default: 0.5) (range: 0 – 0.99)  
 Overlap =  $U \cdot \text{milling diameter}$ 
  - **U = 0** or no input: Contour milling
  - **U > 0:** Pocket milling – Minimum overlap of milling paths =  $U \cdot \text{milling diameter}$
- **JK: Contour milling** – Input is evaluated only for contour milling
  - **0: On the contour**
  - **1: Within the contour**
  - **2: Outside the contour**
- **JT: Pocket milling** – Input is evaluated only for pocket milling
  - **0: From the inside out**
  - **1: From the outside in**



- **R: Apprch angle** (default: 0)
  - **R = 0**: Contour element is approached directly; infeed to starting point above the milling plane—then vertical plunge
  - **R > 0**: Tool moves on approaching/departing arc that connects tangentially to the contour element
  - **R < 0** for inside corners: Tool moves on approaching/departing arc that connects tangentially to the contour element
  - **R < 0** for outside corners: Length of linear approaching/departing element; contour element is approached/departed tangentially
- **RB: Return plane**
- **SCI: Safety clearance** in the working plane
- **SCK: Safety clearance** in infeed direction  
**Further information:** "Safety clearances SCI and SCK", Page 186
- **BG: Cham. width** for deburring
- **JG: Preparation diameter**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Milling**





Notes on parameters and functions:

- **Machining of contours or pockets:** Defined with **Overlap factor U**
- **Milling direction:** Depends on the definition of **Mill cutting direction H** and the direction of rotation of the milling cutter  
**Further information:** "Milling direction for contour milling", Page 396
- **Milling cutter radius compensation:** Effective (except for contour milling with **J=0**)
- **Approach and departure:** For closed contours, the starting point of the first element (in rectangles, the longer element) is the point of approach and departure. The tool approaches directly or on an arc according to **Approach radius R**
- **Contour milling JK** defines whether the milling cutter will machine on the contour (center of milling cutter on the contour) or inside/outside of the contour
- **Pocket milling—roughing (O=0):** Use **JT** to define whether a pocket is machined from the inside toward the outside, or vice versa
- **Pocket milling—finishing (O=1):** First, the edge of the pocket is machined; then the pocket floor is machined. With **JT** you define whether a pocket floor is to be finished from the inside towards the outside, or vice versa

Cycle run:

**All versions:**

- 1 Activate the C axis and position at **Spindle angle C** at rapid traverse (only in **Teach-in** submode)
- 2 Calculate the proportioning of cuts (infeeds to the milling planes, infeeds in the milling planes)

**Contour milling:**

- 3 Depending on the **Approch angle R**, approach the workpiece and plunge to the first milling plane
- 4 Mill the first plane
- 5 Plunge to the next milling plane
- 6 Repeat 4 to 5 until the milling depth is reached

**Pocket milling—roughing:**

- 3 Move to the **Safety clearance** and plunge to the first milling plane
- 4 Depending on **Pocket milling JT**, machine the milling plane either from the inside towards the outside, or vice versa
- 5 Plunge to the next milling plane
- 6 Repeat 4 to 5 until the milling depth is reached

**Pocket milling—finishing:**

- 3 Depending on the **Approch angle R**, approach the workpiece and plunge to the first milling plane
- 4 Finish-machine the edge of the pocket—one working plane after the other
- 5 Depending on **Pocket milling JT**, finish the pocket floor either from the inside towards the outside, or vice versa
- 6 Finish-machine the pocket at the programmed feed rate

**All versions:**

- 7 Position to the **Start point Z** and deactivate the C axis
- 8 Move to the **Tool change point** according to the setting in **G14**

### ICP contour radial



▶ Select **Milling**

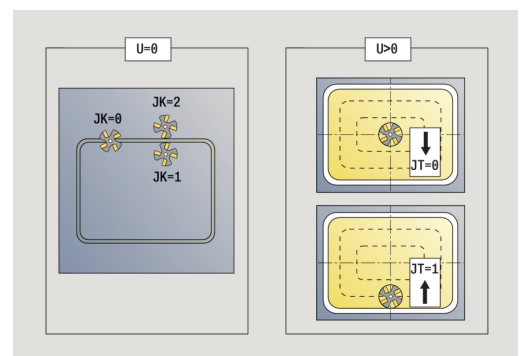
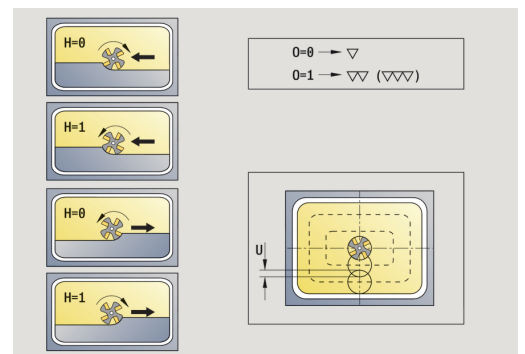
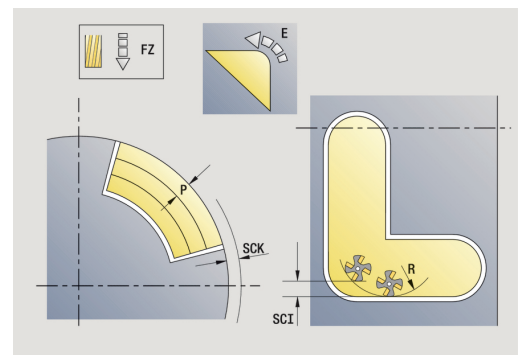
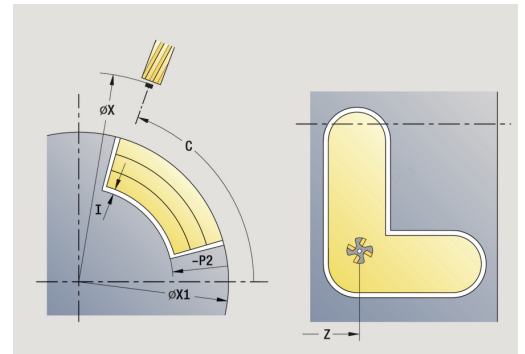


▶ Select **ICP contour radial**

Depending on the parameters, the cycle mills one of the following contours or roughs/finishes a pocket on the lateral surface.

Cycle parameters:

- **X, Z: Start point**
- **C: Spindle angle** – C-axis position
- **X1: Upper edge of milling** (diameter value; default: **Starting point X**)
- **P2: Milling depth**
- **I: Infeed-direction oversize**
- **K: Contour-parallel oversize**
- **P: Feed depth** (default: total depth in one infeed)
- **FZ: Approach feed** (default: active feed rate)
- **E: Reduced feed** for circular elements (default: active feed rate)
- **FK: ICP contour number**
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **O: Roughing/Finish** – Only for pocket milling
  - **0: Roughing**
  - **1: Finishing**
- **H: Mill cutting direction**
  - **0: Up-cut**
  - **1: Climb**
- **U: Overlap factor**—defines the overlap of milling paths (default: 0.5) (range: 0 – 0.99)  
 Overlap =  $U \cdot \text{milling diameter}$ 
  - **U = 0** or no input: Contour milling
  - **U > 0:** Pocket milling – Minimum overlap of milling paths =  $U \cdot \text{milling diameter}$
- **JK: Contour milling** – Input is evaluated only for contour milling
  - **0: On the contour**
  - **1: Within the contour**
  - **2: Outside the contour**
- **JT: Pocket milling** – Input is evaluated only for pocket milling
  - **0: From the inside out**
  - **1: From the outside in**



- **R: Apprch angle** (default: 0)
  - **R = 0**: Contour element is approached directly; infeed to starting point above the milling plane—then vertical plunge
  - **R > 0**: Tool moves on approaching/departing arc that connects tangentially to the contour element
  - **R < 0** for inside corners: Tool moves on approaching/departing arc that connects tangentially to the contour element
  - **R < 0** for outside corners: Length of linear approaching/departing element; contour element is approached/departed tangentially
- **RB: Return plane**
- **SCI: Safety clearance** in the working plane
- **SCK: Safety clearance** in infeed direction  
**Further information:** "Safety clearances SCI and SCK", Page 186
- **BG: Cham. width** for deburring
- **JG: Preparation diameter**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Milling**



Notes on parameters and functions:

- **Machining of contours or pockets:** Defined with **Overlap factor U**
- **Milling direction:** Depends on the definition of **Mill cutting direction H** and the direction of rotation of the milling cutter  
**Further information:** "Milling direction for contour milling", Page 396
- **Milling cutter radius compensation:** Effective (except for contour milling with **J=0**)
- **Approach and departure:** For closed contours, the starting point of the first element (in rectangles, the longer element) is the point of approach and departure. The tool approaches directly or on an arc according to **Approach radius R**
- **Contour milling JK** defines whether the milling cutter will machine on the contour (center of milling cutter on the contour) or inside/outside of the contour
- **Pocket milling—roughing (O=0):** Use **JT** to define whether a pocket is machined from the inside toward the outside, or vice versa
- **Pocket milling—finishing (O=1):** First, the edge of the pocket is machined; then the pocket floor is machined. With **JT** you define whether a pocket floor is to be finished from the inside towards the outside, or vice versa

Cycle run:

**All versions:**

- 1 Activate the C axis and position at **Spindle angle C** at rapid traverse (only in **Teach-in** submode)
- 2 Calculate the proportioning of cuts (infeeds to the milling planes, infeeds in the milling planes)

**Contour milling:**

- 3 Depending on the **Approch angle R**, approach the workpiece and plunge to the first milling plane
- 4 Mill the first plane
- 5 Plunge to the next milling plane
- 6 Repeat 4 to 5 until the milling depth is reached

**Pocket milling—roughing:**

- 3 Move to the **Safety clearance** and plunge to the first milling plane
- 4 Depending on **Pocket milling JT**, machine the milling plane either from the inside towards the outside, or vice versa
- 5 Plunge to the next milling plane
- 6 Repeat 4 to 5 until the milling depth is reached

**Pocket milling—finishing:**

- 3 Depending on the **Approch angle R**, approach the workpiece and plunge to the first milling plane
- 4 Finish-machine the edge of the pocket—one working plane after the other
- 5 Depending on **Pocket milling JT**, finish the pocket floor either from the inside towards the outside, or vice versa
- 6 Finish-machine the pocket at the programmed feed rate

**All versions:**

- 7 Position to the **Start point Z** and deactivate the C axis
- 8 Move to the **Tool change point** according to the setting in **G14**

### Face milling



▶ Select **Milling**



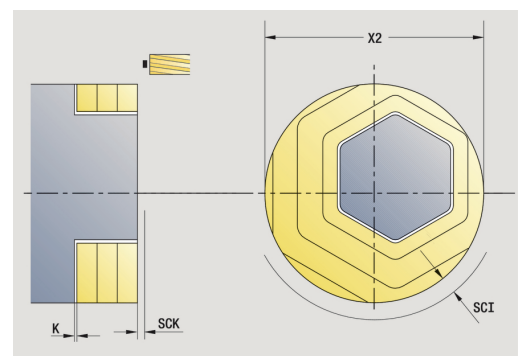
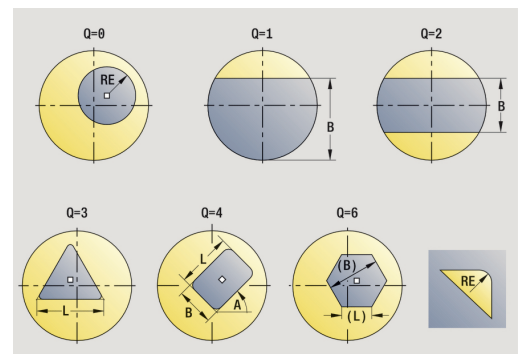
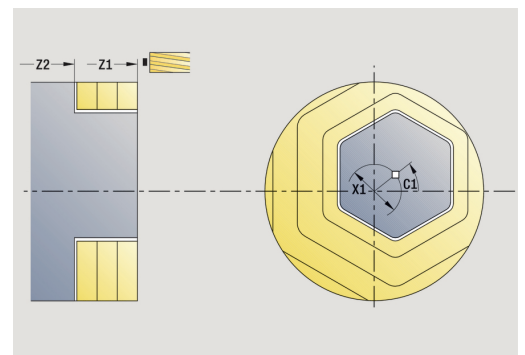
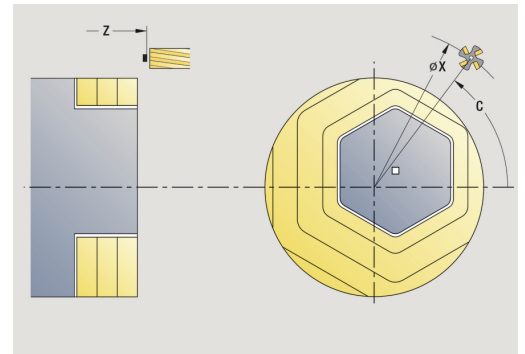
▶ Select **Face milling**

Depending on the parameters, the cycle mills the following contours on the face:

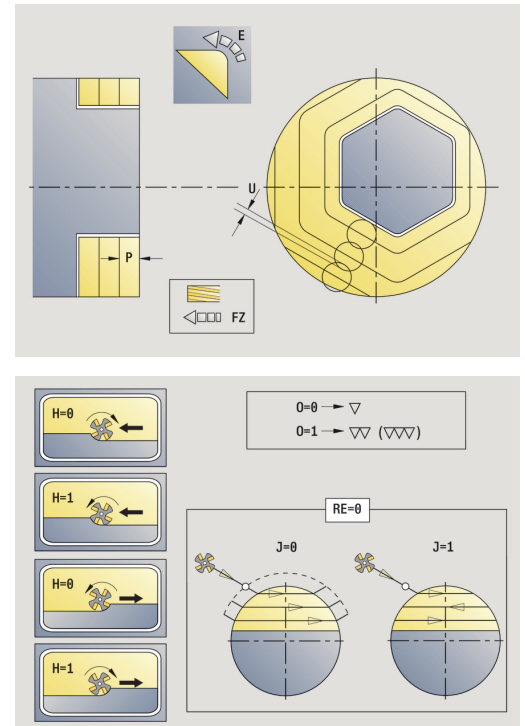
- One or two surfaces (**Q** = 1 or **Q** = 2, **B** > 0)
- Rectangle (**Q** = 4, **L** <> **B**)
- Square (**Q** = 4, **L** = **B**)
- Triangle or polygon (**Q** = 3 or **Q** > 4, **L** <> 0)
- Circle (**Q** = 0, **RE** > 0, **L** and **B**: no input)

Cycle parameters:

- **X, Z**: Start point
- **C**: Spindle angle – C-axis position (default: current spindle angle)
- **X1**: Dia. of figure center
- **C1**: Angle of figure center (default: Spindle angle **C**)
- **Z1**: Millg. top edge (default: Starting point **Z**)
- **Z2**: Milling floor
- **Q**: Number edges
  - **Q** = 0: Circle
  - **Q** = 1: One surface
  - **Q** = 2: Two surfaces offset by 180°
  - **Q** = 3: Triangle
  - **Q** = 4: Rectangle, square
  - **Q** > 4: Polygon
- **L**: Edge length
  - Rectangle: Rectangle length
  - Square, polygon: Edge length
  - Polygon: **L** < 0 inscribed circle diameter
  - Circle: No input
- **B**: Width/Width across flats
  - For **Q** = 1, **Q** = 2: Remaining thickness (remaining material)
  - Rectangle: Rectangle width
  - Square, polygon (**Q** >= 4): Width across flats (use only for even number of surfaces; program "B" as an alternative to **L**)
  - Circle: No input
- **RE**: Rounding radius (default: 0)
  - Polygon (**Q** > 2): Rounding radius
  - Circle (**Q** = 0): Radius of circle
- **A**: Angle to X axis (default: 0°)
  - Polygon (**Q** > 2): Position of figure
  - Circle: No input
- **T**: Tool number – Turret pocket number



- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **I: Contour-parallel oversize**
- **K: Infeed-direction oversize**
- **X2: Limit diameter**
- **P: Feed depth** (default: total depth in one infeed)
- **FZ: Approach feed** (default: active feed rate)
- **E: Reduced feed** for circular elements (default: active feed rate)
- **U: Overlap factor**—defines the overlap of milling paths (default: 0.5) (range: 0 – 0.99)  
 $\text{Overlap} = U * \text{milling diameter}$
- **O: Roughing/Finish**
  - **0: Roughing**
  - **1: Finishing**
- **H: Mill cutting direction**
  - **0: Up-cut**
  - **1: Climb**
- **J: Mill direction**
- **SCI: Safety clearance** in the working plane
- **SCK: Safety clearance** in infeed direction  
**Further information:** "Safety clearances SCI and SCK", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



Type of machining for technology database access:  
**Milling**



Cycle run:

**All versions:**

- 1 Activate the C axis and position at **Spindle angle C** at rapid traverse (only in **Teach-in** submode)
- 2 Calculate the proportioning of cuts (infeeds to the milling planes, infeeds in the milling planes)
- 3 Move to the **Safety clearance** and plunge to the first milling plane

**Roughing:**

- 4 Machine the milling plane, taking **Mill direction J** (unidirectional or bidirectional) into account
- 5 Plunge to the next milling plane
- 6 Repeat 4 to 5 until the milling depth is reached

**Finishing:**

- 4 Finish-machine the edge of the island—one working plane after the other
- 5 Finish-machine the floor from the outside towards the inside

**All versions:**

- 7 Position to the **Start point Z** and deactivate the C axis
- 8 Move to the **Tool change point** according to the setting in **G14**

## Hel. slot milling, radial



- ▶ Select **Milling**

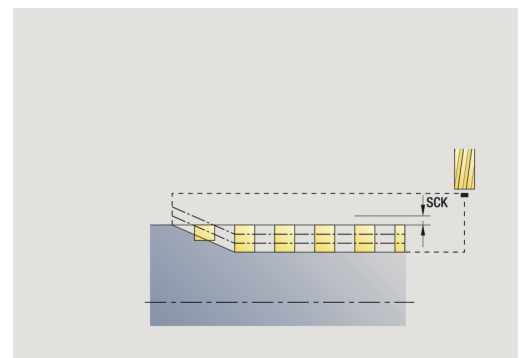
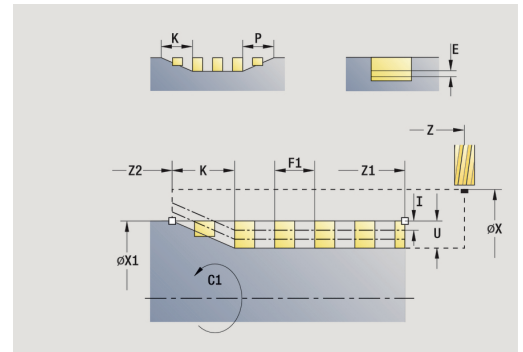


- ▶ Select **Hel. slot milling, radial**

The cycle mills a helical slot from the **Start point thread** to the **End point thread**. The **Start. angle** defines the starting position for the slot. The slot width equals the diameter of the milling cutter.

Cycle parameters:

- **X, Z: Start point**
- **C: Spindle angle** – C-axis position
- **X1: Thread diameter**
- **C1: Start. angle**
- **Z1: Start point thread**
- **Z2: End point thread**
- **F1: Thread pitch**
  - **F1** positive: Right-hand thread
  - **F1** negative: Left-hand thread
- **U: Thread depth**
- **I: Maximum infeed** – The infeed movements are reduced down to  $\geq 0.5$  mm according to the following calculation. Each following infeed movement will then be 0.5 mm
  - Infeed 1: **I**
  - Infeed n:  $I * (1 - (n - 1) * E)$
- **E: Cutting depth reduction**
- **P: Run-in lgth** – ramp at the beginning of the slot
- **K: Thread runout length**—ramp at the end of the slot
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **D: No.gears**
- **SCK: Safety clearance** in infeed direction  
**Further information:** "Safety clearances SCI and SCK", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step



- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)

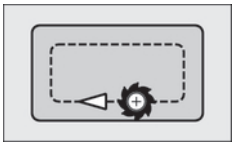
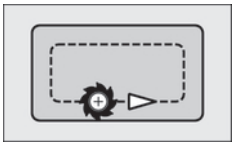
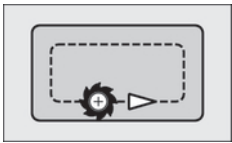
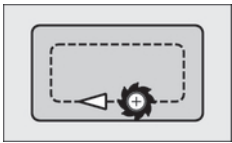
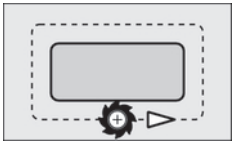
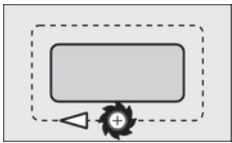
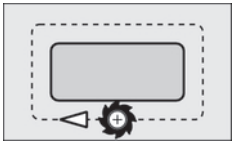
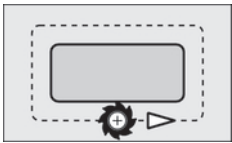
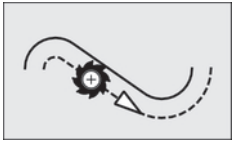
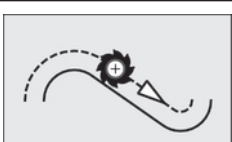


Type of machining for technology database access:  
**Milling**

Cycle run:

- 1 Activate the C axis and position at **Spindle angle C** at rapid traverse (only in **Teach-in** submodule)
- 2 Calculate the current infeed
- 3 Position the tool for the first pass
- 4 Machine up to the **End point thread Z2** at the programmed feed rate, taking the ramps at the beginning and end of the slot into account
- 5 Return on a paraxial path and approach for the next pass
- 6 Repeat 4 to 5 until the slot depth is reached
- 7 Move to the **Tool change point** according to the setting in **G14**

## Milling direction for contour milling

Cycle type	Cutting direction	Direction of tool rotation	MCRC	Execution
Inside ( <b>JK=1</b> )	Up-cut milling ( <b>H=0</b> )	Mx03	Right	
Inside	Up-cut milling ( <b>H=0</b> )	Mx04	Left	
Inside	Climb milling ( <b>H=1</b> )	Mx03	Left	
Inside	Climb milling ( <b>H=1</b> )	Mx04	Right	
Outside ( <b>JK=2</b> )	Up-cut milling ( <b>H=0</b> )	Mx03	Right	
Outside	Up-cut milling ( <b>H=0</b> )	Mx04	Left	
Outside	Climb milling ( <b>H=1</b> )	Mx03	Left	
Outside	Climb milling ( <b>H=1</b> )	Mx04	Right	
Right ( <b>JK=2</b> )	For open contours without function. Machining in direction of contour definition	Without effect	Right	
Left ( <b>JK=1</b> )	For open contours without function. Machining in direction of contour definition	Without effect	Left	

Cycle type	Cutting direction	Direction of tool rotation	MCRC	Execution
Roughing Finishing	Up-cut milling ( <b>H=0</b> )	From the inside toward the outside ( <b>JT=0</b> )	Mx03	
Roughing Finishing	Up-cut milling ( <b>H=0</b> )	From the inside toward the outside ( <b>JT=0</b> )	Mx04	
Roughing	Climb milling ( <b>H=0</b> )	From the outside toward the inside ( <b>JT=1</b> )	Mx03	
Roughing	Up-cut milling ( <b>H=0</b> )	From the outside toward the inside ( <b>JT=1</b> )	Mx04	
Roughing Finishing	Climb milling ( <b>H=1</b> )	From the inside toward the outside ( <b>JT=0</b> )	Mx03	
Roughing Finishing	Climb milling ( <b>H=1</b> )	From the inside toward the outside ( <b>JT=0</b> )	Mx04	
Roughing	Climb milling ( <b>H=1</b> )	From the outside toward the inside ( <b>JT=1</b> )	Mx03	
Roughing	Up-cut milling ( <b>H=1</b> )	From the outside toward the inside ( <b>JT=1</b> )	Mx04	

## Examples of milling cycles

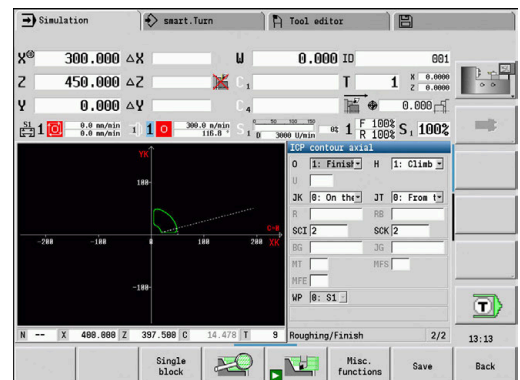
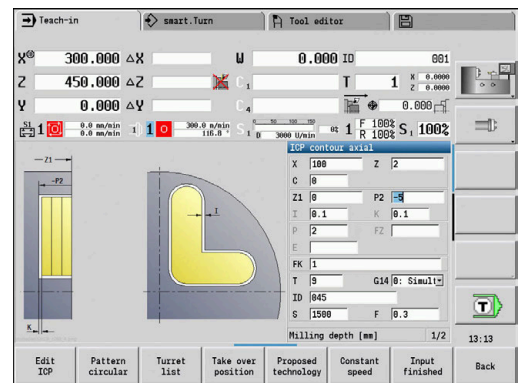
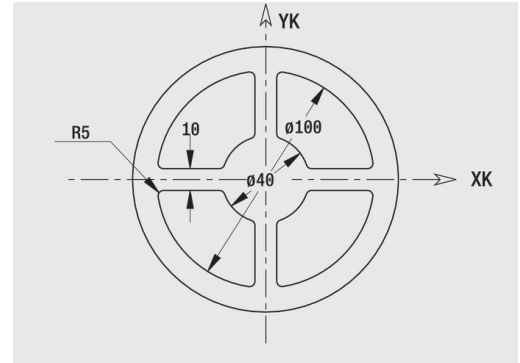
### Milling on the face

In this example, a pocket is milled. The milling example illustrates the complete machining process on the face, including contour definition.

The machining process is performed with the cycle **ICP contour axial**. To describe a contour, define the basic contour first. Then superimpose the rounding arcs.

Tool data (milling cutter)

- **TO** = 8 – Tool orientation
- **I** = 8 – Milling cutter diameter
- **K** = 4 – Number of teeth
- **TF** = 0.025 – Feed per tooth



## Engraving, axial

### Engraving, axial



▶ Select **Milling**



▶ Select **Engraving**



▶ Select **Engraving, axial**

The **Engraving, axial** cycle engraves character strings in linear or polar layout on the face of the workpiece.

Character set and more information:

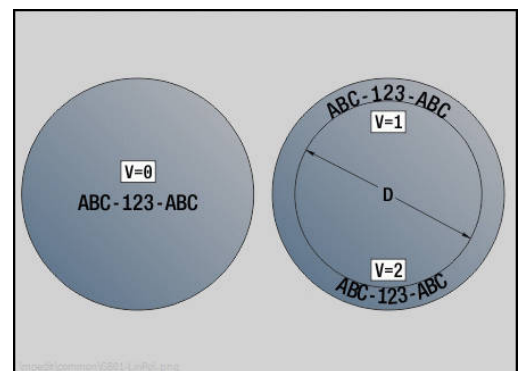
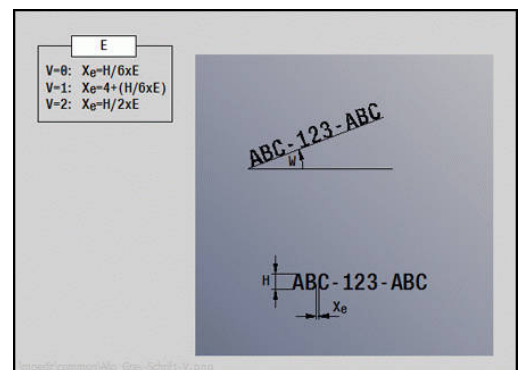
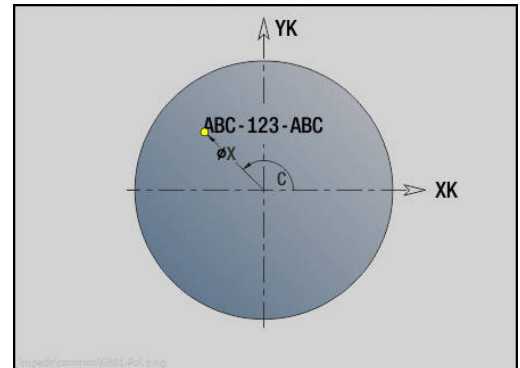
**Further information:** "Engraving, axial and radial", Page 403

Define the **Start point** of the character string in the cycle. If you do not define a **Start point**, the cycle starts at the current tool position.

You can also use multiple calls to engrave a logotype. For this purpose, specify the **Start point** with the first call. All other calls are programmed without a **Start point**.

Cycle parameters:

- **X:** **Starting point** – Pre-positioning the tool (diameter value)
- **Z:** **Starting point** – Pre-positioning the tool
- **C:** **Spindle angle** – Pre-positioning the workpiece spindle
- **TX:** **Text** to be engraved
- **NF:** **Char. no.** – ASCII code of the character to be engraved
- **Z2:** **Final point** – Z position, infeed depth during engraving
- **X1:** **Start point** of first character (polar)
- **C1:** **Start. angle** (polar) of first character
- **XK:** **Start point** of first character (Cartesian)
- **YK:** **Start point** of first character (Cartesian)
- **H:** **Font height**
- **E:** **Distance factor** (calculation: see figure)  
The distance between the characters is calculated according to the following formula:  $H / 6 * E$
- **T:** **Tool number** – Turret pocket number
- **G14:** **Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID:** **ID no.**
- **S:** **Cutting speed** or **Constant speed**
- **F:** **Feed per revolution**
- **W:** **Inclinat. ang.** of the character string
- **FZ:** **Plunging feed rate factor** (plunging feed rate = current feed rate \* **FZ**)
- **V:** **Execution (linear/polar)**
- **D:** **Reference diameter**
- **RB:** **Return plane** – Z position to which the tool retracts for positioning



- **SCK: Safety clearance**  
**Further information:** "Safety clearances SCI and SCK",  
Page 186
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



The engraving cycles are not available in **Machine** mode.

Cycle run:

- 1 Activate the C axis and position to the **Spindle angle C**, **Start point X** and **Z** at rapid traverse
- 2 Position to the **Start point**, if defined
- 3 Infeed at **Plunging feed rate factor FZ**
- 4 Engrave at the programmed feed rate
- 5 Position the tool to the **Return plane RB** or, if **RB** is not defined, to the **Start point Z**
- 6 Position the tool to the next character
- 7 Repeat steps 3 to 6 until all characters are engraved
- 8 Position to the **Start point X, Z** and deactivate the C axis
- 9 Move to the **Tool change point** according to the setting in **G14**



## Engraving, radial



- ▶ Select **Milling**



- ▶ Select **Engraving**



- ▶ Select **Engraving, radial**

The **Engraving, radial** cycle engraves character strings in linear arrangement on the lateral surface of the workpiece.

Character set and more information:

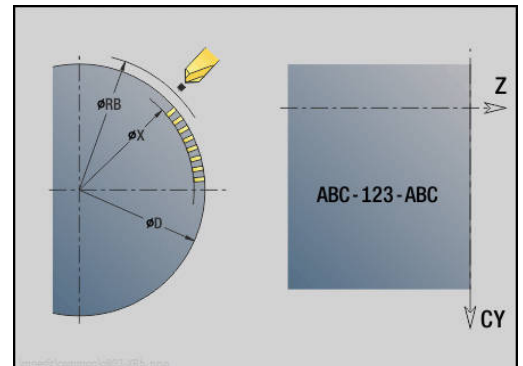
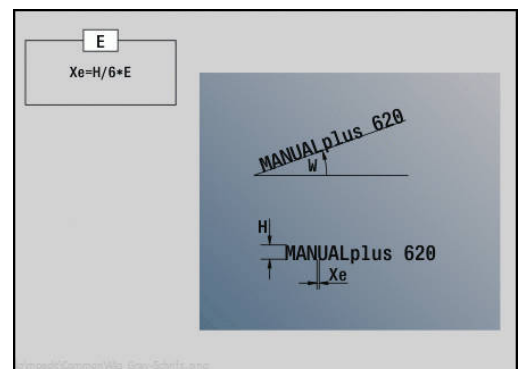
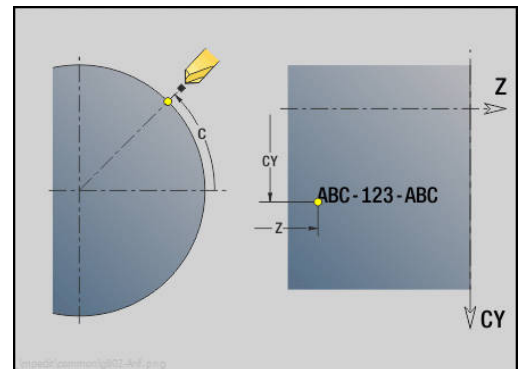
**Further information:** "Engraving, axial and radial", Page 403

Define the **Start point** of the character string in the cycle. If you do not define a **Start point**, the cycle starts at the current tool position.

You can also use multiple calls to engrave a logotype. For this purpose, specify the **Start point** with the first call. All other calls are programmed without a **Start point**.

Cycle parameters:

- **X: Starting point** – Pre-positioning the tool (diameter value)
- **Z: Starting point** – Pre-positioning the tool
- **C: Spindle angle** – Pre-positioning the workpiece spindle
- **TX: Text** to be engraved
- **NF: Char. no.** – ASCII code of the character to be engraved
- **X2: Final point** – X position, infeed depth during engraving (diameter value)
- **Z1: Start point** of first character
- **C1: Start. angle** of first character
- **CY: Start point** of first character
- **D: Reference diameter**
- **H: Font height**
- **E: Distance factor** (calculation: see figure)  
The distance between the characters is calculated according to the following formula:  $H / 6 * E$
- **T: Tool number** – Turret pocket number
- **G14: Tool change point**  
**Further information:** "Tool change point G14", Page 186
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **W: Inclinat. ang.** of the character string
- **FZ: Plunging feed rate factor** (plunging feed rate = current feed rate \* FZ)
- **RB: Return plane** – X position to which the tool retracts for positioning
- **SCK: Safety clearance**  
**Further information:** "Safety clearances SCI and SCK", Page 186
- **MT: M after T: M** function that is executed after the tool call **T**



- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)



The engraving cycles are not available in **Machine** mode.

Cycle run:

- 1 Activate the C axis and position to the **Spindle angle C, Start point X** and **Z** at rapid traverse
- 2 Position to the **Start point**, if defined
- 3 Infeed at **Plunging feed rate factor FZ**
- 4 Engrave at the programmed feed rate
- 5 Position the tool to the **Return plane RB** or, if **RB** is not defined, to the **Start point X**
- 6 Position the tool to the next character
- 7 Repeat steps 3 to 5 until all characters are engraved
- 8 Position to the **Start point X, Z** and deactivate the C axis
- 9 Move to the **Tool change point** according to the setting in **G14**

## Engraving, axial and radial

### Engraving, axial and radial

The control can realize the characters listed in the following table. The text to be engraved is entered as a character string. Diacritics and special characters that you cannot enter in the editor can be defined, character by character, in **NF**. If text is defined in **ID** and a character is defined in **NF**, the text is engraved before the character.



The engraving cycles are not available in **Machine** mode.

**Character**

Lower case

<b>NF</b>	<b>Character</b>
97	a
98	b
99	c
100	d
101	e
102	f
103	g
104	h
105	i
106	j
107	k
108	l
109	m
110	n
111	o
112	p
113	q
114	r
115	s
116	t
117	u
118	v
119	w
120	x
121	y
122	z

Upper case

<b>NF</b>	<b>Character</b>
65	A
66	B
67	C
68	D
69	E
70	F
71	G
72	H
73	I
74	J
75	K
76	L
77	M
78	N
79	O
80	P
81	Q
82	R
83	S
84	T
85	U
86	V
87	W
88	X
89	Y
90	Z

## Numbers

NF	Character
48	0
49	1
50	2
51	3
52	4
53	5
54	6
55	7
56	8
57	9

## Umlauts

NF	Character
196	Ä
214	Ö
220	Ü
223	ß
228	ä
246	ö
252	ü

## Special characters

NF	Character	Meaning
32		Space
37	%	Per cent sign
40	(	Opening parenthesis
41	)	Closing parenthesis
43	+	Plus sign
44	,	Comma
45	-	Minus sign
46	.	Point
47	/	Forward slash
58	:	Colon
60	<	Less than character
61	=	Equal sign
62	>	Greater than character
64	@	At sign
91	[	Opening brackets
93	]	Closing brackets
95	_	Underscore
8364	€###	Euro sign
181	μ	Mu character
186	°	Degrees
215	*	Multiplication sign
33	!	Exclamation point
38	&	Ampersand and
63	?	Question mark
174	®	Trademark
216	∅	Diameter sign

## 5.9 Drilling and milling patterns



Note on using drilling and milling patterns:

- **Drilling patterns:** The control generates the machine commands **M12**, **M13** (apply and release shoe brake) under the following conditions: the drill/tap must be entered as driven tool (parameter **Tool driven, no=0/yes=1 AW**) and the direction of rotation must be defined (parameter **Rotatnl. dir. M3=3, M4=4 MD**)
  - **ICP milling contours:** If the contour starting point is not on the origin of the coordinate system, the distance between the contour starting point and the coordinate origin is added to the pattern position
- Further information:** "Examples of pattern machining", Page 418

### Linear drilling pattern, axial



- ▶ Select **Drilling**



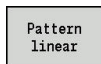
- ▶ Select **Drilling axial**



- ▶ Alternative: Select **Deep drilling axial**



- ▶ Alternative: Select **Tapping axial**



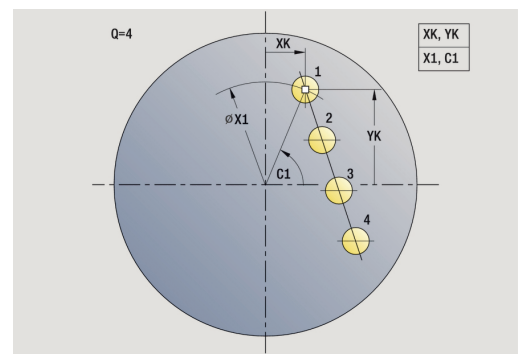
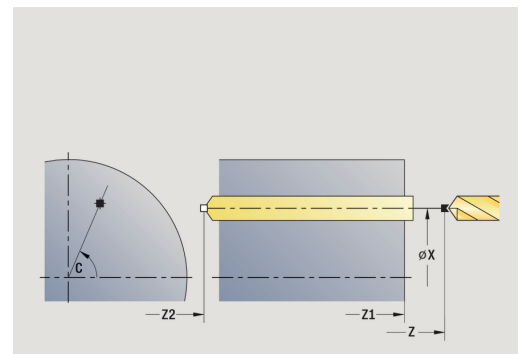
- ▶ Press the **Pattern linear** soft key

Press **Pattern linear** to machine drilling patterns in which the individual features are arranged regularly spaced and in a straight line on the front face.

Cycle parameters:

- **X, Z:** Start point
- **C:** Spindle angle – C-axis position (default: current spindle angle)
- **Q:** Number of holes
- **X1, C1:** Polar starting point – starting point of the pattern
- **XK, YK:** Cartesian starting pnt
- **I, J:** End point (**XK**) and (**YK**) – end point of the pattern (Cartesian)
- **Ii, Ji:** Distance (**XKi**) and (**YKi**) – incremental pattern spacing

The parameters of the hole are also requested.

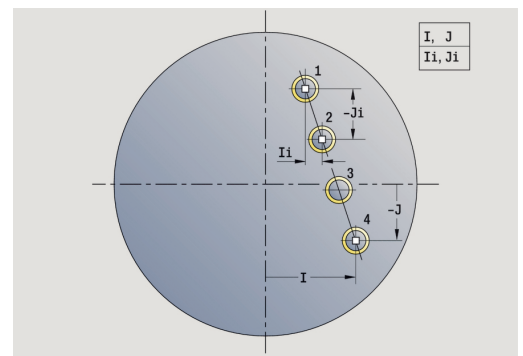
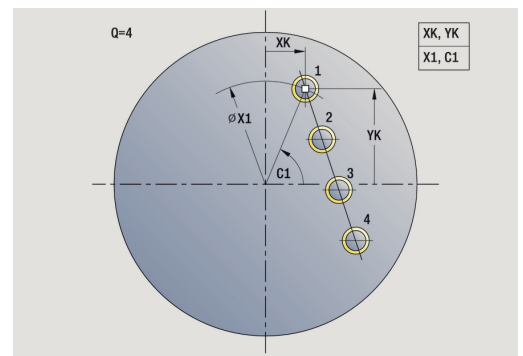
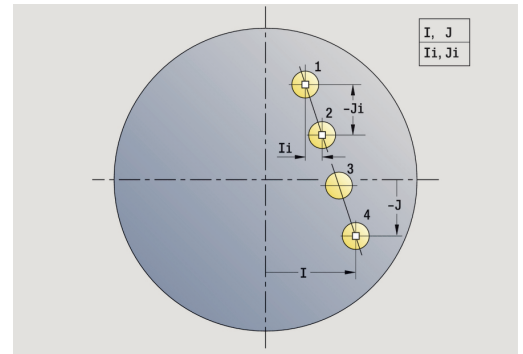


Use the following parameter combinations to define the:

- Starting point of pattern:
  - **X1, C1**
  - **XK, YK**
- Pattern positions:
  - **li, Ji** and **Q**
  - **I, J** and **Q**

Cycle run:

- 1 Positioning (machine-dependent):
  - Without C axis: Position to the **Spindle angle C**
  - With C axis: Activate the C axis and position to the **Spindle angle C** at rapid traverse
  - In **Machine** mode: Machining from the current spindle angle
- 2 Calculate the pattern positions
- 3 Position the tool to the **Start point** of the pattern
- 4 Execute the drilling operation
- 5 Position for the next machining operation
- 6 Repeat 4 to 5 until all machining operations have been completed
- 7 Return to the **Start point**
- 8 Move to the **Tool change point** according to the setting in **G14**



## Linear drilling pattern, radial



- ▶ Select **Drilling**



- ▶ Select **Drilling radial**



- ▶ Alternative: Select **Deep drilling radial**



- ▶ Alternative: Select **Tapping radial**



- ▶ Press the **Pattern linear** soft key

Press **Pattern linear** during drilling cycles to machine drilling patterns in which the individual features are arranged regularly spaced in a straight line on the lateral surface.

Cycle parameters:

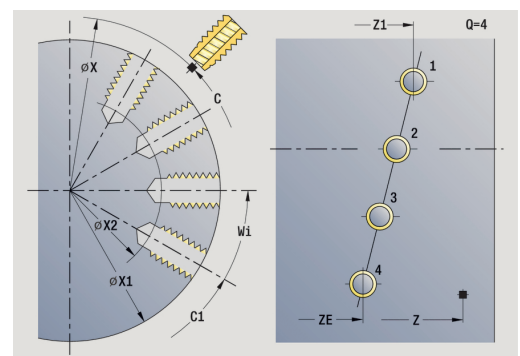
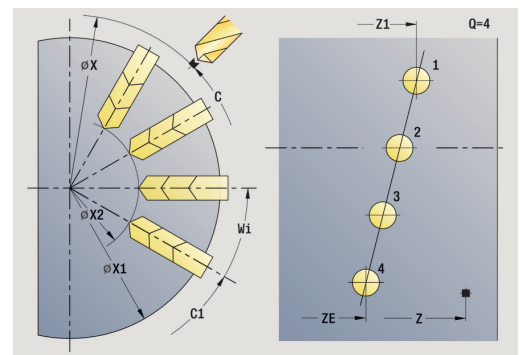
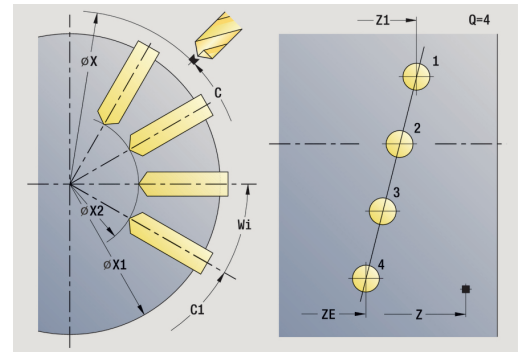
- **X, Z: Start point**
- **C: Spindle angle** – C-axis position (default: current spindle angle)
- **Q: Number of holes**
- **Z1: Start point pattern** – Position of first hole
- **ZE: End point pattern** (default: **Z1**)
- **C1: Angle of 1st hole** – Starting angle
- **Wi: Angle increment** – Pattern spacing (default: holes are regularly spaced on the lateral surface)

Define the pattern positions with **End point pattern** and **Angle increment** or **Angle increment** and **Number of holes**.

The parameters of the hole are also requested.

Cycle run:

- 1 Positioning (machine-dependent):
  - Without C axis: Position to the **Spindle angle C**
  - With C axis: Activate the C axis and position to the **Spindle angle C** at rapid traverse
  - In **Machine** mode: Machining from the current spindle angle
- 2 Calculate the pattern positions
- 3 Position the tool at the **Start point** of the pattern
- 4 Execute the drilling operation
- 5 Position for the next machining operation
- 6 Repeat 4 to 5 until all machining operations have been completed
- 7 Return to the **Start point Z**
- 8 Move to the **Tool change point** according to the setting in **G14**





### Linear milling pattern, axial



- ▶ Select **Milling**



- ▶ Select **Axial slot**



- ▶ Alternative: Select **Axial contour ICP**



- ▶ Press the **Pattern linear** soft key

Press **Pattern linear** to machine milling patterns in which the individual features are arranged regularly spaced in a straight line on the front face.

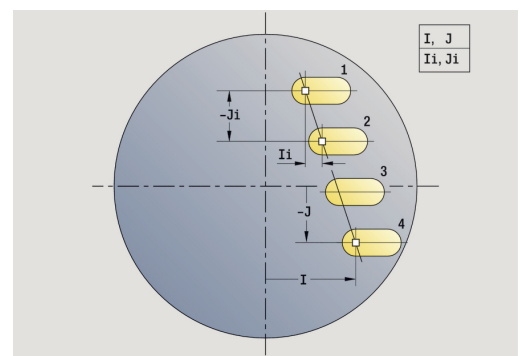
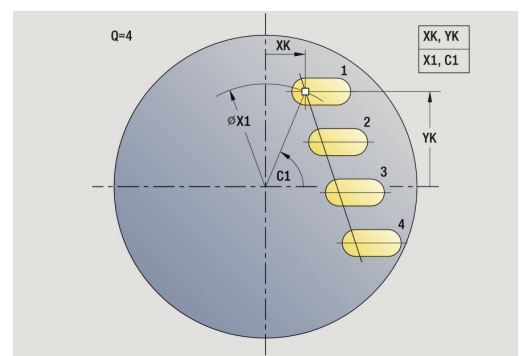
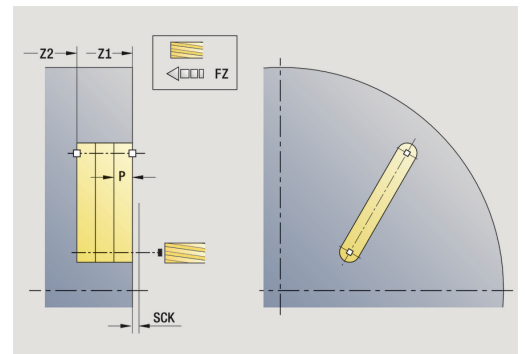
Cycle parameters:

- **X, Z: Start point**
- **C: Spindle angle** – C-axis position (default: current spindle angle)
- **Q: Number of slots**
- **X1, C1: Polar starting point** – starting point of the pattern
- **XK, YK: Cartesian starting pnt**
- **I, J: End point (XK) and (YK)** – end point of the pattern (Cartesian)
- **Ii, Ji: Distance (XKi) and (YKi)** – incremental pattern spacing

The parameters of the milling operation are also requested.

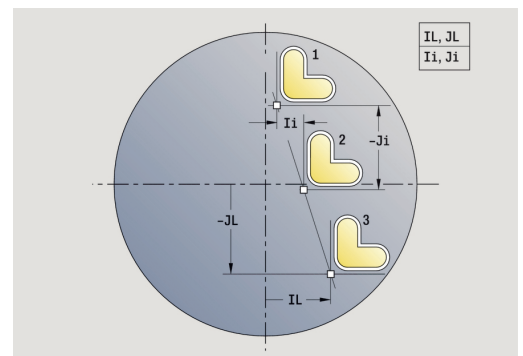
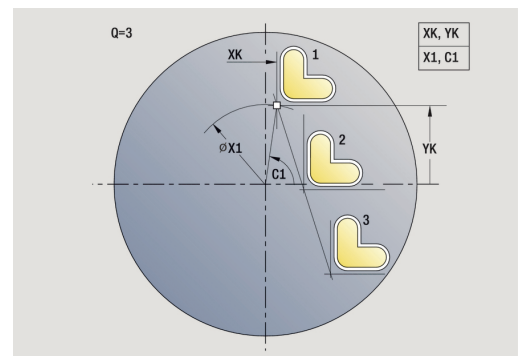
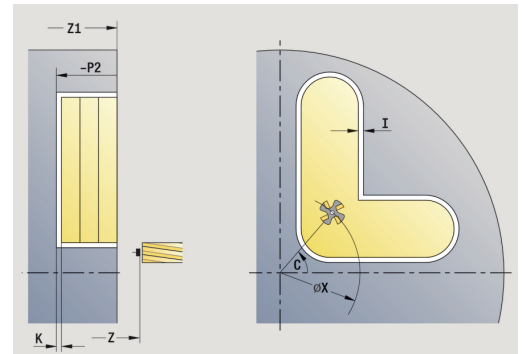
Use the following parameter combinations to define the:

- Starting point of pattern:
  - **X1, C1**
  - **XK, YK**
- Pattern positions:
  - **Ii, Ji** and **Q**
  - **I, J** and **Q**



Cycle run:

- 1 Positioning (machine-dependent):
  - Without C axis: Position to the **Spindle angle C**
  - With C axis: Activate the C axis and position to the **Spindle angle C** at rapid traverse
  - In **Machine** mode: Machining from the current spindle angle
- 2 Calculate the pattern positions
- 3 Position the tool at the **Start point** of the pattern
- 4 Execute the milling operation
- 5 Position for the next machining operation
- 6 Repeat 4 to 5 until all machining operations have been completed
- 7 Return to the **Start point**
- 8 Move to the **Tool change point** according to the setting in **G14**



### Linear milling pattern, radial



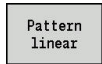
- ▶ Select **Milling**



- ▶ Select **Radial slot**



- ▶ Alternative: Select **Radial contour ICP**



- ▶ Press the **Pattern linear** soft key

Press **Pattern linear** during milling cycles to machine milling patterns in which the individual features are arranged regularly spaced in a straight line on the lateral surface.

Cycle parameters:

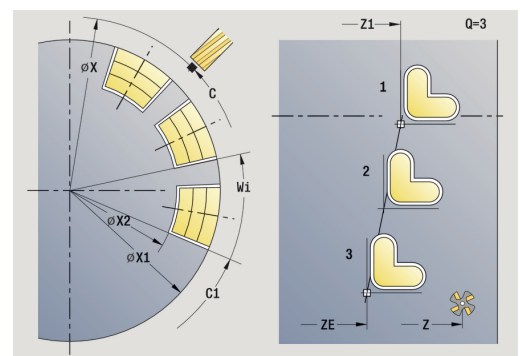
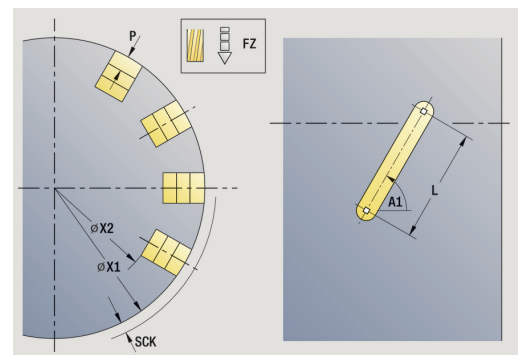
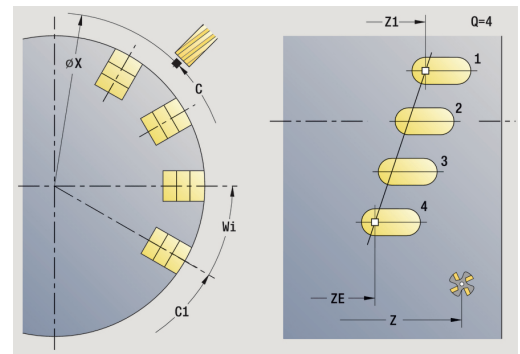
- **X, Z: Start point**
- **C: Spindle angle** – C-axis position (default: current spindle angle)
- **Q: Number of slots**
- **Z1: Start point pattern** – Position of first slot
- **ZE: End point pattern** (default: **Z1**)
- **C1: Start. angle** – Angle 1. Slot
- **Wi: Angle increment** – Pattern spacing (default: milling operations are regularly spaced on the lateral surface)

Define the pattern positions with **End point pattern** and Angle increment or Angle increment and Number of holes.

The parameters of the milling operation are also requested.

Cycle run:

- 1 Positioning (machine-dependent):
  - Without C axis: Position to the **Spindle angle C**
  - With C axis: Activate the C axis and position to the **Spindle angle C** at rapid traverse
  - In **Machine** mode: Machining from the current spindle angle
- 2 Calculate the pattern positions
- 3 Position the tool at the **Start point** of the pattern
- 4 Execute the milling operation
- 5 Position for the next machining operation
- 6 Repeat 4 to 5 until all machining operations have been completed
- 7 Return to the **Start point Z**
- 8 Move to the **Tool change point** according to the setting in **G14**



## Circular drilling pattern, axial



- ▶ Select **Drilling**



- ▶ Select **Drilling axial**



- ▶ Alternative: Select **Deep drilling axial**



- ▶ Alternative: Select **Tapping axial**



- ▶ Press the **Pattern circular** soft key

Press **Pattern circular** during drilling cycles to machine drilling patterns in which the individual features are arranged regularly spaced in a circle or circular arc on the front face.

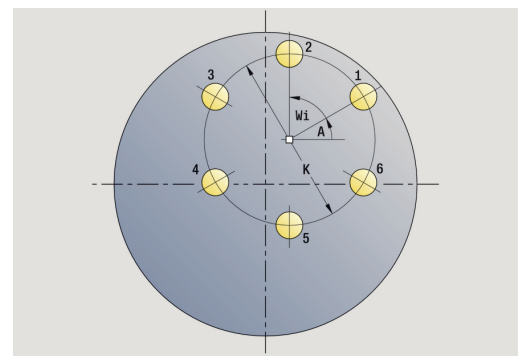
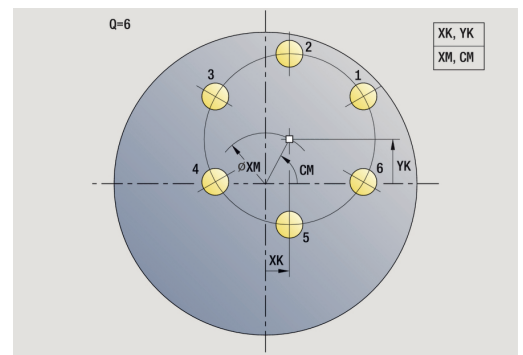
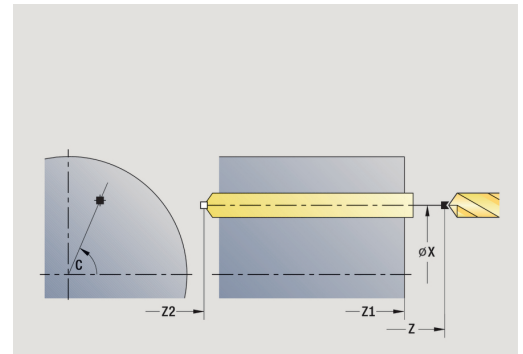
Cycle parameters:

- **X, Z: Start point**
- **C: Spindle angle** – C-axis position (default: current spindle angle)
- **Q: Number of holes**
- **XM, CM: Polar center point**
- **XK, YK: Cartesian center point**
- **K: Pattern diameter**
- **A: Angle of 1st hole** (default: 0°)
- **Wi: Angle increment** – Pattern spacing (default: holes are arranged regularly spaced in a circle)

The parameters of the hole are also requested.

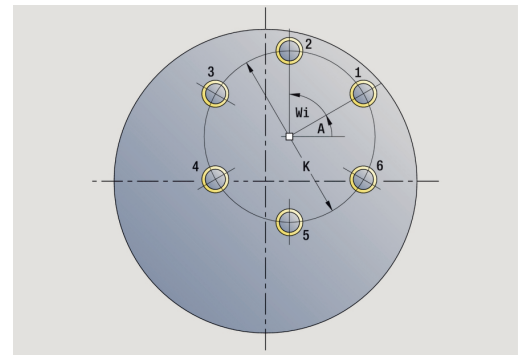
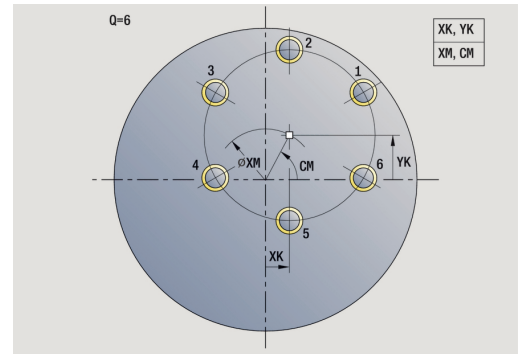
Use the following parameter combinations to define the center of the pattern:

- **XM, CM**
- **XK, YK**



Cycle run:

- 1 Positioning (machine-dependent):
  - Without C axis: Position to the **Spindle angle C**
  - With C axis: Activate the C axis and position to the **Spindle angle C** at rapid traverse
  - In **Machine** mode: Machining from the current spindle angle
- 2 Calculate the pattern positions
- 3 Position the tool at the **Start point** of the pattern
- 4 Execute the drilling operation
- 5 Position for the next machining operation
- 6 Repeat 4 to 5 until all machining operations have been completed
- 7 Return to the **Start point**
- 8 Move to the **Tool change point** according to the setting in **G14**



## Circular drilling pattern, radial



- ▶ Select **Drilling**



- ▶ Select **Drilling radial**



- ▶ Alternative: Select **Deep drilling radial**



- ▶ Alternative: Select **Tapping radial**



- ▶ Press the **Pattern circular** soft key

Press **Pattern circular** during drilling cycles to machine drilling patterns in which the individual features are arranged regularly spaced in a circle or circular arc on the lateral surface.

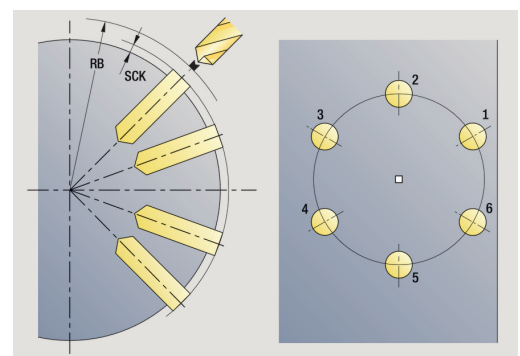
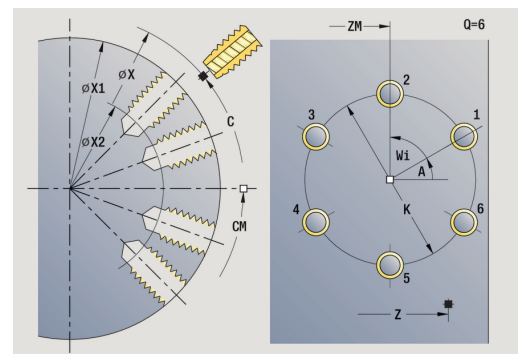
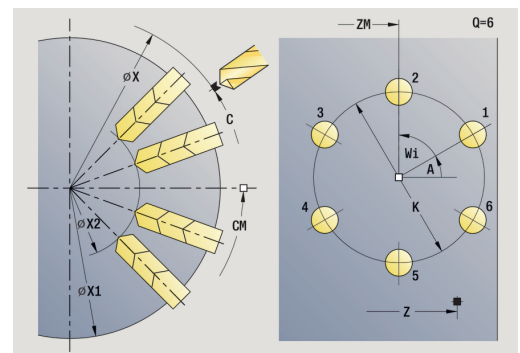
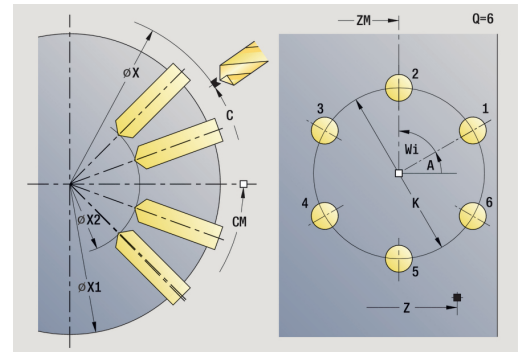
Cycle parameters:

- **X, Z: Start point**
- **C: Spindle angle** – C-axis position (default: current spindle angle)
- **Q: Number of holes**
- **ZM, CM: Center pt. in Z, Angle of pattern center**
- **K: Pattern diameter**
- **A: Angle of 1st hole** (default: 0°)
- **Wi: Angle increment** – Pattern spacing (default: holes are arranged regularly spaced in a circle)

The parameters of the hole are also requested.

Cycle run:

- 1 Positioning (machine-dependent):
  - Without C axis: Position to the **Spindle angle C**
  - With C axis: Activate the C axis and position to the **Spindle angle C** at rapid traverse
  - In **Machine** mode: Machining from the current spindle angle
- 2 Calculate the pattern positions
- 3 Position the tool at the **Start point** of the pattern
- 4 Execute the drilling operation
- 5 Position for the next machining operation
- 6 Repeat 4 to 5 until all machining operations have been completed
- 7 Return to the **Start point**
- 8 Move to the **Tool change point** according to the setting in **G14**



## Circular milling pattern, axial



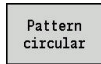
- ▶ Select **Milling**



- ▶ Select **Axial slot**



- ▶ Alternative: Select **Axial contour ICP**



- ▶ Press the **Pattern circular** soft key

Press **Pattern circular** during milling cycles to machine milling patterns in which the individual features are arranged regularly spaced in a circle or circular arc on the front face.

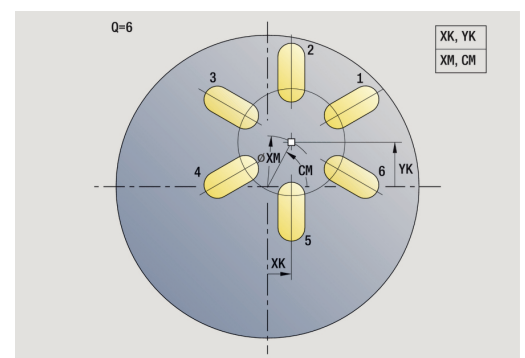
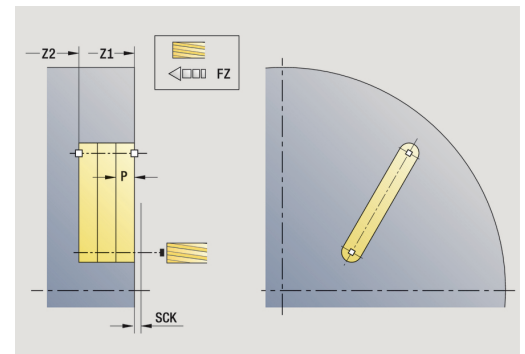
Cycle parameters:

- **X, Z: Start point**
- **C: Spindle angle** – C-axis position (default: current spindle angle)
- **Q: Number of slots**
- **XM, CM: Polar center point**
- **XK, YK: Cartesian center point**
- **K: Pattern diameter**
- **A: Angle of 1st slot** (default: 0°)
- **Wi: Angle increment** – Pattern spacing (default: milling operations are arranged regularly spaced in a circle)

The parameters of the milling operation are also requested.

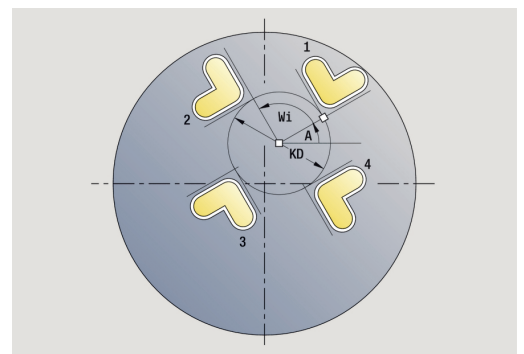
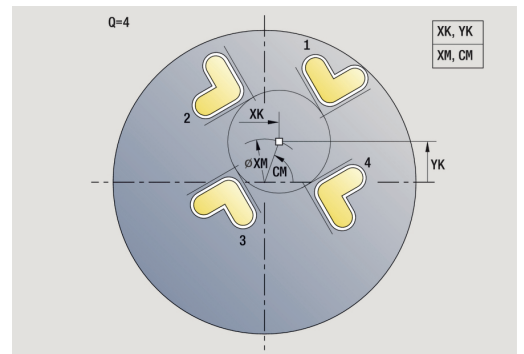
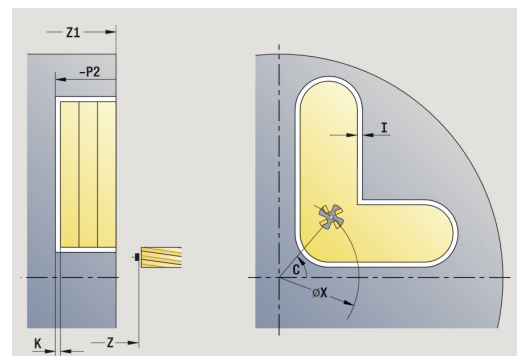
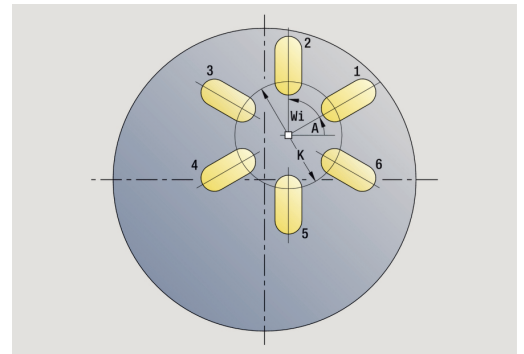
Use the following parameter combinations to define the:

- **XM, CM**
- **XK, YK**



Cycle run:

- 1 Positioning (machine-dependent):
  - Without C axis: Position to the **Spindle angle C**
  - With C axis: Activate the C axis and position to the **Spindle angle C** at rapid traverse
  - In **Machine** mode: Machining from the current spindle angle
- 2 Calculate the pattern positions
- 3 Position the tool at the **Start point** of the pattern
- 4 Execute the milling operation
- 5 Position for the next machining operation
- 6 Repeat 4 to 5 until all machining operations have been completed
- 7 Return to the **Start point**
- 8 Move to the **Tool change point** according to the setting in **G14**





### Circular milling pattern, radial



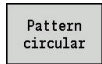
- ▶ Select **Milling**



- ▶ Select **Radial slot**



- ▶ Alternative: Select **Radial contour ICP**



- ▶ Press the **Pattern circular** soft key

Press **Pattern circular** during milling cycles to machine milling patterns in which the individual features are arranged regularly spaced in a circle or circular arc on the lateral surface.

Cycle parameters:

- **X, Z: Start point**
- **C: Spindle angle** – C-axis position (default: current spindle angle)
- **Q: Number of slots**
- **ZM, CM: Center pt. in Z, Angle of pattern center**
- **K: Pattern diameter**
- **A: Angle of 1st slot** (default: 0°)
- **Wi: Angle increment** – Pattern spacing (default: milling operations are arranged regularly spaced in a circle)

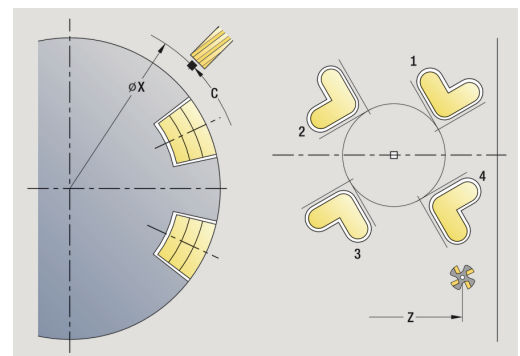
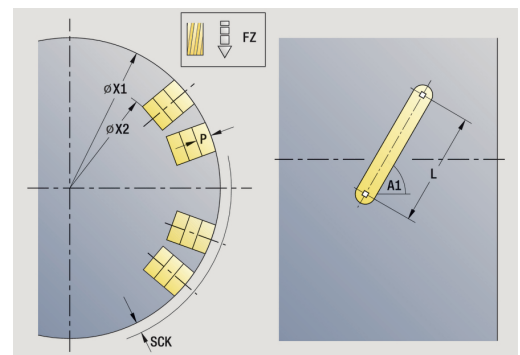
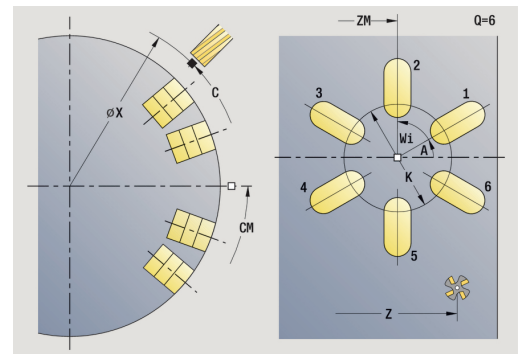
The parameters of the milling operation are also requested.



The starting point of an ICP contour to be arranged in a pattern must lie on the positive XK axis.

Cycle run:

- 1 Positioning (machine-dependent):
  - Without C axis: Position to the **Spindle angle C**
  - With C axis: Activate the C axis and position to the **Spindle angle C** at rapid traverse
  - In **Machine** mode: Machining from the current spindle angle
- 2 Calculate the pattern positions
- 3 Position the tool at the **Start point** of the pattern
- 4 Execute the milling operation
- 5 Position for the next machining operation
- 6 Repeat 4 to 5 until all machining operations have been completed
- 7 Return to the **Start point**
- 8 Move to the **Tool change point** according to the setting in **G14**



## Examples of pattern machining

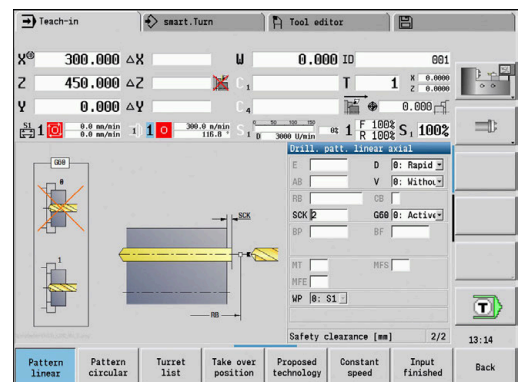
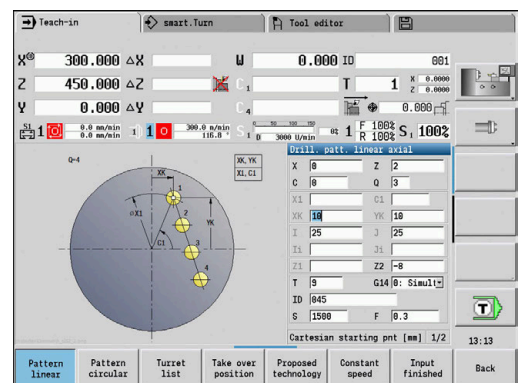
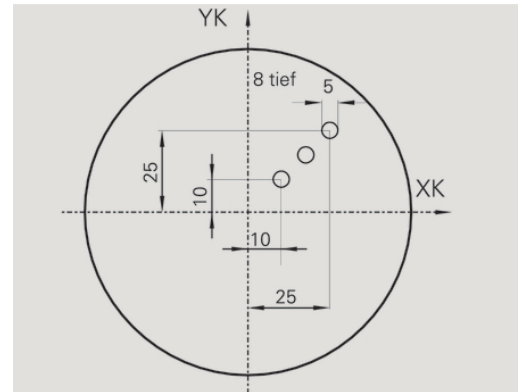
### Linear hole pattern on face

A linear hole pattern is to be machined on the face of the workpiece with the **Drilling radial** cycle. This machining operation requires a traversable spindle and driven tools.

The pattern is programmed by entering the coordinates of the first and last hole, and the number of holes. Only the depth is indicated for the drilling cycle.

Tool data

- **TO** = 8 – Tool orientation
- **DV** = 5 – Drilling diameter
- **BW** = 118 – Point angle
- **AW** = 1 – The tool is a driven tool



**Circular hole pattern on face**

A circular hole pattern is to be machined on the face of the workpiece with the **Drilling axial** cycle. This machining operation requires a traversable spindle and driven tools.

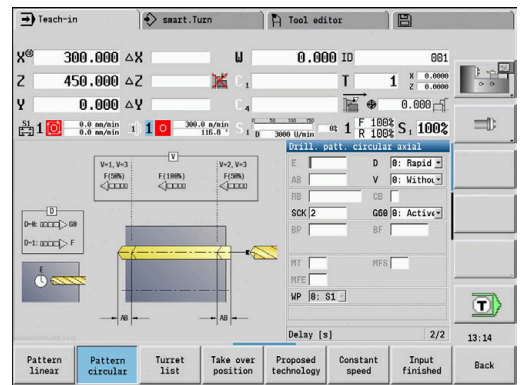
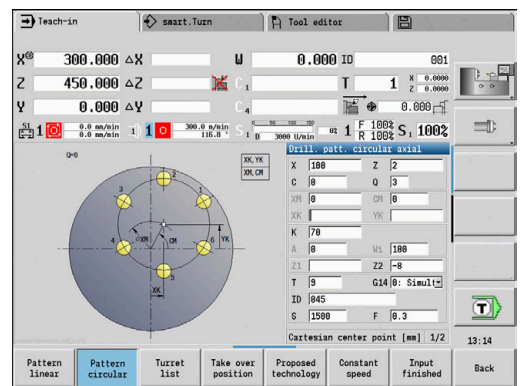
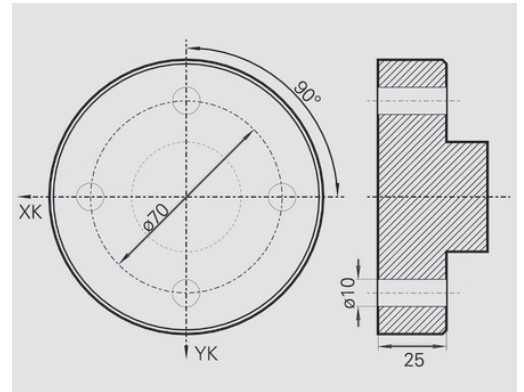
The **Center point pattern** is specified in Cartesian coordinates.

Since this example is to illustrate how you drill a through hole, the **End point drill Z2** is programmed such that the tool has to drill all the way through the workpiece before it reaches the end point.

The **AB** and **V** parameters define a feed-rate reduction for both spot drilling and drilling through-holes.

Tool data

- **TO** = 8 – Tool orientation
- **DV** = 5 – Drilling diameter
- **BW** = 118 – Point angle
- **AW** = 1 – The tool is a driven tool



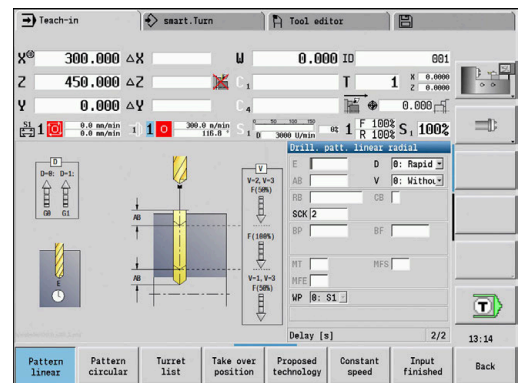
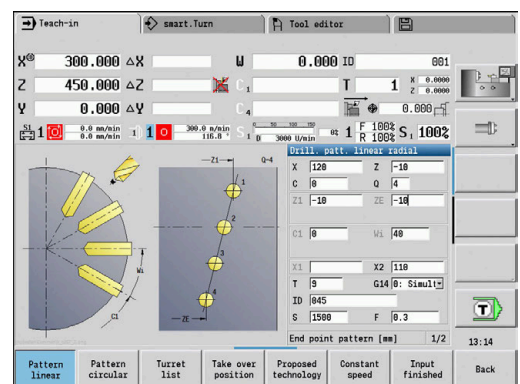
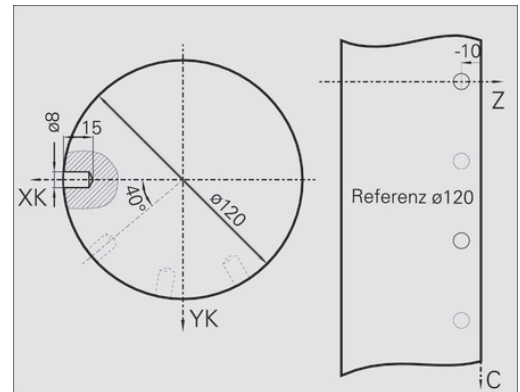
### Linear hole pattern on lateral surface

A linear hole pattern is to be machined on the lateral surface of the workpiece with the **Drilling axial** cycle. This machining operation requires a traversable spindle and driven tools.


The drilling pattern is defined by the coordinates of the first hole, the number of holes, and the spacing between the holes. Only the depth is indicated for the drilling cycle.

Tool data

- **TO** = 2 – Tool orientation
- **DV** = 8 – Drilling diameter
- **BW** = 118 – Point angle
- **AW** = 1 – The tool is a driven tool



## 5.10 DIN cycles

Menu item	Meaning
	This function allows you to select a DIN cycle (DIN subprogram) and integrate it in a cycle program. The dialogs of the parameters defined in the subprogram are then shown in the form.

The technology data that are programmed in the DIN cycle (in **Machine** mode, the currently active technology data) becomes effective as soon as you start the DIN subprogram. However, you can change the machine data (**T**, **S**, **F**) at any time by editing the DIN subprogram.

### DIN cycle

	▶ Select <b>DIN cycle</b>
---	---------------------------

Cycle parameters:

- **L: DIN subprogram** – DIN macro number
- **Q: Number of repetitions** (default: 1)
- **LA-LF: Transmiss.value**
- **LH-LK: Transmiss.value**
- **LO-LP: Transmiss.value**
- **LR-LS: Transmiss.value**
- **LU: Transmiss.value**
- **LW-LZ: Transmiss.value**
- **LN: Transmiss.value**
- **T: Tool number** – Turret pocket number
- **ID: ID no.**
- **S: Cutting speed** or **Constant speed**
- **F: Feed per revolution**
- **MT: M after T: M** function that is executed after the tool call **T**
- **MFS: M at beginning: M** function that is executed at the beginning of the machining step
- **MFE: M at end: M** function that is executed at the end of the machining step
- **WP: No. of spindle** – Displays which workpiece spindle is used to execute the cycle (machine-dependent)
  - Main drive
  - Opposing spindle for rear-face machining
- **BW: Angle in the B axis** (machine-dependent)
- **CW: Reverse the tool** (machine-dependent)
- **HC: Shoe brake** (machine-dependent)
- **DF: Miscellaneous function** (machine-dependent)
- **ID1, AT1: ID number**
- **BS, BE, WS, AC, WC, RC, IC, KC, JC: Transmiss.value**

Type of machining for technology database access depends on the tool type:

- 1 Turning tool: **Roughing**
- 2 Button tool: **Roughing**
- 3 Threading tool: **Thread cutting**
- 4 Recessing tool: **Contour recessg.**
- 5 Twist drill: **Drilling**
- 6 Indexable insert drill: **Predrilling**
- 7 Tap: **Tapping**
- 8 Milling cutter: **Milling**



In the DIN subprogram, you can assign texts and help graphics to the transfer values.

**Further information:** smart.Turn and DIN Programming User's Manual

### NOTICE

#### Danger of collision!

DIN cycles do not contain any starting points. When a DIN cycle is called, the control positions the tool on a diagonal path from the current position to the first position that is programmed in the DIN subprogram. There is danger of collision during the approach movement!

- ▶ Before calling the DIN cycle, pre-position the tool if necessary

### NOTICE

#### Danger of collision!

In **Teach-in** submode, all datum shifts contained in a DIN cycle (DIN macro) will be reset after the cycle has been executed. Danger of collision during subsequent machining operations!

- ▶ Use DIN cycles without datum shifts

# 6

**ICP programming**

## 6.1 ICP contours

The interactive contour programming (**ICP**) feature provides graphic support when you are defining the workpiece contours. ( **ICP** is the abbreviation of **I**nteractive **C**ontour **P**rogramming.)

Contours created with **ICP** are used in the following:

- In the ICP cycles (**Teach-in** submode, **Machine** mode of operation)
- In **smart.Turn** mode of operation

Each contour begins with a starting point. The following contours are defined using linear and circular contour elements as well as form elements like chamfers, rounding radii, and undercuts.

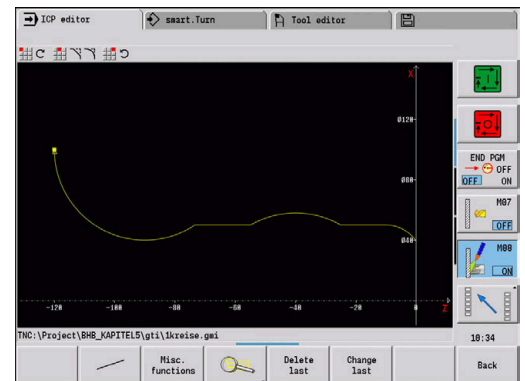
**ICP** is called from the **smart.Turn** mode of operation and the cycle dialogs.

**ICP contours** created in Teach-in mode are saved by the control in independent files. You can enter file names (contour names) with up to 40 characters. ICP contours are integrated in ICP cycles.

The following contour types are possible:

- Turning contours: **\*.gmi**
- Contours of workpiece blanks: **\*.gmr**
- Milling contours on face: **\*.gms**
- Milling contours on lateral surface: **\*.gmm**

The control integrates **ICP contours** created in **smart.Turn** mode of operation into the respective NC program. Contour descriptions are saved as **G** codes.



- In Teach-in mode, **ICP contours** created are managed in independent files. These contours can only be edited with **ICP**
- In **smart.Turn** mode of operation, contours are part of the NC program. They can be machined with the ICP editor or **smart.Turn** editor.



In the **convertICP** (602023) machine parameter, you define whether the control loads the programmed or calculated values into the NC program.



## Loading contours

**ICP contours** that you have created for cycle programs can be loaded in **smart.Turn** mode of operation. **ICP** converts the contours into **G** codes and integrates them in the smart.Turn program. The contour is now part of the smart.Turn program.

Contours that exist in DXF format can be imported with the **ICP editor** submode. During the import process, the contours are converted from DXF format to ICP format. You can use DXF contours both for the **Teach-in** submode and for the **smart.Turn** mode of operation.

## Form elements

- Chamfers and rounding radii can be inserted at each corner of the contour.
- Undercuts according to DIN 76, DIN 509 E, and DIN 509 F can be inserted at paraxial, orthogonal contour corners. Small deviations are tolerated in elements in the X direction

You can insert chamfers and rounding radii at each corner of the contour. Undercuts according to DIN 76, DIN 509 E, and DIN 509 F can be inserted at paraxial, orthogonal contour corners, and small deviations in horizontal elements (X direction) are tolerated.

You have the following alternatives for entering form elements:

- Enter all contour elements, including the form elements, in the sequence in which they are given in the workpiece drawing
- First define the rough contour without the form elements. Then you **superimpose** the form elements

**Further information:** "Superimposing form elements",  
Page 447

## Machining attributes

You can assign the following machining attributes to the contour elements.

Machining attributes:

- **U: Oversz** is additive to other oversizes  
ICP generates a **G52 Pxx H1**.
- **F: Feed per rot.** – (special feed rate for finishing)  
ICP generates a **G95 Fxx**.
- **D: Corr. additiv** – Number of the additive D compensation for the finishing operation, e.g. **D = 01** to 16  
ICP generates a **G149 D9xx**.
- **FP: Do not machine the element** (required only for **TURN PLUS**)
  - **0: No**
  - **1: Yes**
- **IC: Measuring cut oversize** (not available in **Teach-in** submode)
- **KC: Length of measuring cut** (not available in **Teach-in** submode)
- **HC: Measuring cut counter** – Number of workpieces after which a measurement is performed



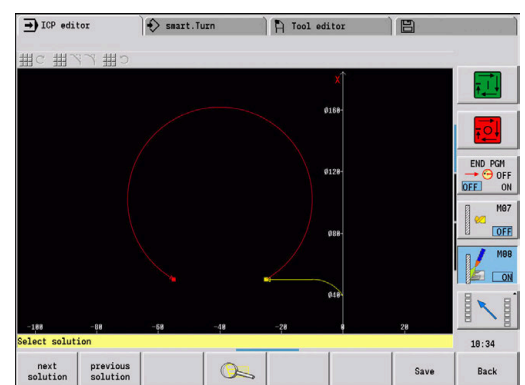
The machining attributes are effective only for the element in which the attributes have been entered in ICP.

## Calculation of contour geometry

The control automatically calculates all missing coordinates, points of intersection, center points, etc. that can be derived mathematically.

If the entered data permit several mathematically possible solutions, you can inspect the individual solutions and select the proposal that matches the drawing.

Each unresolved contour element is represented by a small symbol below the graphic window. The control displays all contour elements that can be drawn, even if they are not yet fully defined.



## 6.2 ICP editor submode in Teach-in

In Teach-in mode you can create:

- Complex workpiece blank contours
- Contours for turning
  - For ICP turning cycles
  - For ICP recessing cycles
  - For ICP recess-turning cycles
- Complex contours for milling with the C axis
  - For the face
  - For the lateral surface

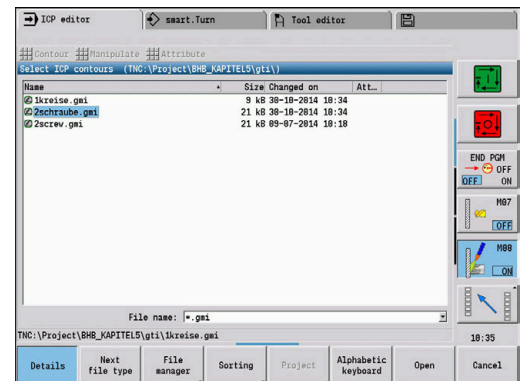
Activate the **ICP editor** submode with the **Edit ICP** soft key. It can only be selected when editing ICP cutting cycles or ICP milling cycles or with the ICP workpiece blank contour cycle.

The description depends on the contour type. Using the cycle, **ICP** distinguishes between:

- Contour for turning or the workpiece blank contour:  
**Further information:** "Contour elements – turning contour", Page 457
- Contour for the face:  
**Further information:** "Front face contours in smart.Turn mode of operation", Page 483
- Contour for the lateral surface:  
**Further information:** "Lateral surface contours in smart.Turn mode of operation", Page 493



If you create or edit two or more **ICP contours** in sequence, the last edited **ICP contour number** is loaded to the cycle after the **ICP editor** submode has been exited.



## Editing contours for cycles

The **ICP contours** of the cycle editing function are assigned names. The contour name is the same as the file name. The contour name is also used in the calling cycle.

You can define the contour name in the following ways:

- Define the contour name in the cycle dialog **before** calling the **ICP editor** submode (**FK** input field). **ICP** loads this name
- Define the contour name in the **ICP editor** submode. The input field **FK** must be empty when you call the **ICP editor** submode
- Load the existing contour. When you exit the **ICP editor** submode, the name of the contour last edited is loaded into the **FK** input field

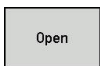
Creating a new contour:



- ▶ Define the contour name in the cycle dialog and press the **Edit ICP** soft key. The **ICP editor** submode switches to contour input



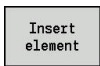
- ▶ Alternative: Press the **Edit ICP** soft key. The **ICP editor** submode opens the **Select ICP contours** window



- ▶ Define the contour name in the **File name:** field and press the **Open** soft key. The **ICP editor** submode switches to contour input



- ▶ Select the **CONTOUR GEOMETRY** menu item






- ▶ Press the **Insert element** soft key
- > **ICP** waits for you to enter a new contour

## File management in ICP editor submode

In file management, you can copy, rename or delete the **ICP contours**.

Opening the file manager:

- |   |  |
|---|--|
|  | ▶ Press the <b>Edit ICP</b> soft key   |
|  | ▶ Press the <b>Contour list</b> soft key<br>> The <b>ICP editor</b> submode opens the <b>Select ICP contours</b> window                |
|  | ▶ Press the <b>File manager</b> soft key<br>> The <b>ICP editor</b> submode switches the soft-key row to the file management functions |

## 6.3 ICP editor submode in smart.Turn mode of operationsmart.Turn

In **smart.Turn** mode of operation you create:

- Contour groups
- Workpiece blank contours and auxiliary workpiece blank contours
- Finished part contours and auxiliary contours
- Standard figures and complex contours for C-axis machining
  - on the face
  - on the lateral surface
- Standard figures and complex contours for Y-axis machining
  - on the XY plane
  - on the YZ plane

**Contour groups:** The control supports up to four contour groups (**BLANK**, **FINISHED PART** and **TEMPORARY**) in one NC program. The **Contour group** section code initiates the description of a contour group.

**Further information:** "Contour groups", Page 536

**Workpiece blank contours and auxiliary workpiece blank contours:** You can describe complex workpiece blanks element by element—just like finished parts. Select the standard forms of bar and tube from the menu and describe them with a few parameters. If a definition of the finished part exists, you can also select Cast part in the menu.

**Further information:** "Workpiece blank definition", Page 456

**Figures and patterns for C and Y axis machining:** You describe complex milling contours element by element. The following standard figures are prepared.

You select the figures by menu and describe them with a few parameters:

- Circle
- Rectangle
- Polygon C
- Linear slot
- Circular slot
- Hole

You can arrange these figures and holes as linear or circular patterns on the face or lateral surface as well as in the XY or YZ plane.

You can import **DXF contours** and integrate them in the smart.Turn program.

**Cycle programming contours** can be loaded and integrated into the smart.Turn program.

The **smart.Turn** operating mode supports loading the following contours:

- Workpiece blank description (extension **\*.gmr**): Loaded as workpiece blank contour or auxiliary workpiece blank contour
- Contour for turning (extension **\*.gmi**): Loaded as finished part contour or auxiliary contour
- Face contour (extension **\*.gms**)
- Lateral surface contour (extension **\*.gmm**)



**ICP** uses **G** codes to describe the contours created in the smart.Turn program.

In the **convertICP** (602023) machine parameter, you define whether the control loads the programmed or calculated values into the NC program.

## Editing contours for cycles

Programming a new workpiece blank contour:



- ▶ Select the **ICP** menu item



- ▶ Select **Workpiece blank** or **New auxiliary blank** in the ICP submenu



- ▶ Select the **Contour** menu item

- ▶ The **ICP editor** submode switches to the editor that allows you to enter the complex workpiece blank contour



- ▶ Alternative: Select the **Bar** menu item

- ▶ Describe the standard workpiece blank **Bar**



- ▶ Alternative: Select the **Tube** menu item

- ▶ Describe the **Tube** standard workpiece blank

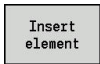
Programming a new contour for turning:



- ▶ Select the **ICP** menu item



- ▶ Select the contour type in the ICP submenu
- ▶ Select the **Contour editing** menu item



- ▶ Alternative: Press the **Insert element** soft key
- ▶ **ICP** waits for you to enter a new contour

Loading a contour from cycle editing:



- ▶ Select the **ICP** menu item



- ▶ Select the contour type in the ICP submenu
- ▶ Press the **Contour list** soft key
- ▶ In **ICP editor** submode, you can display the list of the contours created in Teach-in mode
- ▶ Select and load the contour

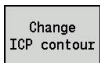
Editing an existing contour:



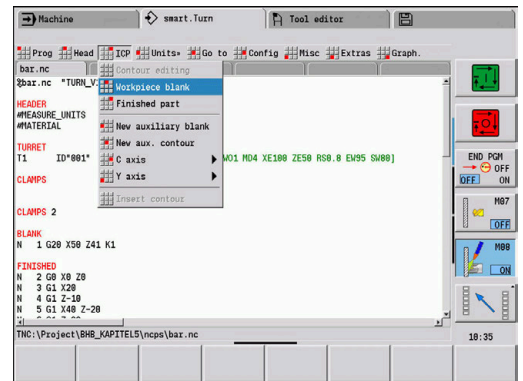
- ▶ Select the **ICP** menu item



- ▶ Select **Contour editing** in the ICP submenu



- ▶ Alternative: Press the **Change ICP contour** soft key
- ▶ The **ICP editor** submode displays the selected existing contour for subsequent editing













## 6.4 Programming ICP contours

An ICP contour consists of individual contour elements. Create the contour by entering the individual contour elements one after the other in the correct sequence. The **Start point** is defined describing the first contour element. The **Final point** is determined by the target point of the last contour element.

The contour elements and subcontours are displayed as soon as they are programmed. With the zoom and panning functions, you can adjust the graphics as required.

The principle described in the following applies to all **ICP contours**.

### Soft keys in the ICP editor submode – Main menu

	Open the file selection dialog for <b>ICP contours</b>
	Invert the definition direction of the contour
	Retroactively insert form elements
	Open the soft-key menu for the zoom functions and display the zoom frame
	Clear an existing element
	Modify an existing element
	Add an element to the existing contour
	Return to the dialog that has called <b>ICP</b>

## Defining an ICP contour

When you create a new contour, the control first asks for the coordinates of the **contour starting point**.

**Linear contour elements:** Use the menu symbol to select the direction of the element and assign it a dimension. When defining horizontal and vertical linear elements, it is not necessary to enter the X and Z coordinates, provided that there are no unresolved elements.

**Circular contour elements:** Use the menu symbol to select the direction of arc rotation and dimension the arc.

After selecting a contour element, enter the known parameters. The control automatically calculates parameters that have not been defined from the adjoining contour elements. Usually the contour elements are described using the dimensions given in the production drawing.

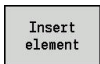
During input of linear or circular elements, the control does display the **Start point**, but it is not editable. The **Start point** is the **Final point** of the preceding element.

You can toggle between the **line and arc menus** by soft key. Form elements (chamfers, roundings, and undercuts) are selected using the menu item.

Programming an ICP contour:



- ▶ Select the **Contour editing** menu item



- ▶ Define the starting point
- ▶ Alternative: Press the **Insert element** soft key



- ▶ Define the starting point
- ▶ Press the **Line menu** soft key

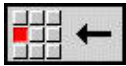


- ▶ Alternative: Press the **arc menu** soft key
- ▶ Select the element type
- ▶ Enter the known parameters of the contour element

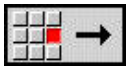
**Menu items of the line menu**



Line with angle in displayed quadrant



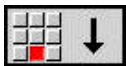
Horizontal line in displayed direction



Line with angle in displayed quadrant



Vertical line in displayed direction

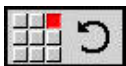


Call the form element menu

**Menu items of arc menu**



Circular arc in the displayed direction of rotation



Call the form element menu

**Soft keys for switching between line menu and arc menu**



Press the **Line menu** soft key



Press the **Arc menu** soft key

## Absolute or incremental dimensions

The setting of the **Increment** soft key determines which type of coordinate is active for dimensioning. Incremental parameters will have the appendix **i** (**Xi**, **Zi**, etc.).

---

### Increment soft key switchover

---



Activate the incremental dimension for the current value

## Transitions between contour elements

A transition between two contour elements is called **tangential** when one contour element makes a smooth and continuous transition to the next. There is no visible kink or corner at the intersection. With geometrically complex contours, tangential transitions are useful for reducing the input of dimensional data to a minimum and eliminating the possibility of mathematically contradictory entries.

To be able to calculate unresolved contour elements, the control must know the type of transition that connects the contour elements. The transition to the next contour element is determined by soft key.



Error messages that occur during definition of the ICP contour are often caused by **forgotten** tangential transitions.

---

### Soft key for tangential transition

---



Activates the tangential condition for the transition in the end point of the contour element

## Fits and internal threads

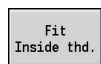
With the **Fit Inside thd.** soft key, you can display an input form for calculating the machining diameter for fits and internal threads. After entering the required values (nominal diameter and tolerance class or thread type), you can load the calculated value as the target point for the contour element.



The machining diameter can only be calculated for suitable contour elements, e.g. for a linear element in X direction when calculating the fit for a shaft.

When calculating internal threads of thread type 9, 10 or 11, you can select the nominal diameter for inch threads in the **Nominal dia. from list L** list.

Calculating the fit for a hole or shaft:

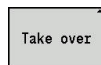


- ▶ Press the **Fit Inside thd.** soft key

- ▶ Enter the nominal diameter
- ▶ Enter the fit data in the **Fit** form

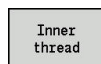


- ▶ Press the **ENT** key to calculate the values



- ▶ Press the **Take over** soft key
- ▶ The calculated center of tolerance is entered in the corresponding field of the open dialog

Calculating the core hole diameter for internal threads:

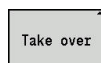


- ▶ Press the **Inner thread** soft key

- ▶ Enter the nominal diameter
- ▶ Enter the thread data in the **Inside thread calculator** form



- ▶ Press the **ENT** key to calculate the values



- ▶ Press the **Take over** soft key
- ▶ The calculated core hole diameter is entered in the corresponding field of the open dialog

## Polar coordinates

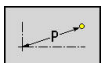
Entry of Cartesian coordinates is expected as standard. With the soft keys for polar coordinates you switch individual coordinates to polar coordinates.

You can mix Cartesian coordinates and polar coordinates to define a point.

### Soft keys for polar coordinates



Switch the field to entering the angle **W**

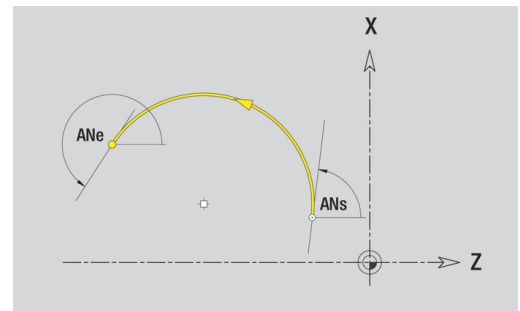


Switch the field to entering the radius **P**

## Angle input

Select the desired angle input by soft key.

- **Linear elements**
  - **AN** Angle to Z axis (**AN** ≤ 90° – Within the preselected quadrant)
  - **ANn** Angle to the following element
  - **ANp** Angle to the previous element
- **Circular arcs**
  - **ANs** Tangential angle in the starting point of the circle
  - **ANe** Tangential angle in the end point of the circle
  - **ANn** Angle to the following element
  - **ANp** Angle to the previous element



### Soft keys for angular input



Angle to successor



Angle to predecessor

## Contour graphics

As soon as you have entered a contour element, the control checks whether the element is "resolved" or "unresolved."

- A **resolved element** is a contour element that is fully and unambiguously defined. It is drawn immediately.
- An **unresolved element** has not yet been fully defined by the specified data. Using the **ICP editor**
  - It places a symbol below the graphic window that reflects the element type and the line direction / direction of rotation
  - It displays an unresolved linear element if the starting point and direction are known
  - It displays an unresolved circular element as a full circle if the circle center and the radius are known

As soon as it can be calculated, the control converts an unresolved contour element to a resolved contour element. The symbol is then deleted.

An incorrect contour element is displayed if possible. In addition, an error message is issued.

**Unresolved contour elements:** If during further contour input an error results because there is not enough information for a contour element, the unresolved element can be selected and the missing information added.

If a contour contains **unresolved** contour elements, the resolved elements cannot be changed. You can, however, set or delete the **tangential transition** for the contour element located directly before the unresolved contour area.



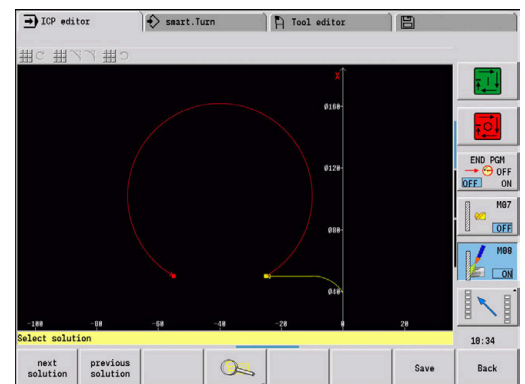
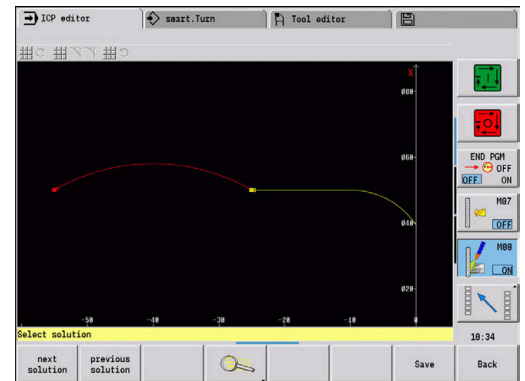
- If the element to be edited is an unresolved element, the associated symbol is marked **selected**
- The element type and the direction of rotation of a circular arc cannot be changed. In this case, the contour element has to be deleted and then added

## Selection of solutions

If the data entered for unresolved contour elements permit several possible solutions, you can use the **next solution** and **previous solution** soft keys to check all mathematically possible solutions. Confirm the correct solution by soft key.



If the contour still contains unresolved contour elements when you exit the editing mode, the control will ask you whether to discard these elements.



## Colors in contour graphics

Resolved, unresolved and selected contour elements as well as selected contour corners and remaining contours are depicted in different colors. (The selection of contour elements, contour corners and remaining contours is important when editing **ICP contours**.)

Colors:

- White: Workpiece blank contour, auxiliary workpiece blank contour
- Yellow: Finished part contours (turned contours, contour for C and Y axis machining)
- Blue: Auxiliary contours
- Gray: For unresolved or incorrect but displayable elements
- Red: Selected solution, selected element or selected corner

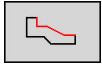


## Selection functions

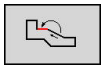
In **ICP editor** submode, the control provides various functions for selecting contour elements, form elements, contour corners and contour areas. You can call these functions by soft key.

Selected contour corners or contour elements are shown in red.

Selecting a contour area:



- ▶ Select the first element of the contour area
- ▶ Activate the area selection

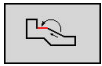


- ▶ Press the **Next element** soft key until the entire area is marked

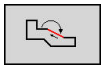


- ▶ Alternative: Press the **Previous element** soft key until the entire area is marked

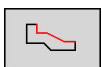
### Selecting contour elements



**Next element** (or the left arrow key) selects the next element in the direction of contour definition



**Previous element** (or the right arrow key) selects the previous element in the direction of contour definition



**Select area** activates the area selection

### Selecting contour corners (for form elements)



**Next contour corner** (or the left arrow key) selects the next corner in the direction of contour definition



**Previous contour corner** (or the right arrow key) selects the previous corner in the direction of contour definition



**Mark all corners** marks all contour corners



#### Corner selection

If the corner selecting function is active, multiple contour corners can be marked



#### Mark

If the corner selecting function is active, individual contour corners can be selected and marked or unmarked

## Datum shift

With this function, you can move a complete turning contour.

First, select the Finished part menu:



- ▶ Select the **ICP** menu item

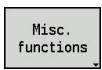


- ▶ Select the **Finished part** menu item

Activating a datum shift:



- ▶ Select the **Contour** menu item



- ▶ Press the **Misc. functions** soft key



- ▶ Select the **Datum** menu item

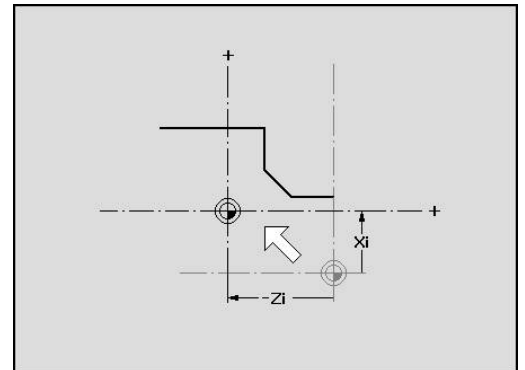


- ▶ Select the **Shift** menu item

- ▶ Enter the contour shift to move the defined contour



- ▶ Press the **Save** soft key



Deactivating a datum shift:



- ▶ Select the **Datum** menu item



- ▶ Select the **Resetting** menu item
- ▶ The control resets the origin of the coordinate system to the originally programmed position



The datum shift cannot be reset after you have exited the **ICP editor** submode. When you exit the **ICP editor** submode, the contour is recalculated with the values of the datum shift and saved. In this case, you can only reset the datum by doing a datum shift in the opposite direction.

Parameters

- **Xi: Target point** – Value by which the datum is shifted
- **Zi: Target point** – Value by which the datum is shifted

## Duplicating a contour section in linear series

With this function, you can define a contour section and append it to the existing contour.

First, select the Finished part menu:



- ▶ Select the **ICP** menu item

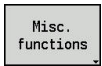


- ▶ Select the **Finished part** menu item

Duplicating:



- ▶ Select the **Contour** menu item



- ▶ Press the **Misc. functions** soft key



- ▶ Select the **Duplicate** menu item



- ▶ Select the **Linear row** menu item



- ▶ Use the **Next element** or **Previous element** soft key to select contour elements



- ▶ Press the **Select** soft key

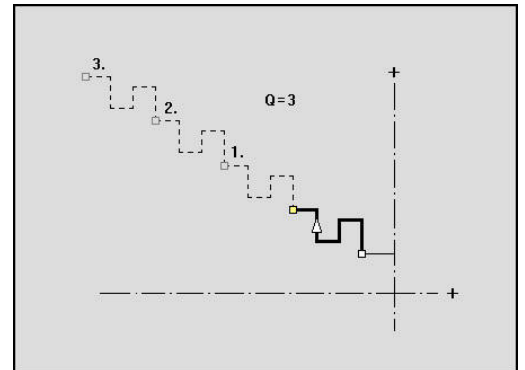
- ▶ Enter the number of repeats



- ▶ Press the **Save** soft key

Parameters

- **Q: Quantity** (number of repeats)



## Duplicating a contour section in circular series

With this function, you can define a contour section and append it to the existing contour in a circular series.

First, select the Finished part menu:



- ▶ Select the **ICP** menu item

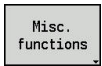


- ▶ Select the **Finished part** menu item

Duplicating:



- ▶ Select the **Contour** menu item



- ▶ Press the **Misc. functions** soft key



- ▶ Select the **Duplicate** menu item in the finished part menu



- ▶ Select the **Circular row** menu item



- ▶ Use the **Next element** or **Previous element** soft key to select contour elements



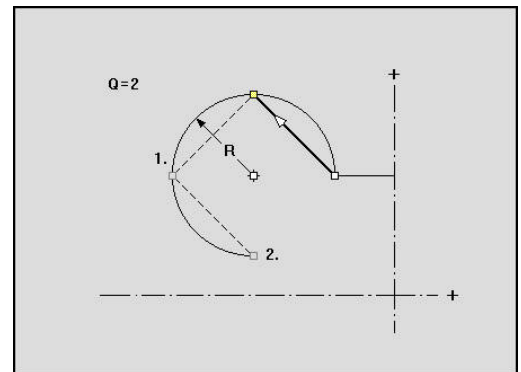
- ▶ Press the **Select** soft key
- ▶ Enter the number of repeats and the radius



- ▶ Press the **Save** soft key

Parameters

- **Q: Quantity** – The contour section is duplicated **Q** times
- **R: Radius**



The control uses the defined radius for creating circles both around the starting point and the end point of the contour section. The points of intersection of the circles define the two possible centers of rotation.

The angle of rotation is calculated from the distance between the starting point and the end point of the contour section.

Use the **next solution** or **previous solution** soft key to select one of the mathematically possible solutions.

## Duplicating a contour section by mirroring

With this function, you can define a contour section, mirror it and append it to the existing contour.

First, select the Finished part menu:



- ▶ Select the **ICP** menu item

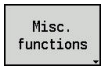


- ▶ Select the **Finished part** menu item

Duplicating:



- ▶ Select the **Contour** menu item



- ▶ Press the **Misc. functions** soft key



- ▶ Select the **Duplicate** menu item



- ▶ Select the **Mirroring** menu item



- ▶ Use the **Next element** or **Previous element** soft key to select contour elements



- ▶ Press the **Select** soft key

- ▶ Enter the angle of the mirror axis



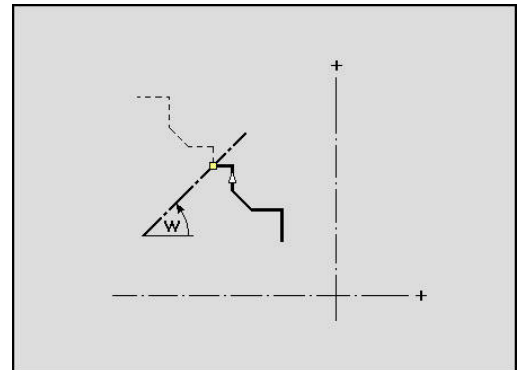
- ▶ Press the **Save** soft key

Parameters

- **W: Angle of the mirror axis** – The mirror axis intersects the current end point of the contour (angle reference: positive Z axis)

## Inverting

With the **Invert** function, you can reverse the programmed direction of a contour.



### Contour direction (cycle programming)

The cutting direction during cycle programming depends on the direction of the contour. If the contour is described in the  $-Z$  direction, a tool with the orientation 1 must be used for longitudinal machining. The cycle used determines whether machining is transverse or longitudinal.

**Further information:** "General tool parameters", Page 585

If the contour is described in the  $-X$  direction, a transverse machining cycle or a tool with the orientation 3 must be used.

- **ICP cut, longitudinal/transverse (roughing):** The control machines the workpiece in the contour direction.
- **ICP finishing, longitudinal/transverse :** The control finishes in the contour direction.

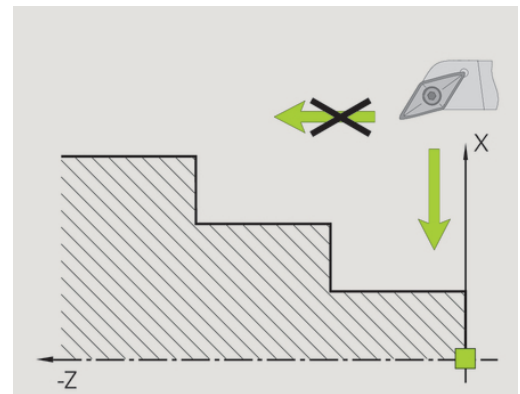
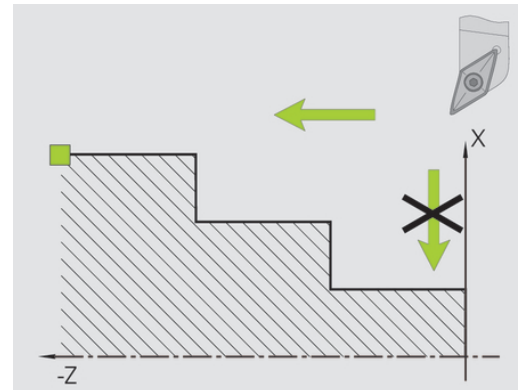


An ICP contour which was defined for a roughing operation with the ICP cycle for longitudinal cutting cannot be used for machining with the ICP cycle for transverse cutting. For this purpose, reverse the contour direction with the **Turn contour** soft key.

#### Soft keys in ICP editor submenu – Main menu

Turn  
contour

Invert the definition direction of the contour



## 6.5 Editing ICP contours

The control offers the following possibilities for extending or changing a programmed contour.

### Superimposing form elements

Superimposing form elements:



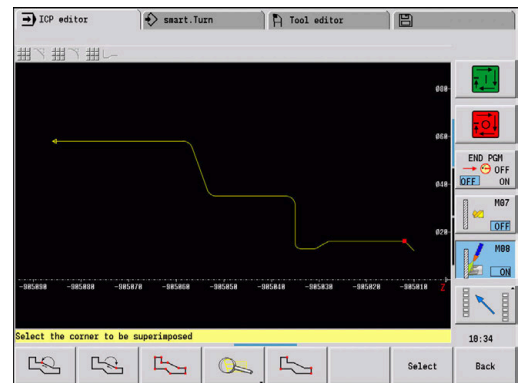
- ▶ Press the **Form elements** soft key



- ▶ Select the desired form element
- ▶ Select the corner



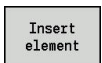
- ▶ Confirm the corner for the form element
- ▶ Enter the data for the form element



### Adding contour elements

You can **add to** an ICP contour by entering additional contour elements that are **appended** to the existing contour. A small square indicates the end of the contour and an arrow indicates the direction.

Adding contour elements:



- ▶ Press the **Insert element** soft key
- ▶ Append additional contour elements to the existing contour

## Editing or deleting the last contour element

**Editing the last contour element:** When you press the **Change last** soft key, the data of the **last** contour element is made available for editing.

Depending on the adjoining contour elements, corrections of linear or circular elements are either transferred immediately or the corrected contour is displayed for inspection. **ICP** highlights the affected contour elements in color. If there are several possible solutions, use the **next solution** and **previous solution** soft keys to check all mathematically possible solutions.

The change will not become effective until you confirm by soft key. If you discard the change, the **old** description becomes effective again.

The type of contour element (linear or circular element), the direction of a linear element, or the direction of rotation of a circular element cannot be changed. Should this be necessary, you must delete the element and add a new contour element.

**Deleting the last contour element:** When you press the **Delete last** soft key, the data of the **last** contour element is discarded. You can use this function repeatedly to delete multiple successive contour elements.

## Deleting contour elements

Deleting a contour element:



- ▶ Select the **Manipulate** menu item
- > The menu displays functions for trimming, editing and deleting contours



- ▶ Select the **Delete** menu item



- ▶ Select the **Element/range** menu item



- ▶ Select the contour element to be deleted



- ▶ Delete the contour element

You can delete several successive contour elements.



## Manipulating contour elements

The control provides various ways to change an existing contour. The procedure is illustrated in the following example of **editing the length of an element**. The other functions work similar to the procedure described here.

The **Manipulate** menu provides the following functions for editing existing contour elements:

- **Trimming**
  - **Length element**
  - **Contour length** (only for closed contours)
  - **Radius**
  - **Diameter**
- **Modify**
  - **Contour element**
  - **Form element**
- **Delete**
  - **Element/range**
  - **Move element/range as well**
  - **Contour/pocket/Figure/pattern**
  - **Form element**
  - **All form elements**
- **Transform**
  - **Shift** a contour **Shift**
  - **Turning** a contour **Turning**
  - **Mirroring** a contour: You can define the position of the mirror axis by entering the starting point and end point coordinates or the starting point coordinates and the angle

### Changing the length of the contour element

Changing the length of the contour element:



- ▶ Select the **Manipulate** menu item
- ▶ The menu displays functions for trimming, editing and deleting contours



- ▶ Select the **Modify** menu item



- ▶ Select the **Contour element** menu item



- ▶ Select the contour element to be edited



- ▶ Present the selected contour element for editing
- ▶ Make the changes



- ▶ Load the changes
- ▶ The contour or the possible solutions are displayed for inspection. Changes in form elements and unresolved elements are loaded immediately (original contour in yellow, changed contour in red for comparison)



- ▶ Load the desired solution

### Changing the paraxial line

When **changing** a paraxial line, an additional soft key is offered with which you can change the second end point as well. From an originally straight line you can make a diagonal in order to make corrections.

Changing the paraxial line:



- ▶ Change the **fixed** end point. By selecting the menu item repeatedly, you can select the direction of the diagonal

### Shifting a contour

Shifting a contour:



- ▶ Select the **Manipulate** menu item
- ▶ The menu displays functions for trimming, editing and deleting contours



- ▶ Select the **Modify** menu item



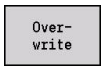
- ▶ Select the **Contour element** menu item



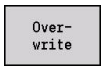
- ▶ Select the contour element to be edited



- ▶ Present the selected contour element for shifting
- ▶ Enter the new **Start point** of the reference element



- ▶ Load the new **Start point** (= new position)
- ▶ The control displays the **shifted contour**



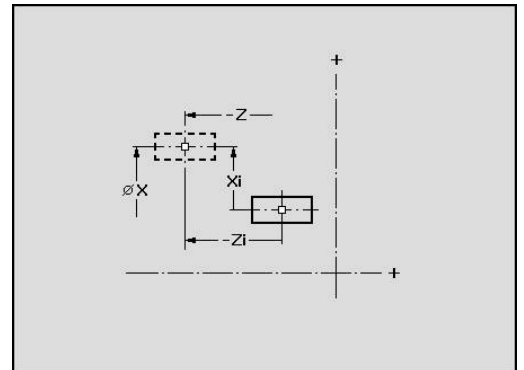
- ▶ Confirm the new position for the contour

### Transformations – Shifting

With this function, you can move a contour by entering incremental or absolute coordinates.

Parameters:

- **X: Target point**
- **Z: Target point**
- **Xi: Target point** (incremental)
- **Zi: Target point** (incremental)
- **H: Master** (only for C-axis contours)
  - **0: Delete:** Delete the master contour
  - **1: Copy:** Retain the master contour
- **ID: Contour** (only for C-axis contours)

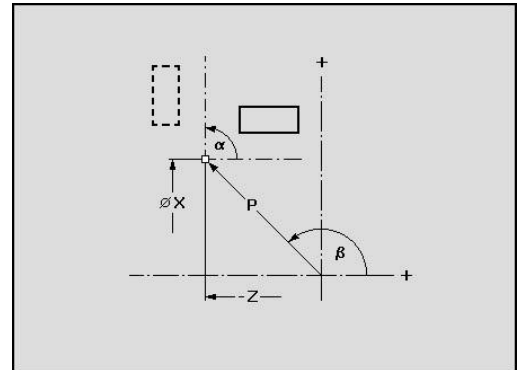


### Transformations – Rotating

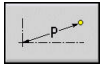
With this function you can rotate a contour about a center of rotation.

Parameters:

- **X: Center of rotation** (in Cartesian coordinates)
- **Z: Center of rotation** (in Cartesian coordinates)
- **W: Center of rotation** (in polar coordinates)
- **P: Center of rotation** (in polar coordinates)
- **A: Rotary angle**
- **H: Master** (only for C-axis contours)
  - **0: Delete:** Delete the master contour
  - **1: Copy:** Retain the master contour
- **ID: Contour** (only for C-axis contours)



### Soft keys



Polar dimension of the center of rotation:  
Angle



Polar dimension of the center of rotation:  
Radius

### Transformations – Mirroring

This function mirrors the contour. Define the position of the **mirror axis** by entering the starting point and end point or the starting point and angle.

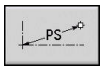
Parameters:

- **XS: Start point** (in Cartesian coordinates)
- **ZS: Start point** (in Cartesian coordinates)
- **X: Target point** (in Cartesian coordinates)
- **Z: Target point** (in Cartesian coordinates)
- **A: Angle** – Angle of rotation
- **WS: Start point** (in polar coordinates)
- **PS: Start point** (in polar coordinates)
- **W: Target point** (in polar coordinates)
- **P: Target point** (in polar coordinates)
- **H: Master** (only for C-axis contours)
  - **0: Delete:** Delete the master contour
  - **1: Copy:** Retain the master contour
- **ID: Contour** (only for C-axis contours)

#### Soft keys for polar dimensions



Polar dimension of the starting point: Angle



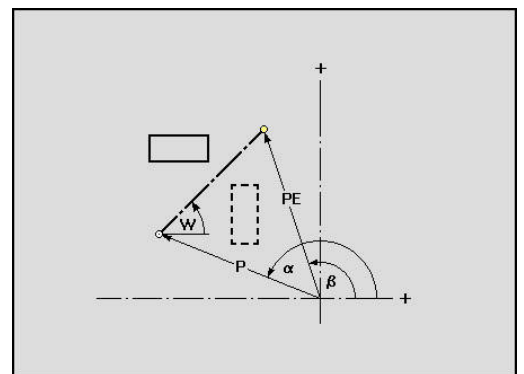
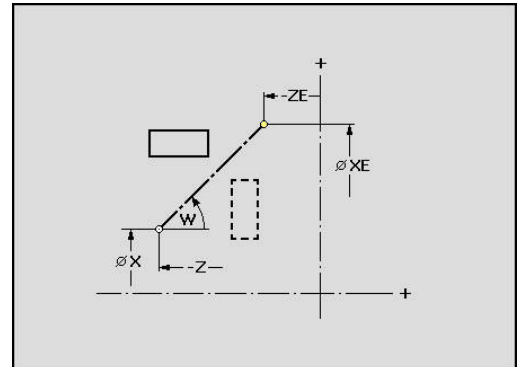
Polar dimension of the starting point: Radius



Polar dimension of the end point: Angle



Polar dimension of the end point: Radius



## 6.6 Zoom functions in ICP editor submodelCP editor

The zoom functions make it possible to change the visible detail by using soft keys, the arrow keys, and the **PgUp** and **PgDn** keys. The **zoom** function can be called in all ICP windows.

The control sizes the detail depending on the programmed contour. With the zoom function you can select another detail.

### Changing the detail

Modifying the detail by using keys:

- ▶ The visible section can be modified with the arrow keys, and the **PgDn** and **PgUp** keys without opening the zoom menu

#### Keys for modifying the displayed detail



The arrow keys move the workpiece in the indicated direction



PG DN

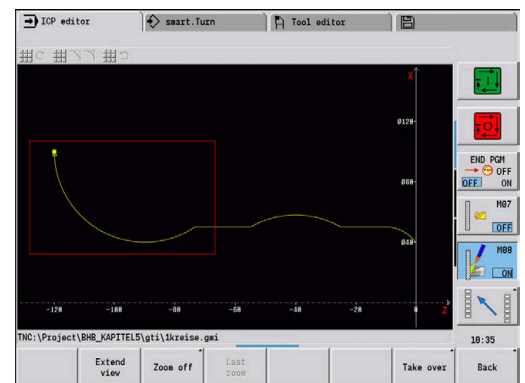
Magnify the displayed frame (zoom -)

PG UP

Reduce the displayed frame (zoom +)

Modifying the detail with the zoom menu:

- ▶ When you activate the zoom menu, a red frame is shown in the contour window. This red frame indicates the zoom area, which you can select using the **Apply** soft key or the **ENT** key. Use the following keys to change the frame size and position.



---

### Keys for modifying the displayed detail

---



The arrow keys move the frame in the indicated direction



PG DN

Reduce the displayed frame (zoom +)

PG UP

Magnify the displayed frame (zoom -)

---

### Soft keys in the zoom menu

---



Activate the zoom functions

Extend view

Magnify the displayed detail directly (zoom -)

Zoom off

Switch back to the standard screen detail and close the zoom menu

Last zoom

Return to the last screen detail selected

Take over

Load the area selected by the red frame as the new detail and close the zoom menu

Back

Close the zoom menu without changing the selected detail

## 6.7 Workpiece blank definition

In **smart.Turn** mode of operation, the standard forms **Bar** and **Tube** are described with a G code.

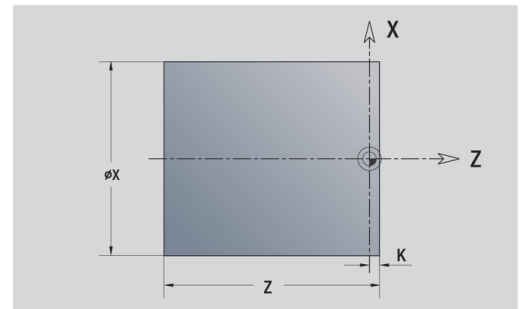
### Workpiece blank – bar

The function describes a cylinder.

Parameters:

- **X: Diameter** of cylinder
- **Z: Length** of workpiece blank
- **K: Oversz** – Distance between workpiece datum and right edge

ICP generates a **G20** in the **BLANK** section in **smart.Turn** mode of operation.



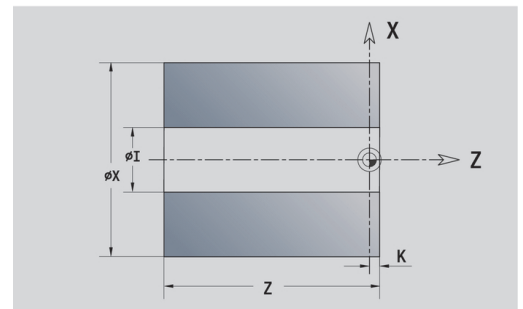
### Workpiece blank – tube

The function describes a hollow cylinder.

Parameters:

- **X: Outside diameter** – Diameter of hollow cylinder
- **I: Inner diameter (pipe)**
- **Z: Length** of workpiece blank
- **K: Oversz** – Distance between workpiece datum and right edge

ICP generates a **G20** in the **BLANK** section in **smart.Turn** mode of operation.



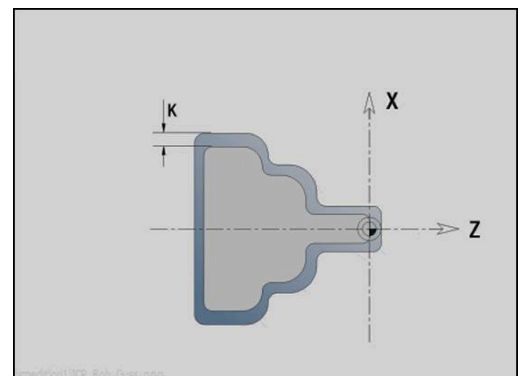
### Workpiece blank – Cast part

The function describes an oversize on an existing finished part contour.

Parameters:

- **K: Contour-parallel oversize**

ICP generates a contour in the **BLANK** section in **smart.Turn** mode of operation.





## 6.8 Contour elements – turning contour

With the contour elements of a turning contour you can create the following:

- In **Teach-in** submode **Teach-in**
  - Complex workpiece blank contours
  - Contours for turning
- In **smart.Turn** mode of operation
  - Complex workpiece blank contours and auxiliary workpiece blank contours
  - Finished part contours and auxiliary contours

### Basic turning contour elements

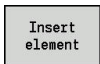
#### Defining the starting point

Enter the coordinates for the starting point and target point in the first contour element of the turning contour. Entering the starting point is only possible in the first contour element. In subsequent contour elements, the starting point results from the previous contour element in each case.

Defining the starting point:



- ▶ Select the **Contour** menu item



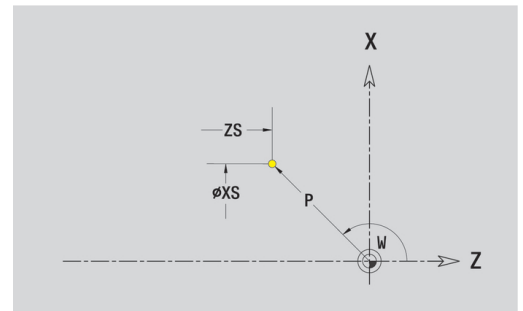
- ▶ Alternative: Press the **Insert element** soft key

- ▶ Select the contour element

Parameters for defining the starting point:

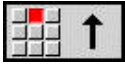
- **XS, ZS:** **Start point** of contour
- **WS:** **Starting point** of contour (angle in polar coordinates)
- **PS:** **Starting point** of contour (radius in polar coordinates)

ICP generates a **G0** in **smart.Turn** mode of operation.



### Vertical lines

Programming a vertical line:

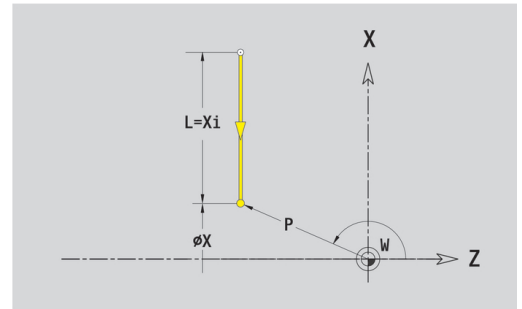


- ▶ Select the line direction
- ▶ Enter the line dimensions
- ▶ Define the transition to the next contour element

Parameters:

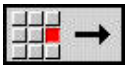
- **X: Target point**
- **Xi: Target point** (incremental)
- **W: Target point** (angle in polar coordinates)
- **P: Target point** (radius in polar coordinates)
- **L: Line length**
- **U, F, D, FP, IC, KC, HC:**  
**Further information:** "Machining attributes", Page 426

ICP generates a **G1** in **smart.Turn** mode of operation.



### Horizontal lines

Programming a horizontal line:

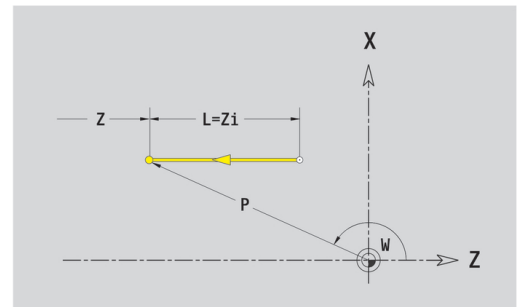


- ▶ Select the line direction
- ▶ Enter the line dimensions
- ▶ Define the transition to the next contour element

Parameters:

- **Z: Target point**
- **Zi: Target point** (incremental)
- **W: Target point** (angle in polar coordinates)
- **P: Target point** (radius in polar coordinates)
- **L: Line length**
- **U, F, D, FP, IC, KC, HC:**  
**Further information:** "Machining attributes", Page 426

ICP generates a **G1** in **smart.Turn** mode of operation.



### Line at angle

Programming a line at an angle:



- ▶ Select the line direction
- ▶ Enter the line dimensions
- ▶ Define the transition to the next contour element

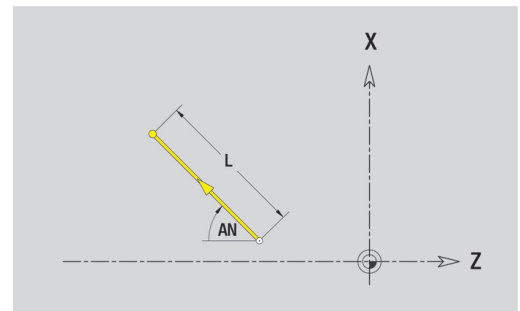
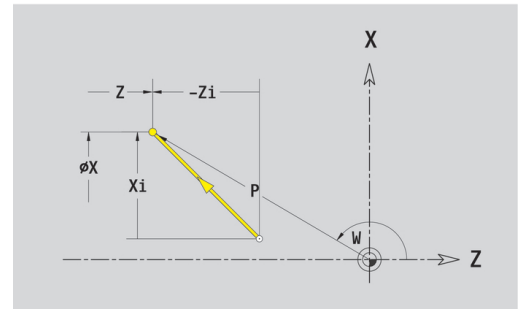
Always enter the angle **AN** within the selected quadrant ( $\leq 90^\circ$ ).

Parameters:

- **X, Z:** Target point
- **Xi, Zi:** Target point (incremental)
- **W:** Target point (angle in polar coordinates)
- **P:** Target point (radius in polar coordinates)
- **L:** Line length
- **AN:** Angle to Z axis
- **ANn:** Angle to Z axis – Angle to the subsequent element
- **ANp:** Angle to Z axis – Angle to the previous element
- **U, F, D, FP, IC, KC, HC:**

**Further information:** "Machining attributes", Page 426

ICP generates a **G1** in **smart.Turn** mode of operation.



### Circular arc

Programming a circular arc:



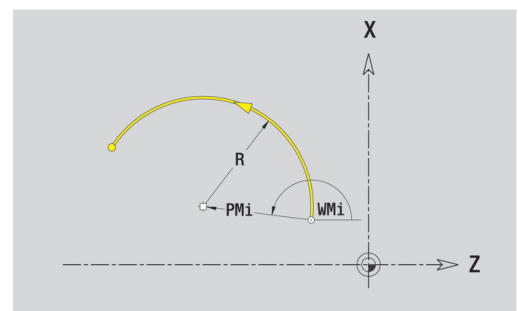
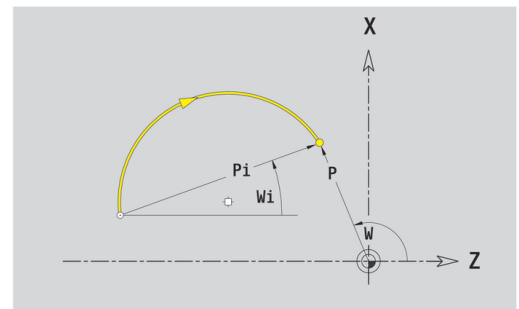
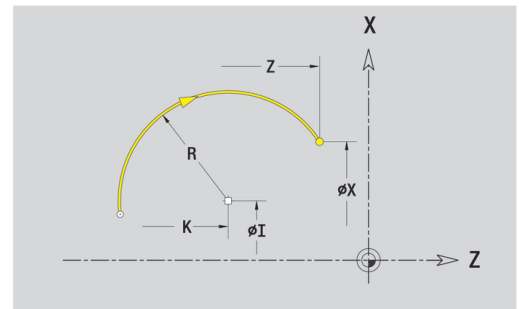
- ▶ Select the arc's direction of rotation
- ▶ Enter the arc dimensions
- ▶ Define the transition to the next contour element

Parameters:

- **X, Z: Target point**
- **Xi, Zi: Target point** (incremental)
- **W: Target point** (angle in polar coordinates)
- **Wi: Target point** (polar angle, incremental; reference: starting point)
- **P: Target point** (radius in polar coordinates)
- **Pi: Target point** – Distance between starting point and target point (polar, incremental)
- **I, K: Center point** of circular arc
- **Ii, Ki: Center point** of circular arc (incremental) – Distance between starting point and center in **X** and **Z**
- **PM: Center point** of circular arc (radius in polar coordinates)
- **PMi: Center point** of circular arc – Distance between starting point and **Center point** (polar, incremental)
- **WM: Center point** of circular arc (polar angle)
- **WMi: Center point** of circular arc (polar angle, incremental; reference: starting point)
- **R: Radius**
- **ANs: Angle** – Tangential angle at the starting point
- **ANe: Angle** – Tangential angle at the target point
- **ANn: Angle** to the subsequent element
- **ANp: Angle** to the previous element
- **U, F, D, FP:**

**Further information:** "Machining attributes", Page 426

ICP generates a **G2** or **G3** in **smart.Turn** mode of operation.



## Turning contour form elements

### Chamfer or rounding

Programming a chamfer or rounding:



- ▶ Select the Form Elements menu item



- ▶ Select the Chamfer menu item



- ▶ Enter the **Cham. width BR**
- ▶ Alternative: Select the Rounding menu item
- ▶ Enter the **Rounding radius BR**
- ▶ Enter the **Rounding radius BR**
- ▶ Enter the chamfer or rounding as first contour element: **Element pos AN**

Parameters:

- **BR: Cham. width** or **Rounding radius**
- **AN: Element pos**
- **U, F, D, FP:**  
**Further information:** "Machining attributes", Page 426

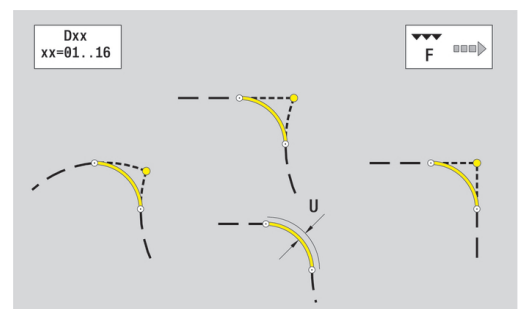
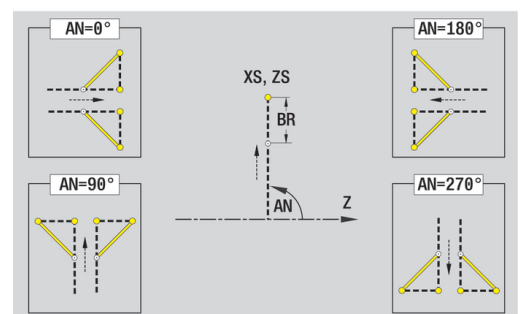
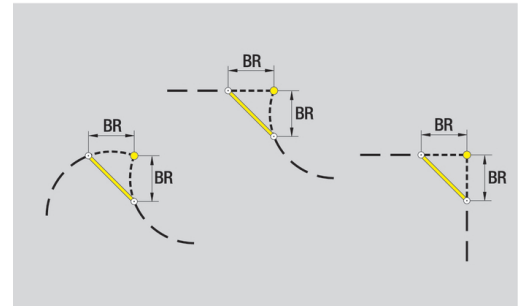
Chamfers or roundings are defined at contour corners. A **contour corner** is the point of intersection between the approaching contour element and the departing contour element. A chamfer or rounding cannot be calculated until the basic contour element is known.

ICP integrates the chamfer or rounding in the **G1, G2** or **G3** basic element in **smart.Turn** mode of operation.

**Contour begins with a chamfer or a rounding:** Enter the position of the **intended** corner as starting point. Then, in the form element menu, select Chamfer or Rounding. Since the **approaching contour element** is missing, you enter the **element position AN** to clearly define the position of the chamfer or rounding radius.

**Example of an outside chamfer at start of contour:** If you program **Element pos AN=90°**, the intended reference element is a planar element in the positive **+ X direction**.

ICP converts a chamfer or rounding at the start of the contour to a linear or circular element.



### Undercut DIN 76

Programming a thread undercut DIN 76:



- ▶ Select the form elements



- ▶ Select **Undercut DIN 76**

- ▶ Enter the undercut parameters

Parameters:

- **FP: Thread pitch** (default: value from standard table)
- **I: Undercut depth** (default: value from standard table)
- **K: Undercut length** (default: standard table)
- **R: Undercut radius** (default: standard table)
- **W: Undercut angle** (default: value from standard table)
- **U, F, D, DF:**

**Further information:** "Machining attributes", Page 426

ICP generates a **G25** in **smart.Turn** mode of operation.

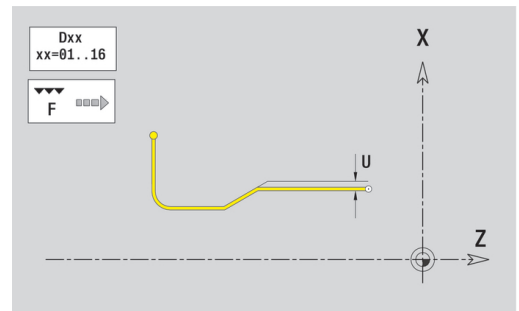
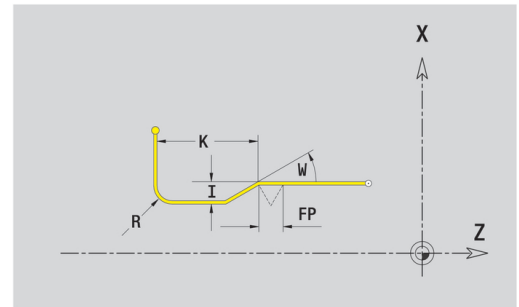
Parameters that are not defined are automatically calculated by the control from the standard table:

- The **Thread pitch FP** is calculated from the diameter
- The parameters **I, K, W** and **R** are calculated from the **Thread pitch FP**

**Further information:** "DIN 76 – undercut parameters", Page 757



- If you are programming an internal thread, it is advisable to preset the **Thread pitch FP**, since the diameter of the longitudinal element is not the thread diameter. If you have the control calculate the thread pitch automatically, slight deviations may occur.
- Undercuts can be programmed only between two linear elements. One of the two linear elements must be parallel to the X axis.



### Undercut DIN 509 E

Programming a DIN 509 E undercut:



- ▶ Select the form elements



- ▶ Select **Undercut DIN 509 E**

- ▶ Enter the undercut parameters

Parameters:

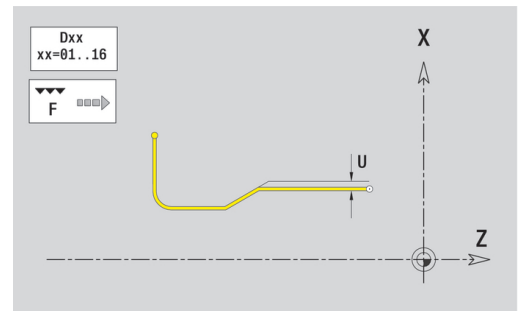
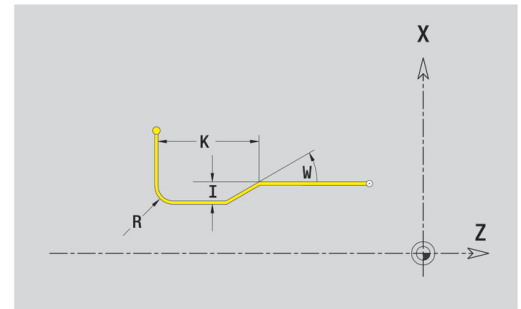
- **I: Undercut depth** (default: value from standard table)
- **K: Undercut length** (default: standard table)
- **R: Undercut radius** (default: standard table)
- **W: Undercut angle** (default: value from standard table)
- **U, F, D, DF:**

**Further information:** "Machining attributes", Page 426

ICP generates a **G25** in **smart.Turn** mode of operation.

The control automatically calculates parameters that have not been entered from the diameter in the standard table.

**Further information:** "DIN 509 E – undercut parameters", Page 758



Undercuts can be programmed only between two linear elements. One of the two linear elements must be parallel to the X axis.

### Undercut DIN 509 F

Programming a DIN 509 F undercut:



- ▶ Select the form elements



- ▶ Select **Undercut DIN 509 F**

- ▶ Enter the undercut parameters

Parameters:

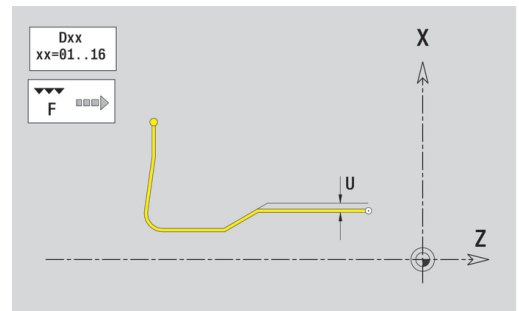
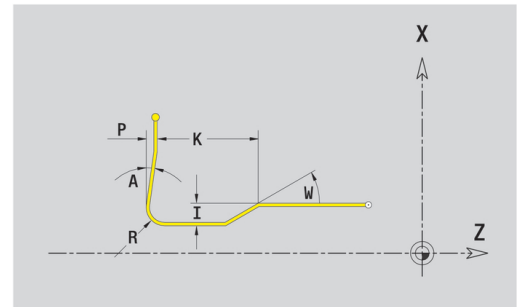
- **I: Undercut depth** (default: value from standard table)
- **K: Undercut length** (default: standard table)
- **R: Undercut radius** (default: standard table)
- **W: Undercut angle** (default: value from standard table)
- **P: Trav.dpth** (default: Value from standard table)
- **A: Face angle** (default: standard table)
- **U, F, D, DF:**

**Further information:** "Machining attributes", Page 426

ICP generates a **G25** in **smart.Turn** mode of operation.

The control automatically calculates parameters that have not been entered from the diameter in the standard table.

**Further information:** "DIN 509 F – undercut parameters", Page 758



Undercuts can be programmed only between two linear elements. One of the two linear elements must be parallel to the X axis.



### Undercut form U

Programming an undercut form U:



- ▶ Select the form elements



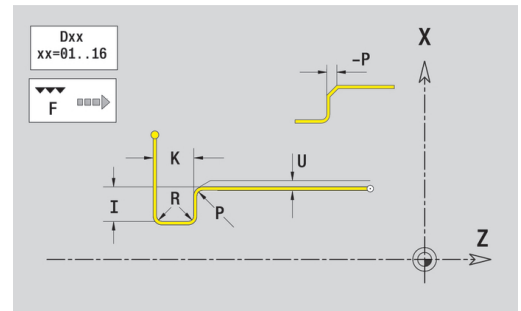
- ▶ Select **Undercut form U**

- ▶ Enter the undercut parameters

Parameters:

- **I: Undercut depth**
- **K: Length**
- **R: Undercut radius**
- **P: Chamf./round.**
- **U, F, D, DF:**  
**Further information:** "Machining attributes", Page 426

ICP generates a **G25** in **smart.Turn** mode of operation.



Undercuts can be programmed only between two linear elements. One of the two linear elements must be parallel to the X axis.

### Undercut form H

Programming an undercut form H:



- ▶ Select the form elements



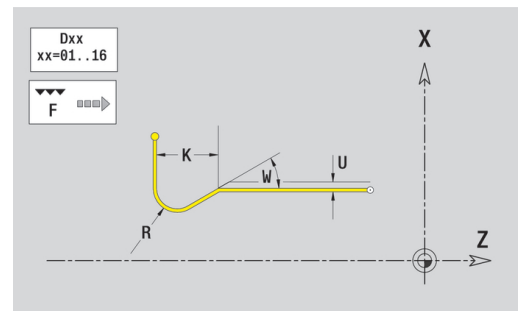
- ▶ Select **Undercut form H**

- ▶ Enter the undercut parameters

Parameters:

- **K: Length**
- **R: Undercut radius**
- **W: Plunging angle**
- **U, F, D, DF:**  
**Further information:** "Machining attributes", Page 426

ICP generates a **G25** in **smart.Turn** mode of operation.



Undercuts can be programmed only between two linear elements. One of the two linear elements must be parallel to the X axis.

### Undercut form K

Programming an undercut form K:



- ▶ Select the form elements



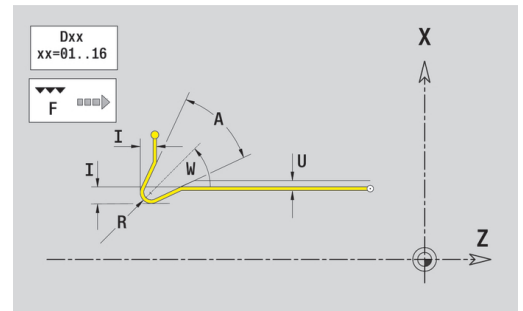
- ▶ Select **Undercut form K**

- ▶ Enter the undercut parameters

Parameters:

- **I: Undercut depth**
- **R: Undercut radius**
- **W: Opening angle**
- **A: Plunging angle**
- **U, F, D, DF:**  
**Further information:** "Machining attributes", Page 426

ICP generates a **G25** in **smart.Turn** mode of operation.



Undercuts can be programmed only between two linear elements. One of the two linear elements must be parallel to the X axis.

## 6.9 Contour elements – front face

With the contour elements of a face you can create complex milling contours.

- In **Teach-in** submode: Contours for axial ICP milling cycles
- In **smart.Turn** mode of operation: Contours for machining with the C axis

Enter the dimensions of the front face contour elements in Cartesian or polar coordinates. You can switch between them by soft key. You can mix Cartesian coordinates and polar coordinates to define a point.

---

### Soft keys for polar coordinates

---



Switch the field to entering the angle **C**



Switch the field to entering the radius **P**

## Basic elements of face

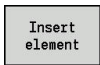
### Starting point of face contour

Enter the coordinates for the starting point and target point in the first contour element. Entering the starting point is only possible in the first contour element. In subsequent contour elements, the starting point results from the previous contour element in each case.

Defining the starting point:



- ▶ Select the **Contour** menu item



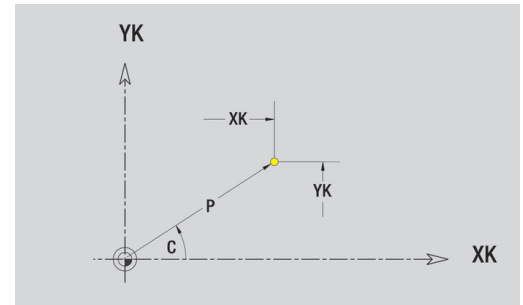
- ▶ Alternative: Press the **Insert element** soft key

- ▶ Define the starting point

Parameters for defining the starting point:

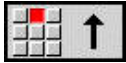
- **XKS, YKS: Starting point** of contour
- **CS: Starting point** of contour (angle in polar coordinates)
- **PS: Starting point** of contour (radius in polar coordinates)
- **HC: Milling/drilling attribute**
  - **1: Contour milling**
  - **2: Pocket milling**
  - **3: Area milling**
  - **4: Deburring**
  - **5: Engraving**
  - **6: Contour + deburring**
  - **7: Pocket + deburring**
  - **14: Do not machine**
- **QF: Cutter position**
  - **0: On the contour**
  - **1: Inside / left**
  - **2: Outside / right**
- **HF: Direction**
  - **0: Up-cut**
  - **1: Climb**
- **DF: Milling diameter**
- **WF: Angle** of chamfer
- **BR: Chamfer width**
- **RB: Return plane**

ICP generates a **G100** in **smart.Turn** mode of operation.



### Vertical lines on front face

Programming vertical lines:



- ▶ Select the line direction
- ▶ Enter the line dimensions
- ▶ Define the transition to the next contour element

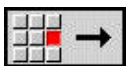
Parameters:

- **YK: Target point** (in Cartesian coordinates)
- **YKi: Target point** (incremental) – Distance between starting point and **Target point**
- **C: Target point** (polar angle)
- **P: Target point** (in polar coordinates)
- **L: Line length**
- **F: Further information:** "Machining attributes", Page 426

ICP generates a **G101** in **smart.Turn** mode of operation.

### Horizontal lines on front face

Programming horizontal lines:

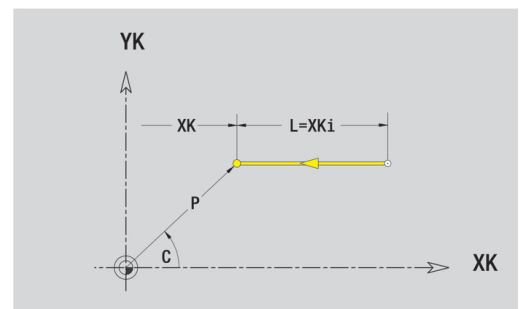
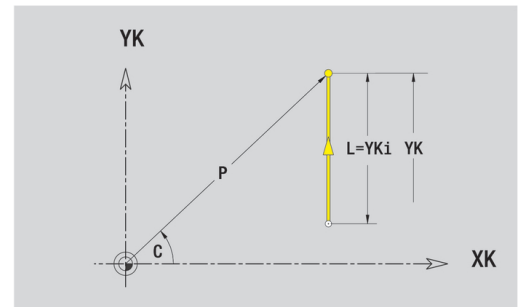


- ▶ Select the line direction
- ▶ Enter the line dimensions
- ▶ Define the transition to the next contour element

Parameters:

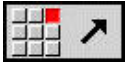
- **XK: Target point** (in Cartesian coordinates)
- **XKi: Target point** (incremental) – Distance between starting point and **Target point**
- **C: Target point** (polar angle)
- **P: Target point** (in polar coordinates)
- **L: Line length**
- **F: Further information:** "Machining attributes", Page 426

ICP generates a **G101** in **smart.Turn** mode of operation.



### Line at angle on front face

Programming a line at an angle:

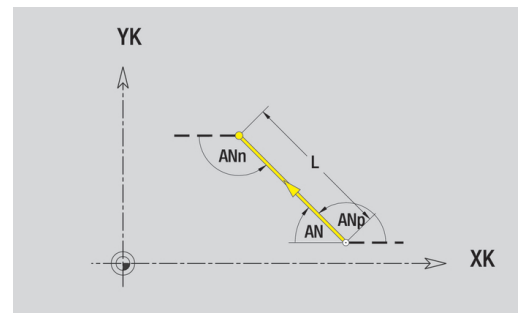
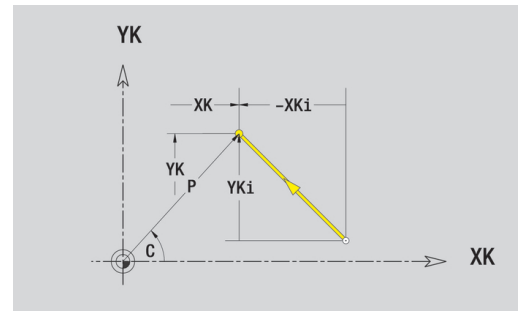


- ▶ Select the line direction
- ▶ Enter the line dimensions
- ▶ Define the transition to the next contour element

Parameters:

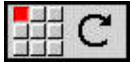
- **XK, YK: Target point** (in Cartesian coordinates)
- **XKi, YKi: Target point** (incremental) – Distance between starting point and **Target point**
- **C: Target point** (polar angle)
- **P: Target point** (in polar coordinates)
- **L: Line length**
- **AN: Angle** to positive XK axis
- **ANn: Angle** to the subsequent element
- **ANp: Angle** to the previous element
- **F: Further information:** "Machining attributes", Page 426

ICP generates a **G101** in **smart.Turn** mode of operation.



### Circular arc on front face

Programming a circular arc:

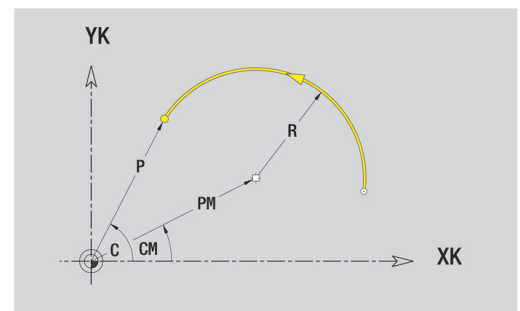
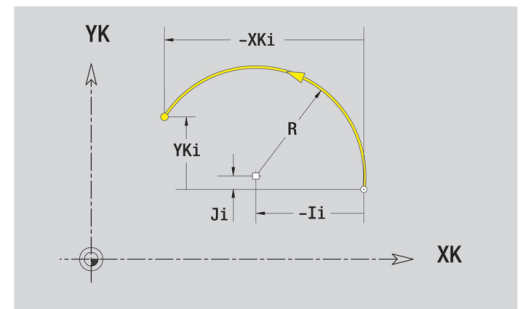
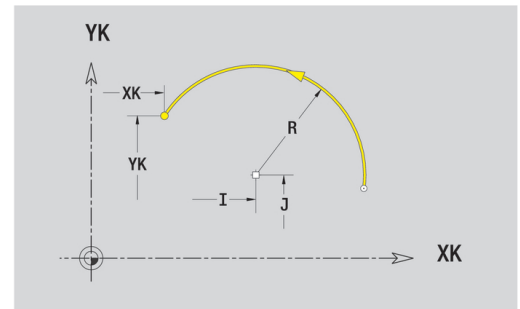


- ▶ Select the arc's direction of rotation
- ▶ Enter the arc dimensions
- ▶ Define the transition to the next contour element

Parameters:

- **XK, YK: Target point** – End point of circular arc
- **XKi, YKi: Target point** (incremental) – Distance between starting point and **Target point**
- **P: Target point** (in polar coordinates)
- **Pi: Target point** – Distance between starting point and target point (polar, incremental)
- **C: Target point** (polar angle)
- **Ci: Target point** (polar angle, incremental; reference: starting point)
- **I, J: Center point** of circular arc
- **Ii, Ji: Center point** of circular arc (incremental) – Distance between starting point and **Center point** in **X** and **Z**
- **PM: Center point** of circular arc (polar)
- **PMi: Center point** of circular arc – Distance between starting point and **Center point** (polar, incremental)
- **CM: Center point** of circular arc (polar angle)
- **CMi: Center point** of circular arc (polar angle, incremental; reference: starting point)
- **R: Radius**
- **ANs: Angle** – Tangential angle at the starting point
- **ANe: Angle** – Tangential angle at the target point
- **ANn: Angle** to the subsequent element
- **ANp: Angle** to the previous element
- **F: Further information:** "Machining attributes", Page 426

ICP generates a **G102** or **G103** in **smart.Turn** mode of operation.



## Form elements of face

### Chamfer or rounding on front face

Programming a chamfer or rounding radius:



- ▶ Select the Form Elements menu item



- ▶ Select the Chamfer menu item

- ▶ Enter the **Cham. width BR**



- ▶ Alternative: Select the Rounding menu item

- ▶ Enter the **Rounding radius BR**

- ▶ Enter the chamfer or rounding as first contour element: **Element pos AN**

Parameters:

- **BR: Cham. width** or **Rounding radius**
- **AN: Element pos**
- **F: Further information:** "Machining attributes", Page 426

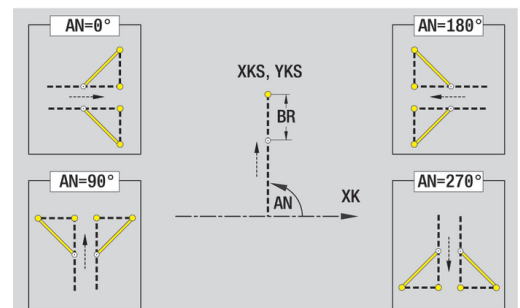
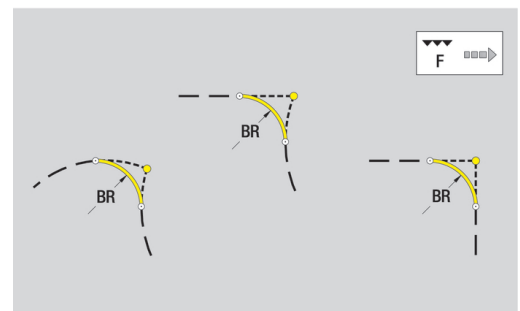
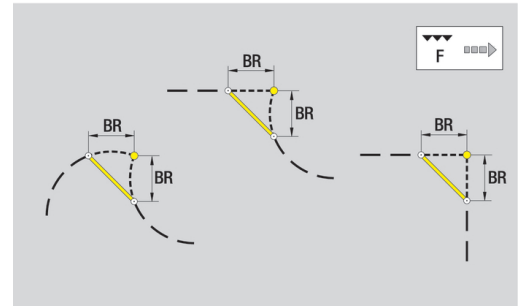
Chamfers or roundings are defined at contour corners. A **contour corner** is the point of intersection between the approaching contour element and the departing contour element. A chamfer or rounding cannot be calculated until the basic contour element is known.

**ICP** integrates the chamfer or rounding in the **G101**, **G102** or **G103** basic element in **smart.Turn** mode of operation.

**Contour begins with a chamfer or a rounding:** Enter the position of the **intended** corner as starting point. Then, in the form element menu, select Chamfer or Rounding. Since the **approaching contour element** is missing, you enter the **Element pos AN** to clearly define the position of the chamfer or rounding.

**Example of an outside chamfer at start of contour:** If you program **Element pos AN=90°**, the intended approaching reference element is a transverse element in the positive **+ X direction**.

**ICP** converts a chamfer or rounding at the start of the contour to a linear or circular element.





## 6.10 Contour elements on lateral surface

With the contour elements of a lateral surface you can create complex milling contours.

- In **Teach-in** submode: Contours for radial ICP milling cycles
- In **smart.Turn** mode of operation: Contours for machining with the C axis

Enter the dimensions of the lateral surface contour elements in Cartesian or polar coordinates. You can use the linear dimension as an alternative to the angular dimension. You can switch between them by soft key.



The linear dimension is essentially the unrolled surface at the reference diameter.

- For lateral surface contours, the reference diameter is specified in the cycle. The linear dimensions of all subsequent contour elements are referenced to this diameter
- When called from **smart.Turn** mode of operation, the reference diameter in the reference data is requested

### Soft keys for polar coordinates



Switch the field from linear dimensions to entry of the angle **C**



Switch the field to entering the polar dimension **P**

## Basic elements of lateral surface

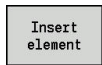
### Starting point of lateral surface contour

Enter the coordinates for the starting point and target point in the first contour element. Entering the starting point is only possible in the first contour element. In subsequent contour elements, the starting point results from the previous contour element in each case.

Defining the starting point:



- ▶ Select the **Contour** menu item



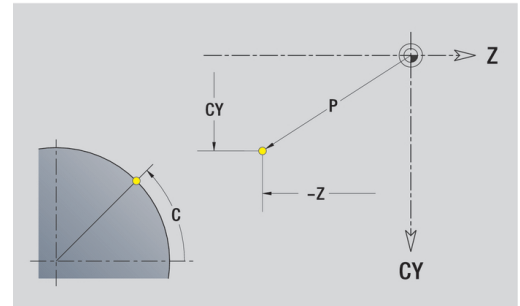
- ▶ Alternative: Press the **Insert element** soft key

- ▶ Define the starting point

Parameters for defining the starting point:

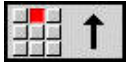
- **ZS: Starting point** of contour
- **CYS: Starting point** of contour as linear dimension (reference: diameter **XS**)
- **PS: Starting point** of contour (radius in polar coordinates)
- **PS: Starting point** of contour (polar)
- **HC: Milling/drilling attribute**
  - 1: Contour milling
  - 2: Pocket milling
  - 3: Area milling
  - 4: Deburring
  - 5: Engraving
  - 6: Contour + deburring
  - 7: Pocket + deburring
  - 14: Do not machine
- **QF: Cutter position**
  - 0: On the contour
  - 1: Inside / left
  - 2: Outside / right
- **HF: Direction**
  - 0: Up-cut
  - 1: Climb
- **DF: Milling diameter**
- **WF: Angle** of chamfer
- **BR: Chamfer width**
- **RB: Return plane**

ICP generates a **G110** in **smart.Turn** mode of operation.



### Vertical lines on lateral surface

Programming vertical lines:



- ▶ Select the line direction
- ▶ Enter the line dimensions
- ▶ Define the transition to the next contour element

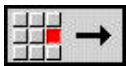
Parameters:

- **CY: Target point** as linear dimension (reference: diameter **XS**)
- **CYi: Target point** (incremental) as linear dimension (reference: diameter **XS**)
- **C: Target point** (angle in polar coordinates)
- **P: Target point** (in polar coordinates)
- **L: Line length**
- **F: Further information:** "Machining attributes", Page 426

ICP generates a **G111** in **smart.Turn** mode of operation.

### Horizontal lines on lateral surface

Programming horizontal lines:

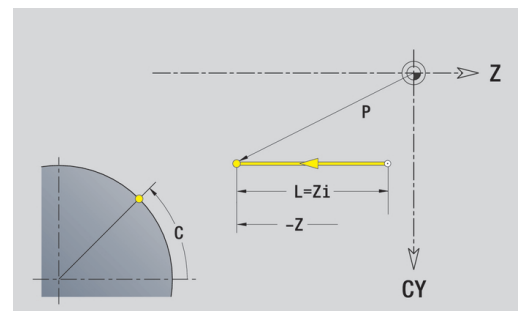
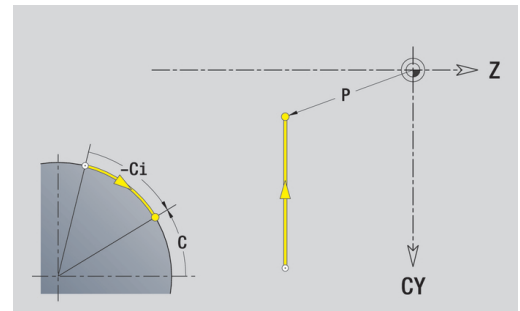


- ▶ Select the line direction
- ▶ Enter the line dimensions
- ▶ Define the transition to the next contour element

Parameters:

- **Z: Target point**
- **Zi: Target point** (incremental)
- **P: Target point** (in polar coordinates)
- **L: Line length**
- **F: Further information:** "Machining attributes", Page 426

ICP generates a **G111** in **smart.Turn** mode of operation.



### Line at angle on lateral surface

Programming a line at an angle:

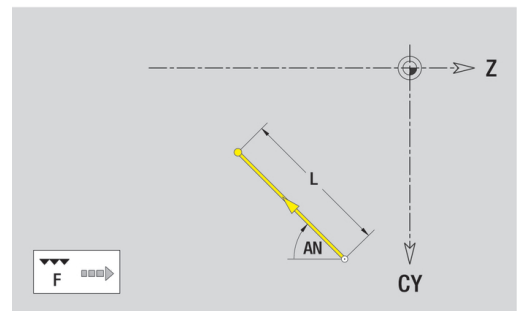
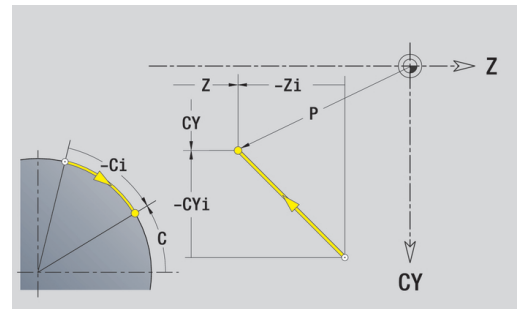


- ▶ Select the line direction
- ▶ Enter the line dimensions
- ▶ Define the transition to the next contour element

Parameters:

- **Z: Target point**
- **Zi: Target point** (incremental)
- **CY: Target point** as linear dimension (reference: diameter **XS**)
- **CYi: Target point** (incremental) as linear dimension (reference: diameter **XS**)
- **P: Target point** (in polar coordinates)
- **C: Target point** (angle in polar coordinates)
- **Ci: Target point** (polar angle, incremental)
- **AN: Angle** to the Z axis (for direction of angle, see help graphics)
- **ANn: Angle** to the subsequent element
- **ANp: Angle** to the previous element
- **L: Line length**
- **F: Further information:** "Machining attributes", Page 426

ICP generates a **G111** in **smart.Turn** mode of operation.



### Circular arc on lateral surface

Programming a circular arc:

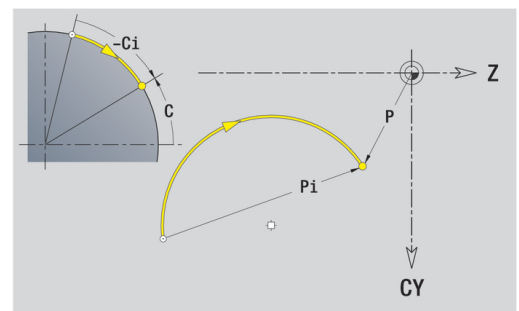
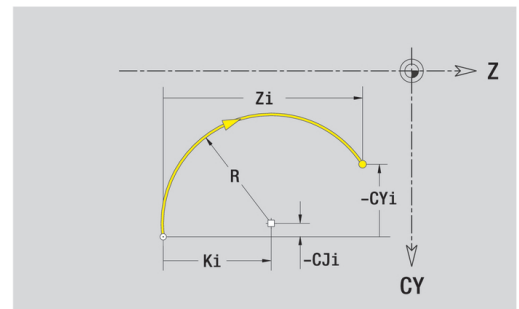
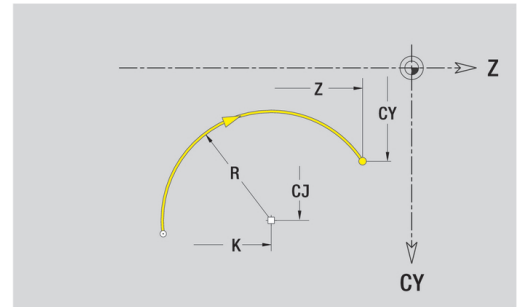


- ▶ Select the arc's direction of rotation
- ▶ Enter the arc dimensions
- ▶ Define the transition to the next contour element

Parameters:

- **Z:** Target point
- **Zi:** Target point (incremental)
- **CY:** Target point as linear dimension (reference: diameter **XS**)
- **CYi:** Target point (incremental) as linear dimension (reference: diameter **XS**)
- **P:** Target point (in polar coordinates)
- **Pi:** Target point – Distance between starting point and target point (polar, incremental)
- **C:** Target point (angle in polar coordinates)
- **Ci:** Target point (angle in incremental polar coordinates)
- **K:** Center point in **Z**
- **Ki:** Center point (incremental; in **Z**)
- **CJ:** Center point as linear dimension (reference: diameter **XS**)
- **CJi:** Center point (incremental) as linear dimension (reference: diameter **XS**)
- **PM:** Center point of circular arc (polar)
- **PMi:** Center point of circular arc – Distance between starting point and Center point (polar, incremental)
- **WM:** Center point of circular arc (polar angle)
- **WMi:** Center point of circular arc (polar angle, incremental; reference: starting point)
- **R:** Radius
- **ANs:** Angle – Tangential angle at the starting point
- **ANe:** Angle – Tangential angle at the target point
- **ANn:** Angle to the subsequent element
- **ANp:** Angle to the previous element
- **L:** Line length
- **F:** Further information: "Machining attributes", Page 426

ICP generates a **G112** or **G113** in **smart.Turn** mode of operation.



## Form elements of lateral surface

### Chamfer or rounding on lateral surface

Programming a chamfer or rounding radius:



- ▶ Select the Form Elements menu item



- ▶ Select the Chamfer menu item

- ▶ Enter the **Cham. width BR**

- ▶ Alternative: Select the Rounding menu item



- ▶ Enter the **Rounding radius BR**

- ▶ Enter the chamfer or rounding radius as first contour element: **Element pos AN**

Parameters:

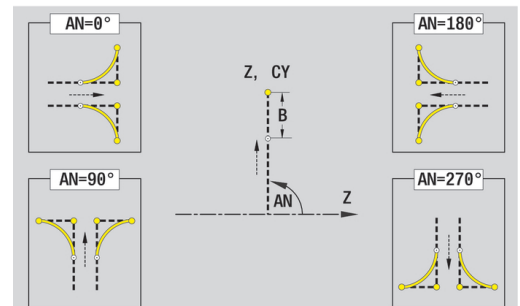
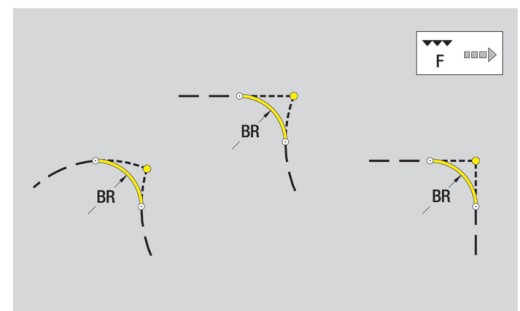
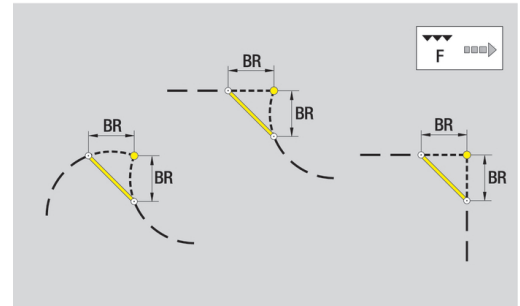
- **BR: Cham. width** or **Rounding radius**
- **AN: Element pos**
- **F: Further information:** "Machining attributes", Page 426

Chamfers or roundings are defined at contour corners. A **contour corner** is the point of intersection between the approaching contour element and the departing contour element. A chamfer or rounding cannot be calculated until the basic contour element is known.

**ICP** integrates the chamfer or rounding in the **G111**, **G112** or **G113** basic element in **smart.Turn** mode of operation.

**Contour begins with a chamfer or a rounding:** Enter the position of the **intended** corner as starting point. Then, in the form element menu, select Chamfer or Rounding. Since the **approaching contour element** is missing, you enter the **Element pos AN** to clearly define the position of the chamfer or rounding.

**ICP** converts a chamfer or rounding at the start of the contour to a linear or circular element.



## 6.11 C-axis and Y-axis machining in smart.Turn mode of operation

In **smart.Turn** mode of operation, ICP supports the definition of milling contours and holes as well as the creation of milling and drilling patterns that are machined with the aid of the C axis or Y axis.

Before you use ICP to describe a milling contour or a hole, select the plane:

- C axis
  - Frontface (XC plane)
  - Surface (ZC plane)
- Y axis
  - Frontface (XY plane)
  - Surface (YZ plane)

A hole can contain the following elements:

- Centering
- Core hole
- Cavity
- Thread

The parameters are evaluated for drilling or tapping.

You can arrange holes in linear or circular patterns.

**Milling contours:** The control is familiar with standard figures (full circle, polygon, slot, etc.). You can define these figures with a few parameters. Complex contours are described with lines and circular arcs.

You can arrange standard figures in linear or circular patterns.

## Reference data and nested contours

When describing a milling contour or hole, you define the **reference plane**. The reference plane is the position on which the milling contour or the hole is created.

- Frontface (C axis): The Z position (Reference dimension)
- Surface (C axis): The X position (Reference diameter)
- Frontface (Y axis): The Z position (Reference dimension)
- Surface (Y axis): The X position (Reference diameter)

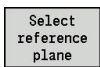
It is also possible to **nest** milling contours and holes. Example: Defining a slot in a rectangular pocket. Holes are drilled inside this slot. You use the reference plane to specify the positions of these elements.

**ICP** supports the selection of the reference plane. The following reference data are loaded during selection of a reference plane.

- Frontface: Reference dimension
- Surface: Reference diameter
- Frontface: Reference dimension, spindle angle, limit diameter
- Surface: Reference diameter, spindle angle

Selecting a reference plane:

- ▶ Select contour, figure, hole, pattern, single surface or polygon

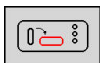


- ▶ Press the **Select reference plane** soft key
- ▶ **ICP** displays the finished part and, if available, the contours already defined
- ▶ Use the soft keys (see table) to select the reference dimension, reference diameter or existing milling contour as reference plane



- ▶ Confirm the reference plane
- ▶ **ICP** loads the values of the reference plane as reference data
- ▶ Complete the reference data and describe the contour, figure, hole, pattern, single surface or polygon

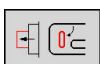
## Soft keys for nested contours



Switch to the next contour of the same reference plane



Switch to the previous contour of the same reference plane



Switch to the next nested contour



Switch to the previous nested contour



## Representation of the ICP elements in the smart.Turn program

Each ICP dialog in smart.Turn programs is represented by a section code followed by further **G** codes.

A hole or milling contour (standard figure and complex contour) contains the following commands:

- Section code (with the reference data of this section):
  - **FRONT** (XC plane)
  - **LATERAL** (ZC plane)
  - **FRONT Y** (XY plane)
  - **SURFACE Y** (ZY plane)
- **G308** (with parameters) as beginning of the reference plane
- **G** code of the figure or hole; sequence of commands for patterns or complex contours
- **G309** as end of a reference plane

In nested contours a reference plane begins with **G308**, the next reference plane with the next **G308**, etc. When the **deepest level** is finally reached, this reference plane is concluded with **G309**.

Then the next reference plane is concluded with **G309** etc.

Note the following points if you describe milling contours or holes with **G** codes and then edit them with **ICP**:

- Some parameters are redundant in the DIN contour description. For example, the milling depth can be programmed in the **G308** and/or in the **G** code of the figure. This redundancy does not appear in **ICP**.
- In DIN programming of figures you can choose between Cartesian or polar center coordinates. In **ICP**, the center of the figures is entered in Cartesian coordinates.

**Example:** In the DIN contour description, the milling depth is programmed in **G308** and in the figure definition. If this figure is changed with **ICP**, **ICP** overwrites the milling depth from **G308** with the milling depth from the figure. When saving, **ICP** saves the milling depth in **G308**. The **G** code of the figure is saved without milling depth.

#### Example: Rectangle on face

```
...
FRONT Z0
N 100 G308 ID"FRONT_1" P-5
N 101 G305 XK40 YK10 A0 K30 B15
N 102 G309
...
```

#### Example: Nested figures

```
...
FRONT Z0
N 100 G308 ID"FRONT_2" P-5
N 101 G307 XK-40 YK-40 Q5 A0 K-50
N 102 G308 ID"FRONT_12" P-3
N 103 G301 XK-35 YK-40 A30 K40 B20
N 104 G309
N 105 G309
...
```

## 6.12 Front face contours in smart.Turn mode of operation

In **smart.Turn** mode of operation, **ICP** provides the following contours for machining with the C axis:

- Complex contours defined with individual contour elements
- Figures
- Holes
- Pattern of figures or holes

### Reference data for complex face contours

The reference data is followed by the contour definition with individual contour elements:

**Further information:** "Contour elements – front face", Page 467

Reference data of face:

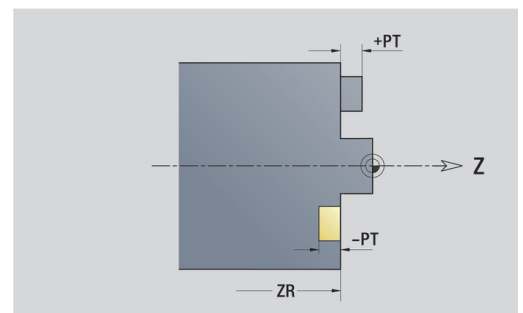
- **ID: Contour**
- **PT: Milling depth**
- **ZR: Reference dimension**

You can use the **Select reference plane** function to determine the **Reference dimension ZR**.

**Further information:** "Reference data and nested contours", Page 480

**ICP** generates the following:

- The **FRONT** section code with the **Reference dimension** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G309** at the end of the contour description



## TURN PLUS attributes

In the TURN PLUS attributes, you can define settings for the **Automatic working plan generation (AWG)** submode.

Parameters for defining the starting point:

- **HC: Milling/drilling attribute**
  - 1: Contour milling
  - 2: Pocket milling
  - 3: Area milling
  - 4: Deburring
  - 5: Engraving
  - 6: Contour + deburring
  - 7: Pocket + deburring
  - 14: Do not machine
- **QF: Cutter position**
  - 0: On the contour
  - 1: Inside / left
  - 2: Outside / right
- **HF: Direction**
  - 0: Up-cut
  - 1: Climb
- **DF: Milling diameter**
- **OF: Plunging behavior**
  - 0 / no input – **vertical plunging**
  - 1: **Helical plunging**
    - In roughing cycles, the tool plunges in a reciprocating movement when milling pockets, otherwise—i.e. when milling slots—in a helical movement.
    - In finishing cycles, the tool plunges in a 3-D approach arc when milling pockets.
  - 2: **Reciprocating plunge**
    - In roughing cycles, the tool plunges in a reciprocating movement when milling pockets.
    - In finishing cycles, the tool plunges in a 3-D approach arc when milling pockets.
- **WF: Angle** of chamfer
- **BR: Chamfer width**
- **RB: Return plane**

## Circle on front face

Reference data of face:

- **ID: Contour**
- **PT: Milling depth**
- **ZR: Reference dimension**

Parameters of figure:

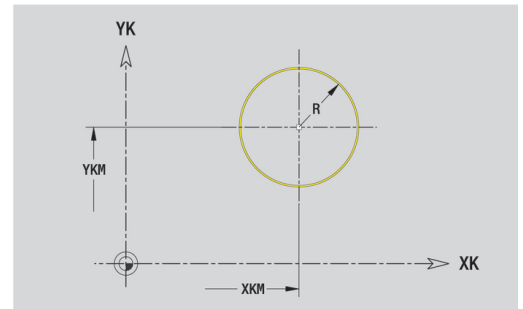
- **XKM, YKM: Center point** of figure (in Cartesian coordinates)
- **R: Radius**

You can use the **Select reference plane** function to determine the **Reference dimension ZR**.

**Further information:** "Reference data and nested contours",  
Page 480

**ICP** generates the following:

- The **FRONT** section code with the **Reference dimension** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G304** with the parameters of the figure
- A **G309**



## Rectangle on front face

Reference data of face:

- **ID: Contour**
- **PT: Milling depth**
- **ZR: Reference dimension**

Parameters of figure:

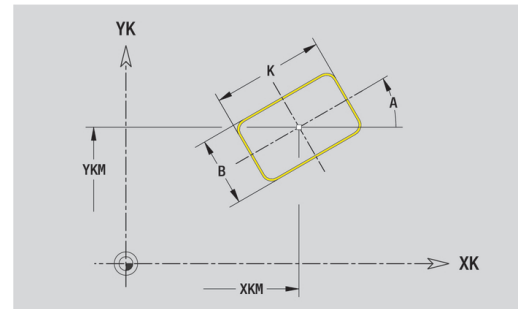
- **XKM, YKM: Center point** of figure (in Cartesian coordinates)
- **A: Position angle** (reference: XK axis)
- **K: Length**
- **B: Breadth**
- **BR: Cham. width** or **Rounding radius**

You can use the **Select reference plane** function to determine the **Reference dimension ZR**.

**Further information:** "Reference data and nested contours",  
Page 480

**ICP** generates the following:

- The **FRONT** section code with the **Reference dimension** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G305** with the parameters of the figure
- A **G309**



## Polygon on front face

Reference data of face:

- **ID: Contour**
- **PT: Milling depth**
- **ZR: Reference dimension**

Parameters of figure:

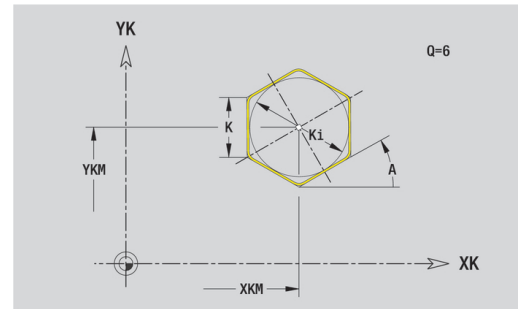
- **XKM, YKM: Center point** of figure (in Cartesian coordinates)
- **A: Position angle** (reference: XK axis)
- **Q: Number of corners**
- **K: Width across** – inscribed circle diameter
- **Ki: Edge length**
- **BR: Cham. width** or **Rounding radius**

You can use the **Select reference plane** function to determine the **Reference dimension ZR**.

**Further information:** "Reference data and nested contours",  
Page 480

ICP generates the following:

- The **FRONT** section code with the **Reference dimension** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G307** with the parameters of the figure
- A **G309**



## Linear slot on front face

Reference data of face:

- **ID: Contour**
- **PT: Milling depth**
- **ZR: Reference dimension**

Parameters of figure:

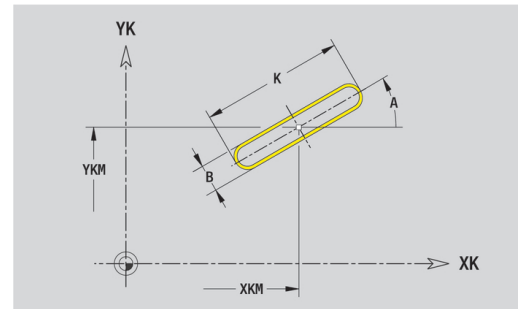
- **XKM, YKM: Center point** of figure (in Cartesian coordinates)
- **A: Position angle** (reference: XK axis)
- **K: Length**
- **B: Breadth**

You can use the **Select reference plane** function to determine the **Reference dimension ZR**.

**Further information:** "Reference data and nested contours",  
Page 480

**ICP** generates the following:

- The **FRONT** section code with the **Reference dimension** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G301** with the parameters of the figure
- A **G309**





## Circular slot on front face

Reference data of face:

- **ID: Contour**
- **PT: Milling depth**
- **ZR: Reference dimension**

Parameters of figure:

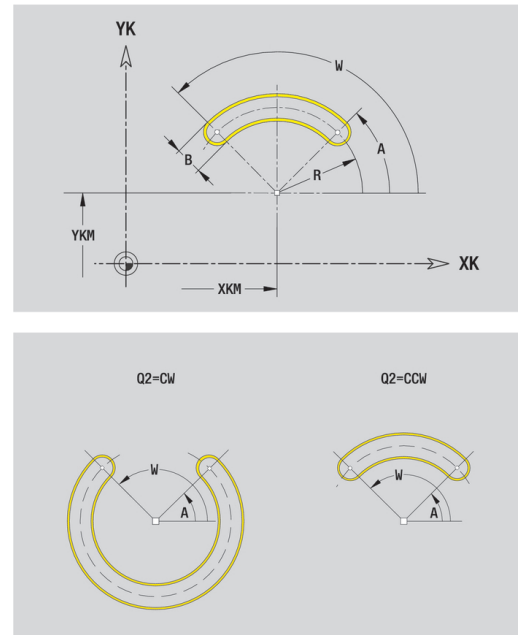
- **XKM, YKM: Center point** of figure (in Cartesian coordinates)
- **A: Start angle** (reference: XK axis)
- **W: Final angle** (reference: XK axis)
- **R: Radius** – Curvature radius (reference: center point path of the slot)
- **Q2: Dir.rot.**
  - CW
  - CCW
- **B: Breadth**

You can use the **Select reference plane** function to determine the **Reference dimension ZR**.

**Further information:** "Reference data and nested contours", Page 480

**ICP** generates the following:

- The **FRONT** section code with the **Reference dimension** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G302** or **G303** with the parameters of the figure
- A **G309**



## Hole on front face

This function defines a single hole that can contain the following elements:

- **Centering**
- **Hole**
- **Cavity**
- **Thread**

Reference data of hole:

- **ID: Contour**
- **ZR: Reference dimension**

Parameters of hole:

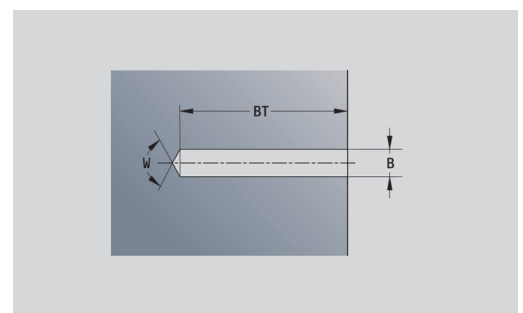
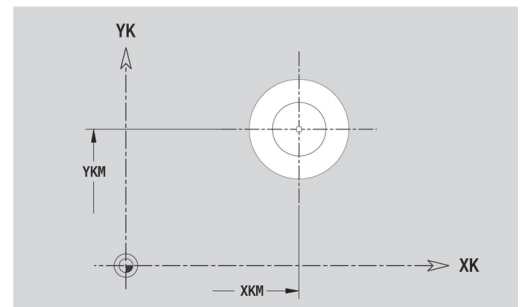
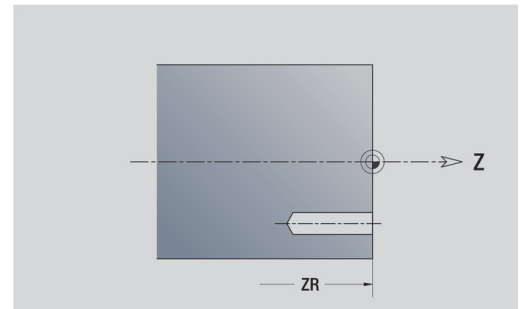
- **XKM, YKM: Center point** of hole (in Cartesian coordinates)
- **Centering**
  - **O: Diameter**
- **Hole**
  - **B: Diameter**
  - **BT: Depth** (without algebraic sign)
  - **W: Angle**
- **Cavity**
  - **R: Diameter**
  - **U: Depth**
  - **E: Sink angle**
- **Thread**
  - **GD: Diameter**
  - **GT: Depth**
  - **K: Cut-in length**
  - **F: Thread pitch**
  - **GA: Thread direction**
    - **0: Right-hand thread**
    - **1: Left-hand thread**

You can use the **Select reference plane** function to determine the **Reference dimension ZR**.

**Further information:** "Reference data and nested contours",  
Page 480

ICP generates the following:

- The **FRONT** section code with the **Reference dimension** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Boring depth** ( $-1 * BT$ ) parameters
- A **G300** with the parameters of the hole
- A **G309**



## Linear pattern on front face

Reference data of face:

- **ID: Contour**
- **PT: Milling depth**
- **ZR: Reference dimension**

Parameters of figure:

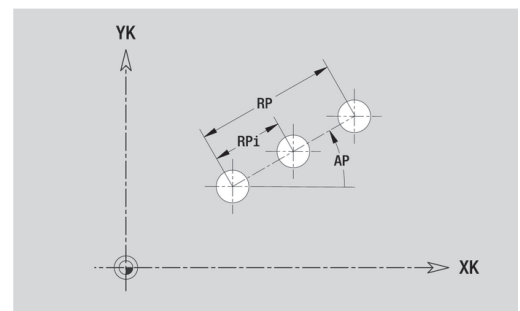
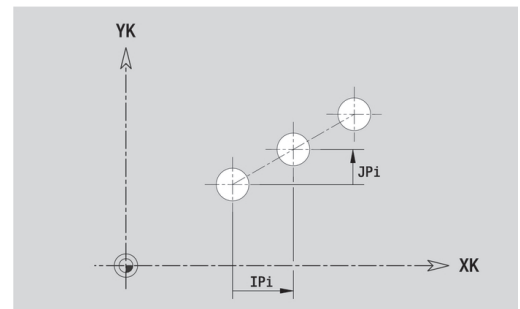
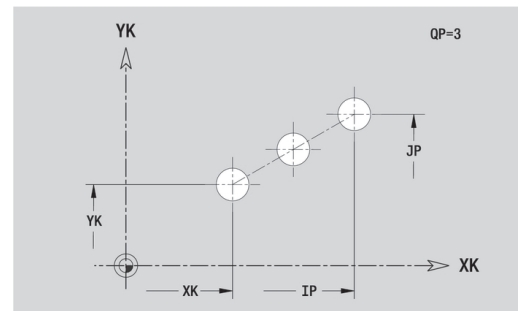
- **XK, YK: 1st pattern point** (in Cartesian coordinates)
- **QP: Quantity** of points in pattern
- **IP, JP: Final point** of pattern (in Cartesian coordinates)
- **IPi, JPi: Final point** – Distance between two pattern points (in XK and YK)
- **AP: Position angle**
- **RP: Length** – Total length of pattern
- **RPi: Length** – Distance between two pattern points
- Parameters of selected figure or hole

You can use the **Select reference plane** function to determine the **Reference dimension ZR**.

**Further information:** "Reference data and nested contours", Page 480

**ICP** generates the following:

- The **FRONT** section code with the **Reference dimension** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Milling depth** or **Boring depth** ( $-1 * BT$ ) parameters
- A **G401** with the parameters of the pattern
- The G code and the parameters of the figure or hole
- A **G309**



## Circular pattern on front face

Reference data of face:

- **ID: Contour**
- **PT: Milling depth**
- **ZR: Reference dimension**

Parameters of figure:

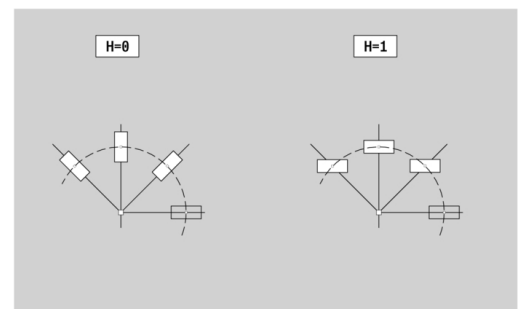
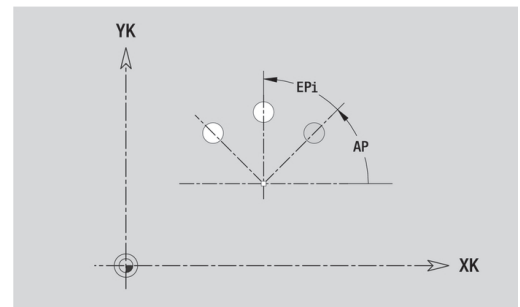
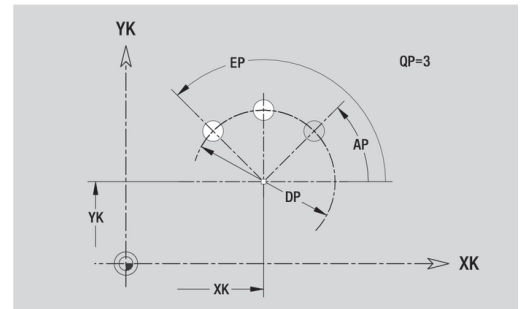
- **XK, YK: Center** of pattern (in Cartesian coordinates)
- **QP: Quantity** of points in pattern
- **DR: Dir.rot.** (default: 0)
  - **DR = 0**, without **EP**: Figures are arranged on a full circle
  - **DR = 0**, with **EP**: Figures are arranged on the longer circular arc
  - **DR = 0**, with **EPi**: The algebraic sign of **EPi** defines the direction (**EPi** < 0: clockwise)
  - **DR = 1**, with **EP**: clockwise
  - **DR = 1**, with **EPi**: clockwise (algebraic sign of **EPi** has no effect)
  - **DR = 2**, with **EP**: counterclockwise
  - **DR = 2**, with **EPi**: counterclockwise (algebraic sign of **EPi** has no effect)
- **DP: Diameter**
- **AP: Start angle** (default: 0°)
- **EP: Final angle** (no input: the pattern elements are distributed evenly around 360°)
- **EPi: Final angle – Angle** between two figures
- **H: Element pos**
  - **0: Normal** – The figures are rotated about the circle center (rotation)
  - **1: Master** – The position of the figure relative to the coordinate system remains unchanged (translation)
- Parameters of the selected figure/hole

You can use the **Select reference plane** function to determine the **Reference dimension ZR**.

**Further information:** "Reference data and nested contours",  
Page 480

**ICP** generates the following:

- The **FRONT** section code with the **Reference dimension** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Milling depth** or **Boring depth** ( $-1 * BT$ ) parameters
- A **G402** with the parameters of the pattern
- The **G** code and the parameters of the figure/hole
- A **G309**



## 6.13 Lateral surface contours in smart.Turn mode of operation

In **smart.Turn** mode of operation, **ICP** provides the following contours for machining with the C axis:

- Complex contours defined with individual contour elements
- Figures
- Holes
- Pattern of figures or holes

### Reference data of lateral surface

The reference data is followed by the contour definition with individual contour elements.

**Further information:** "Contour elements on lateral surface", Page 473

Reference data of lateral surface:

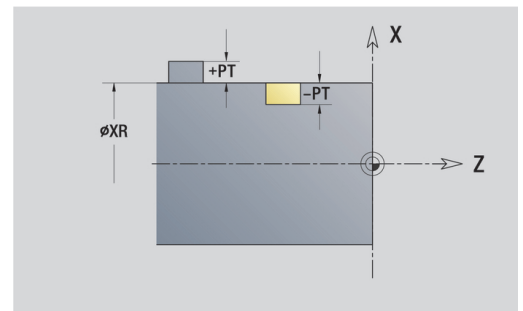
- **ID: Contour**
- **PT: Milling depth**
- **XR: Reference diameter**

You can use the **Select reference plane** function to determine the **Reference diameter XR**. The reference diameter is used for converting angle dimensions into linear dimensions.

"Reference data and nested contours"

**ICP** generates the following:

- The **LATERAL** section code with the **Reference diameter** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G309** at the end of the contour description or after the figure



## TURN PLUS attributes

In the TURN PLUS attributes, you can define settings for the **Automatic working plan generation (AWG)** submode.

Parameters for defining the starting point:

- **HC: Milling/drilling attribute**
  - 1: Contour milling
  - 2: Pocket milling
  - 3: Area milling
  - 4: Deburring
  - 5: Engraving
  - 6: Contour + deburring
  - 7: Pocket + deburring
  - 14: Do not machine
- **QF: Cutter position**
  - 0: On the contour
  - 1: Inside / left
  - 2: Outside / right
- **HF: Direction**
  - 0: Up-cut
  - 1: Climb
- **DF: Milling diameter**
- **OF: Plunging behavior**
  - 0 / no input – **vertical plunging**
  - **1: Helical plunging**
    - In roughing cycles, the tool plunges in a reciprocating movement when milling pockets, otherwise—i.e. when milling slots—in a helical movement.
    - In finishing cycles, the tool plunges in a 3-D approach arc when milling pockets.
  - **2: Reciprocating plunge**
    - In roughing cycles, the tool plunges in a reciprocating movement when milling pockets.
    - In finishing cycles, the tool plunges in a 3-D approach arc when milling pockets.
- **WF: Angle** of chamfer
- **BR: Chamfer width**
- **RB: Return plane**

## Circle on lateral surface

Reference data of lateral surface:

- **ID: Contour**
- **PT: Milling depth**
- **XR: Reference diameter**

Parameters of figure:

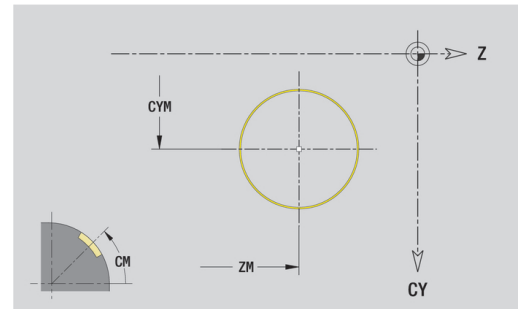
- **ZM: Center**
- **CYM: Center** as linear dimension (reference: diameter **XR**)
- **CM: Center** (angle)
- **R: Radius**

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours",  
Page 480

**ICP** generates the following:

- The **LATERAL** section code with the **Reference diameter** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G314** with the parameters of the figure
- A **G309**



## Rectangle on lateral surface

Reference data of lateral surface:

- **ID: Contour**
- **PT: Milling depth**
- **XR: Reference diameter**

Parameters of figure:

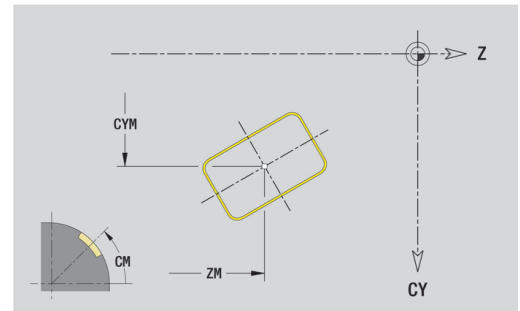
- **ZM: Center**
- **CYM: Center** as linear dimension (reference: diameter **XR**)
- **CM: Center** (angle)
- **A: Position angle**
- **K: Length**
- **B: Breadth**
- **BR: Cham. width** or **Rounding radius**

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours",  
Page 480

**ICP** generates the following:

- The **LATERAL** section code with the **Reference diameter** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G315** with the parameters of the figure
- A **G309**





## Polygon on lateral surface

Reference data of lateral surface:

- **ID: Contour**
- **PT: Milling depth**
- **XR: Reference diameter**

Parameters of figure:

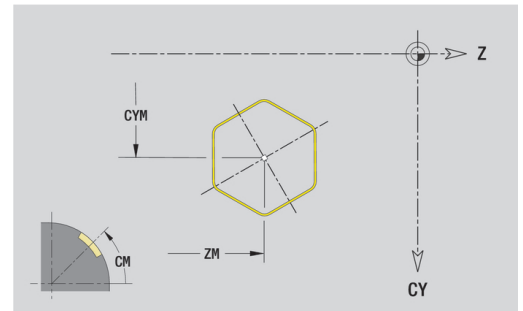
- **ZM: Center**
- **CYM: Center** as linear dimension (reference: diameter **XR**)
- **CM: Center** (angle)
- **A: Position angle**
- **Q: Number of corners**
- **K: Width across** – inscribed circle diameter
- **Ki: Edge length**
- **BR: Cham. width** or **Rounding radius**

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours",  
Page 480

**ICP** generates the following:

- The **LATERAL** section code with the **Reference diameter** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G317** with the parameters of the figure
- A **G309**



## Linear slot on lateral surface

Reference data of lateral surface:

- **ID: Contour**
- **PT: Milling depth**
- **XR: Reference diameter**

Parameters of figure:

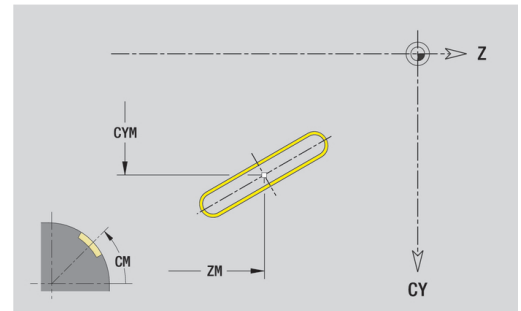
- **ZM: Center**
- **CYM: Center** as linear dimension (reference: diameter **XR**)
- **CM: Center** (angle)
- **A: Position angle**
- **K: Length**
- **B: Breadth**

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours",  
Page 480

**ICP** generates the following:

- The **LATERAL** section code with the **Reference diameter** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G311** with the parameters of the figure
- A **G309**



## Circular slot on lateral surface

Reference data of lateral surface:

- **ID: Contour**
- **PT: Milling depth**
- **XR: Reference diameter**

Parameters of figure:

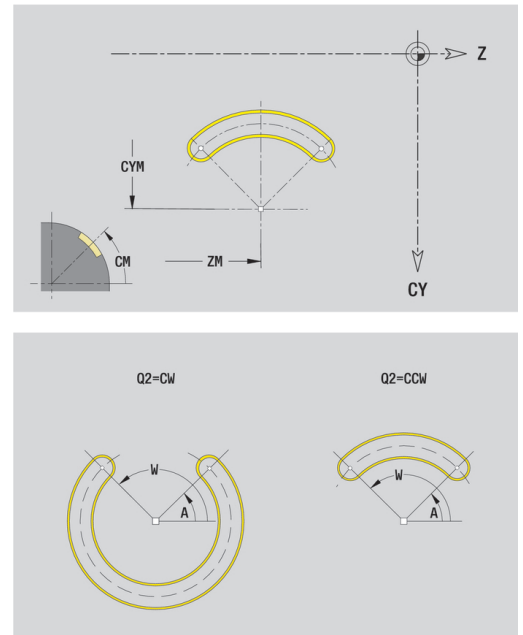
- **ZM: Center**
- **CYM: Center** as linear dimension (reference: diameter **XR**)
- **CM: Center** (angle)
- **A: Start angle**
- **W: Final angle**
- **R: Radius** – Curvature radius (reference: center point path of the slot)
- **Q2: Dir.rot.**
  - CW
  - CCW
- **B: Breadth**

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours",  
Page 480

**ICP** generates the following:

- The **LATERAL** section code with the **Reference diameter** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G312** or **G313** with the parameters of the figure
- A **G309**



## Hole on lateral surface

This function defines a single hole that can contain the following elements:

- **Centering**
- **Hole**
- **Cavity**
- **Thread**

Reference data of hole:

- **ID: Contour**
- **X: Reference dimension**

Parameters of hole:

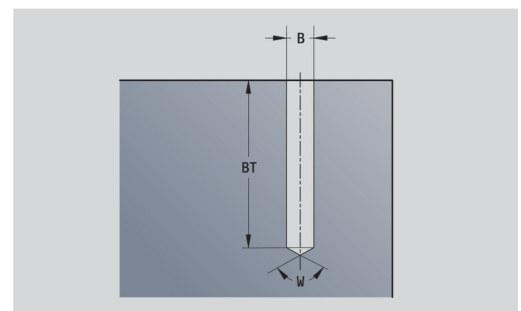
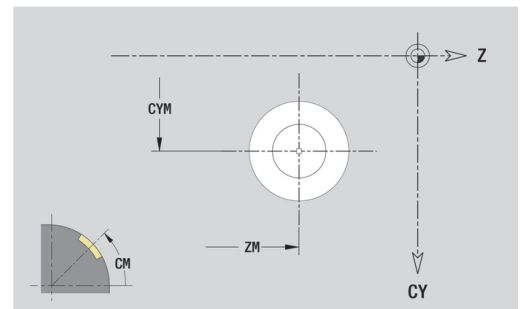
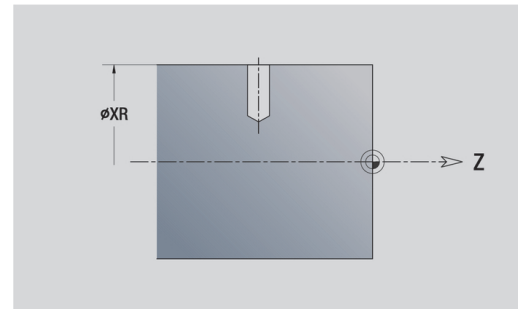
- **ZM: Center**
- **CYM: Center** as linear dimension (reference: diameter **XR**)
- **CM: Center** (angle)
- **Centering**
  - **O: Diameter**
- **Hole**
  - **B: Diameter**
  - **BT: Depth** (without algebraic sign)
  - **W: Angle**
- **Cavity**
  - **R: Diameter**
  - **U: Depth**
  - **E: Sink angle**
- **Thread**
  - **GD: Diameter**
  - **GT: Depth**
  - **K: Cut-in length**
  - **F: Thread pitch**
  - **GA: Thread direction**
    - **0: Right-hand thread**
    - **1: Left-hand thread**

You can use the **Select reference plane** function to determine the **Reference dimension XR**.

**Further information:** "Reference data and nested contours",  
Page 480

**ICP** generates the following:

- The **LATERAL** section code with the **Reference dimension** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Boring depth** ( $-1 * BT$ ) parameters
- A **G310** with the parameters of the hole
- A **G309**



## Linear pattern on lateral surface

Reference data of lateral surface:

- **ID: Contour**
- **PT: Milling depth**
- **XR: Reference diameter**

Parameters of figure:

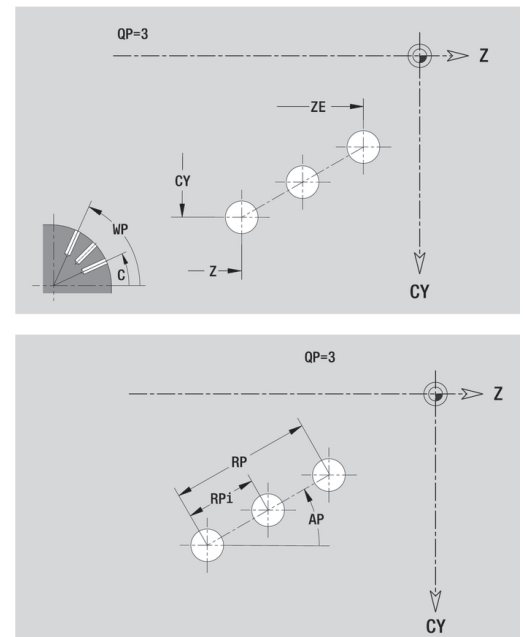
- **Z: 1st pattern point**
- **CY: 1st pattern point** as linear dimension (reference: diameter XR)
- **C: 1st pattern point** (angle)
- **QP: Quantity** of points in pattern
- **ZE: Final point** of pattern
- **ZEi: Final point** – Distance between two pattern points (in Z)
- **WP: Final point** of pattern (angle)
- **WPi: Final point** – Distance between two pattern points (angle)
- **AP: Position angle**
- **RP: Length** – Total length of pattern
- **RPi: Length** – Distance between two pattern points
- Parameters of the selected figure/hole

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours",  
Page 480

ICP generates the following:

- The **LATERAL** section code with the **Reference diameter** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Milling depth** or **Boring depth** ( $-1 * BT$ ) parameters
- A **G411** with the parameters of the pattern
- The **G** code and the parameters of the figure or hole
- A **G309**



## Circular pattern on lateral surface

Reference data of lateral surface:

- **ID: Contour**
- **PT: Milling depth**
- **XR: Reference diameter**

Parameters of figure:

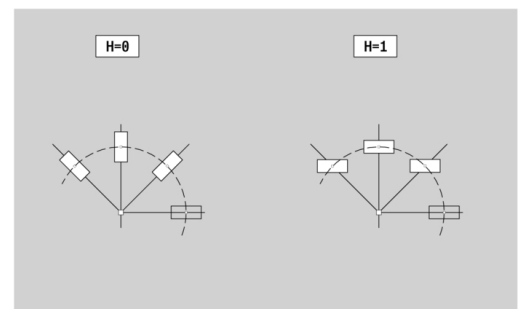
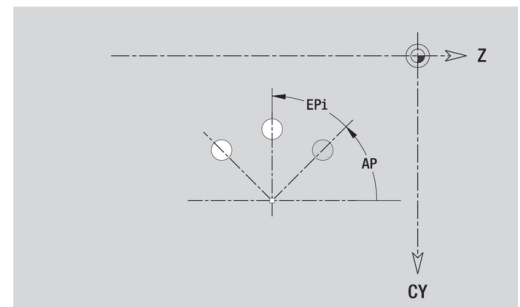
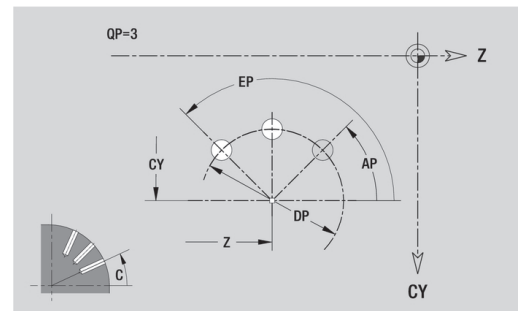
- **Z: Center** of pattern
- **CY: Center** of pattern as linear dimension (reference: diameter **XR**)
- **C: Center** of pattern (angle)
- **QP: Quantity** of points in pattern
  - **DR = 0**, without **EP**: Figures are arranged on a full circle
  - **DR = 0**, with **EP**: Figures are arranged on the longer circular arc
  - **DR = 0**, with **EPi**: The algebraic sign of **EPi** defines the direction (**EPi** < 0: clockwise)
  - **DR = 1**, with **EP**: clockwise
  - **DR = 1**, with **EPi**: clockwise (algebraic sign of **EPi** has no effect)
  - **DR = 2**, with **EP**: counterclockwise
  - **DR = 2**, with **EPi**: counterclockwise (algebraic sign of **EPi** has no effect)
- **DP: Diameter**
- **AP: Start angle** (default: 0°)
- **EP: Final angle** (no input: the pattern elements are distributed evenly around 360°)
- **EPi: Final angle – Angle** between two figures
- **H: Element pos**
  - **0: Normal** – The figures are rotated about the circle center (rotation)
  - **1: Master** – The position of the figure relative to the coordinate system remains unchanged (translation)

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours", Page 480

**ICP** generates the following:

- The **LATERAL** section code with the **Reference diameter** parameter. In nested contours, **ICP** generates only one section code
- A **G308** with the **Contour name** and **Milling depth** or **Boring depth** ( $-1 * BT$ ) parameters
- A **G412** with the parameters of the pattern
- The **G** code and the parameters of the figure/hole
- A **G309**



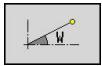
## 6.14 Contours in the XY plane

In **smart.Turn** mode of operation, **ICP** provides the following contours for machining with the Y axis:

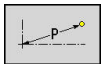
- Complex contours defined with individual contour elements
- Figures
- Holes
- Pattern of figures or holes
- Single surface
- Polygon

Enter the dimensions of the XY plane contour elements in Cartesian or polar coordinates. You can switch between them by soft key. You can mix Cartesian coordinates and polar coordinates to define a point.

### Soft keys for polar coordinates



Switch the field to entering the angle **W**



Switch the field to entering the radius **P**

### Reference data in XY plane

The reference data is followed by the contour definition with individual contour elements.

Reference data of milling operations:

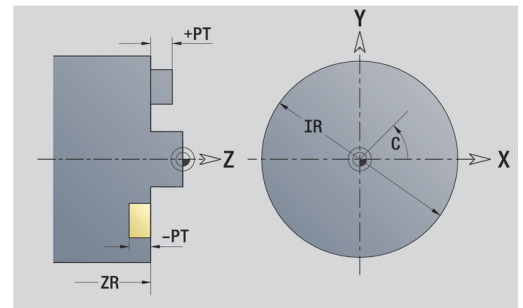
- **ID: Contour**
- **PT: Milling depth**
- **C: Spindle angle**
- **IR: Limit diameter**
- **ZR: Reference dimension**

You can use the **Select reference plane** function to determine the **Reference dimension ZR** and the **Limit diameter IR**.

**Further information:** "Reference data and nested contours", Page 480

**ICP** generates the following:

- The **FRONT Y** section code with the **Reference dimension**, **Spindle angle**, and **Limit diameter** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G309** at the end of the contour description



## Basic elements of XY plane

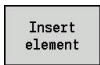
### Starting point of contour in XY plane

Enter the coordinates for the Starting point and Destin. point in the first contour element of the contour. Entering the starting point is only possible in the first contour element. In subsequent contour elements, the Starting point results from the previous contour element in each case.

Defining the Starting point:



- ▶ Select the **Contour** menu item



- ▶ Alternative: Press the **Insert element** soft key

- ▶ Define the Starting point

Parameters for defining the starting point:

- **XS, YS: Starting point** of contour
- **WS: Starting point** of contour (angle in polar coordinates)
- **PS: Starting point** of contour (radius in polar coordinates)

ICP generates a **G170** in **smart.Turn** mode of operation.

### Vertical lines in XY plane

Programming a vertical line:



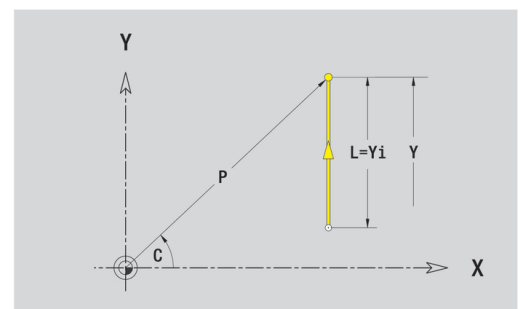
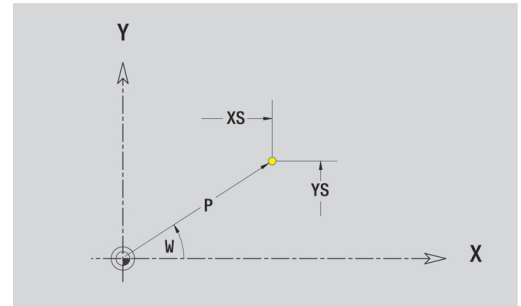
- ▶ Select the line direction

- ▶ Enter the line dimensions
- ▶ Define the transition to the next contour element

Parameters:

- **Y: Target point**
- **Yi: Target point** (incremental)
- **W: Target point** (angle in polar coordinates)
- **P: Target point** (in polar coordinates)
- **L: Line length**
- **F: Further information:** "Machining attributes", Page 426

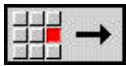
ICP generates a **G171** in **smart.Turn** mode of operation.





### Horizontal lines in XY plane

Programming a horizontal line:

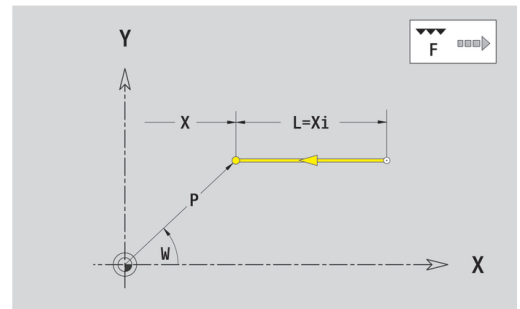


- ▶ Select the line direction
- ▶ Enter the line dimensions
- ▶ Define the transition to the next contour element

Parameters:

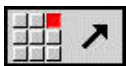
- **X: Target point**
- **Xi: Target point** (incremental)
- **W: Target point** (angle in polar coordinates)
- **P: Target point** (in polar coordinates)
- **L: Line length**
- **F: Further information:** "Machining attributes", Page 426

ICP generates a **G171** in **smart.Turn** mode of operation.



### Line at angle in XY plane

Programming a line at an angle:

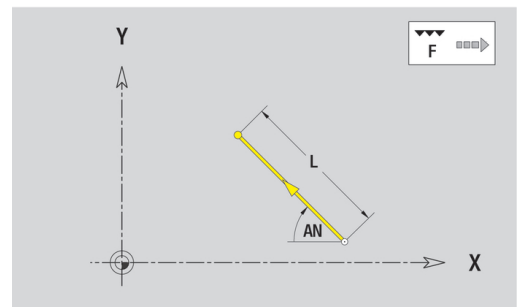
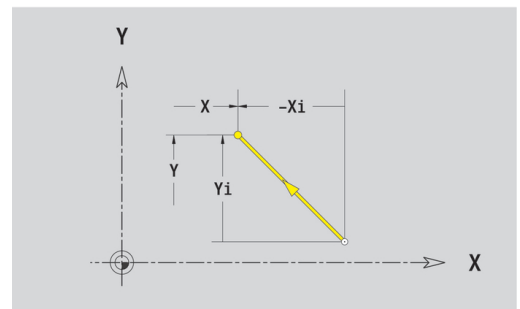


- ▶ Select the line direction
- ▶ Enter the line dimensions
- ▶ Define the transition to the next contour element

Parameters:

- **X, Y: Target point**
- **Xi, Yi: Target point** (incremental)
- **W: Target point** (angle in polar coordinates)
- **P: Target point** (in polar coordinates)
- **L: Line length**
- **AN: Angle**
- **ANn: Angle** to the subsequent element
- **ANp: Angle** to the previous element
- **F: Further information:** "Machining attributes", Page 426

ICP generates a **G171** in **smart.Turn** mode of operation.



### Circular arc in XY plane

Programming a circular arc:

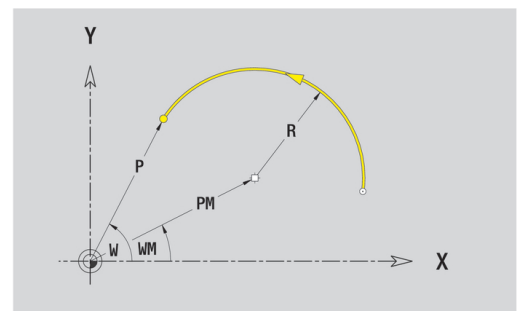
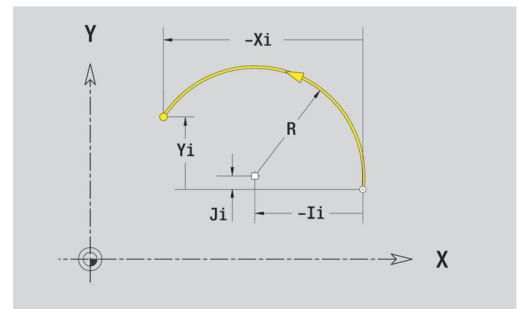
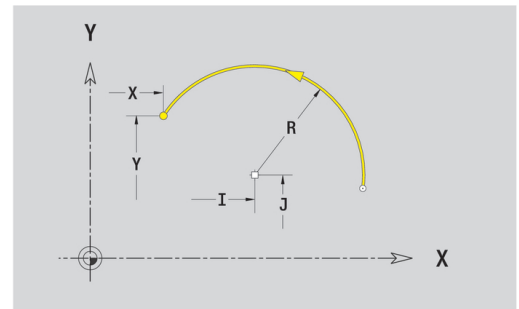


- ▶ Select the arc's direction of rotation
- ▶ Enter the arc dimensions
- ▶ Define the transition to the next contour element

Parameters:

- **X, Y: Target point**
- **Xi, Yi: Target point** (incremental)
- **P: Target point** (in polar coordinates)
- **Pi: Target point** – Distance between starting point and target point (polar, incremental)
- **W: Target point** (angle in polar coordinates)
- **Wi: Target point** (angle in incremental polar coordinates; reference: starting point)
- **I, J: Center point** of circular arc
- **Ii, Ji: Center point** of circular arc (incremental) – Distance between starting point and **Center point** in **X** and **Y**
- **PM: Center point** of circular arc (polar)
- **PMi: Center point** of circular arc – Distance between starting point and **Center point** (polar, incremental)
- **WM: Center point** of circular arc (polar angle)
- **WMi: Center point** of circular arc (polar angle, incremental; reference: starting point)
- **R: Radius**
- **ANs: Angle** – Tangential angle at the starting point
- **ANe: Angle** – Tangential angle at the target point
- **ANn: Angle** to the subsequent element
- **ANp: Angle** to the previous element
- **F: Further information:** "Machining attributes", Page 426

ICP generates a **G172** or **G173** in **smart.Turn** mode of operation.



## Form elements of XY plane

### Chamfer or rounding in XY plane

Programming a chamfer or rounding radius:



- ▶ Select the form elements



- ▶ Select the Chamfer menu item



- ▶ Enter the **Chamfer width BR**

- ▶ Alternative: Select a rounding radius

- ▶ Enter the **Rounding radius BR**

- ▶ Enter the chamfer or rounding radius as first contour element: **Position AN**

Parameters:

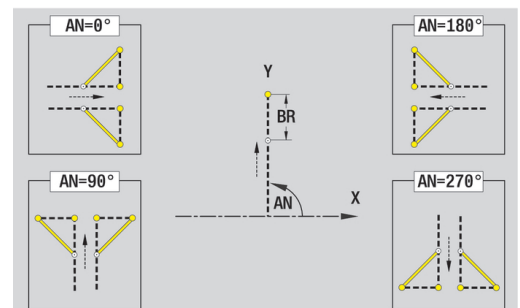
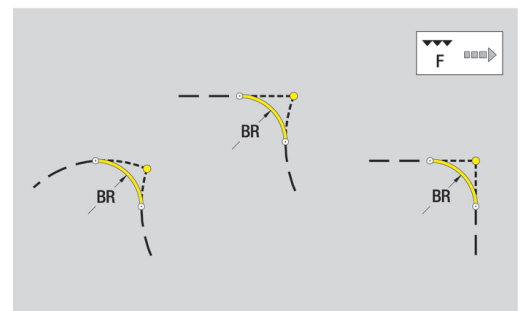
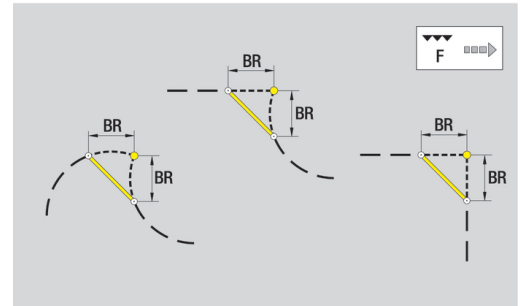
- **BR: Cham. width or Rounding radius**
- **AN: Element pos**
- **F: Further information:** "Machining attributes", Page 426

Chamfers or roundings are defined at contour corners. A **contour corner** is the intersection between the approaching contour element and the departing contour element. A chamfer or rounding cannot be calculated until the basic contour element is known.

**ICP** integrates the chamfer or rounding in the **G171**, **G172** or **G173** basic element in **smart.Turn** mode of operation.

Contour begins with a chamfer or a rounding: Enter the position of the **intended** corner as starting point. Then, in the form element menu, select Chamfer or Rounding. Since the **approaching contour element** is missing, you enter the **Position AN** to clearly define the position of the chamfer or rounding.

**ICP** converts a chamfer or rounding at the start of the contour to a linear or circular element.



## Figures, patterns and holes in XY plane (front face)

### Circle in XY plane

Reference data of XY plane:

- **ID: Contour**
- **PT: Milling depth**
- **C: Spindle angle**
- **IR: Limit diameter**
- **ZR: Reference dimension**

Parameters of figure:

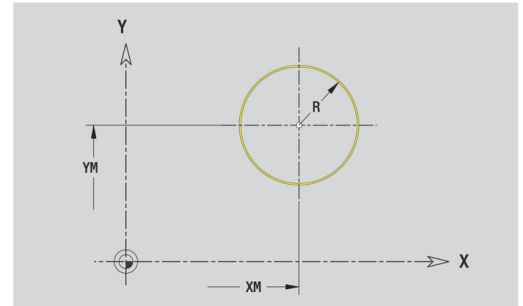
- **XM, YM: Center**
- **R: Radius**

You can use the **Select reference plane** function to determine the **Reference dimension ZR** and the **Limit diameter IR**.

**Further information:** "Reference data and nested contours",  
Page 480

ICP generates the following:

- The **FRONT Y** section code with the **Limit diameter**, **Reference dimension**, and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G374** with the parameters of the figure
- A **G309**



**Rectangle in XY plane**

Reference data of XY plane:

- **ID: Contour**
- **PT: Milling depth**
- **C: Spindle angle**
- **IR: Limit diameter**
- **ZR: Reference dimension**

Parameters of figure:

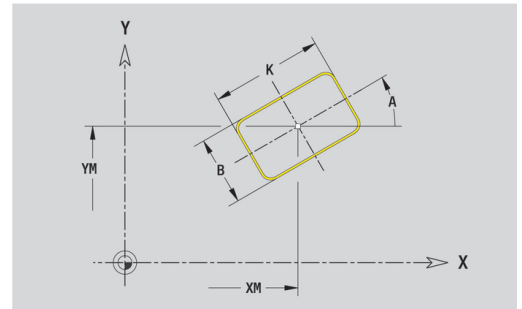
- **XM, YM: Center**
- **A: Position angle**
- **K: Length**
- **B: Breadth**
- **BR: Cham. width or Rounding radius**

You can use the **Select reference plane** function to determine the **Reference dimension ZR** and the **Limit diameter IR**.

**Further information:** "Reference data and nested contours",  
Page 480

ICP generates the following:

- The **FRONT Y** section code with the **Limit diameter**, **Reference dimension**, and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G375** with the parameters of the figure
- A **G309**



### Polygon in XY plane

Reference data of XY plane:

- **ID: Contour**
- **PT: Milling depth**
- **C: Spindle angle**
- **IR: Limit diameter**
- **ZR: Reference dimension**

Parameters of figure:

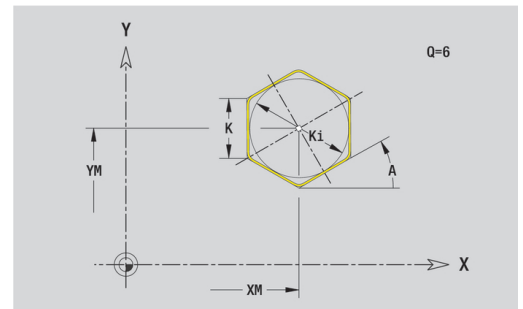
- **XM, YM: Center**
- **A: Position angle**
- **Q: Number of corners**
- **K: Width across** – inscribed circle diameter
- **Ki: Edge length**
- **BR: Cham. width** or **Rounding radius**

You can use the **Select reference plane** function to determine the **Reference dimension ZR** and the **Limit diameter IR**.

**Further information:** "Reference data and nested contours",  
Page 480

**ICP** generates the following:

- The **FRONT Y** section code with the **Limit diameter**, **Reference dimension**, and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G377** with the parameters of the figure
- A **G309**



**Linear slot in XY plane**

Reference data of XY plane:

- **ID: Contour**
- **PT: Milling depth**
- **C: Spindle angle**
- **IR: Limit diameter**
- **ZR: Reference dimension**

Parameters of figure:

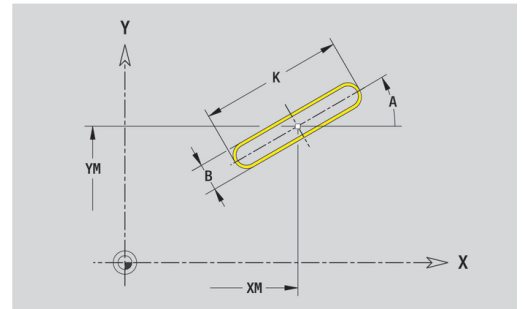
- **XM, YM: Center**
- **A: Position angle**
- **K: Length**
- **B: Breadth**

You can use the **Select reference plane** function to determine the **Reference dimension ZR** and the **Limit diameter IR**.

**Further information:** "Reference data and nested contours",  
Page 480

**ICP** generates the following:

- The **FRONT Y** section code with the **Limit diameter**, **Reference dimension**, and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G371** with the parameters of the figure
- A **G309**



### Circular slot in XY plane

Reference data of XY plane:

- **ID: Contour**
- **PT: Milling depth**
- **C: Spindle angle**
- **IR: Limit diameter**
- **ZR: Reference dimension**

Parameters of figure:

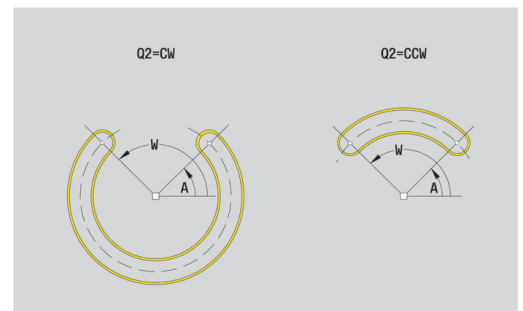
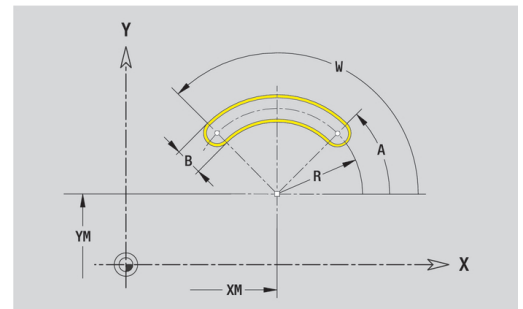
- **XM, YM: Center**
- **A: Start angle**
- **W: Final angle**
- **R: Radius** – Curvature radius (reference: center point path of the slot)
- **Q2: Dir.rot.**
  - CW
  - CCW
- **B: Breadth**

You can use the **Select reference plane** function to determine the **Reference dimension ZR** and the **Limit diameter IR**.

**Further information:** "Reference data and nested contours",  
Page 480

**ICP** generates the following:

- The **FRONT Y** section code with the **Limit diameter**, **Reference dimension**, and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G372** or **G373** with the parameters of the figure
- A **G309**





### Hole in XY plane

This function defines a single hole that can contain the following elements:

- **Centering**
- **Hole**
- **Cavity**
- **Thread**

Reference data of hole:

- **ID: Contour**
- **C: Spindle angle**
- **IR: Limit diameter**
- **ZR: Reference dimension**

Parameters of hole:

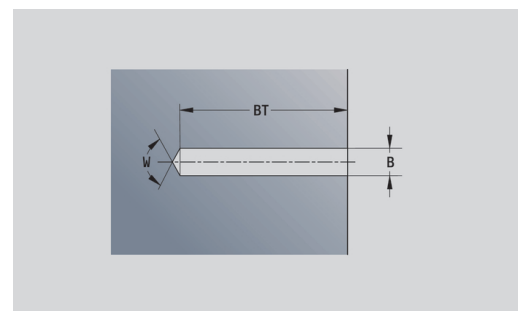
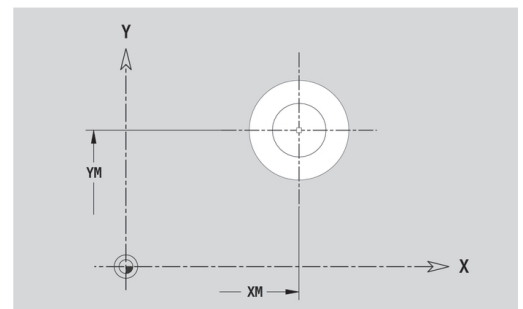
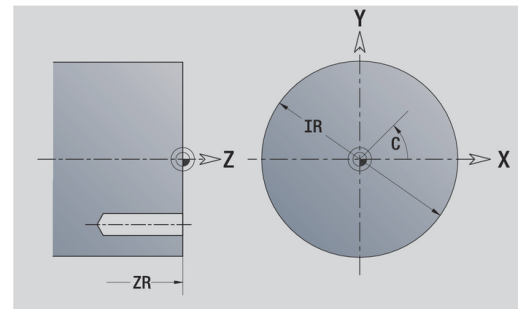
- **XM, YM: Center**
- **Centering**
  - **O: Diameter**
- **Hole**
  - **B: Diameter**
  - **BT: Depth** (without algebraic sign)
  - **W: Angle**
- **Cavity**
  - **R: Diameter**
  - **U: Depth**
  - **E: Sink angle**
- **Thread**
  - **GD: Diameter**
  - **GT: Depth**
  - **K: Cut-in length**
  - **F: Thread pitch**
  - **GA: Thread direction**
    - **0: Right-hand thread**
    - **1: Left-hand thread**

You can use the **Select reference plane** function to determine the **Reference dimension ZR** and the **Limit diameter IR**.

**Further information:** "Reference data and nested contours",  
Page 480

ICP generates the following:

- The **FRONT Y** section code with the **Limit diameter**, **Reference dimension**, and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Boring depth** ( $-1 * BT$ ) parameters
- A **G370** with the parameters of the hole
- A **G309**



### Linear pattern in XY plane

Reference data of XY plane:

- **ID: Contour**
- **PT: Milling depth**
- **C: Spindle angle**
- **IR: Limit diameter**
- **ZR: Reference dimension**

Parameters of pattern:

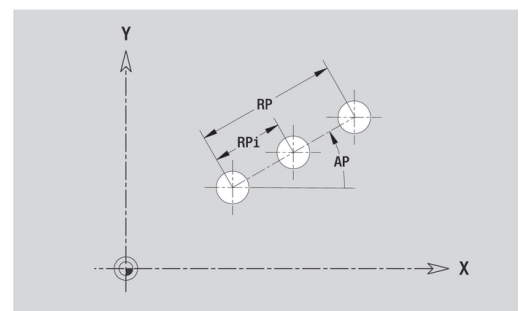
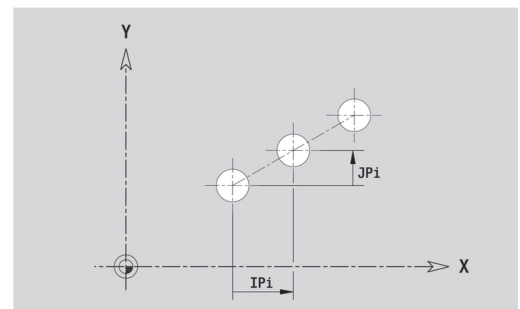
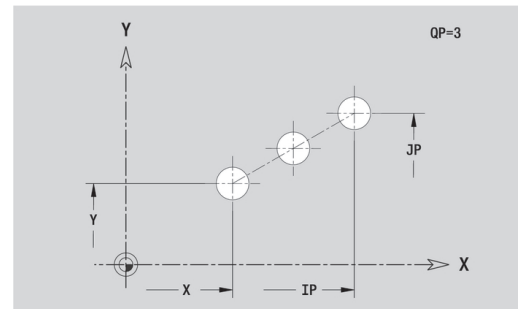
- **X, Y: 1st pattern point**
- **QP: Quantity** of points in pattern
- **IP, JP: Final point** of pattern (in Cartesian coordinates)
- **IPi, JPi: Final point** – Distance between two pattern points (in X and Y)
- **AP: Position angle**
- **RP: Length** – Total length of pattern
- **RPi: Length** – Distance between two pattern points
- Parameters of the selected figure/hole

You can use the **Select reference plane** function to determine the **Reference dimension ZR** and the **Limit diameter IR**.

**Further information:** "Reference data and nested contours", Page 480

**ICP** generates the following:

- The **FRONT Y** section code with the **Limit diameter**, **Reference dimension**, and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Milling depth** or **Boring depth** ( $-1*BT$ ) parameters
- A **G471** with the parameters of the pattern
- The G code and the parameters of the figure/hole
- A **G309**



**Circular pattern in XY plane**

Reference data of XY plane:

- **ID: Contour**
- **PT: Milling depth**
- **C: Spindle angle**
- **IR: Limit diameter**
- **ZR: Reference dimension**

Parameters of pattern:

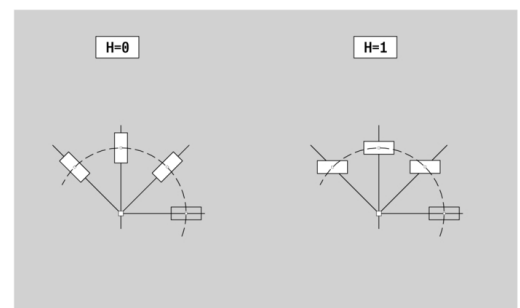
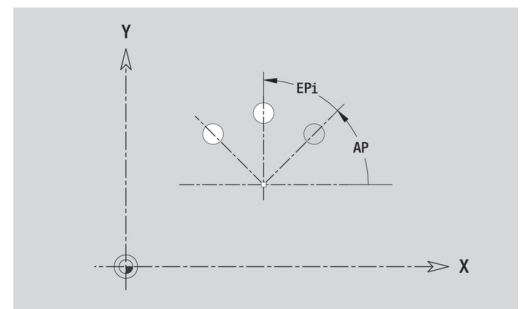
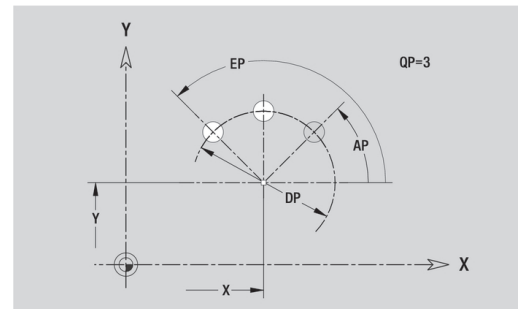
- **X, Y: Center** of pattern
- **QP: Quantity** of points in pattern
- **DR: Dir.rot.** (default: 0)
  - **DR = 0**, without **EP**: Figures are arranged on a full circle
  - **DR = 0**, with **EP**: Figures are arranged on the longer circular arc
  - **DR = 0**, with **EP<sub>i</sub>**: The algebraic sign of **EP<sub>i</sub>** defines the direction (**EP<sub>i</sub> < 0**: clockwise)
  - **DR = 1**, with **EP**: clockwise
  - **DR = 1**, with **EP<sub>i</sub>**: clockwise (algebraic sign of **EP<sub>i</sub>** has no effect)
  - **DR = 2**, with **EP**: counterclockwise
  - **DR = 2**, with **EP<sub>i</sub>**: counterclockwise (algebraic sign of **EP<sub>i</sub>** has no effect)
- **DP: Diameter**
- **AP: Start angle** (default: 0°)
- **EP: Final angle** (no input: the pattern elements are distributed evenly around 360°)
- **EP<sub>i</sub>: Final angle – Angle** between two figures
- **H: Element pos**
  - **0: Normal** – The figures are rotated about the circle center (rotation)
  - **1: Master** – The position of the figure relative to the coordinate system remains unchanged (translation)
- Parameters of the selected figure/hole

You can use the **Select reference plane** function to determine the **Reference dimension ZR** and the **Limit diameter IR**.

**Further information:** "Reference data and nested contours",  
Page 480

**ICP** generates the following:

- The **FRONT Y** section code with the **Limit diameter**, **Reference dimension**, and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Milling depth** or **Boring depth** (-1\*BT) parameters
- A **G472** with the parameters of the pattern
- The G code and the parameters of the figure/hole
- A **G309**



### Single surface in XY plane

This function defines a surface in the XY plane.

Reference data of XY plane:

- **ID: Contour**
- **C: Spindle angle**
- **IR: Limit diameter**

Parameters of single surface:

- **Z: Reference edge**
- **Ki: Depth**
- **K: Residual depth**
- **B: Breadth** (reference: **Reference dimension ZR**)
  - **B < 0**: Surface in negative Z direction
  - **B > 0**: Surface in positive Z direction

You can switch between **Depth Ki** and **Residual depth K** by soft key.

You can use the **Select reference plane** function to determine the **Reference dimension ZR** and the **Limit diameter IR**.

**Further information:** "Reference data and nested contours", Page 480

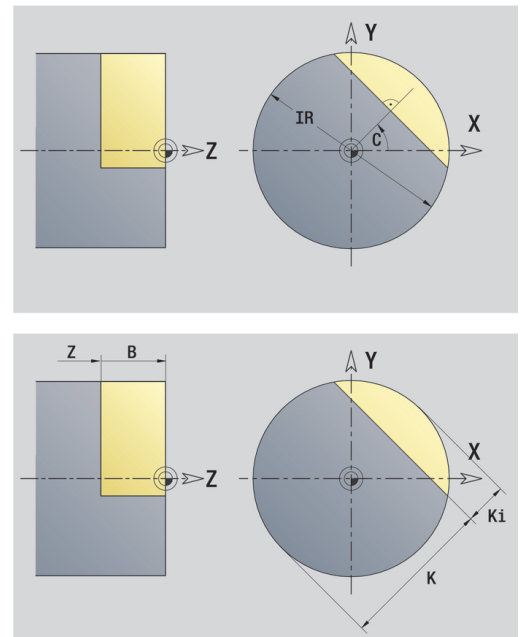
ICP generates the following:

- The **FRONT Y** section code with the **Limit diameter**, **Reference dimension**, and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** parameter
- A **G376** with the parameters of the single surface
- A **G309**

### Soft key

Residual  
depth

Switch the field to the input of **Residual depth K**



### Centric polygon in XY plane

This function defines polygonal surfaces in the XY plane.

Reference data of XY plane:

- **ID: Contour**
- **C: Spindle angle**
- **IR: Limit diameter**

Parameters of single surface:

- **Z: Reference edge**
- **Q: No. of surfaces (Q >= 2)**
- **K: Width across** – inscribed circle diameter
- **Ki: Edge length**
- **B: Breadth** (reference: **Reference dimension ZR**)
  - **B < 0:** Surface in negative Z direction
  - **B > 0:** Surface in positive Z direction

You can switch between **Edge length Ki** and **Width across K** by soft key.

You can use the **Select reference plane** function to determine the **Reference dimension ZR** and the **Limit diameter IR**.

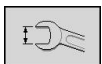
**Further information:** "Reference data and nested contours", Page 480

ICP generates the following:

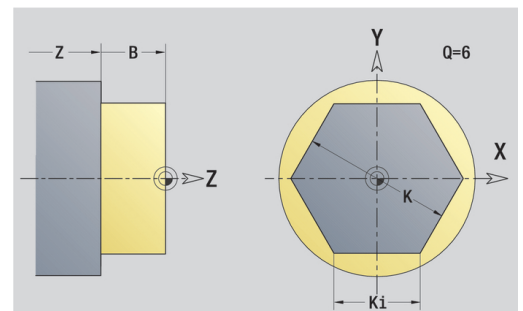
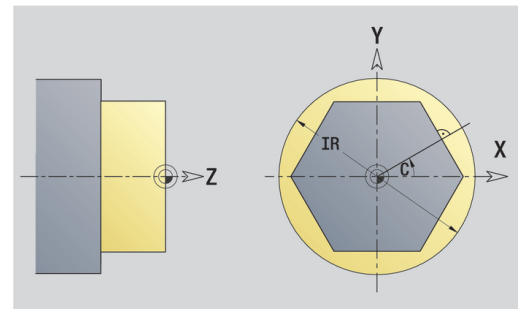
- The **FRONT Y** section code with the **Limit diameter**, **Reference dimension**, and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** parameter
- A **G477** with the parameters of the polygon
- A **G309**

---

#### Soft key



Switch the field to the input of **Width across K**



## 6.15 Contours in the YZ plane

In **smart.Turn** mode of operation, **ICP** provides the following contours for machining with the Y axis:

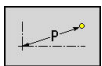
- Complex contours defined with individual contour elements
- Figures
- Holes
- Pattern of figures or holes
- Single surface
- Polygon

Enter the dimensions of the YZ plane contour elements in Cartesian or polar coordinates. You can switch between them by soft key. You can mix Cartesian coordinates and polar coordinates to define a point.

### Soft keys for polar coordinates



Switch the field to entering the angle **W**



Switch the field to entering the radius **P**

### Reference data in YZ plane

The reference data is followed by the contour definition with individual contour elements.

Reference data of milling operations:

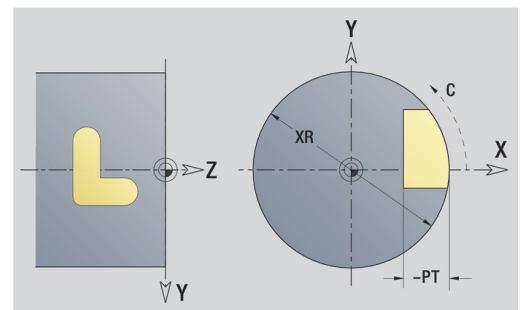
- **ID: Contour**
- **PT: Milling depth**
- **C: Spindle angle**
- **XR: Reference diameter**

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours", Page 480

**ICP** generates the following:

- The **SURFACE Y** section code with the **Reference diameter** and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G309** at the end of the contour description



## TURN PLUS attributes

In the TURN PLUS attributes, you can define settings for the **Automatic working plan generation (AWG)** submode.

Parameters for defining the starting point:

- **HC: Milling/drilling attribute**
  - **1: Contour milling**
  - **2: Pocket milling**
  - **3: Area milling**
  - **4: Deburring**
  - **5: Engraving**
  - **6: Contour + deburring**
  - **7: Pocket + deburring**
  - **14: Do not machine**
- **QF: Cutter position**
  - **0: On the contour**
  - **1: Inside / left**
  - **2: Outside / right**
- **HF: Direction**
  - **0: Up-cut**
  - **1: Climb**
- **DF: Milling diameter**
- **OF: Plunging behavior**
  - 0 / no input – **vertical plunging**
  - **1: Helical plunging**
    - In roughing cycles, the tool plunges in a reciprocating movement when milling pockets, otherwise—i.e. when milling slots—in a helical movement.
    - In finishing cycles, the tool plunges in a 3-D approach arc when milling pockets.
  - **2: Reciprocating plunge**
    - In roughing cycles, the tool plunges in a reciprocating movement when milling pockets.
    - In finishing cycles, the tool plunges in a 3-D approach arc when milling pockets.
- **WF: Angle** of chamfer
- **BR: Chamfer width**
- **RB: Return plane**

## Basic elements of YZ plane

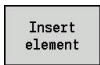
### Starting point of contour in YZ plane

Enter the coordinates for the starting point and target point in the first contour element. Entering the starting point is only possible in the first contour element. In subsequent contour elements, the starting point results from the previous contour element in each case.

Defining the starting point:



- ▶ Select the **Contour** menu item



- ▶ Alternative: Press the **Insert element** soft key

- ▶ Define the starting point

Parameters for defining the starting point:

- **YS, ZS:** Starting point of contour
- **WS:** Starting point of contour (angle in polar coordinates)
- **PS:** Starting point of contour (radius in polar coordinates)

ICP generates a **G180** in **smart.Turn** mode of operation.

### Vertical lines in YZ plane

Programming a vertical line:



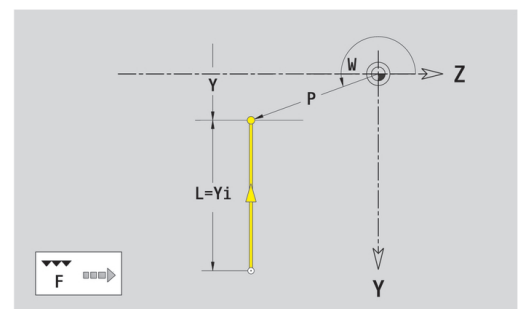
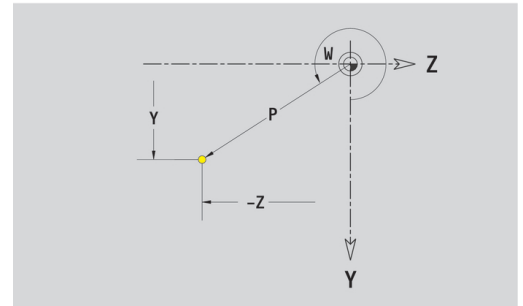
- ▶ Select the line direction

- ▶ Enter the line dimensions
- ▶ Define the transition to the next contour element

Parameters:

- **Y:** Target point
- **Yi:** Target point (incremental)
- **W:** Target point (angle in polar coordinates)
- **P:** Target point (in polar coordinates)
- **L:** Line length
- **F:** Further information: "Machining attributes", Page 426

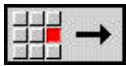
ICP generates a **G181** in **smart.Turn** mode of operation.





### Horizontal lines in YZ plane

Programming a horizontal line:

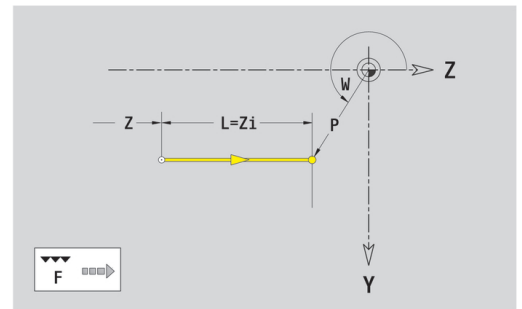


- ▶ Select the line direction
- ▶ Enter the line dimensions
- ▶ Define the transition to the next contour element

Parameters:

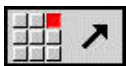
- **Z:** Target point
- **Zi:** Target point (incremental)
- **W:** Target point (angle in polar coordinates)
- **P:** Target point (in polar coordinates)
- **L:** Line length
- **F: Further information:** "Machining attributes", Page 426

ICP generates a **G181** in **smart.Turn** mode of operation.



### Line at angle in YZ plane

Programming a line at an angle:

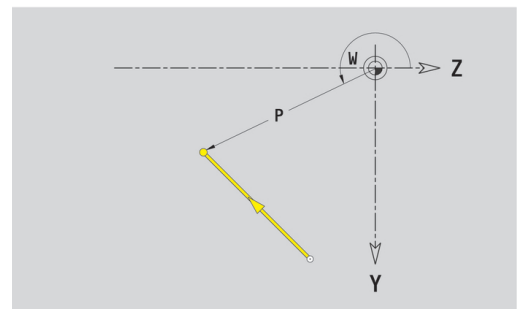
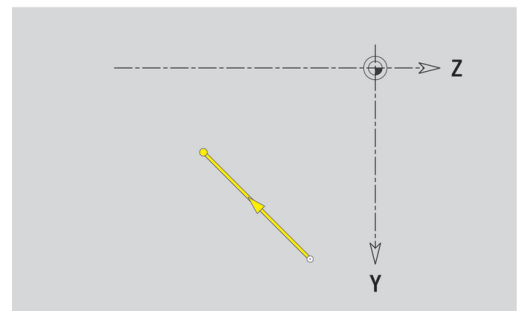


- ▶ Select the line direction
- ▶ Enter the line dimensions
- ▶ Define the transition to the next contour element

Parameters:

- **Y, Z:** Target point
- **Yi, Zi:** Target point (incremental)
- **W:** Target point (angle in polar coordinates)
- **P:** Target point (in polar coordinates)
- **L:** Line length
- **AN:** Angle
- **ANn:** Angle to the subsequent element
- **ANp:** Angle to the previous element
- **F: Further information:** "Machining attributes", Page 426

ICP generates a **G181** in **smart.Turn** mode of operation.



### Circular arc in YZ plane

Programming a circular arc:

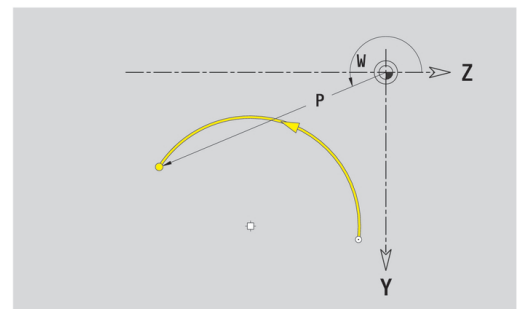
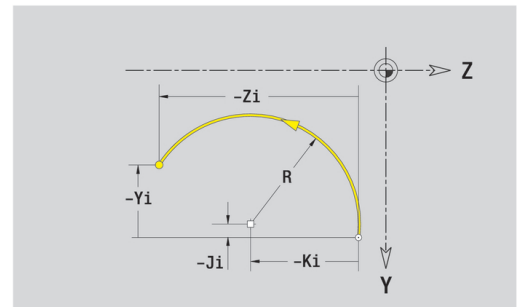
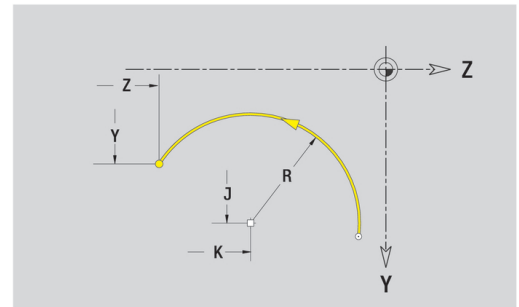


- ▶ Select the arc's direction of rotation
- ▶ Enter the arc dimensions
- ▶ Define the transition to the next contour element

Parameters:

- **Y, Z:** Target point
- **Yi, Zi:** Target point (incremental)
- **P:** Target point (in polar coordinates)
- **Pi:** Target point – Distance between starting point and target point (polar, incremental)
- **W:** Target point (angle in polar coordinates)
- **Wi:** Target point (angle in incremental polar coordinates; reference: starting point)
- **J, K:** Center point of circular arc
- **Ji, Ki:** Center point of circular arc (incremental) – Distance between starting point and Center point in Y and Z
- **PM:** Center point of circular arc (polar)
- **PMi:** Center point of circular arc – Distance between starting point and Center point (polar, incremental)
- **WM:** Center point of circular arc (angle in polar coordinates)
- **WMi:** Center point of circular arc (polar angle, incremental; reference: starting point)
- **R:** Radius
- **ANs:** Angle – Tangential angle at the starting point
- **ANe:** Angle – Tangential angle at the target point
- **ANp:** Angle to the previous element
- **ANn:** Angle to the subsequent element
- **F:** Further information: "Machining attributes", Page 426

ICP generates a **G182** or **G183** in **smart.Turn** mode of operation.



## Form elements of YZ plane

### Chamfer or rounding in YZ plane

Programming a chamfer or rounding radius:



- ▶ Select the Form Elements menu item



- ▶ Select the Chamfer menu item



- ▶ Enter the **Chamfer width BR**
- ▶ Alternative: Select the rounding menu item
- ▶ Enter the **Rounding radius BR**
- ▶ Enter the chamfer or rounding as first contour element: **Position AN**

Parameters:

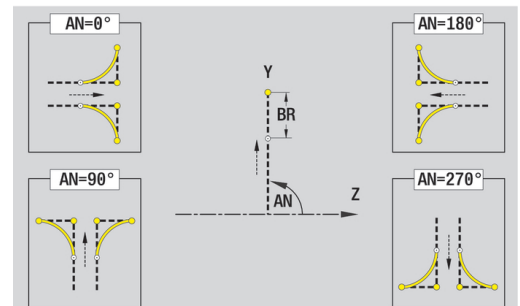
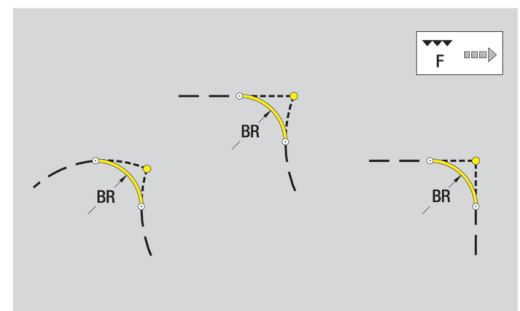
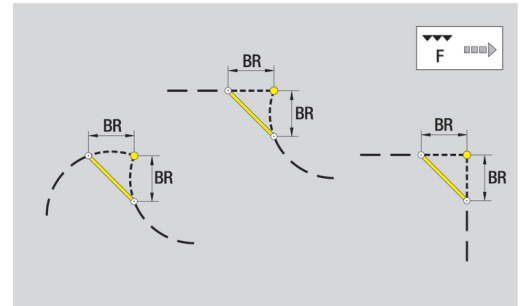
- **BR: Cham. width** or **Rounding radius**
- **AN: Element pos**
- **F: Further information:** "Machining attributes", Page 426

Chamfers or roundings are defined at contour corners. A **contour corner** is the point of intersection between the approaching contour element and the departing contour element. A chamfer or rounding cannot be calculated until the basic contour element is known.

**ICP** integrates the chamfer or rounding in the **G181**, **G182** or **G183** basic element in **smart.Turn** mode of operation.

Contour begins with a chamfer or a rounding: Enter the position of the **intended** corner as starting point. Then, in the form element menu, select Chamfer or Rounding. Since the **approaching contour element** is missing, enter the **Position AN** to clearly define the position of the chamfer or rounding.

**ICP** converts a chamfer or rounding at the start of the contour to a linear or circular element.



## Figures, patterns, and holes in YZ plane (lateral surface)

### Circle in YZ plane

Reference data of YZ plane:

- **ID: Contour**
- **PT: Milling depth**
- **C: Spindle angle**
- **XR: Reference diameter**

Parameters of figure:

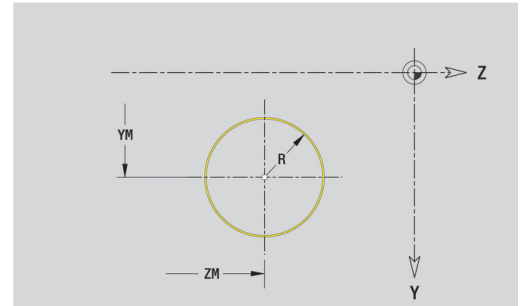
- **YM, ZM: Center**
- **R: Radius**

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours",  
Page 480

ICP generates the following:

- The **SURFACE Y** section code with the **Reference diameter** and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G384** with the parameters of the figure
- A **G309**



**Rectangle in YZ plane**

Reference data of YZ plane:

- **ID: Contour**
- **PT: Milling depth**
- **C: Spindle angle**
- **XR: Reference diameter**

Parameters of figure:

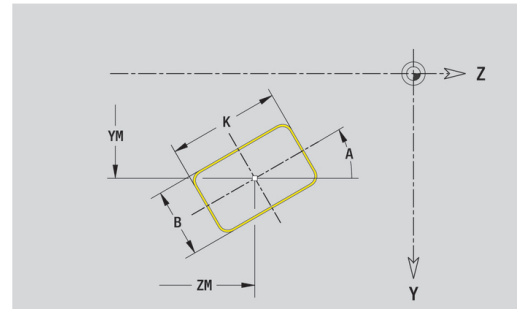
- **YM, ZM: Center**
- **A: Position angle**
- **K: Length**
- **B: Breadth**
- **BR: Cham. width or Rounding radius**

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours",  
Page 480

**ICP** generates the following:

- The **SURFACE Y** section code with the **Reference diameter** and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G385** with the parameters of the figure
- A **G309**



### Polygon in YZ plane

Reference data of YZ plane:

- **ID: Contour**
- **PT: Milling depth**
- **C: Spindle angle**
- **XR: Reference diameter**

Parameters of figure:

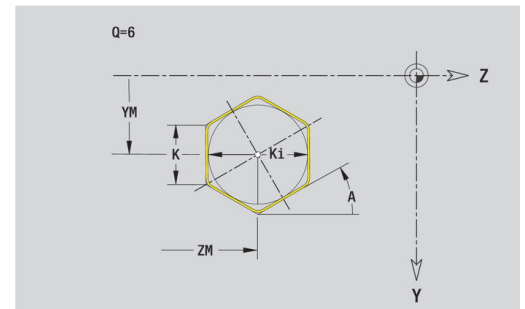
- **YM, ZM: Center**
- **A: Position angle**
- **Q: Number of corners**
- **K: Width across** – inscribed circle diameter
- **Ki: Edge length**
- **BR: Cham. width** or **Rounding radius**

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours",  
Page 480

ICP generates the following:

- The **SURFACE Y** section code with the **Reference diameter** and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G387** with the parameters of the figure
- A **G309**



**Linear slot in YZ plane**

Reference data of YZ plane:

- **ID: Contour**
- **PT: Milling depth**
- **C: Spindle angle**
- **XR: Reference diameter**

Parameters of figure:

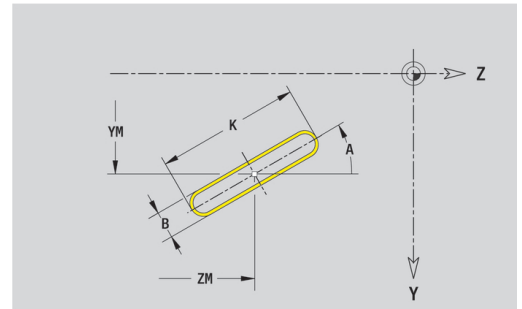
- **YM, ZM: Center**
- **A: Position angle**
- **K: Length**
- **B: Breadth**

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours",  
Page 480

ICP generates the following:

- The **SURFACE Y** section code with the **Reference diameter** and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G381** with the parameters of the figure
- A **G309**



### Circular slot in YZ plane

Reference data of YZ plane:

- **ID: Contour**
- **PT: Milling depth**
- **C: Spindle angle**
- **XR: Reference diameter**

Parameters of figure:

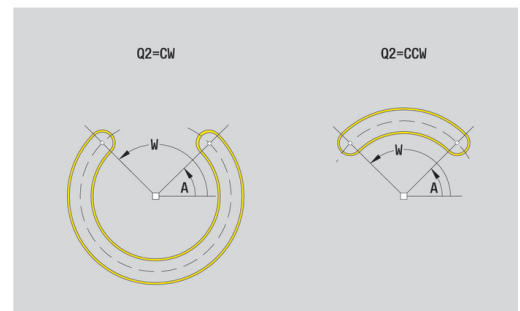
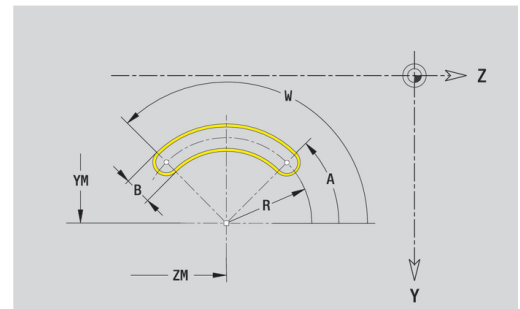
- **YM, ZM: Center**
- **A: Start angle**
- **W: Final angle**
- **R: Radius** – Curvature radius (reference: center point path of the slot)
- **Q2: Dir.rot.**
  - CW
  - CCW
- **B: Breadth**

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours",  
Page 480

ICP generates the following:

- The **SURFACE Y** section code with the **Reference diameter** and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Milling depth** parameters
- A **G382** or **G383** with the parameters of the figure
- A **G309**





### Hole in YZ plane

This function defines a single hole that can contain the following elements:

- **Centering**
- **Hole**
- **Cavity**
- **Thread**

Reference data of hole:

- **ID: Contour**
- **C: Spindle angle**
- **XR: Reference diameter**

Parameters of hole:

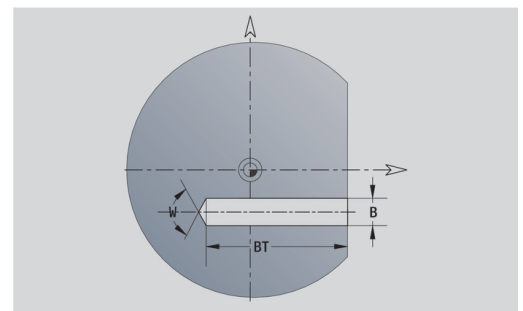
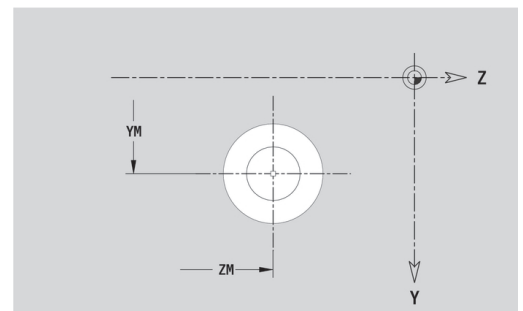
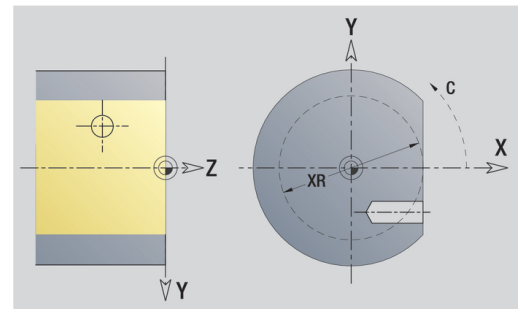
- **YM, ZM: Center**
- **Centering**
  - **O: Diameter**
- **Hole**
  - **B: Diameter**
  - **BT: Depth** (without algebraic sign)
  - **W: Angle**
- **Cavity**
  - **R: Diameter**
  - **U: Depth**
  - **E: Sink angle**
- **Thread**
  - **GD: Diameter**
  - **GT: Depth**
  - **K: Cut-in length**
  - **F: Thread pitch**
  - **GA: Thread direction**
    - **0: Right-hand thread**
    - **1: Left-hand thread**

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours",  
Page 480

**ICP** generates the following:

- The **SURFACE Y** section code with the **Reference diameter** and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Boring depth** ( $-1 * BT$ ) parameters
- A **G380** with the parameters of the hole
- A **G309**



### Linear pattern in YZ plane

Reference data of YZ plane:

- **ID: Contour**
- **PT: Milling depth**
- **C: Spindle angle**
- **XR: Reference diameter**

Parameters of pattern:

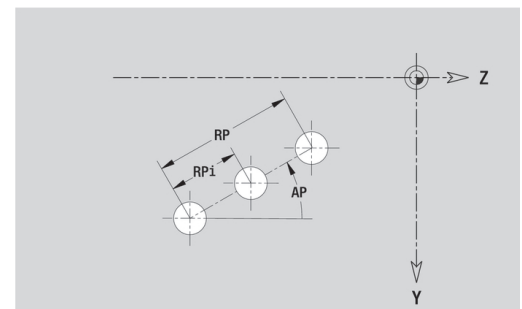
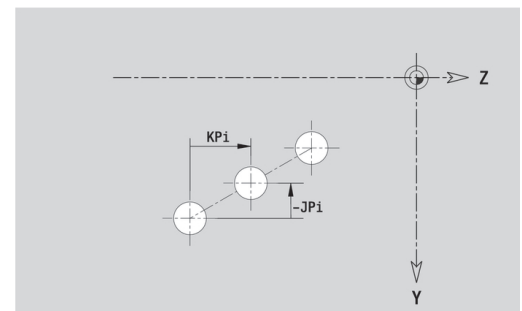
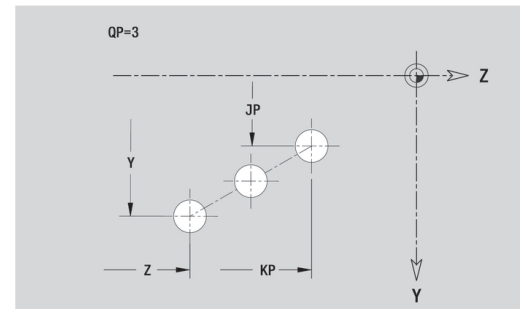
- **Y, Z: 1st pattern point**
- **QP: Quantity** of points in pattern
- **JP, KP: Final point** of pattern (in Cartesian coordinates)
- **JPi, KPi: Final point** – Distance between two pattern points (in Y and Z)
- **AP: Position angle**
- **RP: Length** – Total length of pattern
- **RPi: Length** – Distance between two pattern points
- Parameters of selected figure or hole

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours", Page 480

ICP generates the following:

- The **SURFACE Y** section code with the **Reference diameter** and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Milling depth** or **Boring depth** ( $-1 * BT$ ) parameters
- A **G481** with the parameters of the pattern
- The G code and the parameters of the figure or hole
- A **G309**



**Circular pattern in YZ plane**

Reference data of YZ plane:

- **ID: Contour**
- **PT: Milling depth**
- **C: Spindle angle**
- **XR: Reference diameter**

Parameters of pattern:

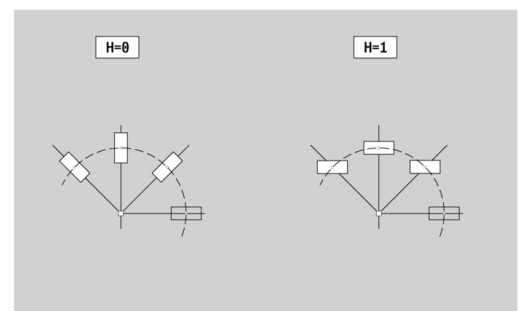
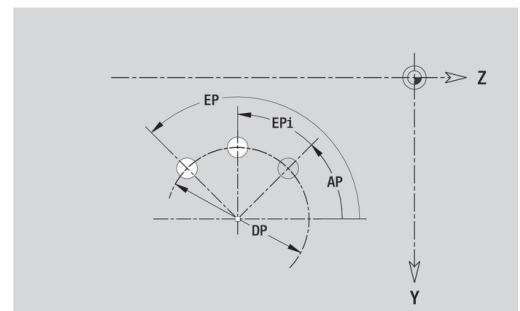
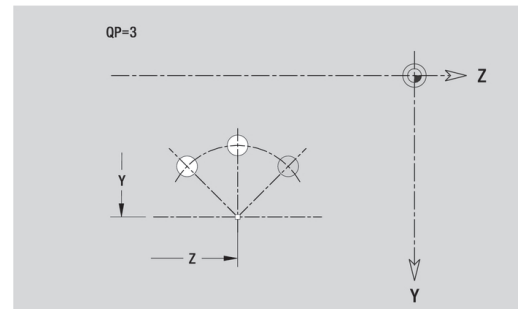
- **Y, Z: Center** of pattern
- **QP: Quantity** of points in pattern
- **DR: Dir.rot.** (default: 0)
  - **DR = 0**, without **EP**: Figures are arranged on a full circle
  - **DR = 0**, with **EP**: Figures are arranged on the longer circular arc
  - **DR = 0**, with **EPi**: The algebraic sign of **EPi** defines the direction (**EPi** < 0: clockwise)
  - **DR = 1**, with **EP**: clockwise
  - **DR = 1**, with **EPi**: clockwise (algebraic sign of **EPi** has no effect)
  - **DR = 2**, with **EP**: counterclockwise
  - **DR = 2**, with **EPi**: counterclockwise (algebraic sign of **EPi** has no effect)
- **DP: Diameter**
- **AP: Start angle** (default: 0°)
- **EP: Final angle** (no input: the pattern elements are distributed evenly around 360°)
- **EPi: Final angle – Angle** between two figures
- **H: Element pos**
  - **0: Normal** – The figures are rotated about the circle center (rotation)
  - **1: Master** – The position of the figure relative to the coordinate system remains unchanged (translation)
- Parameters of selected figure or hole

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours",  
Page 480

ICP generates the following:

- The **SURFACE Y** section code with the **Reference diameter** and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** and **Milling depth** or **Boring depth** ( $-1 * BT$ ) parameters
- A **G482** with the parameters of the pattern
- The G code and the parameters of the figure or hole
- A **G309**



### Single surface in YZ plane

This function defines a surface in the YZ plane.

Reference data of YZ plane:

- **ID: Contour**
- **C: Spindle angle**
- **XR: Reference diameter**

Parameters of single surface:

- **Z: Reference edge**
- **Ki: Depth**
- **K: Residual depth**
- **B: Breadth** (reference: **Reference dimension ZR**)
  - **B < 0**: Surface in negative Z direction
  - **B > 0**: Surface in positive Z direction

You can switch between **Depth Ki** and **Residual depth K** by soft key.

You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours", Page 480

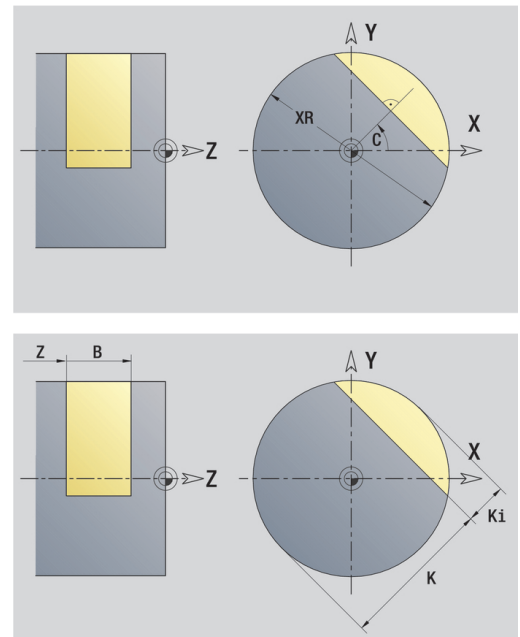
ICP generates the following:

- The **SURFACE Y** section code with the **Reference diameter** and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** parameter
- A **G386** with the parameters of the single surface
- A **G309**

### Soft key

Residual  
depth

Switch the field to the input of **Residual depth K**



### Centric polygon in YZ plane

This function defines centric polygons in the YZ plane.

Reference data of YZ plane:

- **ID: Contour**
- **C: Spindle angle**
- **XR: Reference diameter**

Parameters of single surface:

- **Z: Reference edge**
- **Q: No. of surfaces ( $Q \geq 2$ )**
- **K: Width across** – inscribed circle diameter
- **Ki: Edge length**
- **B: Breadth** (reference: **Reference dimension ZR**)
  - **B < 0:** Surface in negative Z direction
  - **B > 0:** Surface in positive Z direction

You can switch between **Edge length Ki** and **Width across K** by soft key.

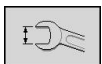
You can use the **Select reference plane** function to determine the **Reference diameter XR**.

**Further information:** "Reference data and nested contours", Page 480

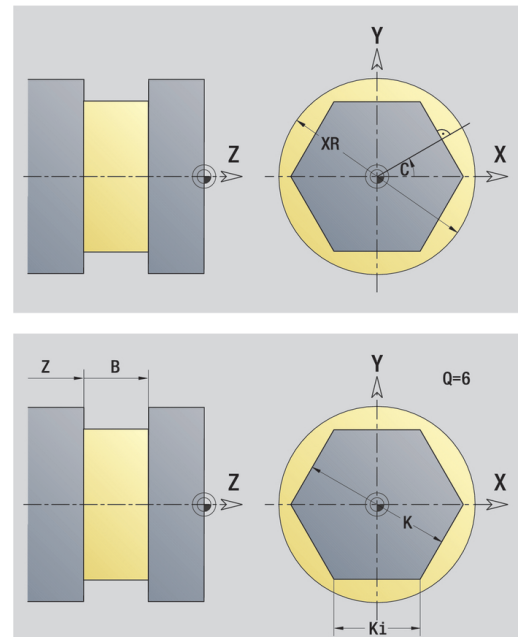
ICP generates the following:

- The **SURFACE Y** section code with the **Reference diameter** and **Spindle angle** parameters. The section code is omitted for nested contours.
- A **G308** with the **Contour name** parameter
- A **G487** with the parameters of the polygon
- A **G309**

### Soft key



Switch the field to the input of **Width across K**



## 6.16 Loading existing contours

### Integrating cycle contours in smart.Turn mode of operation

**ICP contours** that you have created for **cycle programs** can be loaded in **smart.Turn** mode of operation. **ICP** converts the contours into **G** codes and integrates them in the smart.Turn program. The contour is now part of the smart.Turn program.

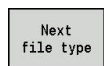
The **ICP editor** submode considers the type of contour. For example, you can load a contour defined for the face only if you have selected the face (C axis) in **smart.Turn** mode of operation.

Integrating a contour:

- ▶ Activate the **ICP editor** submode



- ▶ Press the **Contour list** soft key
- ▶ The **ICP editor** submode opens the **Select ICP contours** window



- ▶ Press the **Next file type** soft key until the cycle contours are displayed



- ▶ Select the file
- ▶ Load the selected file
- ▶ Complete the contour, if necessary
  - Workpiece blank or finished part contour: Complete or adapt the contour
  - C axis contour: Complete the reference data

Extension	Group
*.gmi	Turning contours
*.gmr	Contours of workpiece blanks
*.gms	Milling contours on front face
*.gmm	Milling contours on lateral surface

## DXF contours (option 42)

Contours that exist in DXF format are imported with the **ICP editor**. You can use DXF contours both for **Teach-in** submode and for **smart.Turn** mode of operation.

Requirements for the DXF contour:

- Only two-dimensional elements
- The contour must be in a separate layer (without dimension lines, without wraparound edges, etc.)
- Depending on the setup of the lathe, contours for turning operations must be either in front of or behind the workpiece datum (turning center)
- No full circles, no splines, no DXF blocks (macros), etc.



The control supports all DXF formats.

**Contour preparation during the DXF import:** Since the DXF format is fundamentally different from the ICP format, the contour is converted from DXF to ICP format during the import.

Changes during this conversion:

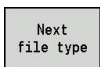
- Polylines are transformed into linear elements
- Gaps between contour elements < 0.01 mm are closed
- Open contours are described from **right to left** (starting point: right)
- The starting point on closed contours is specified according to internal rules
- The rotational direction for closed contours is counterclockwise

Integrating a DXF contour:

▶ Activate the **ICP editor** submode

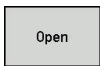


- ▶ Press the **Contour list** soft key
- ▶ The **ICP editor** submode opens the **Select ICP contours** window



- ▶ Press the **Next file type** soft key until the DXF contours are displayed (extension: **.dxf**)

▶ Select the file



▶ Open the selected file



▶ Select the DXF layer



▶ Load the selected contour

- ▶ Complete the contour, if necessary
  - Workpiece blank or finished part contour: Complete or adapt the contour
  - C axis contour: Complete the reference data

## 6.17 Contour groups

### Contour groups in smart.Turn mode of operation

The control supports up to four contour groups in one NC program. The **CONTOUR GROUP** section code initiates the description of a contour group.

You can create a workpiece blank, finished part and auxiliary contours for each contour group. The **ICP editor** submode considers the shift programmed in the specific contour group for the description and display.

**G99** assigns the machining operations to a contour group

Display in NC program:

- If you have activated the graphics in the NC program, the control displays the element on which the cursor is positioned when navigating through the contour description
- The control shows the number of the contour group at top left in the graphic window

Display in unit programming:

- If you program an ICP unit in **smart.Turn** mode of operation, the control displays **ICP contours**. The various contours and contour groups can be displayed as long as you have not selected a contour in the **FK** parameter

### Navigation keys

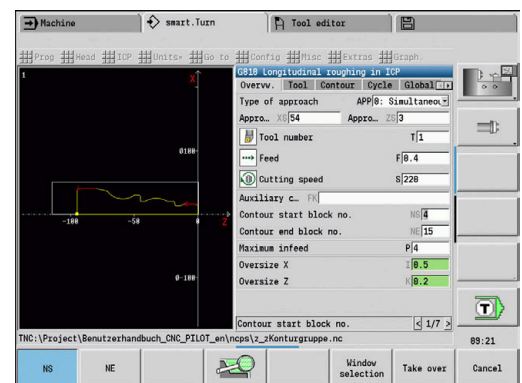
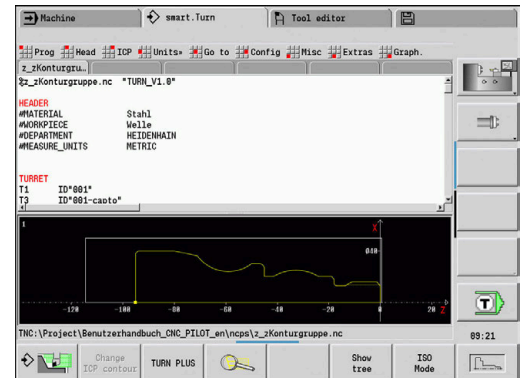


Switch to the next or previous contour (contour group/workpiece blank/auxiliary contour/finished part)



Switch to the next contour element

The control shows the number of the contour group and name of the auxiliary contour if applicable at top left in the graphic window.






# 7

**Graphic simulation**

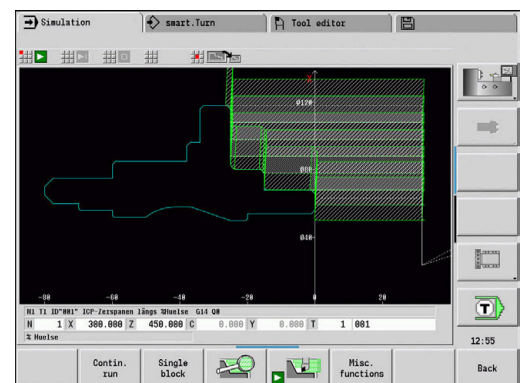
## 7.1 Simulation submode

Soft key	Meaning
	Press this soft key to call <b>Simulation</b> submode

**Simulation** submode can be called from the following operating modes:

- **smart.Turn** mode of operation
- **Program run** submode **Program run**
- **Teach-in** submode **Teach-in**
- **Machine** mode of operation (MDI cycles)


When called from **smart.Turn** mode of operation, **Simulation** submode opens the large simulation window and loads the selected program. When you call **Simulation** submode from the Machine modes of operation, either the small simulation window or the last used window opens.





## Using Simulation submode

**Simulation** submode is operated by soft keys in all operating states. In addition, you can always use the menu items (numeric keys) to operate simulation, even in the small simulation window, where the menu bar is not visible.

### Starting and stopping with soft keys


- 


Start the simulation from the beginning. The soft key switches to the stop symbol; you can now use the soft key to stop and resume the simulation, depending on the simulation status
- 


Resume a stopped simulation (Single block mode)
- 

The soft key indicates that a simulation is currently running. Pressing the soft key stops the simulation

### Starting and stopping with menu items


- 

Start the simulation from the beginning
- 




Resume a stopped simulation (Single block mode)
- 

The key indicates that a simulation is currently running. Pressing the key stops the simulation


### Large and small simulation window

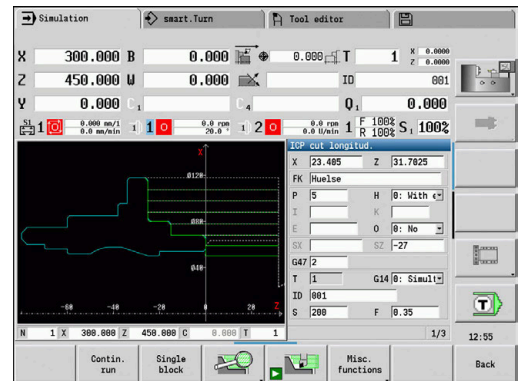
Menu item	Meaning
	This menu item switches between the small and large simulation window, even if the menu bar is not visible

### 2-D and 3-D view in smart.Turn mode of operation


Menu item	Meaning
	This menu item switches to the 3-D view of the machined workpiece
	This menu item switches to the 3-D simulation <b>Further information:</b> "3-D simulation in Simulation submode", Page 562
	This menu item switches to the 2-D simulation

### Soft keys with active simulation window

	Call the warnings. If the interpreter issues warnings during simulation (e.g. "Residual material due to ..."), the soft key is activated and the number of warnings is shown. Each time the soft key is pressed, it switches to the next warning
---	--



### Soft keys with active simulation window

Contin. run	In <b>Contin. run</b> mode, all cycles of the program are simulated in <b>Program run</b> submode without stopping
Single block	In <b>Single block</b> mode, the simulation stops after each traverse path (basic block)
	Open the soft-key menu for the <b>zoom</b> function and display the zoom frame <b>Further information:</b> "Adjusting the displayed detail", Page 551
Misc. functions	Switch the menu and the soft-key row over to the <b>Misc. functions</b>
Change variables	Change variables in Simulation submode This soft key is only active if you are defining variables in the <b>PROGRAM HEAD</b> section.

With the other menu items and the soft keys listed in the table, you define the sequence of the simulation, activate the zoom function, or use the miscellaneous functions to make settings for the simulation.



You can operate **Simulation** submode with the numeric keys, even if the menu bar is not visible



- In the Machine modes of operation, an activation of the **Single block** soft key is also effective in automatic mode
- In the Machine modes of operation, you can start the automatic program run directly from **Simulation** submode with Cycle **On**

## The miscellaneous functions

You use the miscellaneous functions to select the simulation window, to determine how the tool path is depicted, or to call the time calculation.

The tables provide you with an overview of the menu and soft-key functions.

### Miscellaneous functions menu



Select the simulation window

**Further information:** "Simulation window", Page 543



Activate a mid-program startup

**Further information:** "Simulation with start block", Page 553



Select the time calculation

**Further information:** "Time calculation", Page 555



Switch between the large and the small simulation window

**Further information:** "Using Simulation submode", Page 539



Switch between the single and multiple window view

**Further information:** "Multiple window view", Page 544



Misc

- Save contour

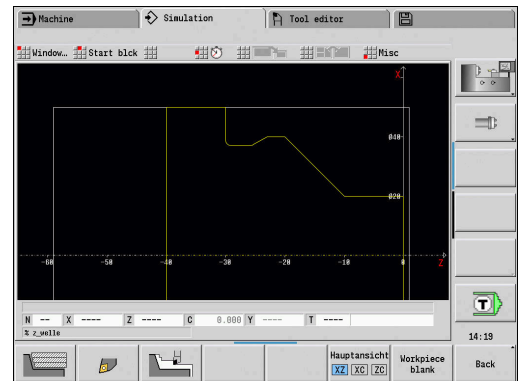
**Further information:** "Saving the contour", Page 556

- Dimensioning

**Further information:** "Dimensioning", Page 558

- Settings

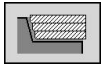
**Further information:** "General Settings", Page 560



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### Miscellaneous functions soft keys

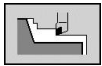
---



Switch between wire-frame graphics and cutting-path graphics



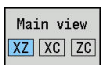
Switch between light-dot and cutting-edge view



Activate the 2-D material-removal graphic



Switch to the next contour group  
This soft key is only active if you are working with multiple contour groups.



Select the view



Display the internally used workpiece blank for programs without a defined workpiece blank



Switch the focus to the next window. Only active for multiple window view

**Further information:** "Multiple window view", Page 544

## 7.2 Simulation window

### Setting up the views

With the simulation windows described in the following you check not only the turning operation but also the drilling and milling operations.

- **XZ view (turning view):** The turning contour is depicted in the XZ coordinate system. The configured coordinate system is taken into account (tool carrier in front of/behind the workpiece, vertical lathes)
- **XC view (face view):** The displayed coordinate system is a Cartesian system with the axis designations XK (horizontal) and YK (vertical). The angle position  $C = 0^\circ$  is on the XK axis, the positive direction of rotation is counterclockwise
- **ZC view (lateral surface view):** The contour display and traverse-path display are oriented to the position on the **unrolled lateral surface** and the Z coordinates. The upper and lower lines of this **workpiece** correspond to the angular positions  $C = -180^\circ/+180^\circ$ , respectively. All drilling and milling operations are within the range  $-180^\circ$  to  $+180^\circ$ 
  - Cycle program or DIN program with workpiece blank definition: The basis for the **unrolled workpiece surface** is the dimensions of the programmed workpiece blank
  - Cycle program or DIN program without workpiece blank definition: The **unrolled workpiece surface** is based on the dimensions of the **standard workpiece blank**
- **YZ view (side view):** The contour and the traverse path are shown in the YZ plane. The side view depicts only the Y and Z coordinates—not the spindle position

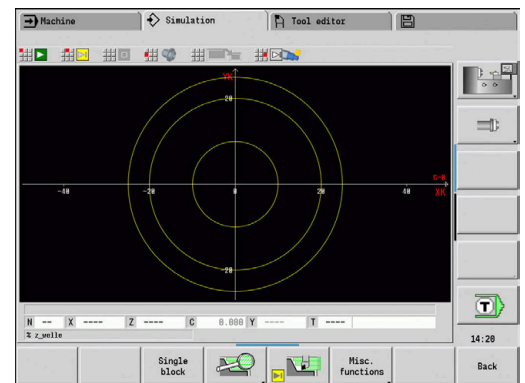
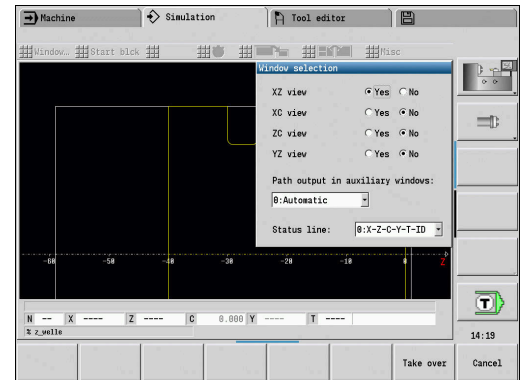


Front face and lateral surface windows operate with a **fixed** spindle position. When the machine turns the workpiece, **Simulation** submodule moves the tool.

### Simulation of multiple contour groups

Please note the following when working with multiple contour groups:

- In the **XZ view (turning view)**, the control displays all contour groups.
- In all other views, the control displays the current contour group.



## Single-window view

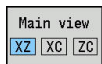
Only one view is shown in the small simulation window. Switch the view using the **Main view** soft key. You can also use this soft key when only one single view is displayed in the large simulation window.

With cycle programs, you can activate the face or lateral surface view only when the C axis is used in the program.

---

### Main view soft key

---



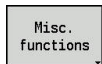
Selecting the view:

- Turning view XZ
- Face view XC
- Lateral surface view ZC

## Multiple window view

The multiple window view is possible only in the large simulation window.

Activating the multiple window view:



- ▶ Press the **Miscellaneous functions** soft key



- ▶ Select the **Window** menu item (in the large simulation window)
- ▶ Select the desired window combination
- ▶ Set **Path output in auxiliary windows:**

**The path display in the supplementary windows:** The front face window, surface window, and YZ view are considered **supplementary windows**.

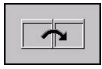
The following setting specifies whether **Simulation** submode depicts traverse paths in these windows:

- **Automatic:** **Simulation** submode displays traverse paths if the C axis has been oriented or a **G17** or **G19** has been executed. **G18** or a C axis out of orientation stops the output of the traverse paths
- **Always:** **Simulation** submode shows every traverse path in all simulation windows

In the multiple window view, a window is marked by a green frame. This window has the **focus**, which means that zoom settings and other functions apply to this window.



Switching the focus:



- ▶ Press the soft key several times until the focus is on the desired window



- ▶ Alternative: Press the **GOTO** key

Switching between the single-window and multiple-window view:



- ▶ Select the menu item (or the decimal point key) to switch from the multiple-window to single-window view
- ▶ The window with the green frame is shown as a single-window view

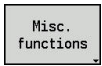


- ▶ Pressing the menu item again (or the decimal point key) switches back to the multiple-window view

## Status display

You can switch the status display in the large simulation window only.

Switching the status display:



- ▶ Press the **Miscellaneous functions** soft key



- ▶ Select the **Window** menu item
- ▶ Select the desired **Status line**:
  - **0: X-Z-C-Y-T-ID** (axis values and tool)
  - **1: X-Z-C-Y-G16** (axis values and tilt)
  - **2: G95-G96-M-SP** (axis values, feed rate, spindle speed, direction of rotation, and main spindle)



You can also switch the status display with the triple-arrow key in the large simulation window.

## 7.3 Views

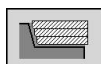
### Traverse path display

**Rapid traverse paths** are shown as a broken white line.

Feed paths are displayed either as a line or as a **cutting path**, depending on the soft-key setting:

- Line display:** A solid line describes the path of the theoretical tool tip (wire-frame graphics). The wire frame display is particularly convenient if you only need a quick overview of the proportioning of cuts. The path of the theoretical tool tip, however, is not identical with the contour of the workpiece. This view is therefore not as suitable if you wish to run a thorough check of the machined contour. This **falsification** is compensated by the cutting radius compensation
- Cutting path display:** **Simulation** submode uses hatch marking to depict the surface covered by the **cutting area** of the tool. You can see the area that will actually be machined, with the exact geometry of the cutting edge (cutting radius, cutting width, position of cutting edge, etc.) already accounted for. You can check in **Simulation** submode whether the contour is machined completely or needs to be reworked, whether the contour is damaged by the tool or overlaps are too large. The cutting-path graphics are especially interesting for recessing or drilling operations and for machining inclined surfaces where the tool shape has an essential influence on the accuracy of the resulting workpiece

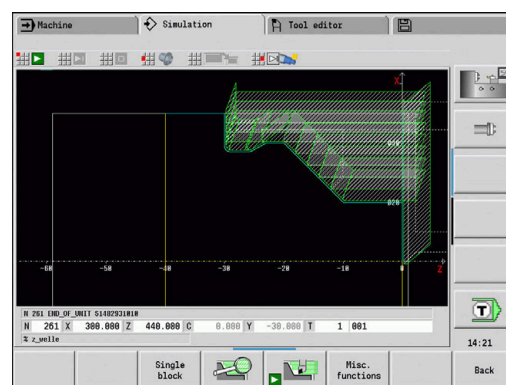
Activating the cutting path graphics:



- ▶ When the soft key is activated, the **cutting paths of traverse** are shown



The **pathDelay** (114802) user parameter can be used to control the simulation speed.

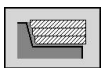


## Tool display

You select by soft key whether the tool cutting edge or the **light dot** is shown:

- The **tool cutting edge** is shown with the correct angles and cutting radius, as defined in the tool database
- **Light dot**: A white square (light dot) is shown at the currently programmed position. The light dot represents the position of the imaginary cutting edge

### Miscellaneous functions soft keys



Switch between wire-frame graphics and cutting-path graphics



Switch between light-dot and cutting-edge view

### Depicting the tool holder in Simulation submode

The control can depict the associated tool holder with the corresponding dimensions in addition to the tool's cutting edge.

The requirements for this are:

- Creating a new tool holder in the **Holder editor** or selecting an existing holder
- Describing the tool holder with the required parameters (type, dimensions and position)
- The appropriate tool holder must be assigned to the tool (**HID**)

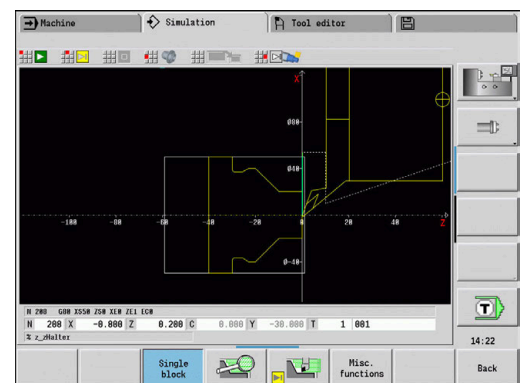


Refer to your machine manual.

The depiction of the tool carrier depends on the machine.

The graphic displays a tool carrier if the following requirements are fulfilled:

- The machine tool builder has saved a description of the tool carrier, e.g. B axis head
- You have assigned a tool holder to a tool



## 2-D material-removal graphic

### 2-D material-removal graphic

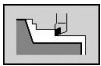
The 2-D material-removal graphic shows the workpiece blank as a **filled surface**. When the cutting edge passes through the workpiece blank, the workpiece area covered by the tool is erased in the graphic.

The 2-D material-removal graphic mode shows all paths of traverse according to the programmed speed. The 2-D material-removal graphic is only available in turning view (XZ). You activate this type of simulation by soft key.



You can change the speed of simulation in the 2-D material-removal graphic by using the keys shown in the table.

### Miscellaneous functions soft keys

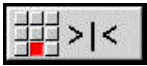


Activate the 2-D material-removal graphic

### Menu for the 2-D material-removal graphic



Slow the 2-D material-removal graphic



2-D material removal graphic at the programmed feed rate



Accelerate the 2-D material-removal graphic

## 3-D view

### Soft key



### Meaning

The **3-D view** menu item switches to a perspective view and shows the programmed finished part

With the 3-D view, you can display the workpiece blank and the finished part with all turning operations, milling contours, drilling and boring operations as well as threads in a solid-model view. Tilted Y planes and machining operations referenced to them, such as pockets or patterns, are also displayed correctly by the control.

The control displays milling contours as a function of the **HC: Milling/drilling attribute** parameter from **G308**. If you have selected the contour milling, pocket milling or area milling values in this parameter, the graphic shows the respective 3-D elements. If other values are specified in the **HC** parameter or if values are missing, the control depicts the described milling contour as a blue line.

Each element that cannot be calculated by the control is displayed as an orange line; for example, if an open milling contour is programmed as a pocket. With the soft keys and the menu functions, you can influence the display of the workpiece.



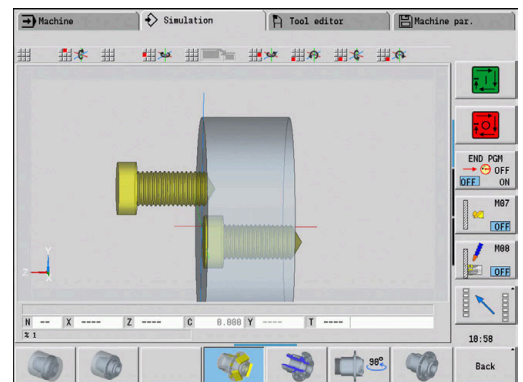
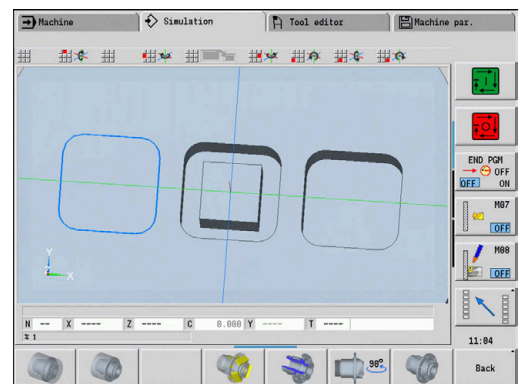
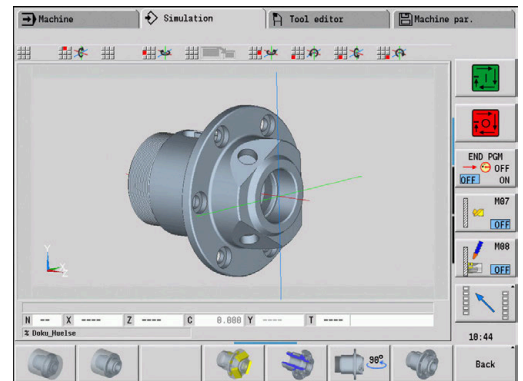
The finished part contour programmed in the **FINISHED** section is shown in the graphic regardless of the machining operation in the NC program.

You can cancel the calculation of the 3-D view by pressing the **ESC** key or the **CANCEL** soft key.

### Check mode

The check mode enables you to verify the correct positioning of holes and milling contours, for example.







In the check mode the control displays turning contours in gray, and drilling and milling contours in yellow. For a better overview, the control shows all contours as transparent.









### Rotating the 3-D view with the menu functions

With the menu functions you rotate the graphic around the depicted axes. The **perspective view** soft key resets the graphic to its initial condition.

#### 3-D view soft keys

	Display the finished part and the programmed workpiece blank
	Display the finished part and the updated workpiece blank
	Activate/deactivate the check mode
	Display a section view
	Select the side view Rotate the side view by 90°
	Select the perspective view

#### Menu for the 3-D view

	Tilt the graphic backward
	Rotate the graphic horizontally in the indicated direction
	Rotate the graphic horizontally in the indicated direction
	Rotate the graphic counterclockwise
	Tilt the graphic forward
	Rotate the graphic clockwise

### Rotating and moving the 3-D view with the mouse


With the right mouse button pressed you can move the displayed workpiece as required.

When you press and hold the left mouse button, you can do the following:

- Vertical movement in the simulation window: Tilt the workpiece forward or backward
- Horizontal movement in the simulation window: Rotate the workpiece horizontally around its own axis
- Horizontal or vertical movement at the edge of the simulation window (gray border): Rotate the workpiece clockwise or counterclockwise
- Movement in any direction: Rotate the workpiece in any direction

## 7.4 Zooming function in simulation

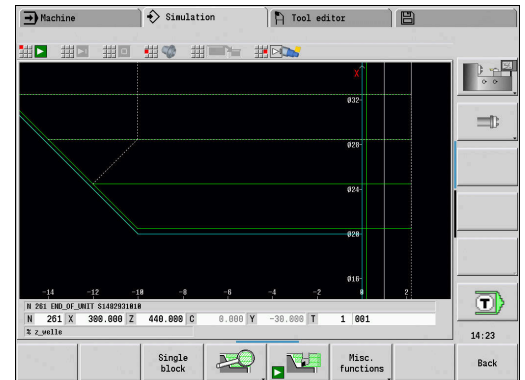
### Adjusting the displayed detail







Soft key	Meaning
	Press this soft key to activate the <b>zoom function</b>

With the zoom menu, you can modify the detail displayed in the simulation window. As an alternative to the soft keys, you can use the arrow keys and the **PgDn** and **PgUp** keys to change the displayed detail.

For cycle programs, and when a program is started for the first time in **Simulation** submode, the control automatically selects the detail. When you simulate the same smart.Turn program again in **Simulation** submode, the last selected detail is used.

In the multiple window view, the zoom function is effective for the window marked by a green frame.






Soft keys in the zoom menu	Meaning
	<ul style="list-style-type: none"> <li>Delete all traverse paths drawn so far</li> <li>If contour follow-up is active, the workpiece blank is updated and newly drawn</li> <li>Close the zoom menu</li> </ul>
	Extend the displayed detail directly (zoom –)
	Switch back to the standard screen detail and close the zoom menu
	Return to the last detail selected
	Load the area selected by the red frame as the new detail and close the zoom menu
	Close the zoom menu without changing the selected detail


### Modifying the displayed detail by using keys

You can use the following keys to change the displayed detail without opening the zoom menu.

#### Keys for modifying the displayed detail

  The arrow keys move the workpiece in the indicated direction



 Reduce the displayed workpiece (zoom -)

 Magnify the displayed workpiece (zoom +)

### Modifying the detail with the zoom menu


When you activate the zoom menu, a red frame is shown in the simulation window. This red frame indicates the zoom area that you can select by pressing the **Apply** soft key or the **ENT** key. Use the following keys to change the frame size and position.

#### Keys for modifying the displayed detail

  The arrow keys move the red frame in the indicated direction

 Reduce the size of the red frame

 Increase the size of the red frame











## 7.5 Simulation with start block

### Start block in smart.Turn programs

smart.Turn programs are always simulated from the first block, regardless of which block the cursor is in. If you use the **Start block, Simulation** submode suppresses all output up to the startup block. If there is a workpiece blank, the simulation scans the blocks up to this position, updates the workpiece blank and redraws it.

The simulation then draws the traverse paths starting from the startup block.





Activating a mid-program startup:

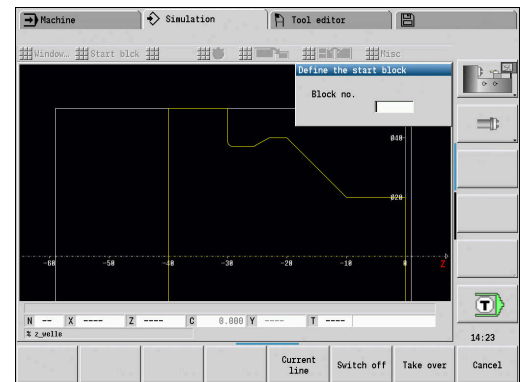
- |   |  |
|---|--|
|    | ▶ Press the <b>Miscellaneous functions</b> soft key  |
|    | ▶ Select the <b>Start blk</b> menu item  |
|    | ▶ Enter the number of the startup block  |
|  | ▶ Transfer the startup block to <b>Simulation submode</b>  |
|  | ▶ Go back to the main menu of <b>Simulation submode</b>  |
|  | ▶ Start the simulation   |
|  | ▶ The control scans the NC program up to the startup block, updates the workpiece blank and stops at this position |
|  | ▶ Continue the simulation  |

The block number for startup is shown in the lowest line of the display. The field for the startup block and the block number in the display have a yellow background as long as the simulation is performing the block scan.

Mid-program startup remains on even if you cancel the simulation. If you restart the simulation after cancellation, it stops at the **MACHINING** section code. This enables you to change settings before continuing the simulation.

#### Start blk soft keys

	Load the NC block number in the display as the startup block
	Switch off the mid-program startup
	Load the defined startup block and activate the mid-program startup
	Cancel the mid-program startup



### Mid-program startup in cycle programs

For cycle programs, first place the cursor on a cycle and then call **Simulation** submode. The simulation begins with this cycle. All previous cycles are ignored.

The **Start blk** menu item is deactivated for cycle programs.

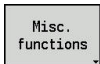
## 7.6 Time calculation

### Showing the machining times

During simulation, the machining and idle-machine times are calculated. The machining times, idle times and total times are shown in the **time calculation** table (green: machining times; yellow: idle times). If you are working with cycle programs, each cycle is shown in a separate line. In DIN programs, each line represents the use of a new tool (for each tool call with **T**).

If there are more table entries than fit on a screen page, you can call further time data with the arrow keys and **PgUp/PgDn**.

You can access the machining times as follows:



- ▶ Press the **Miscellaneous functions** soft key



- ▶ Select the **Time calculation** menu item

T	ID	Mach. Line	Remo(C)	Sum	[h:min:s]
T1	882AP1	0:04	0:01	0:05	
T1	882AP1	0:20	0:05	0:34	
T1	882AP1	0:20	0:05	0:34	
T2	151-000.2	0:18	0:05	0:23	
T2	151-000.2	0:00	0:04	0:18	
T3	201-000.1	0:08	0:01	0:09	
Total machining time:					
1:17					0:22
1:39					

N 84 G8 Z:64  
 N 84 X 270.000 Z -64.000 D 0.000 Y 0.000 T 3 201-000.1  
 S 1

## 7.7 Saving the contour

### Saving the generated contour in Simulation submode

You can save a contour generated in **Simulation** submode and load it into **smart.Turn** operating mode.

Example: Describe the workpiece blank and finished part and simulate machining of the first setup. Then, save the machined contour and use it for the second setup.

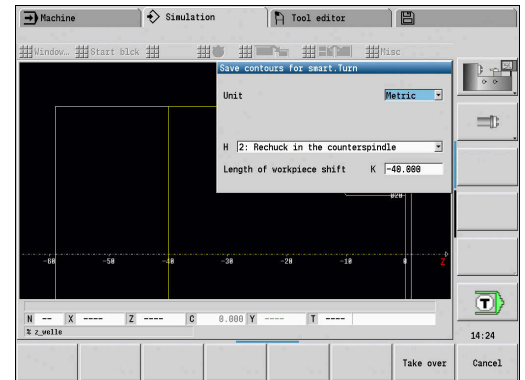
During **contour generation** the control saves all contours of the selected contour group.

**Simulation** submode considers the following shifts of the workpiece datum and/or a mirroring of the workpiece:

- 0: Only move
- 1: Turn over in the main spindle (mirroring)
- 2: Rechuck in the counterspindle (shifting and mirroring)

Saving the contour:

- ▶ Press the **Miscellaneous functions** soft key
  - ▶ Select the **Misc** menu item
  - ▶ Select the **Save contour** menu item
  - ▶ The control opens a dialog box, in which you can define the following input fields:
    - Unit: Contour description metric or in inches
    - Selection of contour group **Q**
    - Type of shift **H**
    - Length of workpiece shift **K**: Shift the workpiece datum



### Loading the saved contour



Only add the saved contour to newly created or copied programs, because all previously generated contours are overwritten. This action cannot be undone.

In **smart.Turn** mode of operation, you can load the workpiece blank and finished part contour generated during simulation into the program. Select the **Insert contour** function in the **ICP** menu.

When loading the contour into the mode of operation, first all contours in all planes are automatically deleted. Then, all saved contours in all planes are loaded from **Simulation** submode.




The **Save contour** function in **Simulation** submode converts all contours in all planes of the selected contour group and the NC editor replaces all contours. If the program contains contour groups, the group where the cursor is positioned will be replaced following a confirmation request.

## 7.8 Dimensioning

### Measuring the generated contour in Simulation submode

You can measure a contour generated in **Simulation** submode or have the dimensions displayed that were used during programming.






Measuring a contour:

- 
  - ▶ Press the **Miscellaneous functions** soft key
- 
  - ▶ Select the **Misc** menu item
- 
  - ▶ Select the **Dimensioning** menu item

You have the following possibilities:

- Element dimensioning
- Point dimensioning
- Setting a datum

#### Dimensioning soft keys

	Select <b>Element forward</b>
	Select <b>Element back</b>
	Select <b>Next contour group</b> (only active with multiple contour groups)
	Select <b>Next contour</b>
	Select <b>Previous contour</b>



### Element dimensioning menu item

The Element dimensioning menu item is automatically active after you have selected the dimensioning function. All data of the marked contour element are shown in the display below the graphic.

- The arrow indicates the direction of the contour description
- To next contour element: Press the **Element forward/back** soft key
- Change contour: Press the **Previous contour** or **Next contour** soft key



The individual elements are measured for figures.

### Point dimensioning menu item

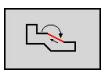
The control displays the dimensions of the contour point relative to the datum.

- To next contour point: Press the **Element forward/back** soft key
- Change contour: Press the **Previous contour** or **Next contour** soft key

### Menu item for setting the datum

This function is only available with point dimensioning. It enables you to shift the datum and measure the distance to the datum.

Setting the datum:



- ▶ Use the **Element back** soft key to select a new datum



- ▶ Select the **Presetting** menu item
- > The point symbol changes color



- ▶ Use the **Element back** soft key to select the point
- > The control displays the distance relative to the selected datum

### Menu item for canceling the preset

Canceling the preset:



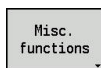


- ▶ Select the **Preset from** menu item
- > The preset is canceled.
- > The displayed values once again reference the original preset.

## 7.9 Settings

### General Settings

In **Simulation** submode, you can define general simulation Settings.

Defining Settings:

- 
  - ▶ Press the **Miscellaneous functions** soft key
- 
  - ▶ Select the **Misc** menu item
- 
  - ▶ Select the **Settings** menu item

The following settings are available:

- Mark the machining area  
**Further information:** "Mark the machining area", Page 560
- Activate the variable display  
**Further information:** "Variables", Page 560
- C0 – Marking on workpiece/3D  
**Further information:** "C0 – Marking on workpiece/3D", Page 561

#### Mark the machining area

In 2-D simulation, you can mark the following machining areas:

- 0: Off – No machining area will be marked
- 1: Line – The current cycle will be marked in blue
- 2: Area – The currently machined cycle, including the approach and departure areas will be marked with a blue frame



This setting is volatile.

#### Variables

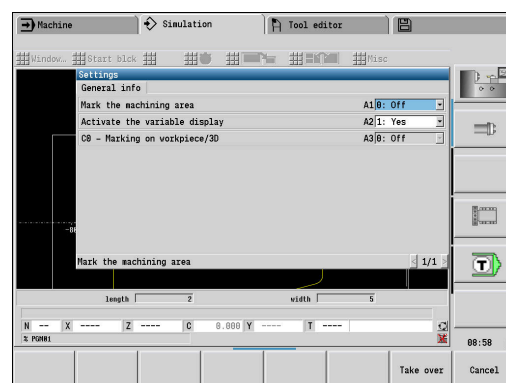
##### Activate the variable display

In 2-D and 3-D simulation, you can display the variables defined in the **PROGRAM HEAD** program section.

**Further information:** smart.Turn and DIN Programming User's Manual

Activate the variable display

- 0: No – Variables are not displayed
- 1: Yes – Variables are displayed below the simulation window





### Change variables

In 2-D and 3-D simulation, you can Change variables defined in the **PROGRAM HEAD** program section.

Change variables:



- ▶ Press the **Change variables** soft key
- > You can now change the variables.



- ▶ Press the **Take over** soft key



If you change variables during the Simulation, the Simulation may be aborted.

### C0 – Marking on workpiece/3D

In 3-D simulation, you can display the **C0** marking on the workpiece. This way, it is possible to check the position of C axis machining:

- 0: Off – No **C0** marking is displayed
- 1: On – The **C0** marking is shown with a green line



This setting is volatile.

## 7.10 3-D simulation

### 3-D simulation in Simulation submode

In the **Simulation** submode, you can test a program with the 3-D simulation.

Activating 3-D simulation:



- ▶ Select the **3-D simulation** menu item

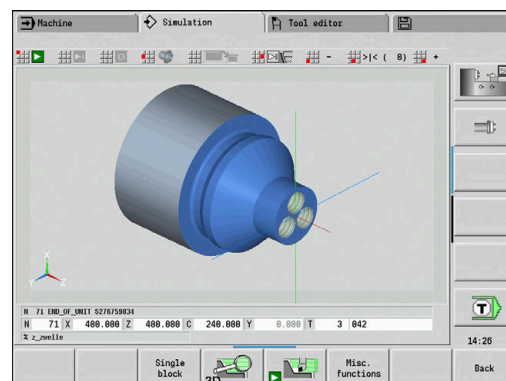
Deactivating 3-D simulation:







- ▶ Select the **2-D simulation** menu item

The following functions are identical to 2-D simulation:

- Using the simulation  
**Further information:** "Using Simulation submode", Page 539
- 3-D view  
**Further information:** "3-D view", Page 549
- Mid-program startup  
**Further information:** "Start block in smart.Turn programs", Page 553
- Time calculation  
**Further information:** "Time calculation", Page 555
- Saving contours  
**Further information:** "Saving the contour", Page 556



### Miscellaneous functions soft keys

	Position a thread pattern on the surface
	Display the workpiece edges
	Switch to the next contour group This soft key is only active if you are working with multiple contour groups.
	Display the tool holders



This function can only be used if values have been specified in the optional **WHT** and **TOF** parameters of the tool holder function.

**Further information:** "Holder editor", Page 580

### Simulation of multiple contour groups

In 3-D simulation, only a single contour group is shown. If the NC program includes multiple contour groups, you can use the soft key to change between the contour groups.

### 3-D zoom

The zoom function enables you to show workpiece blanks and finished parts in various perspectives.

Activating the 3-D zoom:



- ▶ Press the **3-D zoom** soft key



You can rotate the 3-D simulation by using the menu items and the mouse.

**Further information:** "Rotating the 3-D view with the menu functions", Page 550

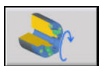
**Further information:** "Rotating and moving the 3-D view with the mouse", Page 550

If the cutting edge collides with the workpiece during rapid traverse, the sectional planes are displayed in red.

### Soft keys for the 3-D zoom



Rotate holes or milling contours to the left



Rotate holes or milling contours to the right



Display a section view



Select the side view. Rotate the side view by 90°



Select the perspective view



# 8

**Tool and  
technology  
database**

## 8.1 Tool database

You usually program the coordinates for the contour by taking the dimensions from the drawing. To enable the control to calculate the slide path, compensate the cutting radius and determine the proportioning of cuts, you need to enter the tool length, cutting radius, tool angle, etc.

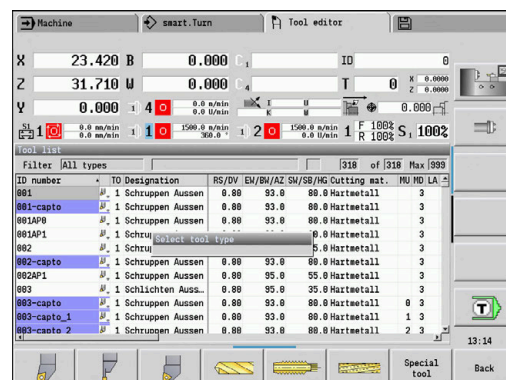
The control can save up to 250 tool data records (optionally 999); each tool data record is identified by an ID number (name). The tool list indicates the maximum number of tool data records and the number of data records found. For each tool, you can enter an additional tool description which makes it easier to find the tool data again when needed.

**Machine** mode of operation has functions for determining the tool length dimensions.

**Further information:** "Tool measurement", Page 138

Wear compensation is managed separately. This allows you to enter new compensation values at any time, even during program run.

You can also assign a **cutting material** to the tools, which gives you direct access to the technology database (feed rate, cutting speed). This saves you a lot of time since you only need to determine and enter the cutting data once.










## Tool types

Tools for drilling, recessing, finishing, etc., have very different shapes. Therefore, the reference points for determining the tool length and other tool data also vary.

The following table provides an overview of the tool types.

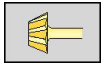
### Tool types

Soft key	Function	Description
	<b>Standard turning tools</b> <ul style="list-style-type: none"> <li>■ Roughing tools</li> <li>■ Finishing tools</li> </ul>	Page 588
	<b>Button tools</b>	Page 588
	<b>Recess. tool</b> <ul style="list-style-type: none"> <li>■ Recessing tools</li> <li>■ Parting tools</li> <li>■ Recess turning tools</li> </ul>	Page 589
	<b>Threading tool</b>	Page 590
	<b>NC center drill</b>	Page 592
	<b>Center drill</b>	Page 593
	<b>Counterbore</b>	Page 594
	<b>Countersinker</b>	Page 595
	<b>Standard milling cutter</b>	Page 588
	<b>Twist drill</b>	Page 591
	<b>Indexable-insert drill</b>	Page 591
	<b>Tap</b>	Page 597
	<b>Reamer</b>	Page 596
	<b>Touch probe</b>	Page 603
	<b>Gripper</b>	Page 605
	<b>Thread cutter</b>	Page 599

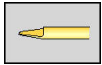
---

**Tool types**

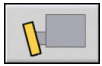
---

**Angle cutter**

Page 600

**Thin mill cutter**

Page 601

**Knurling tool**

Page 602

**Stopper tool**

Page 604



## Multipoint tools



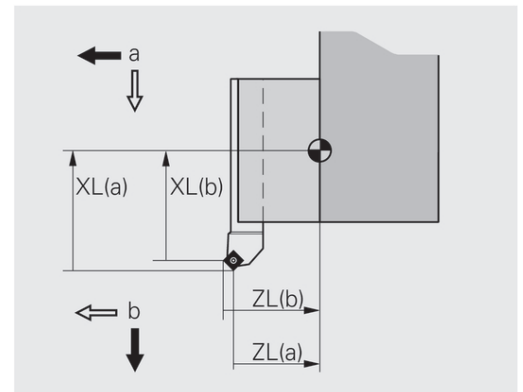
This function is also available on machines with a tool magazine. The control uses the magazine list instead of the turret list.

A multipoint tool is a tool with multiple cutting edges or multiple reference points. A data record is created for every cutting edge or every reference point. Then all data records of the multipoint tool are **linked** together.

**Further information:** "Editing multipoint tools", Page 576

For every data record of a multipoint tool, the position within the multipoint tool chain is shown in the tool list in the column **MU**. Counting starts from **0**.

In the turret list, multipoint tools are displayed with all cutting edges or reference points. The figure shows a tool with two reference points.



## Tool life management

The control can count either the machining time of a tool (i.e. the time a tool is traversed at the programmed feed rate) or the number of parts that were produced with that tool. These two options are used for tool life management.

As soon as the tool life expires or the programmed quantity is reached, the control sets the **diagnostic bit 1**. This causes an error message to be issued the next time the tool is called. If no replacement tool is available, the program run is stopped.

To complete the workpiece currently being produced, press **NC start**.

## 8.2 Tool editor mode of operation

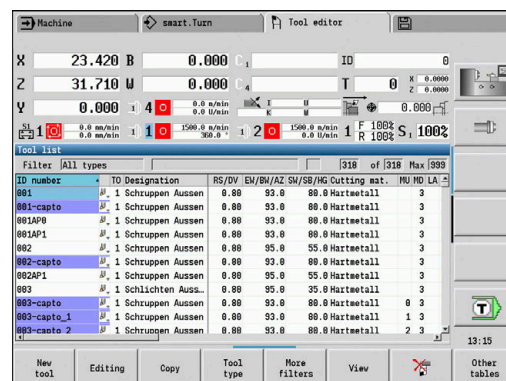
### Navigating in the tool list

In the tool list, the control displays important parameters and the tool descriptions. You can recognize the tool type and the tool orientation from the provided sketch of the tool tip.

You can navigate within the tool list with the arrow keys and **PgUp/PgDn** to view the entries. Infrequently used tool parameters are in the list further to the right, and can be displayed by navigating in the columns.

For orientation purposes, the following columns are always displayed:

- ID number
- Tool type
- Tool orientation
- Designation



### Navigation keys



Switch to the next/previous line (tool) in the tool list



Switch to the next/previous column in the tool list




Jump one page up/down in the tool list








Navigation in the tool list is the same in all modes of operation.

## Sorting and filtering the tool list


Displaying the entries of only one tool type:

- 
  - ▶ Press the **Tool type** soft key
  - ▶ Select the tool type in the following soft-key rows
  - ▶ The control creates a list containing only tools of the selected type




Filtering the tool list:

- 
  - ▶ Press the **More filters** soft key
- 
  - ▶ Press the **Filter orientatn.** soft key
  - ▶ The control creates a list containing only tools with the selected orientation
- 
  - ▶ Alternative: Press the **Filter assignment** soft key
  - ▶ The control switches the display between tools in the tool carrier and unassigned tools
- 
  - ▶ Alternative: Press the **Filter details** soft key
  - ▶ The control displays a pop-up window containing the available selection criteria
  - ▶ Define the filter criteria
- 
  - ▶ Press the **OK** soft key

Clearing filters:

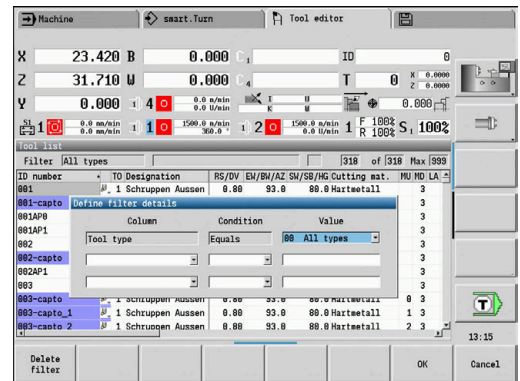
- 
  - ▶ Press the **Filter off** soft key
  - ▶ The control clears the selected filters and displays the complete tool list

Sorting the tool list:

- 
  - ▶ Press the **View** soft key
- 
  - ▶ Press the **Sort by ID / Type** soft key
  - ▶ The tool list switches between **sorting by tool ID number** and **sorting by tool type** (and tool orientation)
- 
  - ▶ Alternative: Press the **Reverse sorting** soft key
  - ▶ This toggles the tool list between ascending and descending sorting.


Searching for tools by ID number:

- ▶ Enter the first few letters or digits of the ID number
- ▶ The control jumps to the desired ID number in the open list ID number



## Editing the tool data

Creating a new tool:


-  ▶ Press the **New tool** soft key
- ▶ Select the tool type
  - > The control opens the input window
  - ▶ Specify the tool orientation
  - ▶ Enter further parameters
  - ▶ Assign the tool ID number (1 to 16 places, alphanumeric)
  - ▶ Assign a tool text

**Further information:** "Tool texts", Page 574



The control does not show the help graphics for individual parameters until the tool orientation is known.


### Tool organization soft keys

 Open the following type selection for creating a new tool




Switch to the soft-key row with the special tools




 Type selection for special drilling tools





 Type selection for special milling tools



 Type selection for handling systems and touch probes



 Open the dialog for the selected tool

 Copy the selected tool and create a new tool with the copied data

---

**Tool organization soft keys**

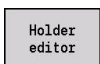

---



Delete the selected tool from the database after a confirmation request



This soft key is available once you have pressed the **Other tables** soft key.  
Start **Technology editor** submode  
**Further information:** "Technology editor submode", Page 607



This soft key is available once you have pressed the **Other tables** soft key.  
Open the **Table of the tool holder**

Creating new tools by copying:



- ▶ Place the cursor on the desired entry



- ▶ Press the **Copy** soft key
- > The control opens the input window with the tool data
- ▶ Enter a new tool ID number
- ▶ Check and edit the other tool data

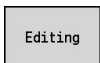


- ▶ Press the **Save** soft key
- > The new tool is added to the database

Editing the tool data:



- ▶ Place the cursor on the desired entry



- ▶ Press the **Editing** soft key
- > The tool parameters are provided for editing

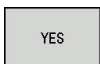
Deleting an entry:



- ▶ Place the cursor on the desired entry



- ▶ Press the **Delete** soft key

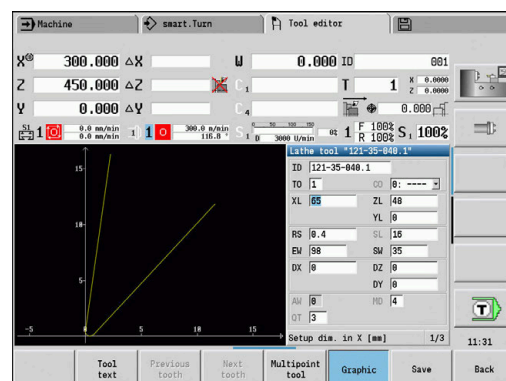


- ▶ Answer **YES** to the confirmation request
- > The control deletes the tool

## Tool control graphics

When the tool dialog box is open, the control provides a control graphic you can use to check the specified tools. To do so, press the **Graphic** soft key.

The control generates the displayed tool from the entered parameters. The tool control graphic enables you to check the entered data. Changes become effective as soon as you exit the input field.



## Tool texts

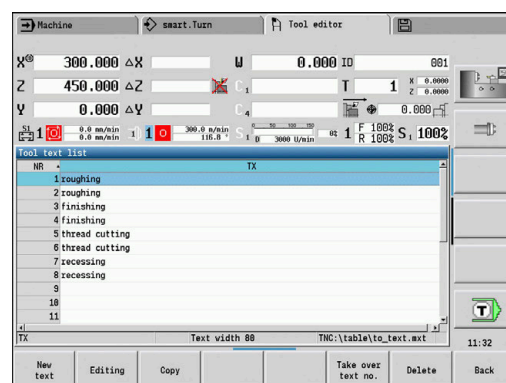
Tool texts are assigned to the tools and displayed in the tool list. The control manages the tool texts in a separate list.

Connections:

- The descriptions are managed in the tool text list. Each entry is preceded by a **QT** number.
- The parameter **Tool text QT** contains the reference number for the **tool text** list. The text indicated by **QT** is then displayed in the tool list

When the tool dialog is open, the control lets you enter tool texts. To do so, press the **Tool texts** soft key.

You can define up to 999 tool texts with a length of max. 80 characters.



- New texts are inserted in the next free line after the cursor position
- When deleting and editing a tool text, please remember that the text might be used for more than one tool

---

**Soft keys in the tool text list**

---

New text	Generate a new line in the text list and open it for text input
Editing	Open the selected tool text for editing
Copy	Copy the currently selected tool text to a new text line. This creates a new tool text
Take over text no.	Transfer the text number to the tool dialog as a reference and exit the tool text editor
Save	Save new or edited tool text
Cancel	Discard the current changes
DELETE	Delete the selected tool text after a confirmation request
Back	Close the tool text editor and return to the tool dialog without applying any changes to the text references

## Editing multipoint tools

Creating a multipoint tool:

- ▶ For each cutting edge, or each reference point, create a separate data record with the tool description



- ▶ In the tool list, place the cursor on the data record for the first cutting edge

Editing

- ▶ Press the **Editing** soft key

Multipoint tool

- ▶ Press the **Multipoint tool** soft key
- ▶ **Tool editor** mode of operation considers this cutting edge to be the **main cutting edge** (MU = 0)



- ▶ Place the cursor on the data record for the next cutting edge

Insert secon. edge

- ▶ Press the **Insert secon. edge** soft key
- ▶ **Tool editor** mode of operation adds this cutting edge to the multipoint tool chain

Cutting edge forward

- ▶ Select a location for the next cutting edge

- ▶ Repeat these steps for any further cutting edges of the multipoint tool

Back

- ▶ Press the **Back** soft key

Removing a cutting edge from the multipoint tool:



- ▶ Place the cursor on a cutting edge of the multipoint tool

Editing

- ▶ Press the **Editing** soft key

Multipoint tool

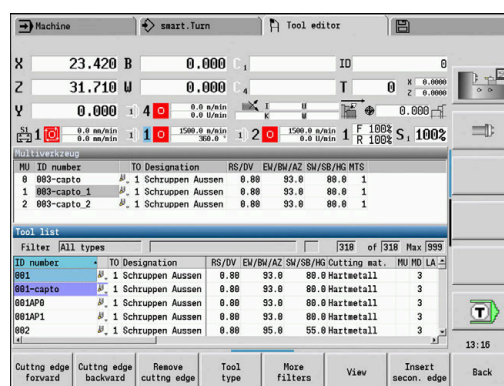
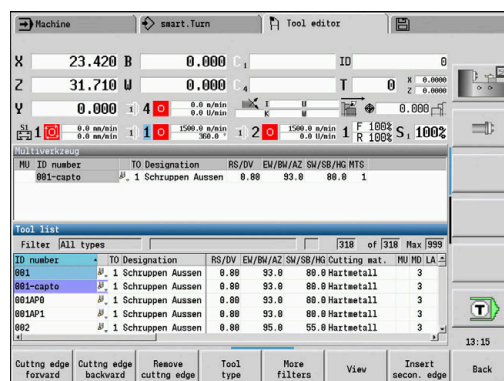
- ▶ Press the **Multipoint tool** soft key
- ▶ The **Tool editor** mode of operation lists all cutting edges of the multipoint tool

Cutting edge forward

- ▶ Select the cutting edge

Remove cutting edge

- ▶ Remove the cutting edge from the multipoint tool chain





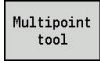
Removing complete multipoint tools:



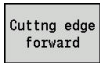
- ▶ Place the cursor on a cutting edge of the multipoint tool



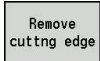
- ▶ Press the **Edit** soft key



- ▶ Press the **Multipoint tool** soft key
- > The **Tool editor** mode of operation lists all cutting edges of the multipoint tool



- ▶ Place the cursor on the cutting edge no. **0** of the multipoint tool



- ▶ The multipoint tool chain is removed

## Editing tool life data

The control counts the tool life in **RT** and the quantity of finished parts in **RZ**. When the predefined tool life or the part quantity limit has been reached, the tool is considered to be worn out.

Setting a limit to tool life:

Dwell

- ▶ Press the **Dwell** soft key
- ▶ **Tool editor** mode of operation opens the **Dwell MT** input field for editing.
- ▶ Enter the tool life of the cutting edge in the **h:mm:ss** format (**h** = hours; **m** = minutes; **s** = seconds). You can use the right and left arrow keys to switch between **h**, **m** and **s**

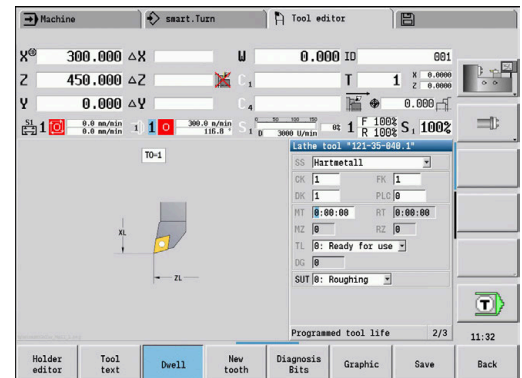
Entering the quantity:

No. pieces

- ▶ Press the **Dwell** soft key
- ▶ The **Dwell** soft key changes to **No.pieces**.
- ▶ **Tool editor** mode of operation opens the **No.pieces MZ** input field for editing.
- ▶ Enter the limit quantity, i.e. the number of workpieces that can be machined with one cutting edge

Setting a new cutting edge:

- ▶ Insert a new cutting edge
  - ▶ Call the associated data record in **Tool editor** mode of operation
- New tooth
- ▶ Press the **New tooth** soft key
  - ▶ The tool life or limit quantity is set to **0** and the diagnostic bits are reset.



- Tool life management can be activated / deactivated in the **lifeTime** (601801) machine parameter  
**Further information:** "List of machine parameters", Page 616
- The quantity is added when the end of the program has been reached
- Tool life / quantity monitoring is also continued after a change of program

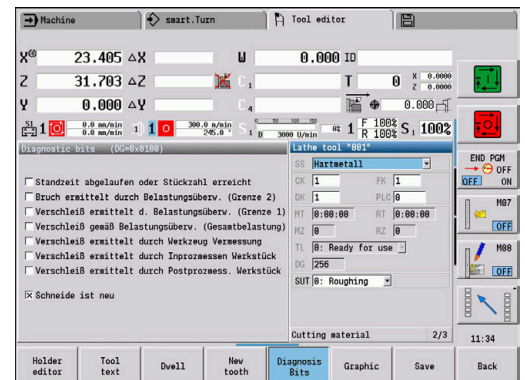
## Diagnostic bits

The diagnostic bits store information about the status of a tool. The bits are set either by programming in the NC program or automatically by the tool and load monitoring functions.

The following diagnostic bits are available:

- **1 Tool life expired or max. quantity exceeded**
- **2 Breakage detected via load monitoring (limit 2)**
- **3 Wear ascertained via load monitoring (limit 1)**
- **4 Wear according to load monitoring (total load)**
- **5 Wear measured through tool calibration**
- **6 Wear measured via in-process workpiece measurement**
- **7 Wear measured via post-process workpc. measurement**
- **8 Cutting edge is new**
  - New = 1
  - Used = 0
- **9 – 15 Not assigned**

If tool life monitoring or quantity monitoring is active and a diagnostic bit has been set, the tool concerned will not be re-inserted during **Program run** submode. If a replacement tool has been defined, it will be inserted instead. If no replacement tool has been defined or if the end of the tool sequence of exchange is reached, the NC program is stopped before the next tool call.



## Editing the diagnostic bits

You can edit the diagnostic bits in **Tool editor** mode of operation as follows:

- |                 |  |
|-----------------|--|
| Editing         | ▶ Press the <b>Edit</b> soft key   |
| Diagnosis Bits  | ▶ Press the <b>Diagnosis Bits</b> soft key   |
| GOTO            | ▶ Use the cursor keys to select the desired bit  |
| GOTO            | ▶ Press the <b>GOTO</b> key to edit the bit  |
| Confirm changes | ▶ Save the bit with the Confirm changes soft key   |
| Confirm changes | ▶ The control copies the new diagnostic bits to the <b>DG</b> parameter. The data on tool life and quantity limit remain unaffected. |

## Resetting the diagnostic bits

You can reset the diagnostic bits in **Tool editor** mode of operation as follows:

- |           |                                       |
|-----------|---------------------------------------|
| Editing   | ▶ Press the <b>Edit</b> soft key      |
| New tooth | ▶ Press the <b>New tooth</b> soft key |



With the **New tooth** soft key, you can reset the diagnostic bits and set bit 8 **Cutting edge is new**. This bit will also be reset as soon as the control inserts the tool.

## Holder editor

The graphic tool representation functions in **Simulation** submode take account of the shape of the tool holder and the mounting position on the tool carrier.

**Further information:** "Tool control graphics", Page 574

**Further information:** "3-D simulation in Simulation submode", Page 562

In the **to\_hold.hld** tool holder table, you can define the holder type and the setting gauges of the tool holder.

Proceed as follows to edit the tool holder table in **Tool editor** mode of operation:

- ▶ Press the **Other tables** soft key
- ▶ Press the **Holder editor** soft key

The tool holder table contains the following entries:

- **NR:** Line number
- **HID:** Holder name – Unique holder name (max. 16 characters)
- **MTS:** Manual change system
  - **0:** Tool holder
  - **1:** Manual change tool
- **XLH:** Setup dim. in X
- **YLH:** Setup dim. in Y
- **ZLH:** Setup dim. in Z

NR	HID	MTS	XLH	YLH	ZLH	HC
1	MB1	0	0.0	0.0	0.0	B1
2	MC1	0	0.0	0.0	0.0	C1
3	C18-capto-50	1	10.0	0.0	30.0	B1
4	C23-capto-50X	1	2.34	2.34	2.34	B1
5	StirnDreh-111	0	0.0	0.0	0.0	B1
6	MantDreh-111	0	0.0	0.0	0.0	D1
7	MantDreh-113	0	0.0	0.0	0.0	C1
8	MantDreh-117	0	0.0	0.0	0.0	A1
9	MantStech-AR	0	0.0	0.0	0.0	A1
10	MantGev-AL	0	0.0	0.0	0.0	C2
11	MantStirn-330	0	0.0	0.0	0.0	T1

- **HC: Holder type**
  - **A1:** Boring bar holder
  - **B1:** Right-hand, short design
  - **B2:** Left-hand, short design
  - **B3:** Right-hand, short design, overhead
  - **B4:** Left-hand, short design, overhead
  - **B5:** Right-hand, long design
  - **B6:** Left-hand, long design
  - **B7:** Right-hand, long design, overhead
  - **B8:** Left-hand, long design, overhead
  - **C1:** Right-hand
  - **C2:** Left-hand
  - **C3:** Right-hand, overhead
  - **C4:** Left-hand, overhead
  - **D1:** Multicarrier
  - **A:** Boring bar holder
  - **B:** Drill holder with coolant supply
  - **C:** Square, longitudinal
  - **D:** Square, transverse
  - **E:** Rear-face machining
  - **E1:** U drill
  - **E2:** Cylindrical shank holder
  - **E3:** Collet chuck holder
  - **F:** Drill holder MK (Morse taper)
  - **K:** Drill chuck
  - **T1:** Driven, axial
  - **T2:** Driven, radial
  - **T3:** Boring bar holder
  - **X5:** Driven, axial
  - **X6:** Driven, radial
- **MP: Tool position in turret**
  - **0:** -Z direction
  - **1:** -X/-Z direction
  - **2:** -X/+Z direction
  - **3:** +Z direction
- **WH: Height of holder**
- **WB: Width of holder**
- **AT: Holder type**
- **WHT: Depth of holder** (default: parameter **WB**)
- **TOF: Offset for depth** (default: parameter **WHT/2**)



Only ASCII characters are allowed for holder names in the tool holder table. Diacritics or Asian characters are not allowed.

You can also view and edit the tool holder table in open tool forms. Use the **Holder editor** soft key for this purpose.

---

**Soft keys in the tool holder table**

---

New Line	Add a new line to the end of the table
Editing	Open the selected tool holder for editing
Copy	Copy the currently selected tool holder to a new text line. This creates a new tool holder
Save	Save the new or edited tool holder
Cancel	Discard the current changes
DELETE	Delete the selected tool holder after a confirmation prompt If you logged in with login code 123, the <b>Delete All</b> soft key is available. It deletes the entire tool holder table after you confirmed a corresponding prompt and writes this event to the log file.
Back	Close the <b>Table of the tool holder</b>

### Manual change systems



Refer to your machine manual.  
Your machine must be prepared by the machine tool builder if you want to use manual change systems.

A tool holder is designated as a manual change system if it can accommodate various tool inserts via an integral clamping device. Most clamping devices designed as polygon coupling enable rapid, position-precise replacement of tool inserts.

With a manual change system it is possible to insert tools that are not in the turret during a program run. For this, the control checks whether the called tool is in the turret or has to be loaded. If a tool change is required, the control interrupts the program run. After you have manually loaded the tool insert, confirm the tool change and continue the program run.

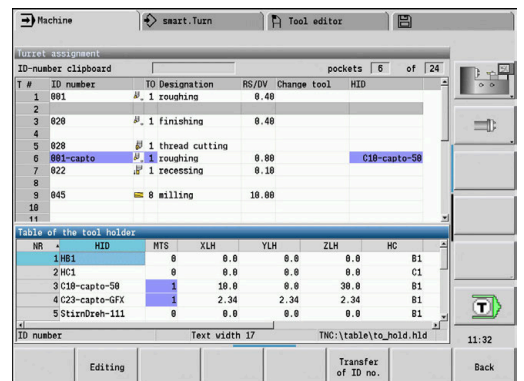
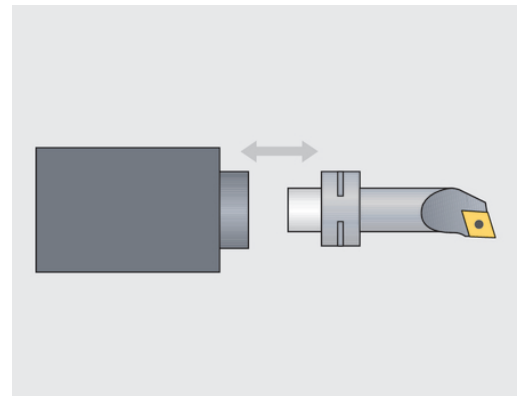
The following steps are necessary for using manual change systems:

- ▶ Create the tool holder in the holder table
- ▶ Select the tool holder in the turret assignment list
- ▶ Enter the tool data for the manual change tool

### Setting up the holder for manual change systems

Setting up the manual change system holder in the turret assignment list:

- ▶ Press the **Turret list** soft key
- ▶ Press the **Special functions** soft key
- ▶ Press the **Set-up the holder** soft key
- ▶ Press the **Transfer of ID no.** soft key



After setting up a holder for a manual change system in the turret assignment list, three fields of the specific line are color-highlighted.

You can remove a holder for a manual change system with the **Remove tool holder** soft key.

In the turret assignment list, you can only set up the holder type **MTS1** (manual change system). For holder type **MTS0** (standard holder), the control displays an error message.

If the **MTS** parameter of the tool has been set to **1: Manual change tool**, you can define a tool holder. If **0: Tool holder** has been defined, the Set-up the holder soft key is grayed out.

### Selecting the manual change system in the tool data

Defining the tool as a manual change tool in the tool data form:

Editing

- ▶ Press the **Editing** soft key
- ▶ On the third form page, select **MTS1: Manual change tool**

Save

- ▶ Press the **Save** soft key



If you define a tool as a manual change system, in the tool list the tool type field (tool symbol) is color-highlighted.

With manual change tools you must not select a **HID** tool holder (empty field). The assignment between the holder and the tool takes place via the turret assignment list. A manual change system has to have been set up on the corresponding turret pocket for this.

With multipoint tools, all cutting edges must be assigned the same **MTS** input value.



## 8.3 Tool data

### General tool parameters

The parameters listed in the following table are available for all tool types. Parameters for specific tool types are described in the later chapters.

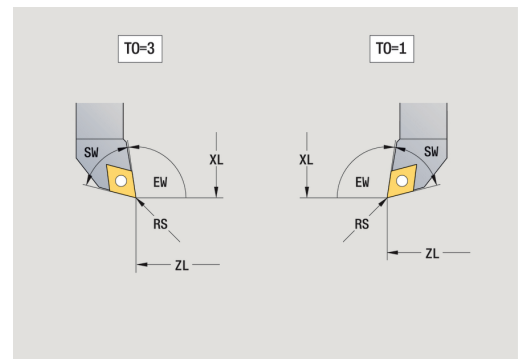
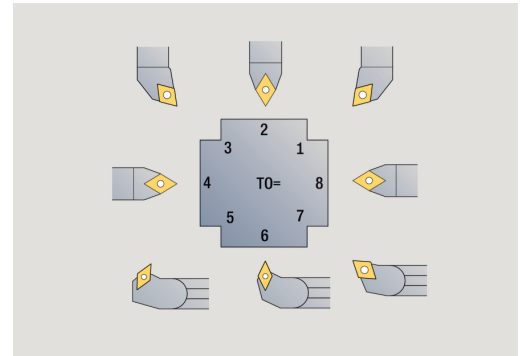
General tool parameters for **tool definition**:

- **ID: ID no.** – Tool name (max. 16 characters)
- **TO: Tool orientation** (for identification number, see help graphic)
- **XL: Setup dim. in X**
- **ZL: Setup dim. in Z**
- **DX: Wear compensation in X** (range:  $-10 < DX < 10$ )
- **DZ: Wear compensation in Z** (range:  $-10 < DZ < 10$ )
- **DS: Special corr.** (range:  $-10 < DS < 10$ )
- **MD: Rotatnl. dir. M3=3, M4=4** (default: not predefined)
  - 3: **M3**
  - 4: **M4**
- **QT:** Reference to **Tool text**
- **CW: C tilting plane angle** – Position of the C axis to determine the work position of the tool (machine-dependent)
- **SS: Cutting material** – Name of the cutting material for access to the technology database
- **CK: G96 compensation factor** (default: 1)
- **FK: G95 compensation factor** (default: 1)
- **DK: Depth compensation factor** (default: 1)
- **PLC: Additional information**  
**Further information:** Machine manual
- **MT: Programmed tool life** – Default value for tool life management (default: not specified)
- **MZ: Programmed quantity** – Default value for tool life management (default: Not defined)
- **RT: Remaining tool life**
- **RZ: Remaining quantity**
- **HID: Tool holder designation** – Unique holder name (max. 16 characters)
- **MTS: Manual change system**
  - 0: **Tool holder**
  - 1: **Manual change tool**
- **PTYP: Pocket type** (machine-dependent)
- **NMX: Max. shaft speed** (spindle speed limitation)

Additional tool parameters and deviating denominations in the **tool list**:

**i** Some of the tool parameters also exist in the turret or magazine assignment.

- **ID no.:** Content of the **ID** parameter from the tool definition



- **Designation:** Content of the **QT** parameter from the tool definition
- **RS/DV:** Content of the **RS** or **DV** parameter from the tool definition
- **EW/BW/AZ:** Content of the **EW**, **BW**, or **AZ** parameter from the tool definition
- **SW/SB/HG:** Content of the **SW**, **SB**, or **HG** parameter from the tool definition
- **Cutting material:** Content of the **SS** parameter from the tool definition
- **MU:** The tool is a **Multipoint tool**
- **LA:** Tool inserted
- **Life:** Remaining tool life / remaining quantity (with tool life monitoring)
- **Status:** With tool life monitoring
- **Diagn.:** Evaluation of diagnostic bits (with tool life monitoring)
- **Holder ID:** Contents of the **HID** parameter from the tool definition

Parameters for drilling tools:

- **DV: Hole diameter**
- **BW: Drill angle** – Point angle of the drill
- **AW: Tool driven, no=0/yes=1**  
This parameter specifies, for drilling and tapping tools, whether switching commands will be generated for the spindle or the driven tool during cycle programming.
  - **0:** Stationary tool
  - **1:** Driven tool
- **NL: Usable length**
- **RW: Position angle** – Deviation from the main machining direction (range:  $-90^\circ$  to  $+90^\circ$ )
- **AX: Salient length in X**
- **FH: Height of the chuck for driven tool**
- **FD: Diameter of the chuck**

Description of the tool parameters:

- **ID number (ID):** The control needs a unique name for each tool. This **ID number** can have up to 16 alphanumeric characters.
- **Tool orientation (TO):** The control determines the position of the tool tip and, depending on the selected tool type, additional information such as the tool angle direction, position of the tool reference point, etc. This information is necessary, for example, for calculating the cutting radius compensation, plunge angle, etc.
- **Setup dimensions (XL, ZL):** They refer to the tool reference point. The position of the reference point depends on the tool type (see help graphics)

- **Compensation values (DX, DZ, DS):** They compensate for the wear of the cutting edge. For recessing and button tools, **DS** stands for the compensation value of the third side of the tool, which is away from the tool reference point. The compensation values have 4 decimal places for **mm** units and 5 decimal places for **inch** units. The cycles automatically switch to the special compensation. With **G148**, you can also switch to special compensation for single-path machining operations
- **Direction of rotation (MD):** If you define a direction of rotation, in the cycles using this tool a switching command (**M3** or **M4**) is automatically generated either for the spindle or, with driven tools, for the auxiliary spindle



It depends on the PLC software of your machine whether the generated switching commands are evaluated. If the PLC does not execute the switching commands, this parameter should not be entered. Refer to your machine manual.

- **Tool text (QT):** You can assign a tool text to each tool. The text is shown in the tool lists. Since the tool texts are maintained in a separate list, you can enter the reference to the text in **QT**  
**Further information:** "Tool texts", Page 574
- **Cutting material (SS):** This parameter is required if you want to use the cutting data from the technology database  
**Further information:** "Technology database", Page 606
- **Compensation factors (CK, FK, DK):** These parameters serve for the tool-specific adjustment of the cutting values. The cutting data from the technology database are multiplied by the compensation factors before they are entered as default values
- **Additional information (PLC):** You can find information on this parameter in the machine manual. This data can be used for machine-specific settings.
- **Idle time (MT, RT):** If you use the tool life management, specify the tool life of the cutting edge in **MT**. In **RT**, the control shows the tool life already **passed**.
- **No.pieces (MZ, RZ):** With tool life management, use **MZ** to specify the number of workpieces that can be machined with one cutting edge. In **RZ** the control shows the number of workpieces that have already been machined with this cutting edge.



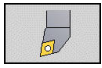
The tool life monitoring and the quantity count are used alternatively.

- **Manual change system (MTS):** Define the tool holder

## Standard turning tools



- ▶ Press the **New tool** soft key



- ▶ Press the **Turning tool** soft key



- ▶ Alternative: For tools with round indexable insert, switch to the dialog for **Button tools**

For the tool orientations **TO=1, 3, 5 and 7**, you can enter the **Setting angle EW**. The tool orientation values **TO=2, 4, 6, 8** are used for neutral tools. **Neutral** tools are tools that are centered precisely in the tool tip. One of the setup dimensions for neutral tools refers to the center of the tool-tip radius.

Special parameters for roughing and finishing tools:

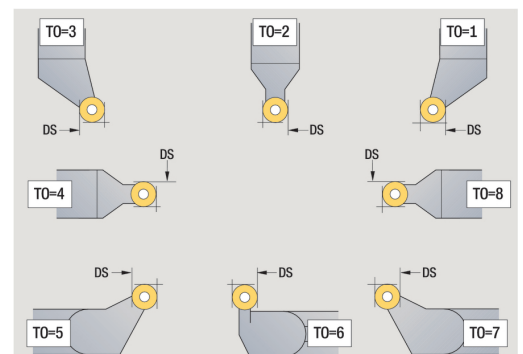
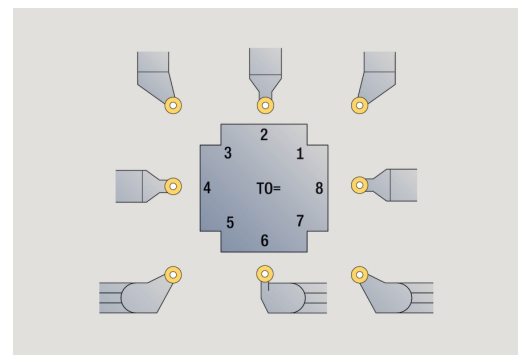
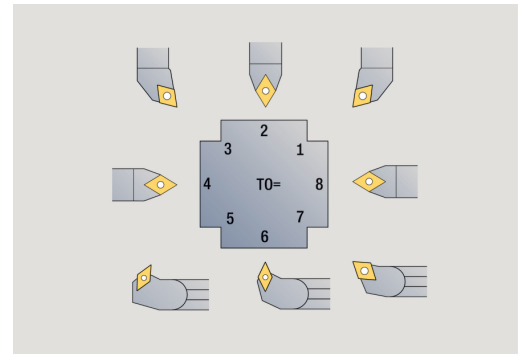
- **CO: Cutting edge position**  
The main machining direction of the tool influences the orientation of the tool angle **EW** and the point angle **SW** (required for **AWG** submode with **TURN PLUS**).
  - **1: Longitudinal preferred**
  - **2: Transverse preferred**
  - **3: Only longitudinal**
  - **4: Only transverse**
- **RS: Cutting edge radius**
- **EW: Setting angle** (range:  $0^\circ \leq EW \leq 180^\circ$ )
- **SW: Point angle** (range:  $0^\circ \leq SW \leq 180^\circ$ )
- **SUT: Tool type** (required for **AWG** submode in **TURN PLUS**)
- Further tool parameters:  
**Further information:** "General tool parameters", Page 585

Special parameters for button tools:

- **RS: Cutting edge radius**
- **EW: Setting angle** (range:  $0^\circ \leq EW \leq 180^\circ$ )
- **DS: Special corr.** (position of the special compensation; see figure)
- Further tool parameters:  
**Further information:** "General tool parameters", Page 585



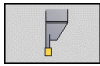
The **DX, DZwear compensation** compensates for wear on the two sides of the cutting edge that lie next to the tool reference point. The **Special corr. DS** compensates for wear on the third side of the cutting edge.



## Recessing tools



- ▶ Press the **New tool** soft key



- ▶ Press the **Recessing tool** soft key

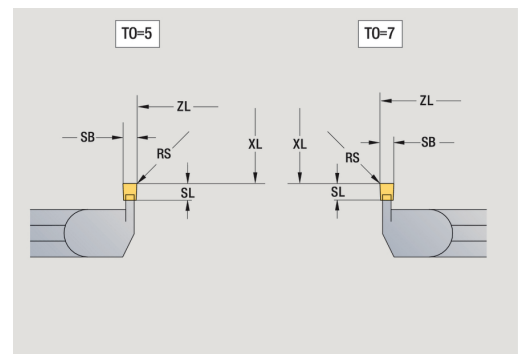
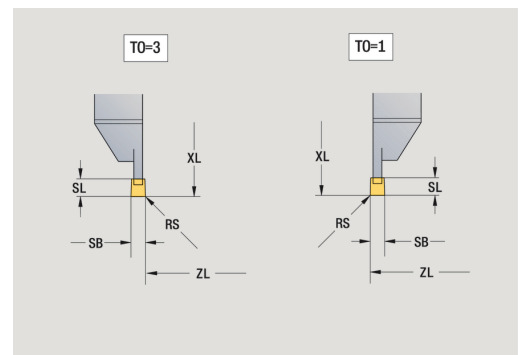
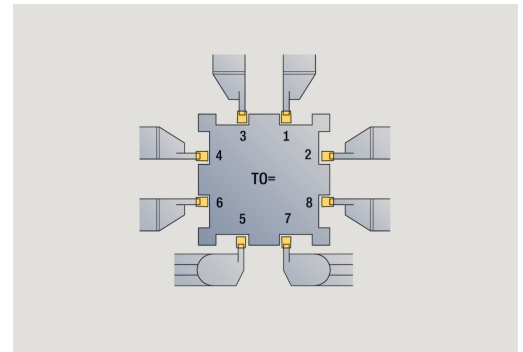
Recessing tools are used for recessing, parting, recess turning and finishing (only in the **smart.Turn** mode of operation).

Special parameters for recessing tools:

- **RS: Cutting edge radius**
- **SW: Point angle**
- **SB: Cutting width**
- **SL: Cutting length**
- **DS: Special corr.**
- **SUT: Tool type** (required for **AWG** submode in **TURN PLUS**)
  - **0: Recessing**
  - **1: Parting**
  - **2: Rec. turn.**
- **DN: Tool width**
- **SD: Shank diameter**
- **ET: Max. plunging depth**
- **NL: Usable length**
- **RW: Angular offset** (only for B axis)
- Further tool parameters:  
**Further information:** "General tool parameters", Page 585



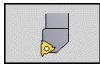
The **DX, DZ** wear compensation compensates for wear on the two sides of the cutting edge that lie next to the tool reference point. The **Special corr. DS** compensates for wear on the third side of the cutting edge.



## Thread-cutting tools



- ▶ Press the **New tool** soft key

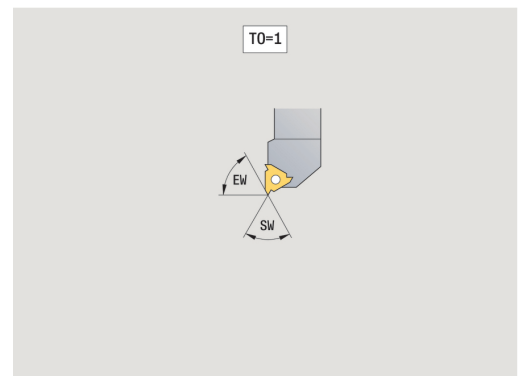
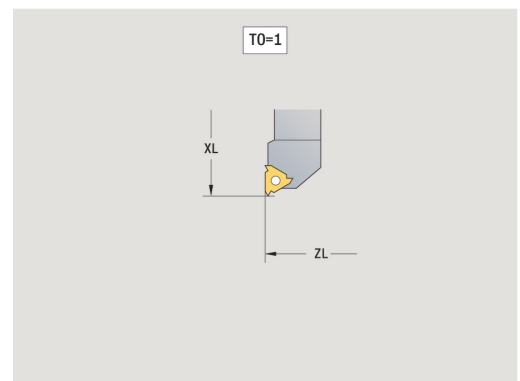
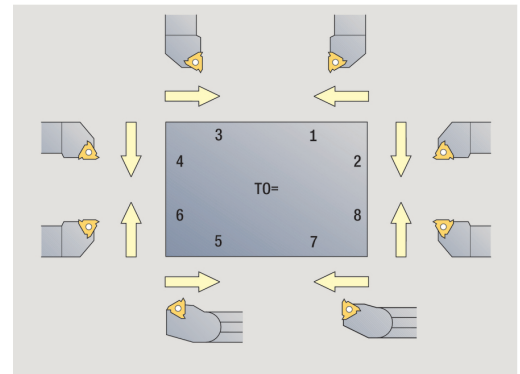


- ▶ Press the **Threading tool** soft key

The help graphics illustrate the dimensions of the tools.

Special parameters for thread cutting tools:

- **RS: Cutting edge radius**
- **SB: Cutting width**
- **EW: Setting angle** (range:  $0^\circ \leq EW \leq 180^\circ$ )
- **SW: Point angle** (range:  $0^\circ \leq SW \leq 180^\circ$ )
- **DN: Tool width**
- **SD: Shank diameter**
- **ET: Max. plunging depth**
- **NL: Usable length**
- Further tool parameters:  
**Further information:** "General tool parameters", Page 585



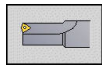
### Twist drills and indexable-insert drills



▶ Press the **New tool** soft key



▶ Press the **Drill** soft key



▶ Alternative: For indexable-insert drills, switch to the dialog for **Indexable-insert drill**

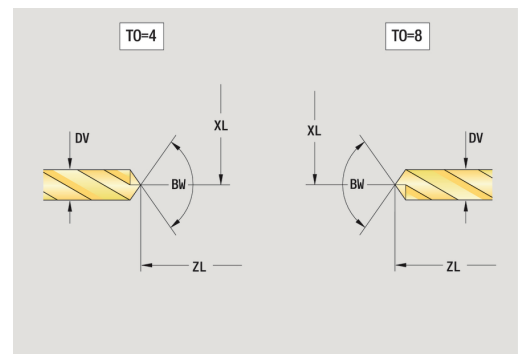
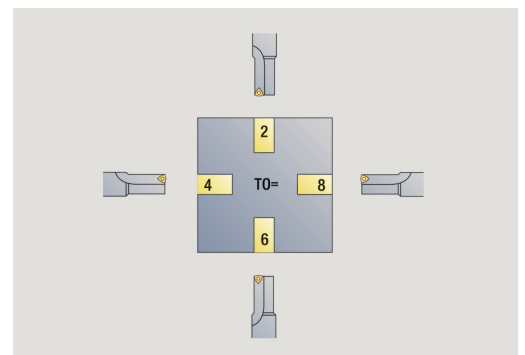
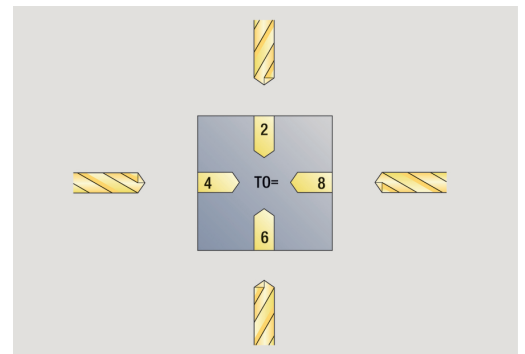
The help graphics illustrate the dimensions of the tools.

Special parameters for twist drills:





- **DV: Hole diameter**
- **BW: Drill angle** – Point angle of the drill
- **AW: Tool driven, no=0/yes=1**  
This parameter specifies, for drilling and tapping tools, whether switching commands will be generated for the spindle or the driven tool during cycle programming.
  - **0:** Stationary tool
  - **1:** Driven tool
- **NL: Usable length**
- **RW: Position angle** – Deviation from the main machining direction (range:  $-90^\circ$  to  $+90^\circ$ )
- **AX: Salient length in X**
- **FH: Height of the chuck for driven tool**
- **FD: Diameter of the chuck**
- Further tool parameters:  
**Further information:** "General tool parameters", Page 585



For drilling operations at **constant cutting speed**, the **Hole diameter DV** parameter is used to calculate the spindle speed.



## NC center drill

-  ▶ Press the **New tool** soft key
-  ▶ Press the **Special tool** soft key
-  ▶ Press the **special drilling tools** soft key
-  ▶ Press the **NC center drill** soft key

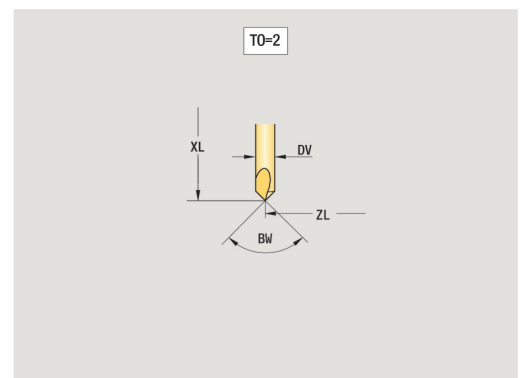
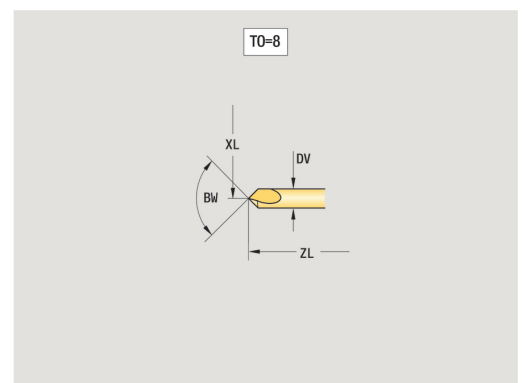
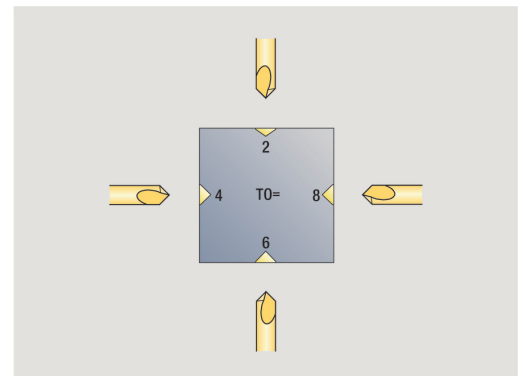
The help graphics illustrate the dimensions of the tools.

Special parameters for NC center drills:

- **DV: Hole diameter**
- **BW: Drill angle** – Point angle of the drill
- Further tool parameters:  
**Further information:** "General tool parameters", Page 585



For drilling operations at **constant cutting speed**, the **Hole diameter DV** parameter is used to calculate the spindle speed.





## Centering tool



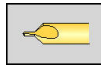
- ▶ Press the **New tool** soft key



- ▶ Press the **Special tool** soft key



- ▶ Press the **special drilling tools** soft key



- ▶ Press the **Cent. drill** soft key

The help graphics illustrate the dimensions of the tools.

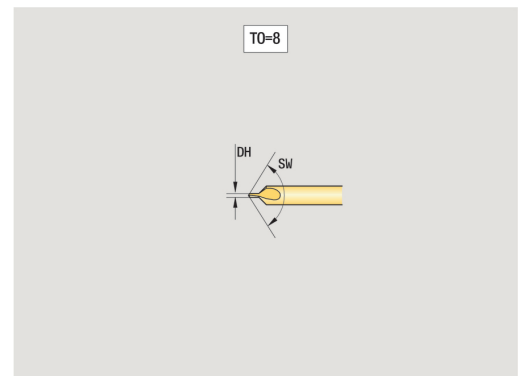
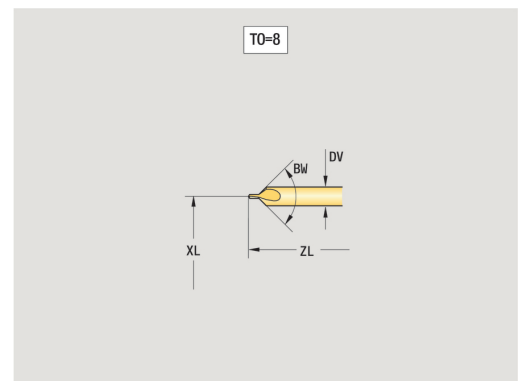
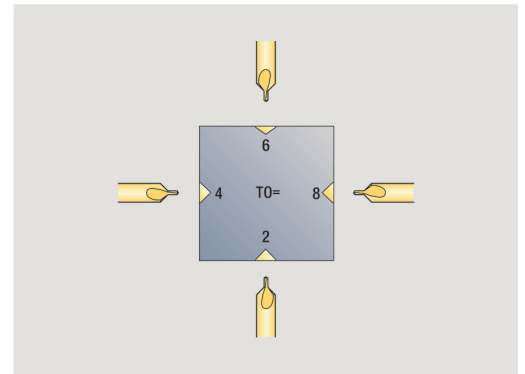
Special parameters for centering tools:

- **DV: Hole diameter**
- **DH: Stud diameter**
- **BW: Drill angle** – Point angle of the drill
- **SW: Point angle**
- **ZA: Stud length**
- Further tool parameters:

**Further information:** "General tool parameters", Page 585



For drilling operations at **constant cutting speed**, the **Hole diameter DV** parameter is used to calculate the spindle speed.



## Counterbore



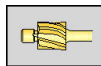
▶ Press the **New tool** soft key



▶ Press the **Special tool** soft key



▶ Press the **special drilling tools** soft key



▶ Press the **Counterbore** soft key

The help graphics illustrate the dimensions of the tools.

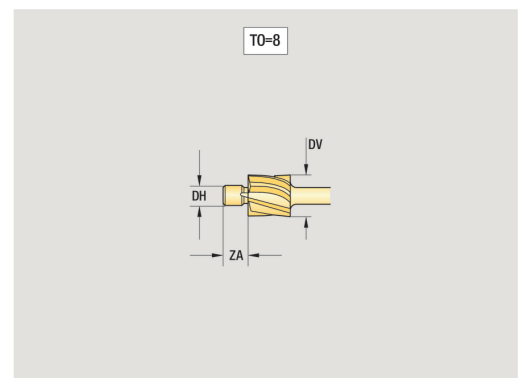
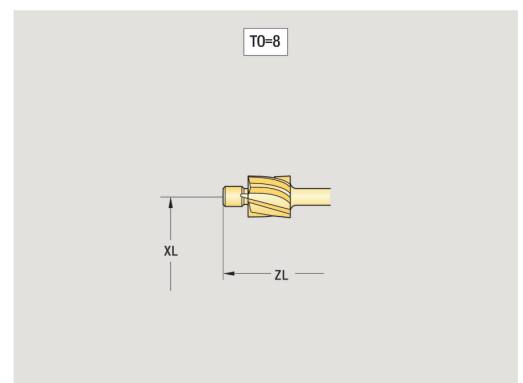
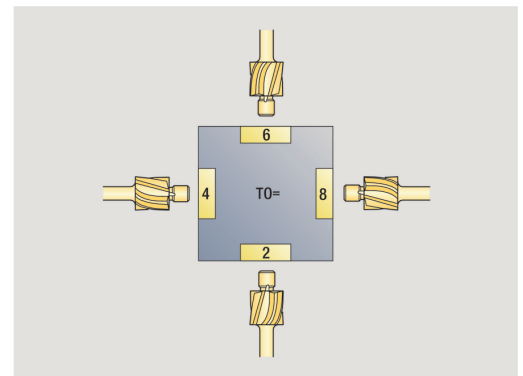
Special parameters for counterbores:

- **DV: Hole diameter**
- **DH: Stud diameter**
- **ZA: Stud length**
- Further tool parameters:

**Further information:** "General tool parameters", Page 585



For drilling operations at **constant cutting speed**, the **Hole diameter DV** parameter is used to calculate the spindle speed.



## Countersink



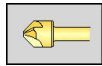
- ▶ Press the **New tool** soft key



- ▶ Press the **Special tool** soft key



- ▶ Press the **special drilling tools** soft key



- ▶ Press the **Countersinker** soft key

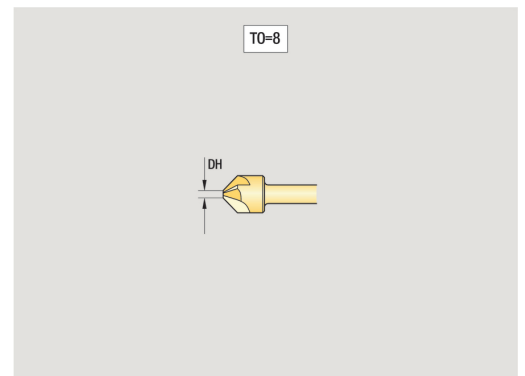
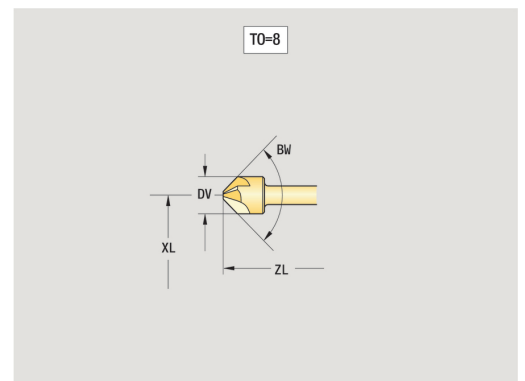
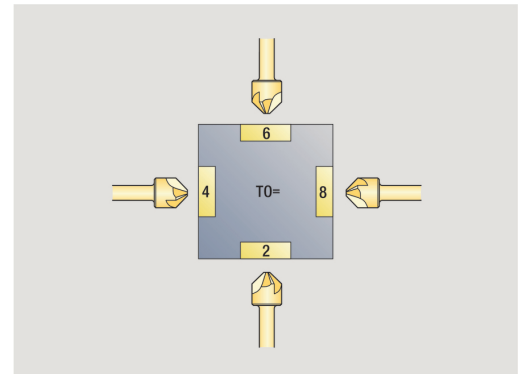
The help graphics illustrate the dimensions of the tools.

Special parameters for countersinks:

- **DV: Hole diameter**
- **DH: Stud diameter**
- **BW: Drill angle**
- Further tool parameters:  
**Further information:** "General tool parameters", Page 585



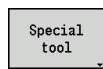
For drilling operations at **constant cutting speed**, the **Hole diameter DV** parameter is used to calculate the spindle speed.



## Reamer



▶ Press the **New tool** soft key



▶ Press the **Special tool** soft key



▶ Press the **special drilling tools** soft key



▶ Press the **Reamer** soft key

The help graphics illustrate the dimensions of the tools.

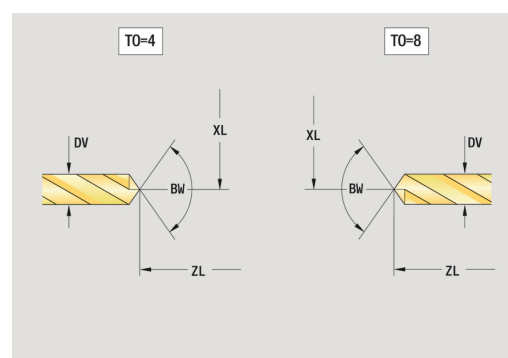
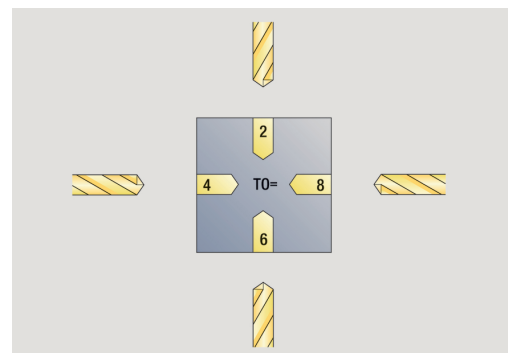
Special parameters for reamers:

- **DV: Hole diameter**
- **DH: Stud diameter**
- **AL: Cut-in length**
- Further tool parameters:

**Further information:** "General tool parameters", Page 585



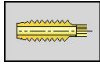
For drilling operations at **constant cutting speed**, the **Hole diameter DV** parameter is used to calculate the spindle speed.



## Tap



▶ Press the **New tool** soft key



▶ Press the **Tap** soft key

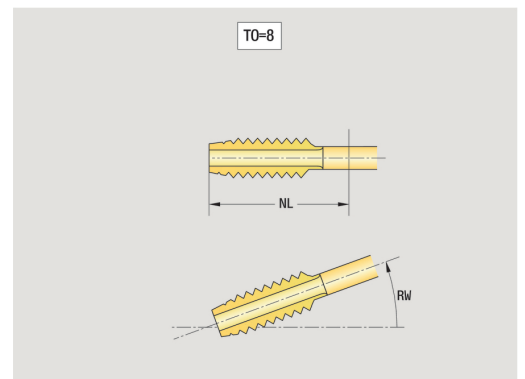
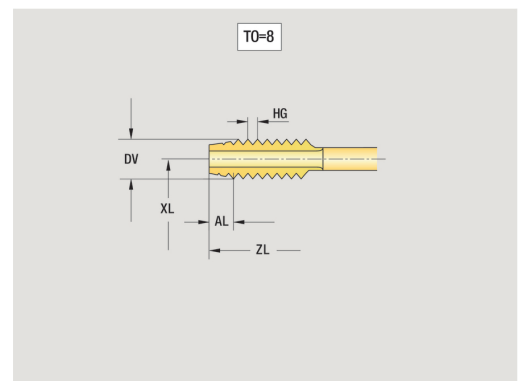
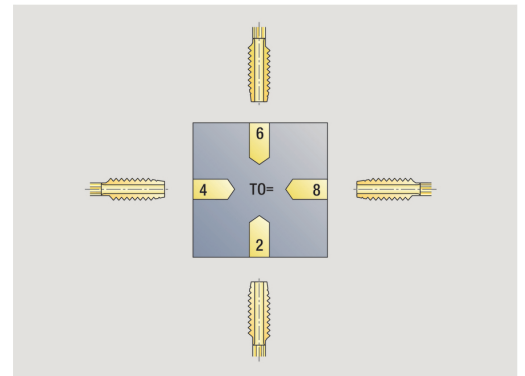
The help graphics illustrate the dimensions of the tools.

Special parameters for taps:

- **DV: Thread diameter**
- **HG: Thread pitch**
- **AL: Cut-in length**
- Further tool parameters:  
**Further information:** "General tool parameters", Page 585



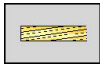
The **Thread pitch HG** is evaluated if the corresponding parameter has not been defined in the tapping cycle.



## Standard milling tools



- ▶ Press the **New tool** soft key



- ▶ Press the **Milling tool** soft key

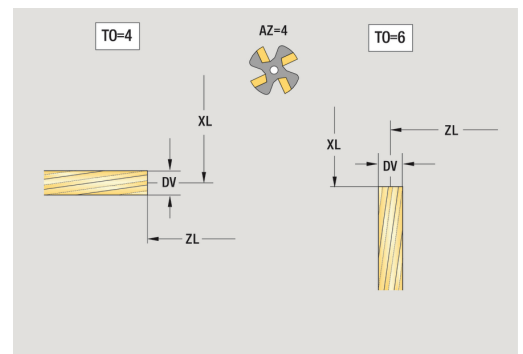
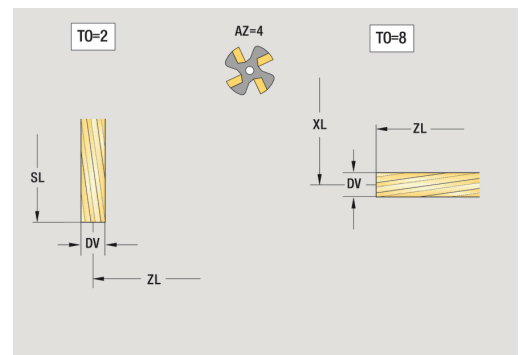
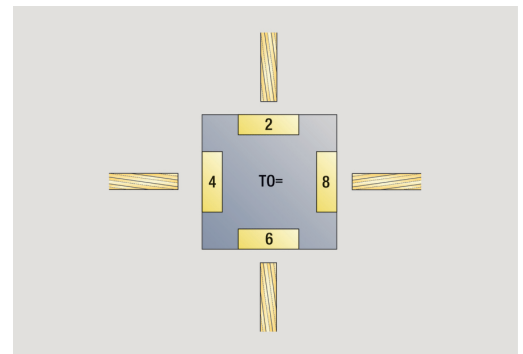
The help graphics illustrate the dimensions of the tools.

Special parameters for standard milling tools:

- **DV: Milling diameter**
- **AZ: No. of teeth**
- **DD: Special corr.**
- **SL: Cutting length**
- **R2: Tool radius 2**
- **DR2: Tool radius 2 oversize**
- Further tool parameters:  
**Further information:** "General tool parameters", Page 585



- For milling operations at **constant cutting speed**, **Cutter diameter DV** is used to calculate the spindle speed
- For **G193 Feed per tooth**, the **No. of teeth AZ** parameter is evaluated



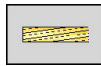
## Thread milling tools



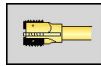
- ▶ Press the **New tool** soft key



- ▶ Press the **Special tool** soft key



- ▶ Press the **Milling tool** soft key



- ▶ Press the **Thread cutter** soft key

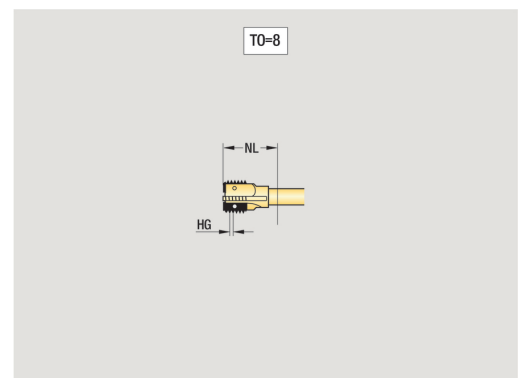
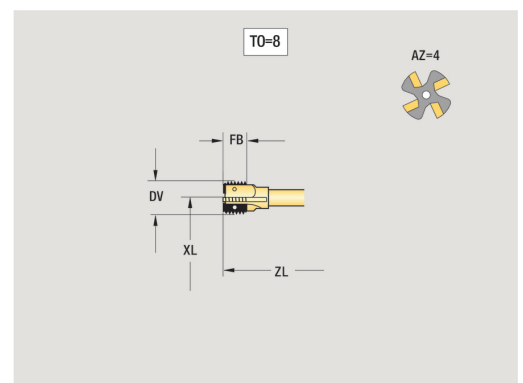
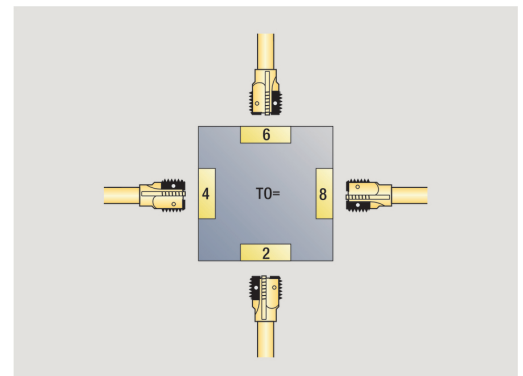
The help graphics illustrate the dimensions of the tools.

Special parameters for thread milling tools:

- **DV: Milling diameter**
- **AZ: No. of teeth**
- **FB: Cutter width/height**
- **HG: Thread pitch**
- **DD: Special corr.**
- Further tool parameters:  
**Further information:** "General tool parameters", Page 585



- For milling operations at **constant cutting speed**, **Cutter diameter DV** is used to calculate the spindle speed
- For **G193 Feed per tooth**, the **No. of teeth AZ** parameter is evaluated



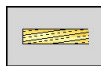
## Angle cutters



- ▶ Press the **New tool** soft key



- ▶ Press the **Special tool** soft key



- ▶ Press the **special milling tools** soft key



- ▶ Press the **Angle cutter** soft key

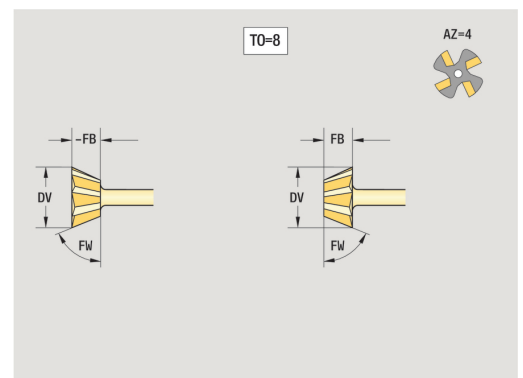
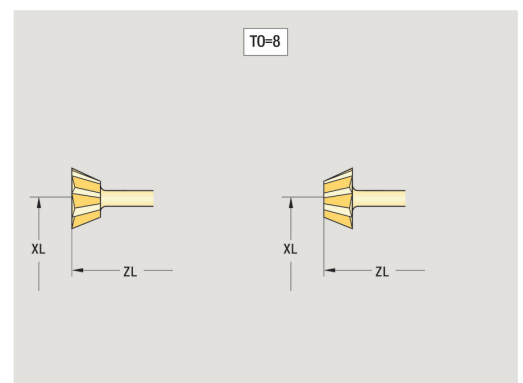
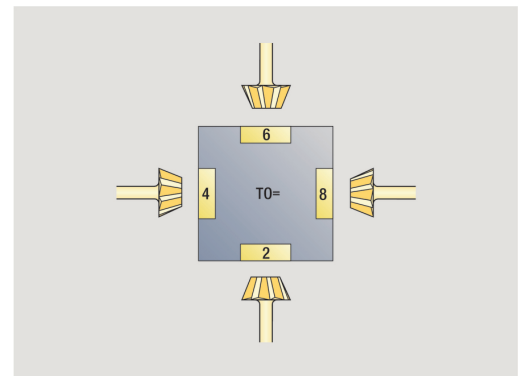
The help graphics illustrate the dimensions of the tools.

Special parameters for angle cutters:

- **DV: Milling diameter**
- **AZ: No. of teeth**
- **FB: Cutter width/height**
  - **FB < 0:** Large cutter diameter on front
  - **FB > 0:** Large cutter diameter on back
- **FW: Cutter angle**
- **DD: Special corr.**
- Further tool parameters:  
**Further information:** "General tool parameters", Page 585







- For milling operations at **constant cutting speed**, **Cutter diameter DV** is used to calculate the spindle speed
- For **G193 Feed per tooth**, the **No. of teeth AZ** parameter is evaluated





## Burr cutters

-  ▶ Press the **New tool** soft key
-  ▶ Press the **Special tool** soft key
-  ▶ Press the **special milling tools** soft key
-  ▶ Press the **Thin millg. cutter** soft key

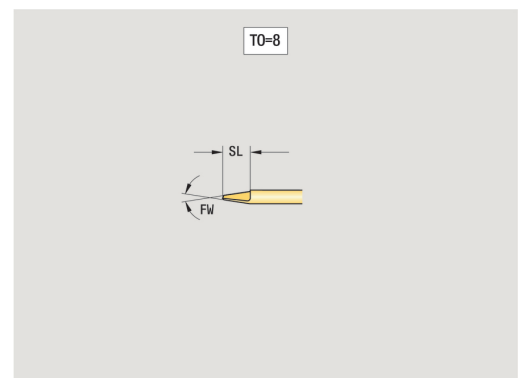
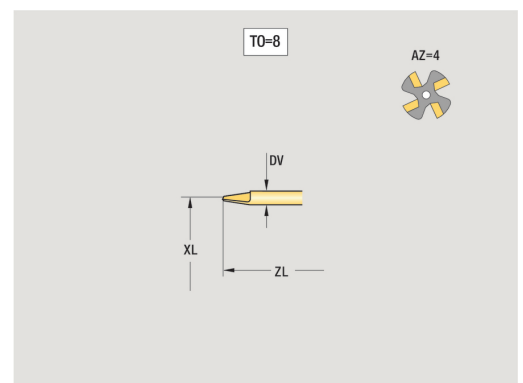
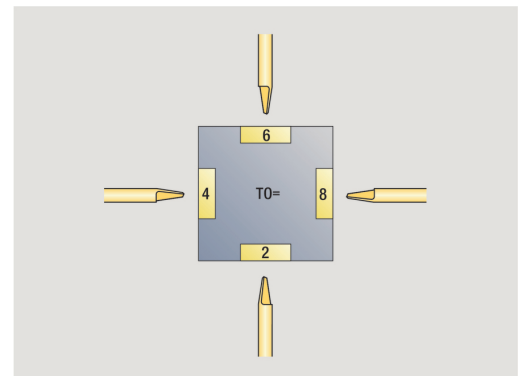
The help graphics illustrate the dimensions of the tools.

Special parameters for burr cutters:

- **DV: Milling diameter**
- **AZ: No. of teeth**
- **SL: Cutting length**
- **FW: Cutter angle**
- **DD: Special corr.**
- Further tool parameters:  
**Further information:** "General tool parameters", Page 585



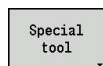
- For milling operations at **constant cutting speed**, **Cutter diameter DV** is used to calculate the spindle speed
- For **G193 Feed per tooth**, the **No. of teeth AZ** parameter is evaluated



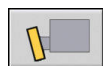
## Knurling tool



▶ Press the **New tool** soft key



▶ Press the **Special tool** soft key

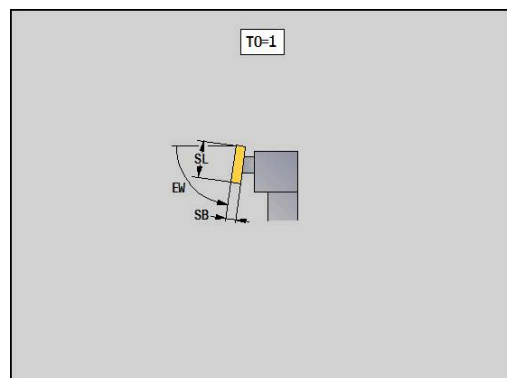
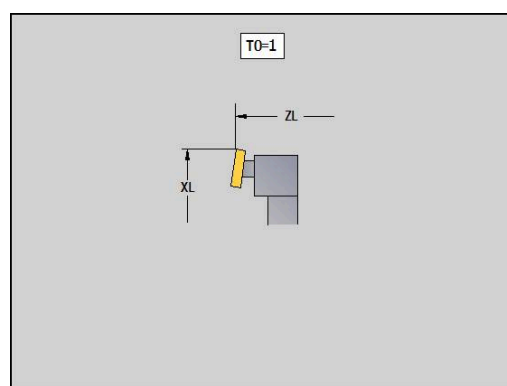
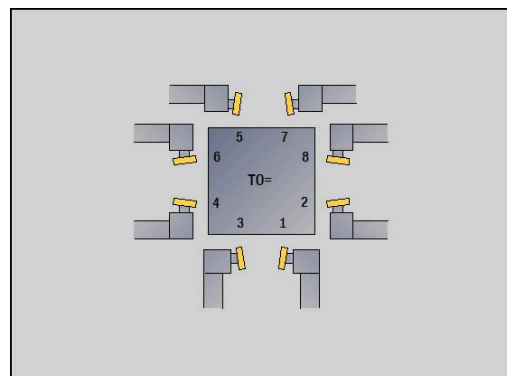


▶ Press the **Knurling tool** soft key

The help graphics illustrate the dimensions of the tools.

Special parameters for knurling tools:

- **SL: Cutting length**
- **EW: Setting angle**
- **SB: Cutting width**
- **DN: Tool width**
- **SD: Shank diameter**
- Further tool parameters:  
**Further information:** "General tool parameters", Page 585



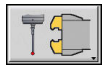
## Length Gauges



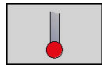
- ▶ Press the **New tool** soft key



- ▶ Press the **Special tool** soft key



- ▶ Press the **handling systems and touch probes** soft key



- ▶ Press the **Touch probe** soft key

The help graphics illustrate the dimensions of the tools.

Special parameters for touch probes:

- **TP: Touch probe number**
- **SD: Sphere diameter**
- **CA1: Center offset, ref. axis** – Determined based on the **G747** and **G748** calibration cycles
- **CA2: Center offset, minor ax.** – Determined based on the **G747** and **G748** calibration cycles
- Further tool parameters:  
**Further information:** "General tool parameters", Page 585



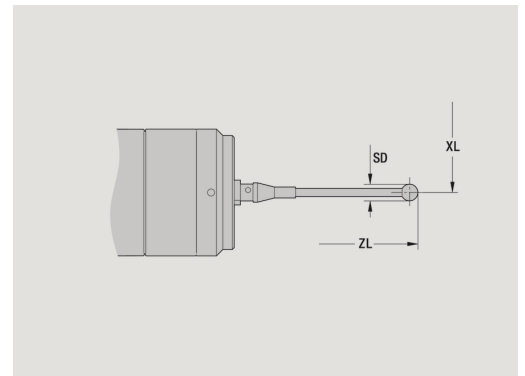
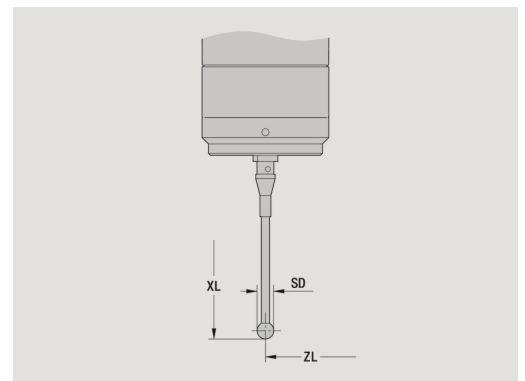
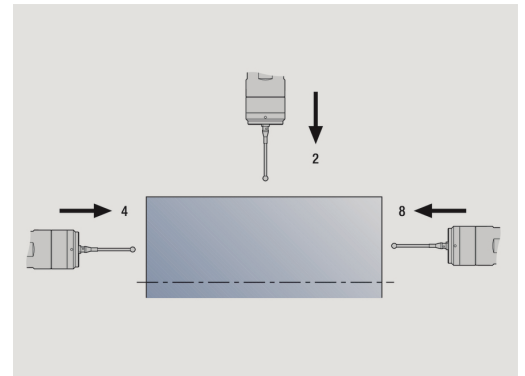
The **CA1** and **CA2** compensation values can also be edited manually in the tool form.



Refer to your machine manual.

The control must be specially prepared by the machine tool builder for the use of a 3-D touch probe.

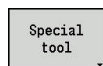
HEIDENHAIN gives a warranty for the function of the touch probe cycles only if HEIDENHAIN touch probes are used!



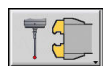
## Stopper tools



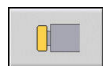
- ▶ Press the **New tool** soft key



- ▶ Press the **Special tool** soft key



- ▶ Press the **handling systems and touch probes** soft key

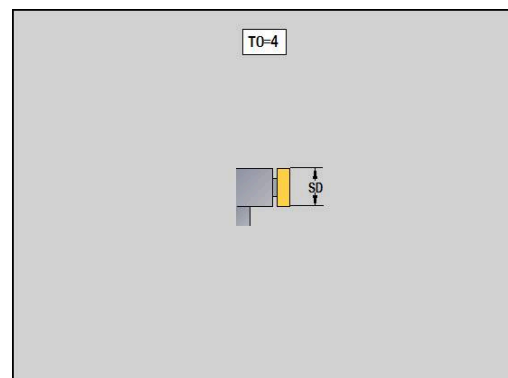
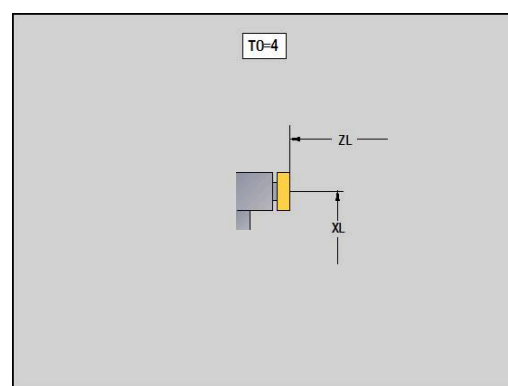
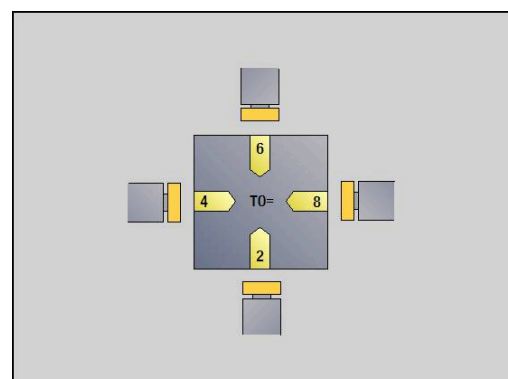


- ▶ Press the **Stopper tool** soft key

The help graphics illustrate the dimensions of the tools.

Special parameters for stopper tools:

- **DD: Special corr.**
- Further tool parameters:  
**Further information:** "General tool parameters", Page 585



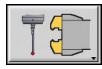
## Gripper



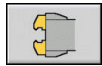
▶ Press the **New tool** soft key



▶ Press the **Special tool** soft key



▶ Press the **handling systems and touch probes** soft key

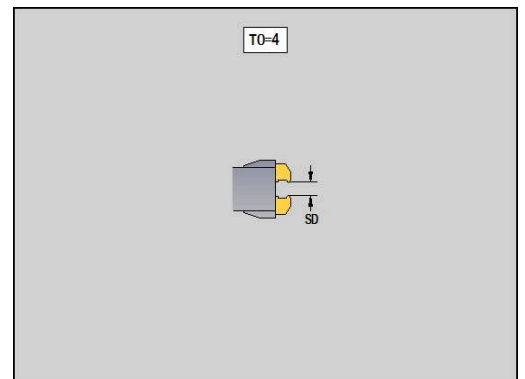
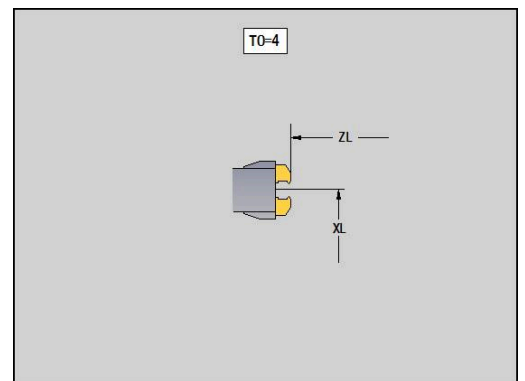
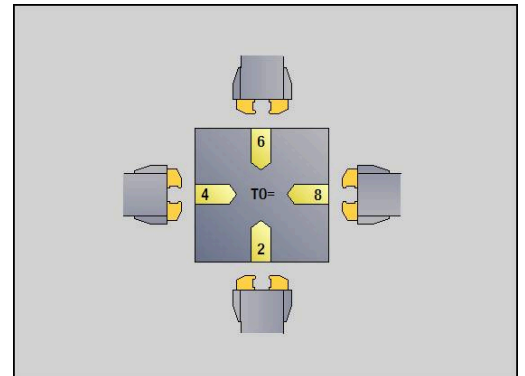


▶ Press the **Gripper** soft key

The help graphics illustrate the dimensions of the tools.

Special parameters for grippers:

- **DD: Special corr.**
- Further tool parameters:  
**Further information:** "General tool parameters", Page 585



## 8.4 Technology database

The technology database manages the cutting data according to the machining mode, the workpiece material and the cutting material. The figure at right shows the composition of the database. Each cube represents a data record with cutting data.

In its standard version, the technology database is designed for 9 workpiece-material/cutting-material combinations. You can optionally expand the database to 62 workpiece-material/cutting-material combinations.

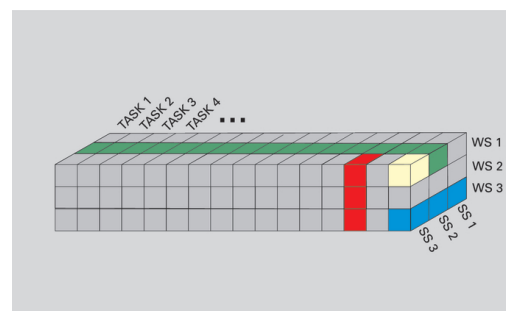
The control ascertains these criteria from the following information:

- **Machining mode:** In cycle programming (**Teach-in** submode), a machining mode is assigned to each cycle, and in **smart.Turn** mode of operation, a machining mode is assigned to each unit
- **Material:** The workpiece material is defined in the **TSF menu** during cycle programming, and in the program header in **smart.Turn** mode of operation
- **Cutting material:** Each tool description contains the cutting material

Using these three criteria, the control accesses a cutting data record (shown yellow in the figure) and generates from it the technology-data proposal.

Explanation of abbreviations used in the figure:

- **Task:** Machining mode
- **WS:** Workpiece material
- **SS:** Cutting material



### Types of machining

Predrilling	Not used
Roughing	2
Finishing	3
Thread cutting	4
Contour recessing	5
Parting	6
Centering	9
Drilling	8
Countersinking	9
Reaming	Not used
Tapping	11
milling	12
Finish milling	13
Deburring	14
Engraving	15
Recessing	16

## Technology editor submode

**Technology editor** submode can be called from the **Tool editor** and **smart.Turn** modes of operation.

Database access to the following combinations is supported:

- Workpiece-material/machining-mode combinations (blue)
- Cutting-material/machining-mode combinations (red)
- Workpiece-material/cutting-material combinations (green)

### Editing workpiece-material and cutting-material designations:

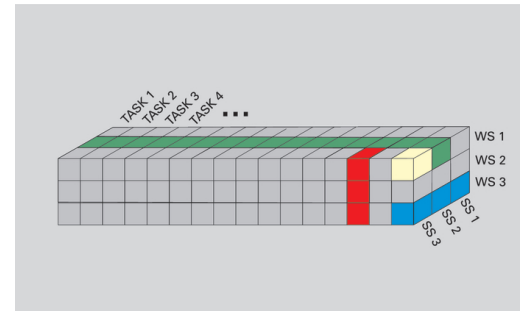
**Technology editor** submode keeps one list each with workpiece-material designations and cutting-material designations.

You have the following options:

- **Insert** new workpiece/cutting materials
- **Do not change** the workpiece/cutting material designations
- **Delete** existing workpiece/cutting material designations. This also deletes the associated cutting data

Explanation of abbreviations used in the figure:

- **Task: Machining mode**
- **WS: Material**
- **SS: Cutting material**



Deleting workpiece-material designations or cutting-material designations also deletes the associated cutting data.

- Following that, the control cannot determine any cutting data for the affected programs or tools.

**Editing the cutting data:** The cutting data of a workpiece-material/cutting-material combination are called a **data record**.

You have the following options:

- Assign cutting data to a workpiece-material/cutting-material combination to create a new data record
- Delete the cutting data of a workpiece-material/cutting-material combination (a data record)

Calling **Technology editor** submode in **Tool editor** mode of operation:



- ▶ Press the **Other tables** soft key



- ▶ Press the **Technology editor** soft key

## Editing a workpiece-material or cutting-material list

Editing a workpiece-material list:



- ▶ Select the **Work materials** menu item
- ▶ The editor opens the list with the workpiece-material designations

Append work piece mat.

Adding a workpiece material:

- ▶ Press the **Append work piece mat.** soft key
- ▶ Enter the workpiece-material designation (max. 16 characters)
- ▶ The sorting number is assigned sequentially

Delete work piece mat.

Deleting a workpiece material:

- ▶ Press the **Delete work piece mat.** soft key
- ▶ After the confirmation request, the control deletes the workpiece material with all associated cutting data

Editing a cutting-material list:



- ▶ Select the **Cuttg. materl.** menu item
- ▶ The editor opens the list with the cutting-material designations

Append cutting mat.

Adding a cutting material:

- ▶ Press the **Append cutting mat.** soft key
- ▶ Enter the cutting-material designation (max. 16 characters)
- ▶ The sorting number is assigned sequentially

Delete cutting mat.

Deleting a cutting material:

- ▶ Press the **Delete cutting mat.** soft key
- ▶ After the confirmation request, the control deletes the cutting material with all associated cutting data

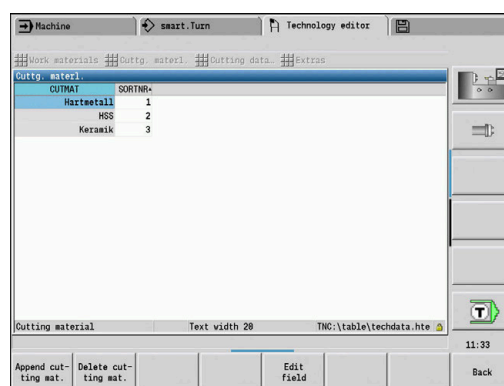
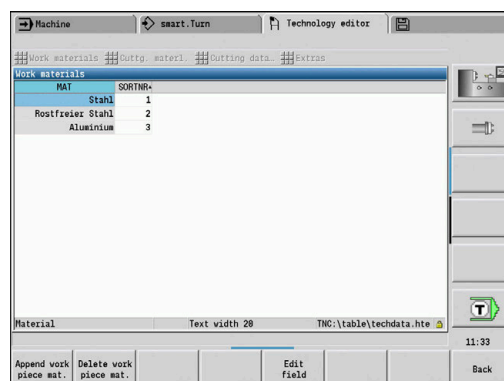
The sorting number only specifies the sequence within the list.

Changing the sorting number:

- ▶ Select the sorting number
- ▶ Press the **Edit field** soft key
- ▶ Enter the new number



Simply expanding the workpiece-material or cutting-material list does not create cutting data. The data record for cutting data of a new workpiece material/cutting material combination is not created until you have requested it through the **New data record** soft key.





## Displaying and editing cutting data

Displaying cutting data of the machining modes:



- ▶ Select the **Cutting data...** menu item
- ▶ The editor opens the dialog for selecting a workpiece material/cutting material combination.
- ▶ Select the desired combination
- ▶ Press the **OK** soft key
- ▶ **Technology editor** submode displays the cutting data.



Displaying cutting data of the workpiece materials:



- ▶ Select the **Extras** menu item



- ▶ Select the **Work mat. tab...** menu item
- ▶ The editor opens the dialog for selecting a machining-mode / cutting-material combination.
- ▶ Select the desired combination
- ▶ Press the **OK** soft key
- ▶ **Technology editor** submode displays the cutting data.



Displaying cutting data of the cutting materials:



- ▶ Select the **Extras** menu item



- ▶ Select the **Cut. mat. tab...** menu item
- ▶ The editor opens the dialog for selecting a workpiece material/cutting material combination.
- ▶ Select the desired combination
- ▶ Press the **OK** soft key
- ▶ **Technology editor** submode displays the cutting data.



The **value 0** in a data record means that no value is transferred to the unit or cycle dialog.

TASK	CUTMAT	CSP	FDR	AFDR	DEP	COOL
Predrilling	Hartmetall	98	0.25	0	0	0
Roughing	Hartmetall	280	0.35	0.25	5	0
Finishing	Hartmetall	220	0.15	0.1	0	0
Thread cutting	Hartmetall	120	0	0	0	0
Contour recess	Hartmetall	160	0.25	0.2	0	0
Parting	Hartmetall	140	0.25	0.18	0	0
Centering	Hartmetall	0	0	0	0	0
Drilling	Hartmetall	80	0.28	0	0	0
Countersinking	Hartmetall	0	0	0	0	0
Reaming	Hartmetall	0	0	0	0	0
Tapping	Hartmetall	60	0	0	0	0
Milling	Hartmetall	64	0.85	0.82	5	0
Finish milling	Hartmetall	74	0.83	0.81	5	0
Deburring	Hartmetall	0	0	0	0	0
Engraving	Hartmetall	0	0	0	0	0
Recess turning	Hartmetall	100	0.5	0.3	5	0

New cutting data dialog box showing:
 

- Material: Stahl
- Cutting mat.: Hartmetall
- Use template: No
- Material: Stahl
- Cutting mat.: Hartmetall
- Data available: Yes

TASK	CUTMAT	CSP	FDR	AFDR	DEP	COOL
Predrilling	Hartmetall	98	0.25	0	0	0
Roughing	Hartmetall	280	0.35	0.25	5	0
Finishing	Hartmetall	220	0.15	0.1	0	0
Thread cutting	Hartmetall	120	0	0	0	0
Contour recess	Hartmetall	160	0.25	0.2	0	0
Parting	Hartmetall	140	0.25	0.18	0	0
Centering	Hartmetall	0	0	0	0	0
Drilling	Hartmetall	80	0.28	0	0	0
Countersinking	Hartmetall	0	0	0	0	0
Reaming	Hartmetall	0	0	0	0	0
Tapping	Hartmetall	60	0	0	0	0
Milling	Hartmetall	64	0.85	0.82	5	0
Finish milling	Hartmetall	74	0.83	0.81	5	0
Deburring	Hartmetall	0	0	0	0	0
Engraving	Hartmetall	0	0	0	0	0
Recess turning	Hartmetall	100	0.5	0.3	5	0

Delete data of the combination Hartmetall and Stahl?

## Editing cutting data:

- ▶ Call the table with cutting data



- ▶ With the arrow keys, select the cutting-data field you want to edit



- ▶ Press the **Edit field** soft key

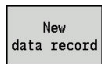
- ▶ Enter a value



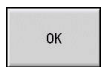
- ▶ Press the **ENT** key

## Adding new cutting data:

- ▶ Select any workpiece-material/cutting material combination



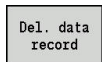
- ▶ Press the **New data record** soft key
- > **Technology editor** submode opens the **New cutting data** dialog.
- ▶ Select the desired workpiece-material/cutting-material combination
- ▶ Decide whether an existing workpiece-material/cutting-material combination should be used as a template. Otherwise, the default value **0** is assigned to all entries



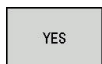
- ▶ Press the **OK** soft key

## Deleting a data record with cutting data:

- ▶ Select the workpiece-material/cutting-material combination (data record) to be deleted



- ▶ Press the **Del. data record** soft key
- > **Technology editor** submode prompts you if you really want to delete the data record.



- ▶ Press the **YES** soft key
- > **Technology editor** submode deletes the data record of the given workpiece material/cutting material combination.

# 9

**Organization mode  
of operation**

## 9.1 Organization mode of operation

**Organization** mode of operation offers various functions for communication with other systems, data backup, setting of parameters, and diagnosis.

The following functions are available:

- **Login code:** Some parameter settings and functions may only be accessed by authorized personnel. Users need to enter a code number to log in to this mode
- **Parameter settings:** Parameters enable you to adapt the control to your specific requirements. The Machine parameter menu provides functions to view and edit parameters
- **Transfer:** **Transfer** submode is used either for exchange of data with other systems or for data backup. You can input and output programs, parameters, and tool data
- **Diagnosis:** The control provides diagnostic functions for checking the system and for troubleshooting



The Configuration and Diagnosis functions can only be accessed by authorized commissioning and service personnel.

### Software numbers

The following software numbers are displayed on the control's screen after the **Key** soft key has been selected:

- HEIDENHAIN
  - **Control model:** Designation of the control (managed by HEIDENHAIN)
  - **NC-SW:** Number of the NC software (managed by HEIDENHAIN)
  - **NCK:** Number of the NC software (managed by HEIDENHAIN)
- Functional safety
  - **MC-FS:** SKERN software of the MC
  - **CC-FS:** SKERN software of the CC number x
  - **SPLC-SW:** Number of the SPLC program
- PLC
  - **PLC-SW:** Number or name of the PLC software (managed by the machine tool builder)



The corresponding information will only be displayed if functional safety (FS) is available on your machine.

**Login code**

<b>Login code (code number)</b>	<b>Possibilities</b>
	<ul style="list-style-type: none"> <li>■ Edit the selected machine parameters</li> <li>■ <b>Transfer</b> submode:                             <ul style="list-style-type: none"> <li>■ Transmit or receive programs</li> <li>■ Create service files</li> </ul> </li> </ul>
123	<ul style="list-style-type: none"> <li>■ Edit all machine parameters</li> <li>■ <b>Transfer</b> submode:                             <ul style="list-style-type: none"> <li>■ Parameter backup</li> <li>■ Back up and restore tools</li> </ul> </li> </ul>
net123	<ul style="list-style-type: none"> <li>■ Configure the network (control name or DHCP)</li> <li>■ <b>Transfer</b> submode:                             <ul style="list-style-type: none"> <li>■ Parameter backup</li> <li>■ Back up and restore tools</li> </ul> </li> </ul>
sik	<ul style="list-style-type: none"> <li>■ Options dialog</li> <li>■ Dialog for activating software options in the SIK (system identification key)</li> </ul>
Service code	<ul style="list-style-type: none"> <li>■ Edit configuration data</li> <li>■ Diagnostic functions</li> <li>■ Restore parameters</li> </ul>








## 9.2 Parameters

### Parameter editor

The parameter values are entered in the configuration editor.

Each parameter object has a name, e.g. **CfgDisplayLanguage** (101300) that gives information about the parameters it contains. Each object has a **key** for unique identification.

The icon at the beginning of each line in the parameter tree shows additional information about this line. The icons have the following meanings.

Icon	Meaning
	Branch exists but is closed
	Branch is open
	Empty object, cannot be opened
	Initialized machine parameter
	Uninitialized (optional) machine parameter
	Can be read but not edited
	Can neither be read nor edited

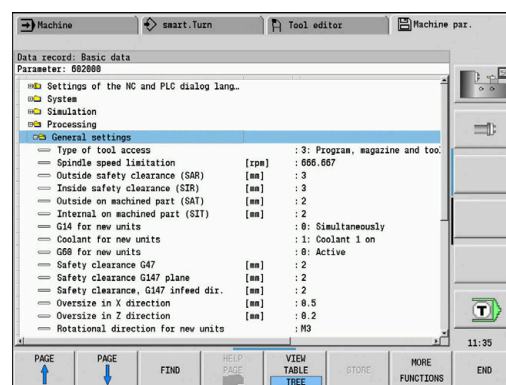
### Machine parameters (user parameters)

Machine parameters are used to adapt the behavior of the control. Machine parameters that are preset for the usual "daily operations" are organized as user parameters.



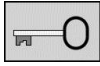
Refer to your machine manual.

Your machine tool builder can make additional machine parameters available as user parameters.



### Editing machine parameters

Editing machine parameters:



- ▶ Press the **Key** soft key

- ▶ Enter the code number 123



- ▶ Alternative: Press the **USER PARAMETER** soft key

### Displaying help texts

Showing a help text:



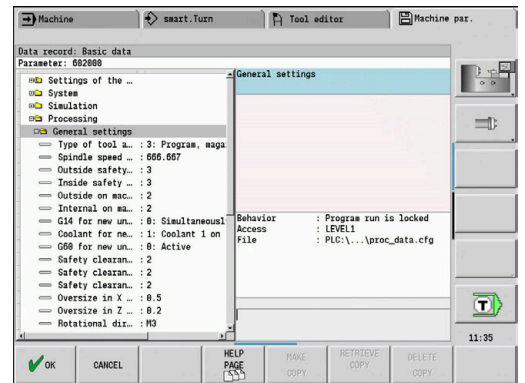
- ▶ Position the cursor on the parameter



- ▶ Press the **Info** key
- ▶ The parameter editor opens a window with information on this parameter.



- ▶ Press the **Info** key again
- ▶ The parameter editor closes the window with information on this parameter.



### Finding parameters

Finding parameters:

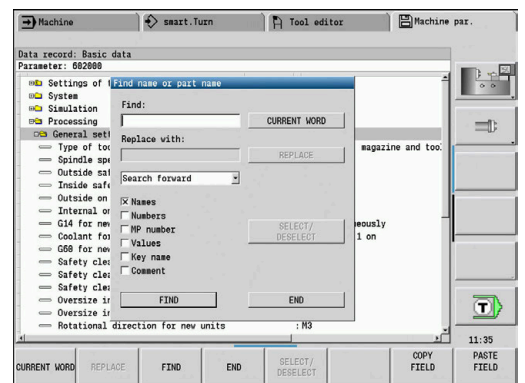


- ▶ Press the **FIND** soft key

- ▶ Enter the search criteria



- ▶ Press the **FIND** soft key again



### Exiting the parameter editor

Exiting the parameter editor:



- ▶ Press the **END** soft key.

## List of machine parameters

---

### Language setting

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Setting the NC and PLC dialog language (101300)

NC dialog language (101301)

**ENGLISH**

**GERMAN**

**CZECH**

**FRENCH**

**ITALIAN**

**SPANISH**

**PORTUGUESE**

**SWEDISH**

**DANISH**

**FINNISH**

**DUTCH**

**POLISH**

**HUNGARIAN**

**RUSSIAN**

**CHINESE**

**CHINESE\_TRAD**

**SLOVENIAN**

**KOREAN**

**NORWEGIAN**

**ROMANIAN**

**SLOVAK**

**TURKISH**

PLC dialog language (101302)

**See NC dialog language**

PLC error message language (101303)

**See NC dialog language**

Help language (101304)

**See NC dialog language**

---

### General settings

---

System

Definition of the unit of measure valid for the display (101100)

Unit of measure for display and user interface (101101)

**metric: Use metric system**

**inch: Use inch system**

---

System

General display settings (604800)

Axis display (604803)

**Default**



---

**General settings**


---

**REFIST: Actual value**

**REF.NOML.: Nominal value**

**LAG: Servo lag**

**DIST: Distance to go**

File preview during program selection(604804)

**TRUE: File preview during program selection is displayed**

**FALSE: No file preview during program selection**

Do not display limit switch warnings (604805)

**TRUE: If an axis is positioned on the limit switch position, no limit switch warning will be displayed**

**FALSE: A limit switch warning will be displayed**

---

**System**

Settings for automatic operation (601800)

Tool life management (601801)

**On: Tool life management is active**

**Off: Tool life management is inactive**

Program run with the most recently selected cycle (601809)

**On: When Program Run is selected, the most recently selected cycle remains active.**

**Off: When Program Run is selected, the first cycle will be active.**

End mid-program startup after start block (601810)

**TRUE: In mid-program startup, program execution begins with the following NC block**

**FALSE: In mid-program startup, program execution begins with the selected NC block**

Special dimensioning of button tools (601812)

**On: When you enter a tool angle of 90 degrees, the tool tip of a button tool that has no neutral tool orientation (TO not equal to 2, 4, 6, 8), will be dimensioned like a neutral tool**

**Off: When you enter a tool angle of 90 degrees, the tool tip of a button tool that has no neutral tool orientation (TO not equal to 2, 4, 6, 8), will be dimensioned with respect to the point on the tool tip that corresponds to the orientation**

Automatic program selection (601814)

**On: When you activate Program Run mode of operation, the program that was last active will be selected**

**Off: When you activate Program Run mode of operation, the program that was last active will not be selected**

---

**System**

Tool dimensioning (604600)

Measuring feed rate (604602)

**[mm/min]: Feed rate for the approach of the touch probe**

---

## General settings

---

Measuring range (604603)

**[mm]: The touch probe must be deflected within the measuring range. Otherwise, an error message will be issued**

---

## System

Settings for Machine mode of operation (604900)

Save cycle without simulation (604903)

**TRUE: The cycle can be saved without previous simulation or execution**

**FALSE: The cycle can only be saved after previous simulation or execution**

Executed tool change with NC start (604904)

**TRUE: A tool change using the TSF dialog will be executed with the Start cycle**

**FALSE: No tool change will not be executed with the Start cycle**

Separate dialogs for tool change, spindle speed and feed rate (TSF) (604906)

**TRUE: Input of tool change, spindle speed, and feed rate data in separate dialogs**

**FALSE: Input of all cutting data in the TSF dialog**

---

## System

Settings for load monitoring (124700)

Activate load monitoring (124701)

**TRUE: Load monitoring is active**

**FALSE: Load monitoring is inactive**

Factor for utilization limit-1 (124702)

**[%]: This value, multiplied by the reference value determined during reference machining, is the load utilization limit-1**

Factor for utilization limit -2 (124703)

**[%]: This value, multiplied by the reference value determined during reference machining, is the utilization limit-2**

Factor for the limit of the utilization sum (124704)

**[%]: This value, multiplied by the reference value determined during reference machining, is the limit value of the utilization sum**

---

## Channel settings

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### Channels

CH\_NC1

Configuration of the machining cycles (201000)

Suppress "Residual material due to cutting edge geometry" warning (201010)

**On: No warning is displayed**

**Off: A warning is displayed**

---

## Settings for the simulation

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### Simulation

---

**Settings for the simulation**


---

General settings (114800)

Restart with M99 (114801)

**On: Simulation restarts at the beginning of the program**

**Off: Simulation stops**

Path-delay (114802)

**[s]: Waiting time after each path display. This setting influences the speed of simulation**

Software limit switch active (114803)

**On: Software limit switch is also active during simulation**

**Off: Software limit switch is not active during simulation**

---

**Simulation**

Processing times for NC functions (general) (115000)

Time allowance for tool change (115001)

**[s]: These times are used as non-machining times for the time calculation function**

Time allowance for gear shifting (115002)

**[s]: These times are used as non-machining times for the time calculation function**

General time allowance for M functions (115003)

**[s]: These times are used as non-machining times for the time calculation function**

---

**Simulation**

Processing times for M functions (115100): Individual time allowances for a maximum of 20 M functions

T01 (115100)

Number of the M function

Time allowance for the M function

**[s]: Time calculation adds this time to the general time allowance for M functions**

TXX (115100)

**See T01**

---

**Simulation**

Definition of the (default) window size (115200): The simulation adapts the window size to the workpiece blank. If no workpiece blank has been programmed, the simulation will use the default window size

Datum position in X (115201)

**[mm]: Distance of the coordinate origin from the lower edge of the window**

Datum position in Z (115202)

**[mm]: Distance of the coordinate origin from the left edge of the window**

Delta X (115203)

**[mm]: Vertical extension of the graphic window**

---

## Settings for the simulation

---

Delta Z (115204)

**[mm]: Horizontal extension of the graphic window**

---

### Simulation

Definition of the (default) workpiece blank size (115300): If no workpiece blank has been programmed in DIN PLUS, the simulation will use the default workpiece blank

Outside diameter (115301)

**[mm]**

Length of the workpiece blank (115302)

**[mm]**

Right edge of the workpiece blank (115303)

**[mm]**

Inside diameter (115304)

**[mm]**

---

## Settings for fixed cycles and units

---

### Processing

General settings (602000)

Type of tool access (602001)

**0: First from the NC program, then from the tool table**

**1: Only from the NC program**

**2: First from the NC program, then from the magazine**

**3: First from the NC program, then from the magazine, then from the tool table**

Safety clearance, outside (SAR) (602005)

**[mm]: Safety clearance to the workpiece blank, outside**

Safety clearance, inside (SIR) (602006)

**[mm]: Safety clearance to workpiece blank, inside**

Safety clearance to the prepared workpiece, outside (SAT) (602007)

**[mm]: Safety clearance to the prepared workpiece, outside**

Safety clearance to the prepared workpiece, inside (SIT) (602008)

**[mm]: Safety clearance to the prepared workpiece, inside**

G14 for new units (602009): Default value for tool change position G14

**No axis**

**0: Simultaneously**

**1: First X, then Z**

**2: First Z, then X**

**3: Only X**

**4: Only Z**

**5: Only Y**

---

**Settings for fixed cycles and units**


---

**6: Simultaneously with Y**

Coolant for new units (602010): Default value for coolant CLT

**0: Without**

**1: Circuit 1 on**

**2: Circuit 2 on**

G60 for new units (602011): Default value for protection zone G60

**0: Active**

**1: Inactive**

Safety clearance G47 (602012)

**[mm]: Default value for safety clearance G47**

Safety clearance G147 in plane (602013)

**[mm]: Default value for safety clearance SCK**

Safety clearance G147 in infeed direction (602014)

**[mm]: Default value for safety clearance SCI**

Oversize in X direction (602015)

**[mm]: Default value for oversize (X) I**

Oversize in Z direction (602016)

**[mm]: Default value for oversize (Z) K**

Direction of rotation for new units (602017): Default value for direction of rotation MD

**M3**

**M4**

Datum shift (602022)

**On: The AWG generates a datum shift**

**Off: The AWG does not generate a datum shift**

Front edge of chuck on main spindle (602018)

**[mm]: Position of the front edge of chuck in Z direction for calculating the workpiece datum**

Front edge of chuck on counter spindle (602019)

**[mm]: Position of the front edge of chuck in Z direction for calculating the workpiece datum**

Jaw width on main spindle (602020)

**[mm]: Jaw width on the main spindle in Z direction for calculating the workpiece datum**

Jaw width on counter spindle (602021)

**[mm]: Jaw width on the counter spindle in Z direction for calculating the workpiece datum**

---

**Settings for fixed cycles and units**


---

Conversion of ICP contours (602023)

**0: Read out calculated parameters**

**1: Read out programmed parameters**

Generate contour groups (602024)

**OFF: The AWG does not generate contour groups**

**ON: The AWG generates two contour groups when performing full-surface machining at the main and counter spindle**

Generate structure program (602025)

**OFF: The AWG does not generate a structural program**

**ON: The AWG generates a structural program**

Delete contour group at counter spindle (602026)

**OFF: The contour group at the counter spindle will not be deleted**

**ON: The AWG deletes the contour group at the counter spindle**

---

**Processing**

Global parameters for finished parts (601900)

Max. inward copying angle (EKW) (601903)

**[°]: Limit angle for the distinction between turning and recessing**

---

**Processing**

Centric predrilling (602100)

First drill limit diameter [UBD1] (602101)

**[mm]: Limit diameter for the first predrilling pass**

Second drill limit diameter [UBD2] (602102)

**[mm]: Limit diameter for the second predrilling pass**

Point angle tolerance [SWT] (602103)

**[°]: Permissible point angle deviations for oblique drilling limit elements**

Drilling oversize – diameter [BAX] (602104)

**[mm]: Machining oversize for drilling diameter in X-direction (radius dimension)**

Drilling oversize – depth [BAZ] (602105)

**[mm]: Machining oversize for drilling depth in Z-direction**

Approach to predrilling [ANB] (602106): Approach strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Departure for tool change [ABW] (602106): Departing strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

---

**Settings for fixed cycles and units**


---

Safety clearance to workpiece blank [SAB] (602108)

**[mm]: Safety clearance to workpiece blank**

Safety clearance, inside [SIB] (602109)

**[mm]: Retraction clearance for deep drilling (B in G74)**

Drilling depth ratio [BTV] (602110)

**Ratio for checking the predrilling passes ( $BTV \leq BT/d_{max}$ )**

Drilling depth factor [BTF] (602111)

**Factor for the calculation of the first drilling depth for deep drilling ( $bt1 = BTF \cdot db$ )**

Drilling depth reduction [BTR] (602112)

**[mm]: Reduction for deep drilling ( $bt2 = bt1 - IBTR$ )**

Overhang length – predrilling [ULB] (602113)

**[mm]: Default value for spot drilling/through hole A**

---

**Processing**

Roughing (602200)

Tool angle – outside/longitudinal [RALEW] (602201)

**[°]: Tool angle for roughing tool**

Point angle – outside/longitudinal [RALSW] (602202)

**[°]: Point angle for roughing tool**

Tool angle – outside/transverse [RAPEW] (602203)

**[°]: Tool angle for roughing tool**

Point angle – outside/transverse [RAPSW] (602204)

**[°]: Point angle for roughing tool**

Tool angle – inside/longitudinal [RILEW] (602205)

**[°]: Tool angle for roughing tool**

Point angle – inside/longitudinal [RILSW] (602206)

**[°]: Point angle for roughing tool**

Tool angle – inside/transverse [RIPEW] (602207)

**[°]: Tool angle for roughing tool**

Point angle – inside/transverse [RIPSW] (602208)

**[°]: Point angle for roughing tool**

Machining – outside/longitudinal [RAL] (602209): Roughing strategy

**0: Full-surface roughing cycle, including plunge-cutting**

**1: Standard roughing cycle, without plunge-cutting**

Machining – inside/longitudinal [RIL] (602210): Roughing strategy

---

**Settings for fixed cycles and units**


---

**0: Full-surface roughing cycle, including plunge-cutting**

**1: Standard roughing cycle, without plunge-cutting**

Machining – outside/transverse [RAP] (602211): Roughing strategy

**0: Full-surface roughing cycle, including plunge-cutting**

**1: Standard roughing cycle, without plunge-cutting**

Machining – inside/transverse [RIP] (602212): Roughing strategy

**0: Full-surface roughing cycle, including plunge-cutting**

**1: Standard roughing cycle, without plunge-cutting**

Secondary angle tolerance [RNWT] (602213)

**[°]: Tolerance range for secondary tool cutting edge**

Relief cutting angle [RFW] (602214)

**[°]: Minimum difference between contour and secondary cutting edge**

Oversize type [RAA] (602215)

**16: Different longitudinal/transverse oversizes – no individual oversizes**

**32: Equidistant oversize – no individual oversizes**

**144: Different longitudinal/transverse oversizes – with individual oversizes**

**160: Equidistant oversize – with individual oversizes**

Equidistant or longitudinal [RLA] (602216)

**[mm]: Equidistant oversize or longitudinal oversize**

Traverse oversize [RPA] (602217)

**[mm]: Traverse oversize**

Approach/outside roughing [ANRA] (602218): Approach strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Approach/inside roughing [ANRI] (602219): Approach strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Departing/outside roughing [ABRA] (602220): Departing strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Departing/inside roughing [ABRI] (602221): Departing strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**



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**Settings for fixed cycles and units**


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Traverse/longitudinal ratio, outside [PLVA] (602222)

**Ratio for the decision to perform longitudinal or traverse machining**

Traverse/longitudinal ratio, inside [PLVI] (602223)

**Ratio for the decision to perform longitudinal or traverse machining**

Minimum traverse length [RMPL] (602224)

**[mm]: Radius dimension for the determination of the machining type**

Traverse angle deviation [PWA] (602225)

**[°]: Tolerance range in which the first element is considered as a traverse element**

Overhang length – outside [ULA] (602226)

**[mm]: Length by which the machine performs outside roughing beyond the target point**

Overhang length – inside [ULI] (602227)

**[mm]: Length by which the machine performs inside roughing beyond the target point**

Lift-off length – outside [RAHL] (602228)

**[mm]: Lift-off length for smoothing variants H = 1 and H = 2**

Lift-off length – inside [RIHL] (602229)

**[mm]: Lift-off length for smoothing variants H = 1 and H = 2**

Cutting depth reduction factor [SRF] (602230)

**Factor for the reduction of the infeed (cutting depth) – for tools that do not machine in the main machining direction**

---

## Processing

Finishing (602300)

Tool angle – outside/longitudinal [FALEW] (602301)

**[°]: Tool angle for finishing tool**

Point angle – outside/longitudinal [FALSW] (602302)

**[°]: Point angle for finishing tool**

Tool angle – outside/transverse [FAPEW] (602303)

**[°]: Tool angle for finishing tool**

Point angle – outside/transverse [FAPSW] (602304)

**[°]: Point angle for finishing tool**

Tool angle – inside/longitudinal [FILEW] (602305)

**[°]: Tool angle for finishing tool**

Point angle – inside/longitudinal [FILSW] (602306)

**[°]: Point angle for finishing tool**

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**Settings for fixed cycles and units**


---

Tool angle – inside/transverse [FIPEW] (602307)

**[°]: Tool angle for finishing tool**

Point angle – inside/transverse [FIPSW] (602308)

**[°]: Point angle for finishing tool**

Machining – outside/longitudinal [FAL] (602309): Finishing strategy

**0: Full-surface finishing cycle, with optimum tool**

**1: Standard finishing cycle; relief turns and undercuts with suitable tool**

Machining – inside/longitudinal [FIL] (602310): Finishing strategy

**0: Full-surface finishing cycle, with optimum tool**

**1: Standard finishing cycle; relief turns and undercuts with suitable tool**

Machining – outside/transverse [FAP] (602311): Finishing strategy

**0: Full-surface finishing cycle, with optimum tool**

**1: Standard finishing cycle; relief turns and undercuts with suitable tool**

Machining – inside/transverse [FIP] (602312): Finishing strategy

**0: Full-surface finishing cycle, with optimum tool**

**1: Standard finishing cycle; relief turns and undercuts with suitable tool**

Secondary angle tolerance [FNWT] (602313)

**[°]: Tolerance range for secondary tool cutting edge**

Relief cutting angle [FFW] (602314)

**[°]: Minimum difference between contour and secondary cutting edge**

Approach/outside finishing [ANFA] (602315): Approach strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Approach/inside finishing [ANFI] (602316): Approach strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Departing/outside finishing [ABFA] (602317): Departing strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Departing/inside finishing [ABFI] (602318): Departing strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

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**Settings for fixed cycles and units**


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Min. finishing transverse length [FMPL] (602319)

**[mm]: Dimension for determination of the machining type**

Max. Finishing cutting depth [FMST] (602320)

**[mm]: Permissible plunging depth for unmachined undercuts**

Revolutions for chamfer/rounding [FMUR] (602321)

**Minimum number of revolutions, the feed rate is automatically reduced**

Check of cutting edge length (602322)

**On: Checks whether the usable length of the cutting edge is sufficient for machining**

**Off: No check whether the usable length of the cutting edge is sufficient for machining**

---

**Processing**

Recessing (602400)

Approach/outside recessing [ANESA] (602401): Approach strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Approach/inside recessing [ANESI] (602402): Approach strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Departing/outside recessing [ABESA] (602403): Departing strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Departing/inside recessing [ABESI] (602404): Departing strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Approach/outside contour recessing [ANKSA] (602405): Approach strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Approach/inside contour recessing [ANKSI] (602406): Approach strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Departing/outside contour recessing [ABKSA] (602407): Departing strategy

**1: XZ – Simultaneously**

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**Settings for fixed cycles and units**


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**2: XZ – Sequentially**

**3: ZX – Sequentially**

Departing/inside contour recessing [ABKSI] (602408): Departing strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Recessing width divisor [SBD] (602409)

**Value for the selection of the tool for contour recessing with linear elements at the bottom of the recess**

Oversize type [KSAA] (602410)

**16: Different longitudinal/transverse oversizes – no individual oversizes**

**32: Equidistant oversize – no individual oversizes**

**144: Different longitudinal/transverse oversizes – with individual oversizes**

**160: Equidistant oversize – with individual oversizes**

Equidistant or longitudinal [KSLA] (602411)

**[mm]: Equidistant oversize or longitudinal oversize**

Traverse oversize [KSPA] (602412)

**[mm]: Traverse oversize**

Recessing width factor [SBF] (602413)

**Factor for determination of the maximum tool offset**

Recessing/Finishing (602414): Sequence of finishing cuts

**1: Divide floor element (previous behavior)**

**2: Move through and lift-off**

---

**Processing**

Thread cutting (602500)

Approach/thread cutting, outside [ANGA] (602501): Approach strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Approach/thread cutting, inside [ANGI] (602502): Approach strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Departing/thread cutting, outside [ABBS] (602503): Departing strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

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**Settings for fixed cycles and units**


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Departing/thread cutting, inside [ABGI] (602504): Departing strategy

- 1: XZ – Simultaneously**
- 2: XZ – Sequentially**
- 3: ZX – Sequentially**

Thread run-in length [GAL] (602505)

**[mm]: Default value for the run-in length B**

Thread run-out length [GUL] (602506)

**[mm]: Default value for the run-out length (ending length) P**

---

**Processing**

Measuring (602600)

Measuring loop counter [MC] (602602)

**Specifies the measuring intervals**

Measuring departing length in Z [MLZ] (602603)

**[mm]: Departing length in the Z direction**

Measuring departing length in X [MLX] (602604)

**[mm]: Departing length in the X direction**

Measuring allowance [MA] (602605)

**[mm]: Allowance on the element to be measured**

Measuring cut length [MSL] (602606)

**[mm]: Measuring cut length**

---

**Processing**

Drilling (602700)

Approach/front face – drilling [ANBS] (602701): Approach strategy

- 1: XZ – Simultaneously**
- 2: XZ – Sequentially**
- 3: ZX – Sequentially**

Approach/lateral surface – drilling [ANBM] (602702): Approach strategy

- 1: XZ – Simultaneously**
- 2: XZ – Sequentially**
- 3: ZX – Sequentially**

Departing/front face – drilling [ABBS] (602703): Departing strategy

- 1: XZ – Simultaneously**
- 2: XZ – Sequentially**
- 3: ZX – Sequentially**

Departing/lateral surface – drilling [ABBM] (602704): Departing strategy

- 1: XZ – Simultaneously**
- 2: XZ – Sequentially**

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**Settings for fixed cycles and units**


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**3: ZX – Sequentially**

Inside safety clearance [SIBC] (602705)

**[mm]: Retraction clearance for deep drilling B**

Driven drilling tool [SBC] (602706)

**[mm]: Safety clearance for driven tools**

Non-driven drilling tool [SBCF] (602707)

**[mm]: Safety clearance for tools that are not driven**

Driven tap [SGC] (602708)

**[mm]: Safety clearance for driven tools**

Non-driven tap [SGCF] (602709)

**[mm]: Safety clearance for tools that are not driven**

Drilling depth factor [BTFC] (602710)

**Factor for the calculation of the first drilling depth for deep drilling**

Drilling depth reduction [BTRC] (602711)

**[mm]: Reduction for deep drilling**

Diameter tolerance for drills [BDT] (602712)

**[mm]: Used for the selection of the tool for drilling**

---

**Processing**

Milling (602800)

Approach/front face – milling [ANMS] (602801): Approach strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Approach/lateral surface – milling [ANMM] (602802): Approach strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Departing/front face – milling [ABMS] (602803): Departing strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

Departing/lateral surface – milling [ABMM] (602804): Departing strategy

**1: XZ – Simultaneously**

**2: XZ – Sequentially**

**3: ZX – Sequentially**

**Settings for fixed cycles and units**

Safety clearance in infeed direction [SMZ] (602805)

**[mm]: Distance between the starting position and the upper edge of the milled object**

Safety clearance in milling direction [SME] (602806)

**[mm]: Distance between the milling contour and the edge of the milling cutter**

Oversize in milling direction [MEA] (602807)

**[mm]: Oversize**

Oversize in infeed direction [MZA] (602808)

**[mm]: Oversize**

Processing

ExpertPrograms

Expert programs (606800)

Parameter list

**Key in parameter list**

Parameter lists for expert programs (606900)

Name of the expert program

**Name of the expert program without path**

Parameter

**Parameter value**

Processing

ProgramUnits

Define units (607000)

**Template list**

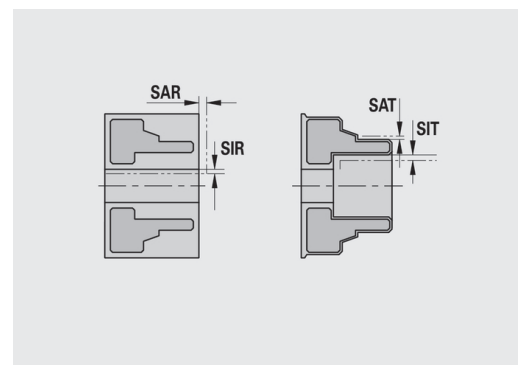
**Descriptions of the most important machining parameters (Processing)**



Machining parameters are used by the **AWG** working plan generation feature (**TURN PLUS** mode of operation) and various machining cycles.

**General settings**

Global technology parameters – Safety clearances



### Global safety clearances

Parameter	Meaning
<ul style="list-style-type: none"> <li>■ Outside on workpiece blank <b>SAR</b></li> <li>■ Inside on workpiece blank <b>SIR</b></li> </ul>	<p><b>TURN PLUS</b> takes <b>SAR</b> and <b>SIR</b> into account:</p> <ul style="list-style-type: none"> <li>■ for all roughing operations</li> <li>■ for centric predrilling</li> </ul>
<ul style="list-style-type: none"> <li>■ Outside on machined part <b>SAT</b></li> <li>■ Inside on machined part <b>SIT</b></li> </ul>	<p><b>TURN PLUS</b> considers <b>SAT</b> and <b>SIT</b> on premachined workpieces for:</p> <ul style="list-style-type: none"> <li>■ Finish-machining</li> <li>■ Recess turning</li> <li>■ Contour recessing (contour cutting)</li> <li>■ Recessing</li> <li>■ Thread cutting</li> <li>■ Measuring</li> </ul>
Protection zone <b>G60</b> for new units	<p>Default setting for the protection zone (start unit: <b>G60</b> parameter):</p> <ul style="list-style-type: none"> <li>■ 0: Active</li> <li>■ 1: Inactive</li> </ul>
Global safety clearance <b>G47</b>	Default setting for the global safety clearance (start unit: <b>G47</b> parameter)
Global safety clearance <b>G147</b> in the plane	Default setting for the global safety clearance in the plane (start unit: <b>SCK</b> parameter)
Global safety clearance <b>G147</b> in infeed direction	Default setting for the global safety clearance in infeed direction (start unit: <b>SCI</b> parameter)
Global oversize in X direction	Default setting for the global safety clearance in X direction (start unit: <b>I</b> parameter)
Global oversize in Z direction	Default setting for the global safety clearance in Z direction (start unit: <b>K</b> parameter)
Front edge of chuck on main spindle	Z position of the front edge of the chuck for calculating the workpiece datum ( <b>AWG</b> submode)



Parameter	Meaning
Front chuck edge on counter spindle	Z position of the front edge of the chuck for calculating the workpiece datum ( <b>AWG</b> submode)
Jaw width on main spindle	Jaw width in Z direction for calculating the workpiece datum ( <b>AWG</b> submode)
Jaw width on counter spindle	Jaw width in Z direction for calculating the workpiece datum ( <b>AWG</b> submode)

Further global technology parameters

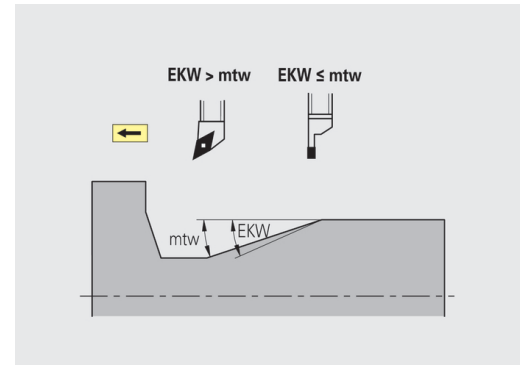
### Global technology parameters

Parameter	Meaning
<b>G14</b> for new units	<p>Default setting for the axis sequence (start unit: <b>GWW</b> parameter) that is used to approach the tool change position:</p> <ul style="list-style-type: none"> <li>■ No axis</li> <li>■ 0: Simultaneously</li> <li>■ 1: First X, then Z</li> <li>■ 2: First Z, then X</li> <li>■ 3: Only X</li> <li>■ 4: Only Z</li> <li>■ 5: Only Y</li> <li>■ 6: Simultaneous w/ Y</li> </ul>
Coolant for new units	<p>Default setting for the coolant (start unit: <b>CLT</b> parameter):</p> <ul style="list-style-type: none"> <li>■ 0: Without coolant</li> <li>■ 1: Coolant circuit 1 on</li> <li>■ 2: Coolant circuit 2 on</li> </ul>
Rotational direction for new units	<p>Default for the spindle direction of rotation <b>MD</b> when creating or opening a new unit (<b>Tool</b> tab)</p>
Conversion of the ICP contours	<p>Type of conversion for the ICP contours</p> <ul style="list-style-type: none"> <li>■ 0: The calculated parameters are output</li> <li>■ 1: The programmed parameters are output</li> </ul>

Global parameters for finished parts

**Global parameters for finished parts**

Parameter	Meaning
Max. inward copying angle <b>EKW</b>	<p>Tolerance angle for recess areas, used for distinguishing turning from recessing (<math>mtw =</math> contour angle):</p> <ul style="list-style-type: none"> <li>■ <b>EKW</b> &gt; <b>mtw</b>: Relief turn</li> <li>■ <b>EKW</b> &lt;= <b>mtw</b>: Undefined recess (no form element)</li> </ul>



## Centric predrilling

Centric predrilling – Tool selection

### Tool selection

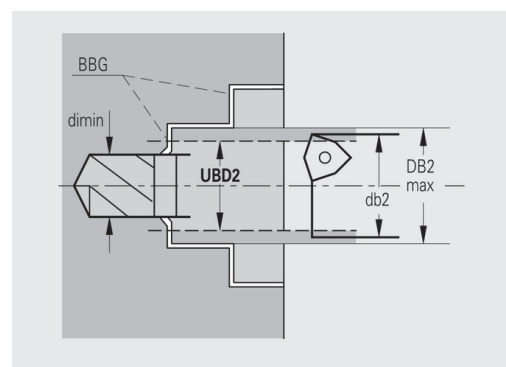
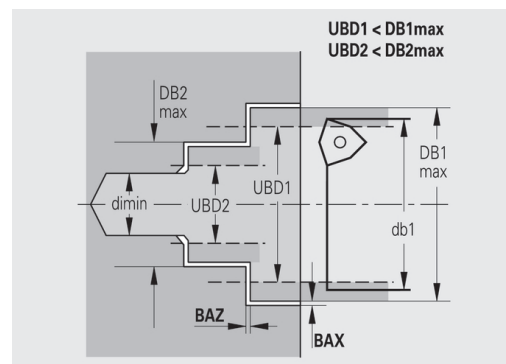
Parameter	Meaning
1st drilling diameter limit <b>UBD1</b>	<ul style="list-style-type: none"> <li>1st predrilling step: if <b>UBD1 &lt; DB1max</b></li> <li>Tool selection: <b>UBD1 &lt;= db1 &lt;= DB1max</b></li> </ul>
2nd drilling diameter limit <b>UBD2</b>	<ul style="list-style-type: none"> <li>2nd predrilling step: If <b>UBD2 &lt; DB2max</b></li> <li>Tool selection: <b>UBD2 &lt;= db2 &lt;= DB2max</b></li> </ul>

For predrilling, a maximum of three drilling steps is used:

- 1st predrilling step (limit diameter **UBD1**)
- 2nd predrilling step (limit diameter **UBD2**)
- Finish-drilling step
  - Finish-drilling is performed with:  $dimin \leq UBD2$
  - Tool selection: **db = dimin**

Designations in the figures at right:

- **db1, db2**: Drill diameter
- **DB1max**: Max. inside diameter for 1st drilling step
- **DB2max**: Max. inside diameter for 2nd drilling step
- **dimin**: Min. inside diameter
- **BBG** (drilling limitation elements): Contour elements intersected by **UBD1** and **UBD2**

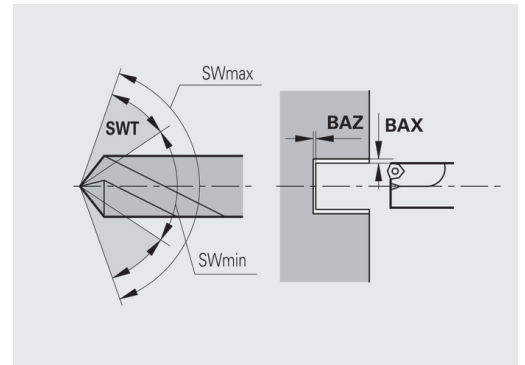


- **UBD1** and **UBD2** have no effect when **Centric predrilling** has been defined as main machining operation followed by **Finish-drilling** as submachining operation in the machining sequence  
**Further information:** smart.Turn and DIN Programming User's Manual
- Prerequisite: **UBD1 > UBD2**
- **UBD2** must permit subsequent inside machining with boring bars

Centric predrilling – Oversizes

**Oversizes**

Parameter	Meaning
Point angle tolerance <b>SWT</b>	If the drilling limitation element is a diagonal element, <b>TURN PLUS</b> prefers using a twist drill with suitable point angle. If no suitable twist drill is available, an indexable-insert drill is selected for the predrilling operation. <b>SWT</b> defines the permissible point angle tolerance.
Drilling oversize – Diameter <b>BAX</b>	Machining oversize on drilling diameter (X direction – radius value)
Drilling oversize – Depth <b>BAZ</b>	Machining oversize on drilling depth (Z direction)



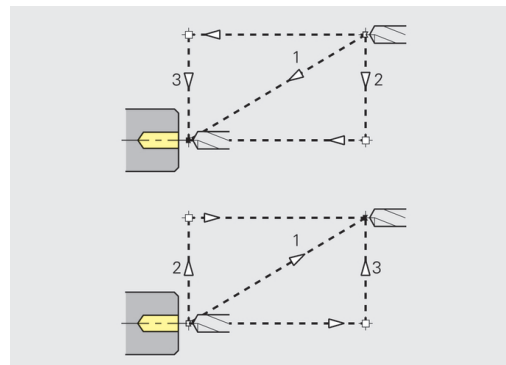
**BAZ** is not considered if:

- A subsequent inside finishing operation is not possible due to the small diameter
- $dimin < 2 * UBD2$  in the finish-drilling step for blind holes

Centric predrilling – Approach and departure

### Approach and departure

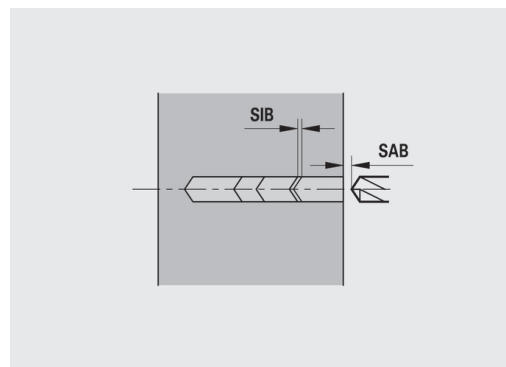
Parameter	Meaning
<ul style="list-style-type: none"> <li>■ Traverse for predrilling <b>ANB</b></li> <li>■ Traverse for tool change <b>ABW</b></li> </ul>	Approach or departure strategy: <ul style="list-style-type: none"> <li>■ 1: Move simultaneously in X and Z directions</li> <li>■ 2: First X, then Z direction</li> <li>■ 3: First Z, then X direction</li> </ul>



Centric predrilling – Safety clearances

### Safety clearances

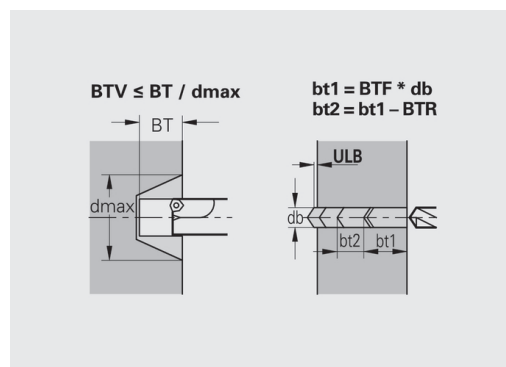
Parameter	Meaning
Safety clearance on workpiece blank <b>SAB</b>	
Internal safety clearance <b>SIB</b>	Retraction distance for deep-hole drilling ( <b>B</b> for <b>G74</b> )



Centric predrilling – Machining

### Machining

Parameter	Meaning
Drilling depth ratio <b>BTV</b>	<b>TURN PLUS</b> checks the 1st and 2nd drilling steps. The predrilling step is performed if: $BTV \leq BT / d_{max}$
Drilling depth factor <b>BTF</b>	1st drilling depth for deep-hole drilling cycle ( <b>G74</b> ): $bt1 = BTF * db$
Depth reduction <b>BTR</b>	Reduction for deep-hole drilling cycle ( <b>G74</b> ): $bt2 = bt1 - BTR$
Overhang length – Predrilling <b>ULB</b>	Through-drilling length



## Roughing

Roughing – Tool standards

Furthermore:

- Roughing cycles are primarily executed with standard roughing tools
- Alternatively, tools that allow full-surface machining are used

### Tool standards

#### Parameter

- Tool angle – External/Longitudinal **RALEW**
- Point angle – External/Longitudinal **RALSW**
- Tool angle – External/Transverse **RAPEW**
- Point angle – External/Transverse **RAPSW**
- Tool angle – Internal/Longitudinal **RILEW**
- Point angle – Internal/Longitudinal **RILSW**
- Tool angle – Internal/Transverse **RIPEW**
- Point angle – Internal/Transverse **RIPSW**

Roughing – Machining standards

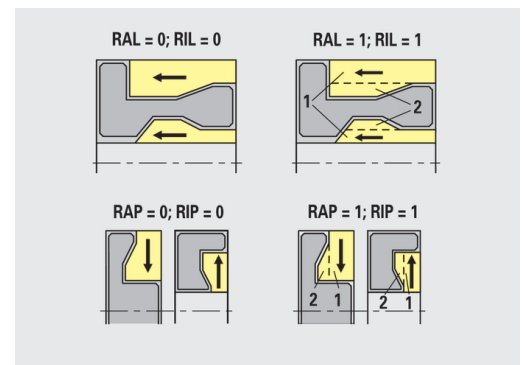
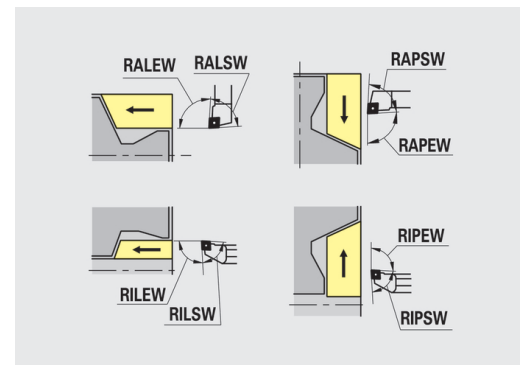
### Machining standards

#### Parameter

- Standard/Full-surface – External/Longitudinal **RAL**
- Standard/Full-surface – Internal/Longitudinal **RIL**
- Standard/Full-surface – External/Transverse **RAP**
- Standard/Full-surface – Internal/Transverse **RIP**

Input for **RAL**, **RIL**, **RAP**, **RIP**:

- 0: Full-surface roughing cycle, including plunge-cutting.  
**TURN PLUS** looks for a tool for full-surface machining
- 1: Standard roughing cycle without plunge-cutting



### Roughing – Tool tolerances

For tool selection, the following applies:

- Tool angle **EW**:  $EW \geq mkw$  (*mkw*: ascending contour angle)
- Tool angle **EW** and point angle **SW**:  $NWmin < (EW+SW) < NWmax$
- Adjacent angle **RNWT**:  $RNWT = NWmax - NWmin$

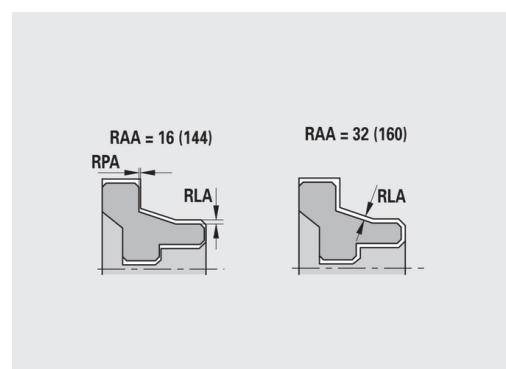
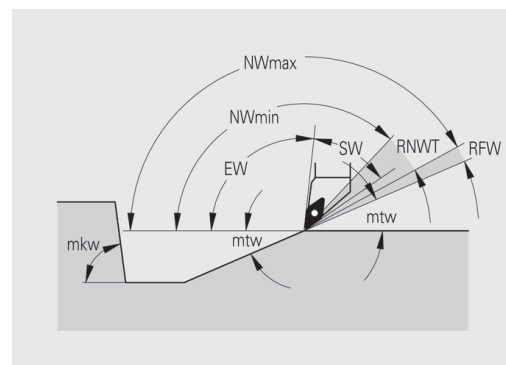
### Tool tolerances

Parameter	Meaning
Adjacent angle tolerance <b>RNWT</b>	Tolerance range for secondary cutting edge
Relief cutting angle <b>RFW</b>	Minimum angle differential between the contour and secondary cutting edge

### Roughing – Oversizes

#### Oversizes

Parameter	Meaning
Type of oversize <b>RAA</b>	<ul style="list-style-type: none"> <li>■ 16: Longitudinal and transverse oversizes differ – No single oversizes</li> <li>■ 32: Equidistant oversize – No single oversizes</li> <li>■ 144: Longitudinal and transverse oversizes differ – With single oversizes</li> <li>■ 160: Equidistant oversize – With single oversizes</li> </ul>
Equidistant or longitudinal <b>RLA</b>	Equidistant oversize or longitudinal oversize
None or transverse <b>RPA</b>	Transverse oversize





Roughing – Approach and departure

Approach and departure movements are at rapid traverse (**G0**).

### Approach and departure

#### Parameter

- Approach – External roughing **ANRA**
- Approach – Internal roughing **ANRI**
- Departure – External roughing **ABRA**
- Departure – Internal roughing **ABRI**

Approach or departure strategy:

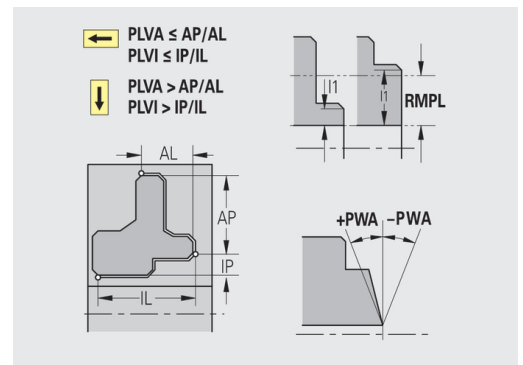
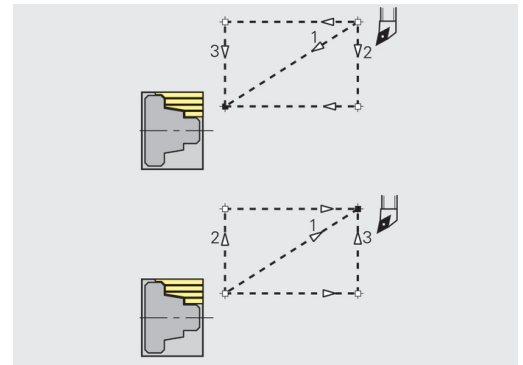
- 1: Move simultaneously in X and Z directions
- 2: First X, then Z direction
- 3: First Z, then X direction

Roughing – Machining analysis

**TURN PLUS** uses the **PLVA** and **PLVI** parameters to define whether a roughing area is to be rough-machined longitudinally or transversely.

### Machining analysis

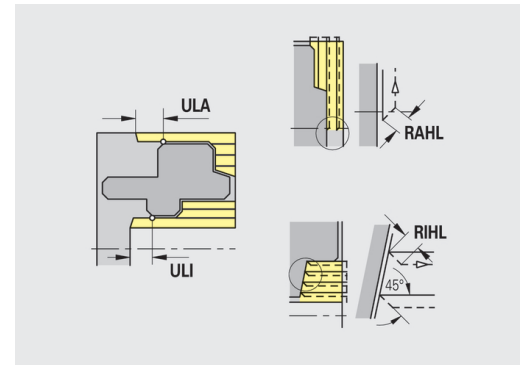
Parameter	Meaning
Transverse/longitudinal ratio – External <b>PLVA</b>	<ul style="list-style-type: none"> <li>■ <b>PLVA</b> <math>\leq</math> <b>AP / AL</b>: Longitudinal machining</li> <li>■ <b>PLVA</b> <math>&gt;</math> <b>AP / AL</b>: Transverse machining</li> </ul>
Transverse/longitudinal ratio – Internal <b>PLVI</b>	<ul style="list-style-type: none"> <li>■ <b>PLVI</b> <math>\leq</math> <b>IP / IL</b>: Longitudinal machining</li> <li>■ <b>PLVI</b> <math>&gt;</math> <b>IP / IL</b>: Transverse machining</li> </ul>
Minimum roughing transverse length <b>RMPL</b> (radius value)	<p>Defines whether transverse roughing is used for the front transverse element of the outside contour of a finish part</p> <ul style="list-style-type: none"> <li>■ <b>RMPL</b> <math>&gt;</math> <b>I1</b>: Without additional transverse roughing</li> <li>■ <b>RMPL</b> <math>&lt;</math> <b>I1</b>: With additional transverse roughing</li> <li>■ <b>RMPL</b> = <b>0</b>: Special case</li> </ul>
Transverse angle variation <b>PWA</b>	<p>The first front element is declared a transverse element when it is within <b>+PWA</b> and <b>-PWA</b></p>



Fixed cycles

### Machining analysis

Parameter	Meaning
Overhang length outside <b>ULA</b>	Relative length for external rough-machining allowing roughing beyond the target position in longitudinal direction. <b>ULA</b> is not considered when the cutting limitation is in front of or within the overhang length.
Overhang length – Inside <b>ULI</b>	<ul style="list-style-type: none"> <li>■ Relative length for internal rough-machining allowing roughing beyond the target position in longitudinal direction. <b>ULI</b> is not considered when the cutting limitation is in front of or within the overhang length.</li> <li>■ This parameter is used for calculating the drilling depth for centric predrilling.</li> </ul>
Retracting length outside <b>RAHL</b>	Retracting length for smoothing variants ( <b>H</b> = 1 and 2) of roughing cycles ( <b>G810</b> and <b>G820</b> ) for external machining ( <b>RAHL</b> ).
Retracting length – Inside <b>RIHL</b>	Retracting length for smoothing variants ( <b>H</b> = 1 and 2) of roughing cycles ( <b>G810</b> and <b>G820</b> ) for internal machining ( <b>RIHL</b> ).
Cutting depth reduction factor <b>SRF</b>	<p>For rough-machining with tools machining opposite to the main machining direction, the infeed value (cutting depth) is reduced.</p> <p>Infeed (<b>P</b>) for the roughing cycles (<b>G810</b> and <b>G820</b>): <b>P</b> = <b>ZT</b> * <b>SRF</b></p> <p>(<b>ZT</b>: Infeed value from technology database)</p>

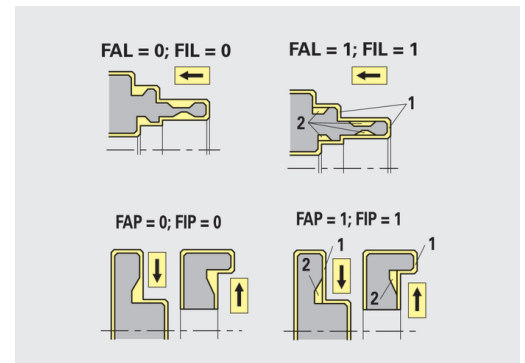


## Finishing

Finishing – Tool standards

Tool selection:

- Finishing cycles are primarily executed with standard finishing tools
- If form elements such as relief turns (**form FD**) and undercuts (**form E, F, G**) cannot be machined with a standard finishing tool, one form element after the other is skipped. **TURN PLUS** starts a renewed attempt to machine the **remaining contour** with the standard tool. Subsequently, the skipped form elements are machined individually with a suitable finishing tool.



## Tool standards

### Parameter

- Tool angle – External/Longitudinal **FALEW**
- Point angle – Internal/Longitudinal **FILEW**
- Tool angle – External/Transverse **FAPEW**
- Point angle – Internal/Transverse **FIPEW**

Finishing – Machining standards

## Machining standards

### Parameter

- Standard/Full-surface – External/Longitudinal **FAL**
- Standard/Full-surface – Internal/Longitudinal **FIL**
- Standard/Full-surface – External/Transverse **FAP**
- Standard/Full-surface – Internal/Transverse **FIP**

Machining of contour areas:

- Complete: **TURN PLUS** searches for an optimum tool for machining the complete contour area
- Default:
  - The machining operation is primarily executed with standard finishing tools. Relief turns and undercuts are machined with a suitable tool
  - If the standard finishing tool cannot be used for relief turns and undercuts, **TURN PLUS** splits up the machining operation into standard machining operations and machining the form elements
  - If a division into standard machining and form-element machining is not possible, **TURN PLUS** switches to **full-surface machining**

## Finishing – Tool tolerances

For tool selection, the following applies:

- Tool angle **EW**:  $EW \geq mkw$  (*mkw*: ascending contour angle)
- Tool angle **EW** and point angle **SW**:  $NWmin < (EW+SW) < NWmax$
- Adjacent angle **FNWT**:  $FNWT = NWmax - NWmin$

## Tool tolerances

Parameter	Meaning
Adjacent angle tolerance <b>FNWT</b>	Tolerance range for secondary cutting edge
Relief cutting angle <b>FFW</b>	Minimum angle differential between the contour and secondary cutting edge

## Finishing – Approach and departure

Approach and departure movements are at rapid traverse (**GO**).

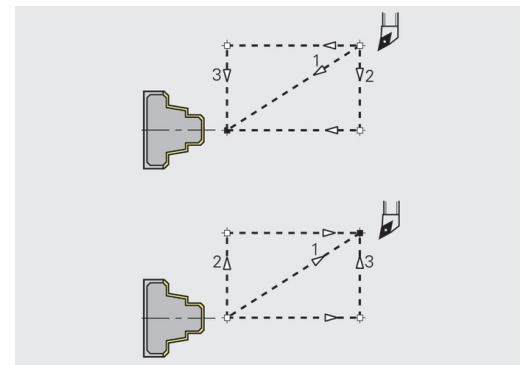
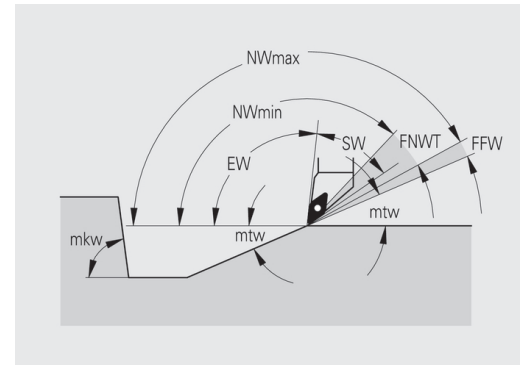
## Approach and departure

## Parameter

- Approach – External finishing **ANFA**
- Approach – Internal finishing **ANFI**
- Departure – External finishing **ABFA**
- Departure – Internal finishing **ABFI**

Approach or departure strategy:

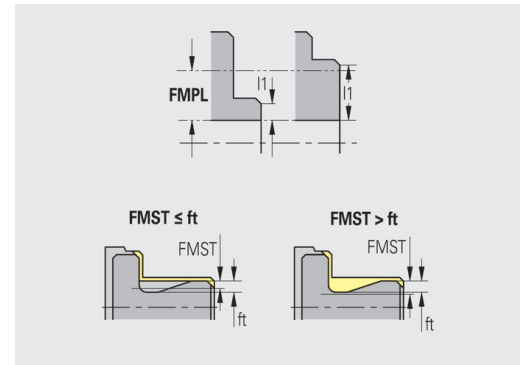
- 1: Move simultaneously in X and Z directions
- 2: First X, then Z direction
- 3: First Z, then X direction



Finishing – Machining analysis

**Machining analysis**

Parameter	Meaning
Minimum finishing transverse length <b>FMPL</b>	<p><b>TURN PLUS</b> checks the front-most element of the outside contour to be finished.</p> <p>The following applies:</p> <ul style="list-style-type: none"> <li>Without inside contour: Always with additional transverse cut</li> <li>With inside contour – <b>FMPL</b> <math>\geq</math> <b>I1</b>: Without additional transverse cut</li> <li>With inside contour – <b>FMPL</b> <math>&lt;</math> <b>I1</b>: With additional transverse cut</li> </ul>
Maximum finishing cut depth <b>FMST</b>	<p><b>FMST</b> defines the permissible infeed depth for non-machined undercuts. The finishing cycle (<b>G890</b>) uses this parameter to determine whether undercuts (<b>form E, F, G</b>) will be machined with a contour-finishing operation.</p> <p>The following applies:</p> <ul style="list-style-type: none"> <li><b>FMST</b> <math>&gt;</math> <b>ft</b>: With undercut machining (<b>ft</b>: undercut depth)</li> <li><b>FMST</b> <math>\leq</math> <b>ft</b>: Without undercut machining</li> </ul>
Number of revolutions for chamfer or rounding <b>FMUR</b>	<p>The feed rate is reduced such that at least <b>FMUR</b> revolutions can be executed (evaluation: finishing cycle <b>G890</b>).</p>



The following applies to FMPL:

- The additional transverse cut is executed from the outside toward the inside
- The **Transverse angle variation PWA** has no effect on the analysis of the transverse elements

## Recessing and contour recessing

Recessing and contour recessing – Tool selection

### Tool selection

Parameter	Meaning
Recessing width divisor <b>SBD</b>	<p>If a recess base machined with a contour-recessing cycle does not contain paraxial elements but only linear elements, a suitable tool is selected using the <b>recessing width divisor SBD</b>.</p> <p><math>SB \leq b / SBD</math> (<b>SB</b>: width of recessing tool; <b>b</b>: width of machining area)</p>

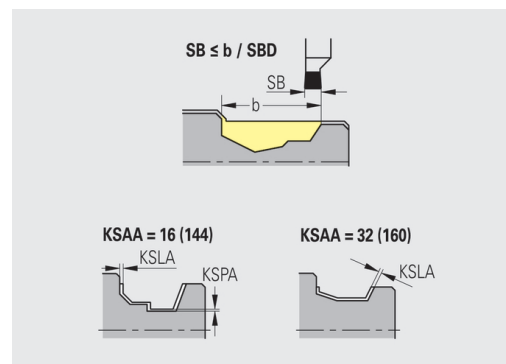
Recessing and contour recessing – Oversizes

### Oversizes

Parameter	Meaning
Type of oversize <b>KSAA</b>	<p>The recessing area to be machined can be assigned oversizes. When oversizes have been defined, a recess is first rough-machined and then finish-machined. Inputs:</p> <ul style="list-style-type: none"> <li>■ 16: Longitudinal and transverse oversizes differ – No single oversizes</li> <li>■ 32: Equidistant oversize – No single oversizes</li> <li>■ 144: Longitudinal and transverse oversizes differ – With single oversizes</li> <li>■ 160: Equidistant oversize – With single oversizes</li> </ul>
Equidistant or longitudinal <b>KSLA</b>	Equidistant oversize or longitudinal oversize
None or transverse <b>KSPA</b>	Transverse oversize



- The oversizes are accounted for when machining contour valleys with a contour-recessing operation
- Standardized recesses, such as recess types **D, S, A**, are completed in one machining operation. A division into rough-machining and finish-machining is only possible in **DIN PLUS**



Recessing and contour recessing – Approach and departure  
 Approach and departure movements are at rapid traverse (**G0**).

**Approach and departure**

**Parameter**

- Approach – External recessing **ANESA**
  - Approach – Internal recessing **ANESI**
  - Departure – External recessing **ABESA**
  - Departure – Internal recessing **ABESI**
- 
- Approach – External contour recessing **ANKSA**
  - Approach – Internal contour recessing **ANKSI**
  - Departure – External contour recessing **ABKSA**
  - Departure – Internal contour recessing **ABKSI**

Approach or departure strategy:

- 1: Move simultaneously in X and Z directions
- 2: First X, then Z direction
- 3: First Z, then X direction

Recessing and contour recessing – Machining

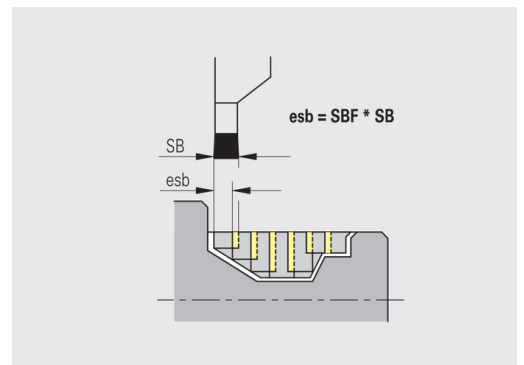
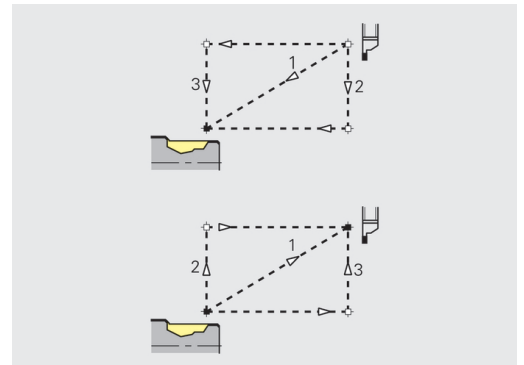
Evaluation: **DIN PLUS**

**Machining**

**Parameter**

**Meaning**

Recessing width factor <b>SBF</b>	<p><b>SBF</b> is used for calculating the maximum offset for recessing cycles <b>G860</b> and <b>G866</b>:</p> <p><b>esb = SBF * SB</b> (<b>esb</b>: effective recessing width; <b>SB</b>: width of recessing tool)</p>
-----------------------------------	---



### Thread cutting

Thread cutting – Approach and departure

Approach and departure movements are at rapid traverse (**G0**).

### Approach and departure

#### Parameter

- Approach – External thread **ANGA**
- Approach – Internal thread **ANGI**
- Departure – External thread **ABGA**
- Departure – Internal thread **ABGI**

Approach or departure strategy:

- 1: Move simultaneously in X and Z directions
- 2: First X, then Z direction
- 3: First Z, then X direction

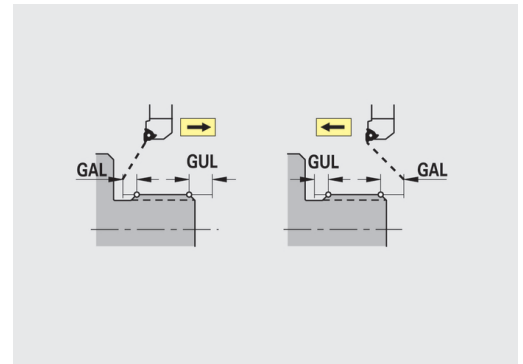
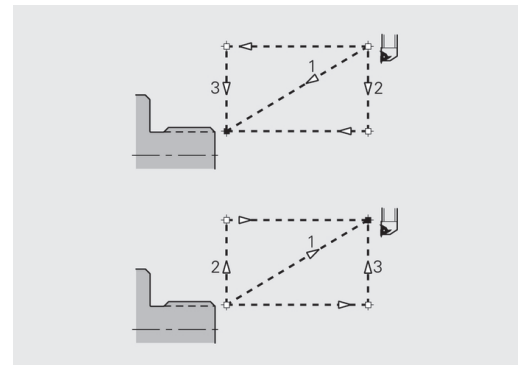
Thread cutting – Machining

### Machining

Parameter	Meaning
Thread run-in length <b>GAL</b>	Run-in length before thread chamfer
Thread run-out length <b>GUL</b>	Overrun length after thread chamfer



**GAL** and **GUL** are automatically copied to the **Run-in length B** and **End. length P** thread attributes if they have not been entered as attributes.





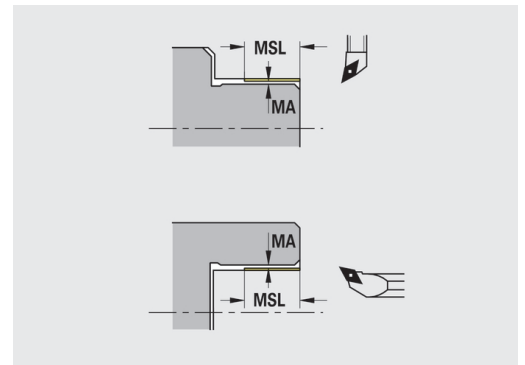
**Measuring**

Measuring – Measurement procedure

The measuring parameters are assigned to the fit elements as attributes.

**Measurement procedure**

Parameter	Meaning
Measuring loop counter <b>MC</b>	Defines the measurement/loop intervals
Measuring departing length in Z <b>MLZ</b>	Distance in Z for departure movement
Measuring departing length in X <b>MLX</b>	Distance in X for departure movement
Measuring oversize <b>MA</b>	Oversize still existing on the element to be measured
Measuring cut length <b>MSL</b>	



## Drilling

Drilling – Approach and departure

Approach and departure movements are at rapid traverse (**G0**).

### Approach and departure

#### Parameter

- Approach – Face **ANBS**
- Approach – Lateral surface **ANBM**
- Departure – Face **ABGA**
- Departure – Lateral surface **ABBM**

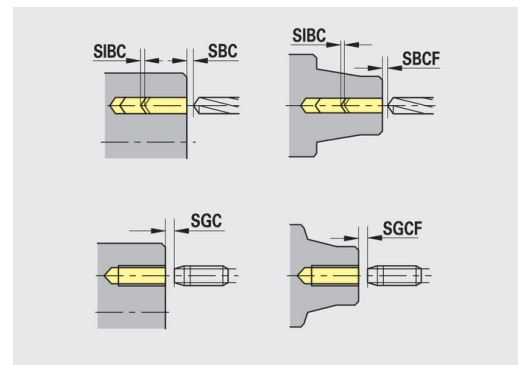
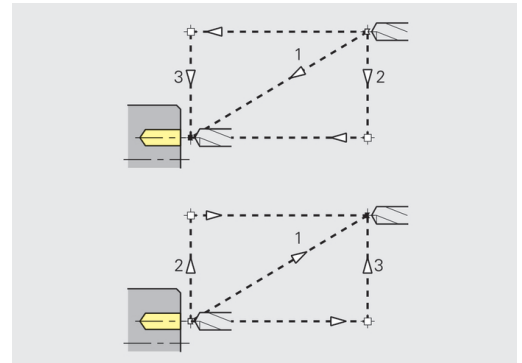
Approach or departure strategy:

- 1: Move simultaneously in X and Z directions
- 2: First X, then Z direction
- 3: First Z, then X direction

Drilling – Safety clearances

### Safety clearances

Parameter	Meaning
Internal safety clearance <b>SIBC</b>	Retraction distance for deep-hole drilling ( <b>B</b> for <b>G74</b> )
Driven drills <b>SBC</b>	Safety clearance for driven tools on face and lateral surface
Stationary drills <b>SBCF</b>	Safety clearance on face and lateral surface for tools that are not driven
Driven taps <b>SGC</b>	Safety clearance for driven tools on face and lateral surface
Stationary taps <b>SGCF</b>	Safety clearance on face and lateral surface for tools that are not driven

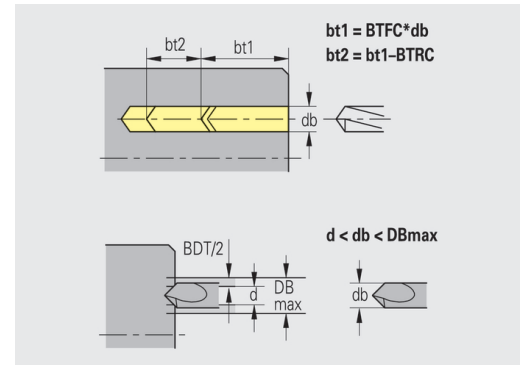


Drilling – Machining

The parameters apply to drilling with deep-hole drilling cycle (**G74**).

**Machining**

Parameter	Meaning
Drilling depth factor <b>BTFC</b>	1st drilling depth: <b>bt1</b> = <b>BTFC</b> * <b>db</b> ( <b>db</b> : Drill diameter)
Depth reduction <b>BTRC</b>	2nd drilling depth: <b>bt2</b> = <b>bt1</b> – <b>BTRC</b> The subsequent drilling steps are reduced accordingly
Diameter tolerance for drill <b>BDT</b>	For selecting the desired drill (centering drills, countersinks, stepped drill, taper reamers). <ul style="list-style-type: none"> <li>■ Drilling diameter: <b>DBmax</b> = <b>BDT</b> + <b>d</b> (<b>DBmax</b>: Maximum drilling diameter)</li> <li>■ Tool selection: <b>DBmax</b> &gt; <b>DB</b> &gt; <b>d</b></li> </ul>



## Milling

Milling – Oversizes

### Oversizes

#### Parameter

Oversize in milling direction **MEA**

Oversize in infeed direction **MZA**

Milling – Approach and departure

Approach and departure movements are at rapid traverse (**GO**).

### Approach and departure

#### Parameter

- Approach – Face **ANMS**
- Approach – Lateral surface **ANMM**
- Departure – Face **ABMS**
- Departure – Lateral surface **ABMM**

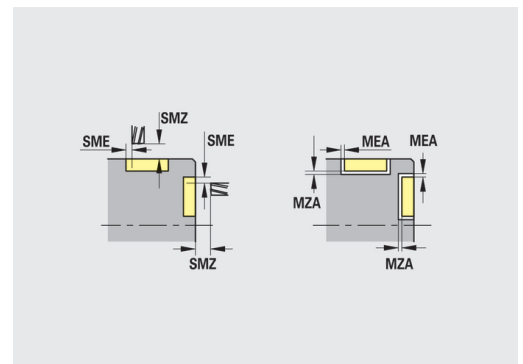
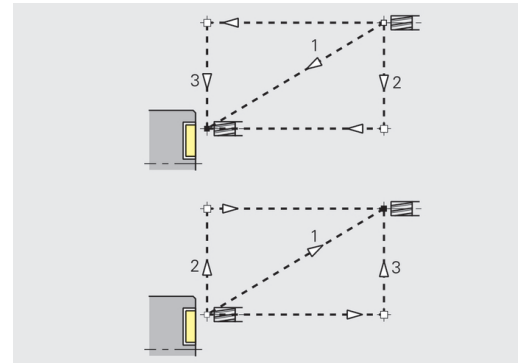
Approach or departure strategy:

- 1: Move simultaneously in X and Z directions
- 2: First X, then Z direction
- 3: First Z, then X direction

Milling – Safety clearances

### Safety clearances

Parameter	Meaning
Safety clearance in infeed direction <b>SMZ</b>	Distance between starting position and top edge of object to be milled
Safety clearance in milling direction <b>SME</b>	Distance between milling contour and edge of milling cutter



## 9.3 Transfer submode

**Transfer** submode is used for data backup and data exchange via networks or USB devices. Speaking of **files** in the following, means programs, parameters, or tool data.

The following file types can be transferred:

- Programs (cycle programs, smart.Turn programs, DIN main programs and DIN subprograms, ICP contour descriptions)
- Parameter
- Tool data



Screenshots (taken with the **PRT SC** key) can be transferred from the **Service** area.

### Data backup

HEIDENHAIN recommends backing up the tool data and programs created on the control on an external device at regular intervals.

You should also back up the parameters. Since the parameters are not changed very often, however, you only need to back up the parameters from time to time, as required.

### Data exchange with TNCremo

HEIDENHAIN offers the PC program TNCremo to complement the control. This program enables you to access the control data from a PC.

### External access



The machine tool builder can configure the external access options. Refer to your machine manual.

The **External access** soft key can be used to permit or restrict access through the LSV2 interface.

Permitting external access:



- ▶ Select the **Organization** operating mode

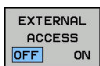


- ▶ Set the **External access** soft key to **ON**
- > The control will then permit data access through the LSV2 interface

Restricting external access:



- ▶ Select the **Organization** operating mode



- ▶ Set the **External access** soft key to **OFF**
- > The control will then disable access through the LSV2 interface

## Connections

You can establish connections over the network (Ethernet) or with a USB storage device. Data is transferred over the **Ethernet** or **USB** interface.

- Network (via Ethernet): The control supports **SMB** networks (Server Message Block, WINDOWS) and **NFS** networks (Network File Service)
- USB storage devices can be connected directly to the control. The control uses only the first partition of a USB storage device

### NOTICE

#### Danger of collision!

#### Caution: Data may be lost!

Unprotected or insufficiently configured networks facilitate unauthorized and insecure access to control data. As a consequence, NC programs and machine settings may be changed or deleted. This results in a risk of data loss and in an increased danger of collision!

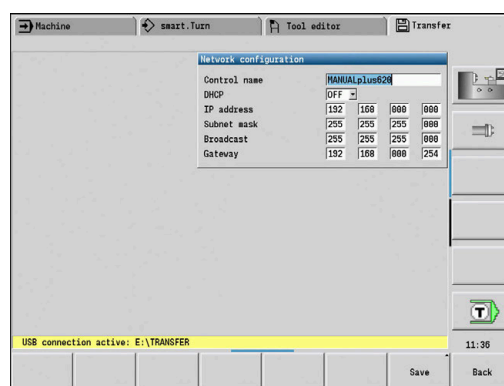
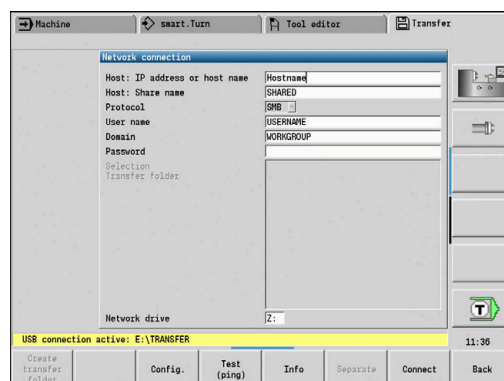
- ▶ Enable only authorized persons to access the control over the network
- ▶ If required, deactivate external access in **Organization** mode of operation
- ▶ Alternative: Write-protect data, where necessary

HEIDENHAIN also recommends backing up the data at regular intervals.



You can also create new folders on a connected USB storage device or network drive. Press the **Create transfer folder** soft key and enter a name for the folder.

The control displays all active connections in a selection window. If a folder contains subfolders, you can open and select these subfolders.



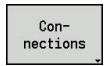
Calling the network configuration:



- ▶ Select the **Organization** operating mode



- ▶ Enter code number **net123**
- ▶ Press the **Transfer** soft key (login required)



- ▶ Press the **Connections** soft key








- ▶ Press the **Network** soft key
- ▶ The control displays the **Network connection** dialog. In this dialog, you can enter the settings for the connection target

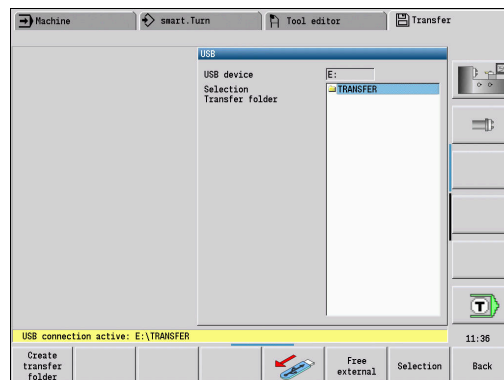


- ▶ Press the **Config.** soft key (login required)
- ▶ The Network configuration dialog opens

## USB connection






Establishing a USB connection:

- 
  - ▶ Select **Organization** operating mode
- 
  - ▶ Connect the USB storage device to the USB interface of the control
  - ▶ Press the **Transfer** soft key (login required)
- 
  - ▶ Press the **Connections** soft key
- 
  - ▶ Press the **USB** soft key
  - ▶ The control opens the **USB** dialog. In this dialog, you can enter the settings for the connection target
- 
  - ▶ Use the soft keys to disconnect or reconnect USB storage devices



In principle, it should be possible to connect most USB devices to the control. It may happen that a USB device is not identified correctly by the control, for example when the cable between the control panel and the main computer is very long. In such cases, use another USB device.

### Soft keys for USB connection

Soft key	Meaning
	Create a folder of the specified name on the USB storage device
	Disconnect the USB storage device and prepare the device for removal
	Allow access to files that have not been properly saved in a project folder
	Select the project folder that you selected before with the arrow keys
	Return to the Transfer soft-key menu



## Data transfer options

The control manages DIN programs, DIN subprograms, cycle programs, and **ICP contours** in different directories. When you select the **Program group**, the control automatically switches to the applicable directory.

Parameters and tool data are stored under the file name entered for backup name and saved to a ZIP file located in the **para** or **tool** folder on the control. You can then send this backup file to a project folder in the remote station.



- If program files are opened in another operating mode, they are not overwritten
- You can transfer tool data and parameters only if no program has been started in **Program run** submenu

The following transfer functions are available:

- **Programs:** Transmit and receive files
- **Parameter backup:** Create, transmit, and receive parameter backups
- **Parameter restore:** Restore the parameter backup files
- **Tools backup:** Create, transmit, and receive tool backups
- **Restore tools:** Restore the tool backup files
- **Service data:** Create and transmit service data
- Make **data backup:** Save all data in a project folder
- **Free external:** Freely select program files on a USB storage device
- **Misc. functions:** Import cycle programs and DIN programs from the MANUALplus 4110 and import tool data from the CNC PILOT 4290

### Folder structure – Storage of files

Folder	File types
\dxf	Drawings in DXF format
\gtb	Machining sequences ( <b>TURN PLUS</b> )
\gti	ICP contour definitions: <ul style="list-style-type: none"> <li>■ <b>*.gmi</b> (turning contour)</li> <li>■ <b>*.gmr</b> (workpiece-blank contour)</li> <li>■ <b>*.gms</b> (C axis, face)</li> <li>■ <b>*.gmm</b> (C axis, lateral surface)</li> </ul>
\gtz	Cycle programs ( <b>Teach-in</b> submode) <b>*.gmz</b>
\ncps	DIN programs ( <b>smart.Turn</b> mode of operation): <ul style="list-style-type: none"> <li>■ <b>*.nc</b> (main programs)</li> <li>■ <b>*.ncs</b> (subprograms)</li> </ul>
\para	Parameter backup files PA_*.zip (parameters)
\table	Parameter backup files TA*.zip (tables)
\tool	Tool backup files TO*.zip (tool and technology data)
\pictures	Image files for subprograms <b>*.bmp, *.png or *.jpg</b>
\data	Service files Service*.zip

### Transfer folder

The control exchanges data with an external storage device by accessing transfer folders created in the storage device. Files in transfer folders are organized using the same folder structure as on the control.

Transfer folders can only be used directly in the selected network path or in the root directory of the USB storage device.

## Transferring programs (files)

### Selecting a program group



Screenshots (taken with the **PRT SC** key) can be transferred from the **Service** area.

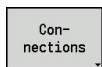
Selecting a program group:



- ▶ Select **Organization** operating mode



- ▶ Press the **Transfer** soft key (login required)



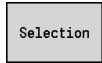
- ▶ Press the **Connections** soft key



- ▶ Press the **USB** soft key



- ▶ Alternative: Press the **Network** soft key



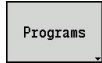
- ▶ Select a project folder and then press the **Selection** soft key (USB)



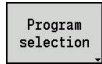
- ▶ Alternative: Press the **Connect** soft key (network)



- ▶ Press the **Back** soft key to return to data selection



- ▶ Switch to program transfer



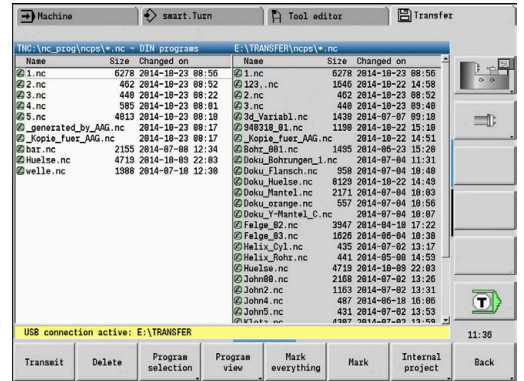
- ▶ Open a selection of program types



- ▶ Press the **DIN programs** (or other program types) soft key to activate transfer



With the transfer of automatic jobs, the control automatically transfers the selected jobs with all main programs and the subprograms contained in these.



### Soft keys for program group selection

Soft key	Meaning
DIN programs	*.nc: DIN and smart. Turn main programs. <b>Transfer</b> submode scans programs for subprograms and asks whether you want to transfer them as well.
DIN subprogram	*.ncs: DIN and smart. Turn subprograms. Help graphics are also transferred.
Cycle programs	*.gmz: Cycle programs. <b>Transfer</b> submode scans the programs for subprograms and <b>ICP contours</b> , and asks whether you want to transfer them as well.
ICP contours	<b>ICP contours</b> for cycle programs: <ul style="list-style-type: none"> <li>■ *.gmi (turning contour)</li> <li>■ *.gmr (workpiece-blank contour)</li> <li>■ *.gms (C axis, face)</li> <li>■ *.gmm (C axis, lateral surface)</li> </ul>
Next file type	Switch between possible file types. You can also select automatic jobs here.
Free external	Select program files on a USB storage device without using a project folder.
File mask	Mask the file names within the selected program group.

### Selecting the program

In the window on the left, the control shows a file list of the control. The files of the remote station are displayed in the window on the right when a connection is established. With the arrow keys you can switch back and forth between the two windows.

When selecting a program, place the cursor on the desired program and press the **Mark** soft key. You can also select all programs with the **Mark everything** soft key.

Marked programs are highlighted in color. To unmark a program, simply mark the program again.

The control displays the file size and the time of the last modification of the program in the list if permitted by the length of the file name.

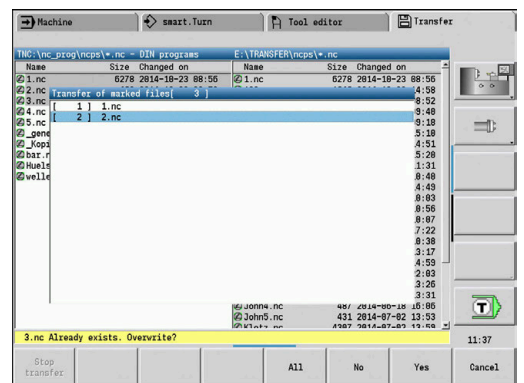
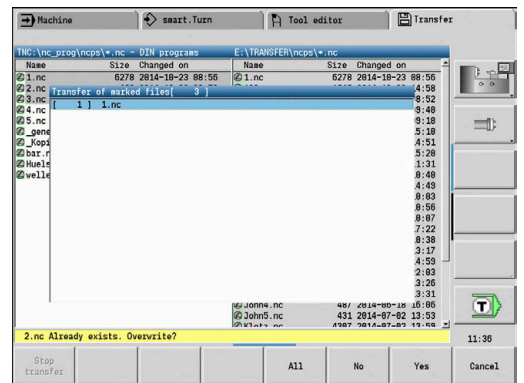
With DIN programs/subprograms, you can also view the NC program with the **Program view** soft key.

Press the **Transmit** or **Receive** soft key to start transferring the files.

During transfer, the control displays the following information in a transfer window:

- The name of the program which is currently being transferred
- If a file already exists in the target path, the control asks whether you want to overwrite the file. You can then activate overwriting for only that file or for all files in the transfer

If the control detects during transfer that the transferred files are linked to other files (subprograms, **ICP contours**), a dialog opens where you can select the linked files for transfer.



### Soft keys for program selection

Soft key	Meaning
Mark everything	Mark all files in the current window
Mark	Mark or unmark the file at the cursor position and move the cursor down one position
Program view	Open a DIN main program or subprogram for reading

### Transferring project files

If you wish to transfer files from a project, the **Project** soft key enables you to open the project management of the control and select the corresponding project.

**Further information:** "Project management", Page 173

**i** The **Internal project** soft key enables you to manage projects and transfer entire project folders.

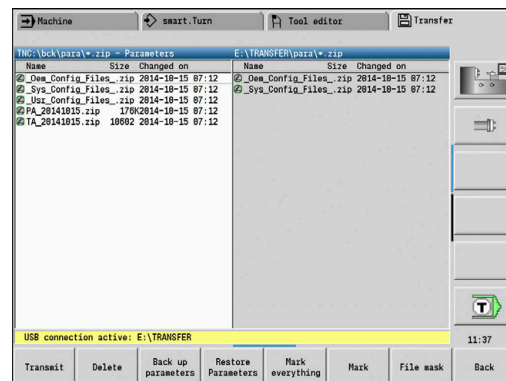
**Further information:** "Project management", Page 173

## Transferring parameters

### Transferring parameters

Parameters can be backed up and restored in the following steps:

- **Creating a parameter backup:** The parameters are archived in ZIP files and stored in the control
- **Transmitting or receiving the parameter backup files**
- **Restoring parameters:** Restore the backup files into the active data of the control (login required).



### Parameter selection

You can also create a parameter backup without connecting to an external storage device.

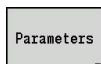
Creating a parameter backup:



- ▶ Select **Organization** operating mode











- ▶ Press the **Transfer** soft key (login required)



- ▶ Open the parameter transfer

### Soft keys for parameter transfer

Soft key	Meaning
	Transmit all marked files from the control to the remote station
	Receive all files marked on the remote station
	Delete all marked files after a confirmation prompt (login required)
	Create a parameter backup data record as a .zip file
	Restore data from the selected backup data record to the active control system (login required)
	Mark all files in the current window
	Mark or unmark the file at the cursor position and move the cursor down one position
	Open the file mask

**Parameter backup data**

A parameter backup file contains all the parameters and tables of the control, except tool and technology data.

Path and file names of the backup files:

- Config data: \para\PA\_\*.zip
- Tables: \table\TA\_\*.zip

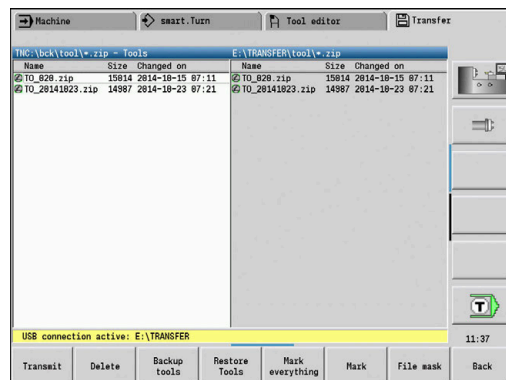
The transfer window only shows the **para** folder. The associated file in the **table** folder is automatically created and transferred.

Press the **Transmit** or **Receive** soft key to start transferring the files.

## Transferring tool data

Tool data is backed up and restored in the following steps:

- **Creating a tool backup:** The parameters are archived in ZIP files and stored in the control
- **Transmitting or receiving the tool backup files**
- **Restoring tools:** Restore the backup files into the active data of the control (login required)



## Tool selection

You can also create a tool backup without connecting to an external storage device.

Creating a tool backup:



- ▶ Select **Organization** operating mode



- ▶ Press the **Transfer** soft key (login required)



- ▶ Press the **Tools** soft key

## Soft keys for tool transfer







Soft key	Meaning
	Transmit all marked files from the control to the remote station
	Receive all files marked on the remote station
	Delete all marked files after a confirmation prompt (login required)
	Create a tool backup data record as a .zip file
	Restore data from the selected backup data record to the active control system (login required)
	Mark all files in the current window
	Mark or unmark the file at the cursor position and move the cursor down one position
	Select the ZIP or HTT file type. The tool data can also be transferred directly as a HTT file (e.g. from a tool presetter)



### Tool backup data

When creating a tool backup, you can choose whether to save the data of specific tools or all tools. Select the desired tools in the tool list or turret list.

Selecting the tools for tool backup:

- |   |  |
|---|--|
|  | ▶ Press the <b>Backup tools</b> soft key                                   |
|  | ▶ Press the <b>Tool list</b> soft key                                      |
|  | ▶ Alternative: Press the <b>Turret list</b> soft key                       |
|  | ▶ Alternative: Press the <b>Magazine list</b> soft key (machine-dependent) |
|  | ▶ Press the <b>Mark</b> soft key   |
|  | ▶ Press the <b>Confirm selection</b> soft key                              |

The control shows a selection window. Here you can define which tool data you want to save.

Selection for the content of backup files:

- Tools
- Tool texts
- Technology data
- Touch probes
- Tool holders

Path and file names of the backup files: \bck\tool\TO\_\*.zip

Press the **Transmit** or **Receive** soft key to start transferring the files.

When restoring backup data, all available backup files are displayed. With the **Tool list** soft key, you can select individual tools from a backup file.

Choose the tool data you want to restore from the backup file.

## Creating service files

Service files contain various log files used by the service department for troubleshooting. All important information is summarized in a services file data record as a zip file.

Path and file names of the backup files: \data\SERVICEx.zip ("x" stands for a consecutive number)

The control always generates the service file with the number **1**. Already existing files are renamed to the numbers **2 to 5**. An existing file with the number **5** is deleted.

Service files are saved in the following steps:

- **Creating service files:** The information is summarized in a ZIP file and stored in the control
- **Transmitting service files**

### Selecting service files

You can also create service files without connecting to an external storage device.

Creating service files:



- ▶ Select **Organization** operating mode

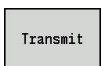

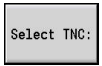


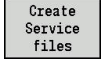


- ▶ Press the **Transfer** soft key (login required)



- ▶ Press the **Service** soft key

### Soft keys for transferring service files

Soft key	Meaning
	Transmit all marked files from the control to the remote station
	Delete all marked files after a confirmation prompt (login required)
	Select the TNC main directory, e.g. when if you want to transfer previously created screenshots (by pressing the <b>PRT SC</b> key)
	Mark all files in the current window
	Mark or unmark the file at the cursor position and move the cursor down one position
	Create a service files data record as a .zip file

### Saving service files

Saving service files:



- ▶ Press the **Create Service files** soft key
- ▶ Enter a file name under which you want to save the service file



- ▶ Press the **Save** soft key

## Creating a data backup file

Creating a data backup file involves the following steps:

- Copying the program files to the transfer folder
  - NC main programs
  - NC subprograms (with graphics)
  - Cycle programs
  - ICP contours
- Creating a parameter backup and copying all backup files from the **para** and **table** folders to the project folder. (PA\_Backup.zip, TA\_Backup.zip)
- Creating a tool backup file and copying all tool backup files from the **tool** folder to the project folder (TO\_Backup.zip)
- Service files are **not** created and copied

## Selecting a data backup file

You can also create a data backup file without connecting to an external storage device.

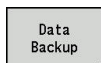
Creating a data backup file:



- ▶ Select **Organization** operating mode

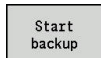


- ▶ Press the **Transfer** soft key (login required)



- ▶ Press the **Data Backup** soft key

## Soft keys for transferring data backup files

Soft key	Meaning
	Start backing up the data to a complete transfer folder



- Existing files will be overwritten without a confirmation prompt
- To cancel the data backup, press the **Cancel** soft key. The backup process stops as soon as the currently running partial backup is completed

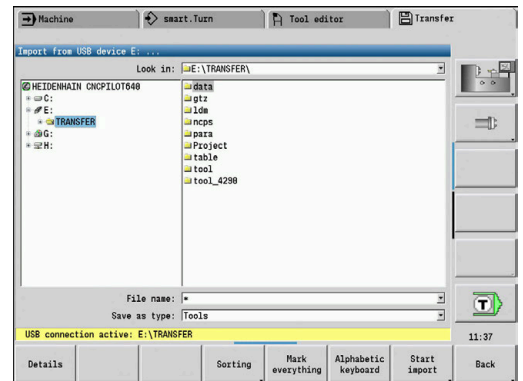
## Importing NC programs from predecessor controls

The program formats of the predecessor controls MANUALplus 4110 and CNC PILOT 4290 differ from the format of the MANUALplus 620 and the CNC PILOT 640. However, you can use the program converter to adapt programs of the predecessor control to the new control. This converter is a component of your control. The converter completes the required adaptations as automatically as possible.

Overview of convertible NC programs:











- MANUALplus 4110
  - Cycle programs
  - ICP contour descriptions
  - DIN programs
- CNC PILOT 4290: DIN-PLUS programs

TURN PLUS programs of the CNC PILOT 4290 can **not** be converted.



## Importing NC programs from the connected data medium

Importing NC programs:

- 
  - ▶ Select the **Organization** operating mode
  
- 
  - ▶ Press the **Transfer** soft key (login required)
  
- 
  - ▶ Open the menu with the **Misc. functions** soft key
  
- 
  - ▶ Open the menu with the **Import functions** soft key
  
- 
  - ▶ Selection of cycle programs or ICP contours of the MANUALplus 4110 (\*.gtz)
  
- 
  - ▶ Alternative: Selection of DIN programs of the MANUALplus 4110 (\*.nc/ \*.ncs)
  
- 
  - ▶ Alternative: Selection of programs of the CNC PILOT 4290 (\*.nc/ \*.ncs)
  
- 
  - ▶ Use the cursor keys to select the folder, then press the **ENT** key to switch to the right window
  - ▶ With the cursor keys, select the NC program to be converted
  
- 
  - ▶ Alternative: Mark all NC programs
  
- 
  - ▶ Start the import filter for converting the program(s) to the format of your control



The names of imported cycle programs, ICP contour descriptions, DIN programs and DIN subprograms are given the prefix **CONV\_...**

In addition, the control adapts the extension and imports the NC programs to the correct folders.

### Converting cycle programs

MANUALplus 4110 and MANUALplus 620 or CNC PILOT 640 have different solutions for tool management, technology data, etc.

Also, the cycles of the MANUALplus 620 or CNC PILOT 640 have more parameters than those of the MANUALplus 4110.

Please note the following:

- **Tool call:** The loading of the tool number depends on whether the program is a **multifix program** (2-digit tool number) or **turret program** (4-digit tool number)
  - 2-digit tool number: The tool number is loaded as **ID** and entered as the tool number **T1**
  - 4-digit tool number (Tddpp): The first two digits of the tool number (dd) are loaded as **ID** and the last two (pp) as **T**
- **Approaching the tool change position:** In **Tool change point G14**, the converter enters the **no axis** setting. This parameter is not used in the MANUALplus 4110
- **Safety clearance:** The safety clearances defined in the **General Settings** parameter are entered by the converter in the **Safety clearance G47**, ... **SCI**, ... **SCK** fields
- **M functions** are left unchanged
- **Calling ICP contours:** When ICP contours are called, the converter prefixes **CONV\_...** to the name
- **Calling DIN cycles:** When a DIN cycle is called, the converter prefixes **CONV\_...** to the name

### NOTICE

#### Danger of collision!

Converted NC programs may have incorrectly converted contents (machine-dependent) or nonconvertible contents. Danger of collision during machining!

- ▶ Adapt converted NC programs to the current control
- ▶ Test the NC program in **Simulation** submode, using the graphic displayed there.

### Converting DIN programs

When converting DIN/ISO programs, the different solutions for tool management, technology data, etc. must be taken into account, as well as contour description and variable programming.

Remember the following when converting DIN/ISO programs of the MANUALplus 4110:

- **Tool call:** The loading of the tool number depends on whether the program is a **multifix program** (2-digit tool number) or **turret program** (4-digit tool number)
- **Moving to the tool change point:** In **tool change point G14**, the converter enters the **no axis** setting. This parameter is not used in the MANUALplus 4110
- **Workpiece-blank definition:** A **G20** and **G21** workpiece-blank definition of the MANUALplus 4110 becomes an **AUX. BLANK** on your control
- **Contour descriptions:** In MANUALplus 4110 programs, the machining cycles are followed by the contour description. During conversion, the contour description is converted to an **AUX. BLANK**. The associated cycle in the **MACHINING** section then refers to this auxiliary contour
- **Variable programming:** Variable accesses to tool data, machine dimensions, **D** compensation values, parameter data, and events cannot be converted. These program sequences have to be adapted
- **M functions** are left unchanged
- **Inches or metric:** The converter cannot detect the unit of measure of the MANUALplus 4110 program. Consequently, no unit of measure is entered in the target program. This has to be completed by the user

Remember the following when converting DIN programs of the CNC PILOT 4290:

- **Tool call (T commands of the TURRET section):**
  - T commands containing a reference to the tool database are left unchanged (example: T1 ID"342-300.1")
  - T commands containing tool data cannot be converted
- **Variable programming:** Variable accesses to tool data, machine dimensions, **D** compensation values, parameter data, and events cannot be converted. These program sequences have to be adapted
- **M functions** are left unchanged
- **Names of external subprograms:** When an external subprogram is called, the converter prefixes **CONV\_...** to the name



If the DIN program contains nonconvertible elements, the corresponding NC block is saved as a comment. The word **WARNING** is inserted in front of this comment. Depending on the situation, the nonconvertible command is taken into the comment line, or the nonconvertible NC block follows the comment.



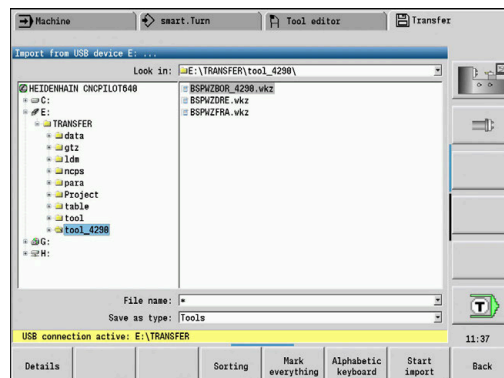
**NOTICE****Danger of collision!**

Converted NC programs may have incorrectly converted contents (machine-dependent) or nonconvertible contents. Danger of collision during machining!

- ▶ Adapt converted NC programs to the current control
- ▶ Test the NC program in **Simulation** submode, using the graphic displayed there.










## Importing tool data from the CNC PILOT 4290

The format of the tool list of the CNC PILOT 4290 differs from the format of the MANUALplus 620 and CNC PILOT 640. You can use the program converter to adapt tool data to the new control.



## Importing tool data from the connected data medium

Importing tool data:

-  ▶ Select the **Organization** operating mode
-  ▶ Press the **Transfer** soft key (login required)
-  ▶ Open the menu with the **Misc. functions** soft key
-  ▶ Open the menu with the **Import functions** soft key
-  ▶ Press the **Tools** soft key
-  ▶ Use the cursor keys to select the folder, then press the **ENT** key to switch to the right window
-  ▶ Use the arrow keys to select the tool data
-  ▶ Alternative: Mark all tool data
-  ▶ Start the import filter for the conversion

The control generates a table named CONV\_\*.HTT for each imported file. You can load this table with the Restore function by setting the file mask to the **\*.htt** file type.

## 9.4 Service pack

If changes or enhancements are required in the control software, your machine tool builder will provide you with a service pack. The service pack is usually installed with the aid of a USB memory stick (1 GB or larger). The software required for the service pack is compressed in the **setup.zip** file. This file is saved on the USB stick.

## Installing a service pack

The control is shut down during the installation of the service pack. So end any NC program editing, etc. before you begin installation.

### NOTICE

#### Caution: Data may be lost!

The control does not back up the data automatically before installing a service pack. Power failures or other problems may interfere with the installation of a service pack. As a consequence, data may be irreversibly damaged or deleted.

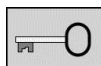
- ▶ Save the data through a backup before installing the service pack

Installing a service pack:

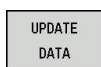
- ▶ Connect a USB stick



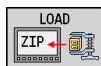
- ▶ Switch to **Organization** mode of operation



- ▶ Press the **Key** soft key



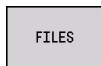
- ▶ Enter the code number 231019
- ▶ Press the **UPDATE DATA** soft key (if the soft key is not shown, switch the soft-key menu)



- ▶ Press the **LOAD** soft key



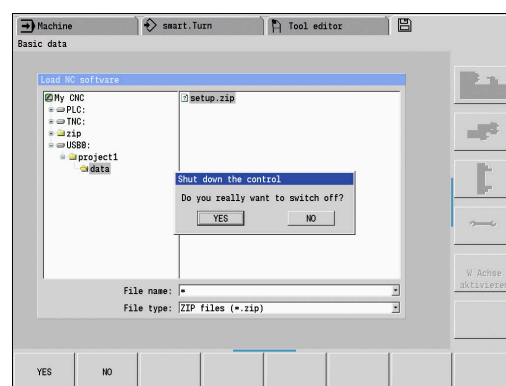
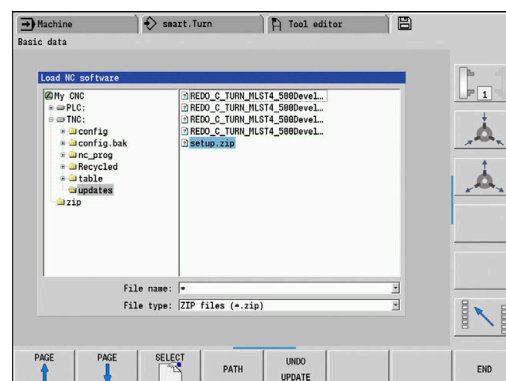
- ▶ Press the **PATH** soft key to select the directory in the left window



- ▶ Press the **FILES** soft key to select the file in the right window



- ▶ Place the cursor on the **setup.zip** file
- ▶ Press the **SELECT** soft key
- ▶ The control checks whether the service pack can be used for the current software version of the control
- ▶ Confirm the **Do you really want to switch off?** prompt
- ▶ The update program starts
- ▶ Select the desired language (English or German)
- ▶ Run the update



The control restarts automatically after the update has been completed.

# 10

**HEROS functions**

## 10.1 Remote Desktop Manager (option 133)

### Introduction

The Remote Desktop Manager enables you to display external computer units on the control screen that are connected via Ethernet, and to operate them via the control. You can also start programs specifically under HEROS or display web pages of an external server.

HEIDENHAIN offers you the IPC 6641 as a Windows computer. With the IPC 6641 Windows computer you can start and operate Windows-based applications directly from the control.

The following connection options are available:

- **Windows Terminal Server (RemoteFX):** Displays the desktop of a remote Windows computer on the control
- **VNC:** Connection to an external computer. Displays the desktop of a remote Windows, Apple or Unix computer on the control
- **Switch-off/restart of a computer:** Configure automatic shutdown of a Windows computer
- **Web browser:** Available only to authorized specialists
- **SSH:** Available only to authorized specialists
- **XDMCP:** Available only to authorized specialists
- **User-defined connection:** Available only to authorized specialists



HEIDENHAIN assures a functioning connection between HEROS 5 and the IPC 6641. No guarantee is given for other combinations and connections.



If you are using a MANUALplus 620 with touch control, you can replace some keystrokes with hand-to-screen contact.

**Further information:** "Operating the Touchscreen", Page 83

## Configuring connections – Windows Terminal Service (RemoteFX)

### Configuring an external computer



You do not need additional software for your external computer to connect to the Windows Terminal Service.



Proceed as follows to configure the external computer, e.g. in the Windows 7 operating system:

- ▶ Press the Windows Start button and select **Control Panel** on the Start menu
- ▶ Select **System and Security**
- ▶ Select **System**
- ▶ Select **Remote settings**
- ▶ Under **Remote Assistance**, enable **Allow Remote Assistance connections to this computer**
- ▶ Under **Remote Desktop**, select **Allow connections from computers running any version of Remote Desktop**
- ▶ Press **OK** to confirm your settings





### Configuring the control

Proceed as follows to configure the control:

- ▶ Press the **DIADUR** key to open the HEROS menu
- ▶ Select **Remote Desktop Manager**
- > The control opens the **Select server operating system** pop-up window.
- ▶ Select the desired operating system
  - Win XP
  - Win 7
  - Win 8.X
  - Win 10
  - Other Windows version
- ▶ Press **OK**
- > The control opens the **Edit the connection** pop-up window.
- ▶ Edit the connection

Setting	Meaning	Input
<b>Connection name</b>	Name of the connection in the Remote Desktop Manager	Required
<b>Restarting after end of connection</b>	Behavior after disconnection: <ul style="list-style-type: none"> <li>■ Always restart</li> <li>■ Never restart</li> <li>■ Always after an error</li> <li>■ Ask after an error</li> </ul>	Required
<b>Automatic starting upon login</b>	Connection automatically established during control start-up	Required
<b>Add to favorites</b>	Connection icon in the task bar: <ul style="list-style-type: none"> <li>▶ Single click with the left mouse button</li> <li>&gt; The control switches to the desktop of the connection.</li> <li>▶ Single click with the right mouse button</li> <li>&gt; The control displays the connection menu.</li> </ul>	Required
<b>Move to the following workspace</b>	Number of the desktop for the connection, desktop 0 being reserved for the NC software Default setting: Third desktop Select desktop 1 as the workspace or desktop for the connection	Required
<b>Release USB mass memory</b>	Permit access to connected USB mass memory devices	Required
<b>Computer</b>	Host name or IP address of the external computer HEIDENHAIN recommends the following setting for the IPC (6641): <b>IPC6641.machine.net</b> The host name <b>IPC6641</b> must be assigned to the IPC in the Windows operating system for this setting. <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> <p> The <b>.machine.net</b> code is very important in this context. When <b>.machine.net</b> is specified, the control automatically searches the Ethernet interface <b>X116</b>, and not the interface <b>X26</b>—this reduces the time needed for access.</p> </div>	Required
<b>User name</b>	Name of the user	Required
<b>Password</b>	User password	Required
<b>Windows domain</b>	Domain of the external computer	Optional
<b>Full-screen mode or User-defined window size</b>	Size of the connection window	Required
<b>Multimedia enhancements</b>	Enables hardware acceleration when playing videos Certain formats, e.g. MP4 files, require the paid Fluendo Codec Pack <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> <p> Any additional software will be installed by your machine tool builder.</p> </div>	Optional
<b>Touchscreen input</b>	Enables operation of multitouch systems and applications	Optional
<b>Encryption</b>	Sets the encryption that is appropriate for the selected Windows system	Required



Setting	Meaning	Input
	<p> If you activate the <b>Encryption</b> function, you need to remove the <b>-sec-tls -sec-nla</b> entries from the <b>Additional options</b> input field.</p> <p>If problems occur, try to set up a connection with the encryption function deactivated. The Windows log files are required for analysis.</p>	
<b>Color depth</b>	Setting for the display of the external system on the control	Required
<b>Locally effective keys</b>	<p>Shortcuts for automatically switching to the next active connection and workspace or desktop</p> <p>Default setting:</p> <ul style="list-style-type: none"> <li>■ <b>Super_R</b> corresponds to the right DIADUR key and switches between the active connections</li> <li>■ <b>F12</b> switches between the workspaces or desktops</li> </ul> <p> With the touchscreen of the MANUALplus 620, you can select the workspace or desktop via the touch keyboard.</p> <p>It is possible to adjust the default settings or to make additional entries</p>	Required
<b>Max. connection time (seconds)</b>	<p>Waiting time for connection</p> <p>If this timeout is exceeded, the connection could not be established</p>	Required
<b>Additional options</b>	<p>Available only to authorized specialists</p> <p>Additional command lines with transfer parameters</p> <p> If you activate the <b>Encryption</b> function, you need to remove the <b>-sec-tls -sec-nla</b> entries from the <b>Additional options</b> input field.</p>	Required
<b>Pass USB devices through</b>	<p>Passing the USB devices (e.g. 3-D mouse for operating CAD programs) connected to the control through to the Windows computer</p> <p>This requires installation of the Eltima EveUSB software on the Windows computer.</p> <p> All USB devices that have been passed through are not available on the control while the connection to the Windows computer is active.</p>	Optional

For integrating the IPC 6641, HEIDENHAIN recommends the use of a RemoteFX connection.

When using a RemoteFX connection, the screen of the external computer is not mirrored, as with VNC. Instead, a separate desktop is opened. The desktop that is active on the external computer when establishing the connection is then locked and the user is logged off. This prevents two users from accessing the control simultaneously.

## Configuring the connection – VNC

### Configuring an external computer



You need an additional VNC server for your external computer when trying to connect to VNC.  
Install and configure the VNC server, e.g. the TightVNC server, before configuring the control.

Proceed as follows to configure the control:

- ▶ Press the **DIADUR** key to open the HEROS menu
- ▶ Select **Remote Desktop Manager**
- > The control opens the **Remote Desktop Manager**.
- ▶ Press **New connection**
- ▶ Press **VNC**
- > The control opens the **Edit the connection** pop-up window.
- ▶ Edit the connection

Setting	Meaning	Input
<b>Connection name:</b>	Name of the connection in the Remote Desktop Manager	Required
<b>Restarting after end of connection:</b>	Behavior after disconnection: <ul style="list-style-type: none"> <li>■ Always restart</li> <li>■ Never restart</li> <li>■ Always after an error</li> <li>■ Ask after an error</li> </ul>	Required
<b>Automatic starting upon login</b>	Connection automatically established during control start-up	Required
<b>Add to favorites</b>	Connection icon in the task bar: <ul style="list-style-type: none"> <li>▶ Single click with the left mouse button</li> <li>&gt; The control switches to the desktop of the connection.</li> <li>▶ Single click with the right mouse button</li> <li>&gt; The control displays the connection menu.</li> </ul>	Required
<b>Move to the following workspace</b>	Number of the desktop for the connection, desktops 0 and 1 being reserved for the NC software Default setting: Third desktop	Required
<b>Release USB mass memory</b>	Permit access to connected USB mass memory devices	Required
<b>Calculator</b>	Host name or IP address of the external computer. In the recommended configuration of the IPC 6641, the IP address 192.168.254.3 is used.	Required
<b>User name:</b>	Name of the user to be logged on	Required
<b>Password</b>	Password for connecting to the VNC server	Required

Setting	Meaning	Input
<b>Full-screen mode or User-defined window size:</b>	Size of the connection window	Required
<b>Permit further connections (share)</b>	Additionally grant other VNC connections access to the VNC server	Required
<b>View only</b>	In display mode, the external computer cannot be operated	Required
Entries in the <b>Advanced options</b> area	Available only to authorized specialists	Optional

With VNC, the screen of the external computer is mirrored directly. The active desktop at the external computer is not locked automatically.

With a VNC connection, it is also possible to completely shut down the external computer via the Windows menu. As the computer cannot be rebooted via a connection, it must actually be switched off and on again.

## Shutting down or rebooting an external computer

### NOTICE

#### Caution: Data may be lost!

If you do not shut down the external computer properly, data may be irreversibly damaged or deleted.

- ▶ Configure the automatic shutdown of the Windows computer

Proceed as follows to configure the control:

- ▶ Press the **DIADUR** key to open the HEROS menu
- ▶ Select **Remote Desktop Manager**
- > The control opens the **Remote Desktop Manager**.
- ▶ Press **New connection**
- ▶ Press **Switch-off/restart of a computer**
- > The control opens the **Edit the connection** pop-up window.
- ▶ Edit the connection

Setting	Meaning	Input
<b>Connection name:</b>	Name of the connection in the Remote Desktop Manager	Required
<b>Restarting after end of connection:</b>	Not necessary with this connection	–
<b>Automatic starting upon login</b>	Not necessary with this connection	–
<b>Add to favorites</b>	Connection icon in the task bar: <ul style="list-style-type: none"> <li>▶ Single click with the left mouse button</li> <li>&gt; The control switches to the desktop of the connection.</li> <li>▶ Single click with the right mouse button</li> <li>&gt; The control displays the connection menu.</li> </ul>	Required
<b>Move to the following workspace</b>	Not active with this connection	–

Setting	Meaning	Input
Release USB mass memory	Not advisable with this connection	–
Calculator	Host name or IP address of the external computer. In the recommended configuration of the IPC 6641, the IP address 192.168.254.3 is used.	Required
User name	User name to be used for establishing the connection	Required
Password	Password for connecting to the VNC server	Required
Windows domain:	Domain of the target computer, if required	Optional
Max. waiting time (seconds):	<p>A shutdown of the control causes the Windows computer to shut down as well.</p> <p>Before the control displays the message <b>Now you can switch off.</b>, it waits for <b>&lt;Timeout&gt;</b> seconds. While waiting, the control checks whether the Windows computer is still accessible (port 445).</p> <p>If the Windows computer is switched off before the <b>&lt;Timeout&gt;</b> seconds have expired, the control will wait no longer.</p>	Required
Additional waiting time:	<p>Waiting time after the Windows computer has stopped being accessible.</p> <p>Windows applications may delay the shutdown of the computer after port 445 has been closed.</p>	Required
Force	<p>Close all programs on the Windows computer, even if dialogs are still open.</p> <p>If Force is not selected, Windows waits up to 20 seconds. This delays the shutdown process or the Windows computer is switched off before Windows has shut down.</p>	Required
Restart	Reboot the Windows computer	Required
Run during restart	Reboot the Windows computer when the control reboots. Effective only if the control is rebooted using the shutdown icon at the bottom right in the taskbar or if it is rebooted as a result of a change in the system settings (e.g. network settings).	Required
Run during switch-off	The Windows computer is switched off when the control shuts down (no reboot). This is the standard scenario. Even the <b>END</b> key will then no longer trigger a reboot.	Required
Entries in the <b>Advanced options area</b>	Available only to authorized specialists	Optional

## Starting and stopping the connection

Once a connection has been configured, this connection is shown as an icon in the Remote Desktop Manager window. Click the connection icon with the right mouse key to open a menu in which the display can be started and stopped.

If the desktop of the external connection or the external computer is active, all inputs from the mouse and the alphabetic keyboard are transmitted there.

When the HEROS 5 operating system is shut down, the control automatically terminates all connections. Please note, however, that only the connection is terminated, whereas the external computer or the external system is not shut down automatically.

**Further information:** "Shutting down or rebooting an external computer", Page 683

Proceed as follows to switch between the third desktop and the control interface:

- Use the right DIADUR key on the alphabetic keyboard
- Use the taskbar
- Use the operating mode key

## 10.2 Additional tools for ITCs

The following additional tools allow you to apply various settings for the touch screens on connected ITCs.

ITCs are industrial PCs without their own memory media, and therefore they do not have their own operating system. This feature is what makes ITCs different from IPCs.

ITCs are frequently used with large machinery, e.g. as a clone of the actual control system.



Refer to your machine manual.

The machine manufacturer defines and configures the display and function of the connected ITCs and IPCs.

Additional tool	Application
<b>ITC Calibration</b>	4-point calibration
<b>ITC Gestures</b>	Configuration of gesture control
<b>ITC touchscreen configuration</b>	Selection of touch sensitivity



The additional tools for the ITCs are only provided by the control in the taskbar with connected ITCs.

Using the additional tool **ITC Calibration**, you align the position for the mouse cursor displayed with the actual movement position of your finger.

Calibration using the additional **ITC Calibration** tool is recommended in the following cases:

- After replacing the touchscreen
- When changing the touch screen position (parallel axis error due to amended viewing angle)

Calibration involves the following steps:

- ▶ Start the tool in control using the task bar
- > The ITC opens the calibration screen with four touch points in the corners of the screen
- ▶ Touch the four touch points shown one after the other
- > The ITC closes the calibration screen once calibration has been successfully completed

Using the additional **ITC Gestures** tool, the machine manufacturer configures the gesture control on the touch screen.



Refer to your machine manual.

This function may only be used with the permission of your machine manufacturer.

Using the additional **ITC Touchscreen Configuration** tool, you can select the touch sensitivity of the touch screen.

The ITC gives you the following options:

- **Normal Sensitivity (Cfg 0)**
- **High Sensitivity (Cfg 1)**
- **Low Sensitivity (Cfg 2)**

Use the **Normal Sensitivity (Cfg 0)** setting as standard. If you find it difficult to operate the equipment while wearing gloves in this setting, select the **High Sensitivity (Cfg 1)** setting.



If the ITC touch screen is not splash-proof, select the **Low Sensitivity (Cfg 2)** setting. This stops the ITC interpreting drops of water as touches.

Configuration involves the following steps:

- ▶ Start the tool in control using the task bar
- > The ITC opens a pop-up window with three options
- ▶ Select Touch Sensitivity
- ▶ Press the **OK** button
- > The ITC closes the pop-up window

### 10.3 Window Manager



Refer to your machine manual.

The machine tool builder determines the scope of function and behavior of the window manager.

The control features the Xfce window manager. Xfce is a standard application for UNIX-based operating systems, and is used to manage graphical user interfaces. The following functions are possible with the window manager:

- Display a task bar for switching between various applications (user interfaces)
- Manage an additional desktop, on which special applications from your machine manufacturer can run
- Control the focus between NC software applications and those of the machine manufacturer
- You can change the size and position of pop-up windows. It is also possible to close, minimize and restore pop-up windows



The control shows a star in the upper left of the screen if an application of the window manager or the window manager itself has caused an error. In this case, switch to the window manager and correct the problem. If required, refer to your machine manual.



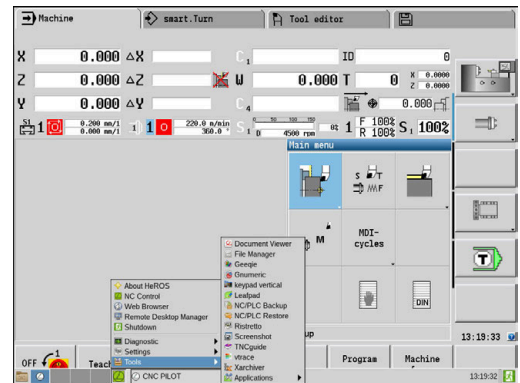
## Overview of taskbar

In the task bar, you can choose different workspaces by mouse click.

The control provides the following workspaces:

- Workspace 1: Active operating mode
- Workspace 2: Active programming mode
- Workspace 3: Applications of the machine tool builder (optionally available)
- Workspace 4: Display and remote control of external computer units (option 133) or applications of the machine tool builder (optionally available)

In addition, you can also select other applications from the task bar which you have started in parallel to the control software, e.g. the **TNCguide**.



You can randomly move all open applications to the right of the green HEIDENHAIN symbol between the workspaces by pressing and holding the left mouse button.

Click the green HEIDENHAIN symbol to open a menu in which you can get information, make settings or start applications.

The following functions are available:

- **About HEROS:** Open information about the operating system of the control
- **NC Control:** Start and stop the control software (for diagnostic purposes only)
- **Web Browser:** Start the web browser
- **Touchscreen Configuration:** Adjust the screen properties (only for touch operation)  
**Further information:** "Touchscreen Configuration", Page 89
- **Touchscreen Cleaning:** Lock the screen (only for touch operation)  
**Further information:** "Touchscreen Cleaning", Page 89
- **Remote Desktop Manager** (option 133): For display and remote control of external computer units  
**Further information:** "Remote Desktop Manager (option 133)", Page 678
- **Diagnostic:** Diagnostic applications
  - **GSmartControl:** Available only to authorized specialists
  - **HE Logging:** Define settings for internal diagnostic files
  - **HE Menu:** Available only to authorized specialists
  - **perf2:** Check processor load and process load
  - **Portscan:** Test active connections  
**Further information:** "Portscan", Page 691
  - **Portscan OEM:** Available only to authorized specialists
  - **RemoteService:** Start and stop remote maintenance  
**Further information:** "Remote Service", Page 692
  - **Terminal:** Enter and execute console commands
- **Settings:** Operating system settings

- **Date/Time:** Set date and time
- **Firewall:** Configure the firewall  
**Further information:** "Firewall", Page 705
- **HePacketManager:** Available only to authorized specialists
- **HePacketManager Custom:** Available only to authorized specialists
- **Language/Keyboards:** Select system dialog language and keyboard version—the control overwrites the user interface language setting when starting with the language setting of the machine parameter **CfgDisplayLanguage** (no. 101300)
- **Network:** Define network settings
- **Printer:** Configure and manage printer  
**Further information:** "Printers", Page 694
- **Screensaver:** Set the screensaver  
**Further information:** "Screensaver with lockout", Page 743
- **Current User:** Show the current user  
**Further information:** "Current User", Page 745
- **UserAdmin:** Configure the user administration  
**Further information:** "Configuring the user administration", Page 721
- **OEM Function Users:** Edit the OEM function users  
**Further information:** "HEIDENHAIN function users", Page 731
- **SELinux:** Define safety software for Linux-based operating systems
- **Shares:** Connect and manage external network drives
- **State Reporting Interface** (option 137): Activate the **SRI** and clear the status data  
**Further information:** "State Reporting Interface (option 137)", Page 696
- **VNC:** Define the setting for external software accessing the control, e.g. for maintenance procedures (**V**irtual **N**etwork **C**omputing)  
**Further information:** "VNC", Page 699
- **WindowManagerConfig:** Available only to authorized specialists
- **Tools:** File applications
  - **Document Viewer:** Display and print files, e.g. PDF files
  - **File Manager:** Available only to authorized specialists

- **Geeqie**: Open, manage, and print graphics
- **Gnumeric**: Open, edit, and print tables
- **Keypad**: Open virtual keyboard
- **Leafpad**: Open and edit text files
- **NC/PLC Backup**: Create backup file  
**Further information**: "Backup and restore", Page 702
- **NC/PLC Restore**: Restore backup file  
**Further information**: "Backup and restore", Page 702
- **QupZilla**: Alternative web browser for touch operation
- **Ristretto**: Open graphics
- **Screenshot**: Create screenshots
- **TNCguide**: Call up help system
- **Xarchiver**: Extract or compress directories
- **Applications**: Supplementary applications
  - **Orage Calender**: Open calendar
  - **Real VNC viewer**: Define the setting for external software accessing the control for e.g. maintenance procedures (Virtual Network Computing)
- **Shutdown**: Shut down the control  
**Further information**: "Switching or logging out users", Page 742

## Portscan

The PortScan function allows the cyclic or manual searching for all open, incoming TCP and UDP listen ports on the system. All ports found are compared with whitelists. If the control finds a non-listed port it shows a corresponding pop-up window.

The HEROS **Diagnostic** menu contains the **Portscan** and **Portscan OEM** applications for this purpose. **Portscan OEM** is only executable after entering the machine manufacturer password.

The **Portscan** function searches for all open, incoming TCP and UDP ports on the system and compares them to four whitelists stored in the system:

- System-internal whitelists **/etc/sysconfig/portscan-whitelist.cfg** and **/mnt/sys/etc/sysconfig/portscan-whitelist.cfg**
- Whitelist for ports with machine manufacturer-specific functions, e.g. for Python and DNC applications: **/mnt/plc/etc/sysconfig/portscan-whitelist.cfg**
- Whitelist for ports with customer-specific functions: **/mnt/tnc/etc/sysconfig/portscan-whitelist.cfg**

For each entry, the whitelist specifies the type of port (TCP/UDP), the port number, the providing program, and optional comments. If the automatic port scan function is active, only ports listed in the whitelists can be open. Non-listed ports trigger a notification window.

The result of the scan is saved to a log file (LOG:/portscan/scanlog and LOG:/portscan/scanlogevil), and if new ports are found that are not listed in one of the whitelists these are displayed.

### Manually starting Portscan

Proceed as follows to manually start the Portscan:

- ▶ Open the task bar at the bottom edge of the screen  
**Further information:** "Window Manager", Page 688
- ▶ Press the green HEIDENHAIN button to open the HEROS menu
- ▶ Select the **Diagnostic** menu item
- ▶ Select the **Portscan** menu item
- > The control opens the **HEROS Portscan** pop-up window.
- ▶ Press the **Start** key

### Cyclically starting Portscan

Proceed as follows to automatically start the Portscan cyclically:

- ▶ Open the task bar at the bottom edge of the screen
- ▶ Press the green HEIDENHAIN button to open the HEROS menu
- ▶ Select the **Diagnostic** menu item
- ▶ Select the **Portscan** menu item
- > The control opens the **HEROS Portscan** pop-up window.
- ▶ Press the **Automatic update on** key
- ▶ Set the time interval with the slider

### Remote Service

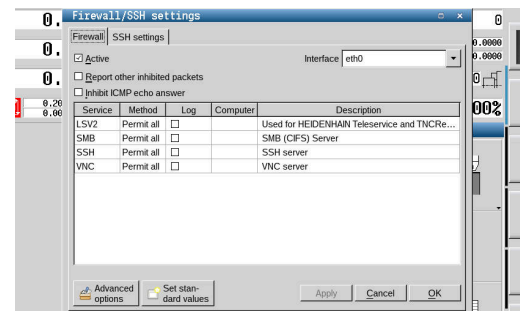
In conjunction with the remote service setup tool, TeleService from HEIDENHAIN offers the possibility to establish encrypted end-to-end connections between a service computer and a machine.

To enable the HEIDENHAIN control to communicate with the HEIDENHAIN server, the control needs to be connected to the Internet.

In its basic state the firewall of the control blocks all incoming and outgoing connections. Therefore, the firewall settings must be adjusted or the firewall must be deactivated for the duration of the service session.

### Setting up the control

- ▶ Open the task bar at the bottom edge of the screen
- ▶ Press the green HEIDENHAIN button to open the HEROS menu
- ▶ Select the **Settings** menu item
- ▶ Select the **Firewall** menu item
- > The control displays the **Firewall settings** dialog.
- ▶ Deactivate the firewall by removing the **Active** option in the **Firewall** tab.
- ▶ Press the **Apply** button to save the settings
- ▶ Press the **OK** button
- > The firewall is disabled.



Do not forget to activate the firewall again after the end of the service session.



#### Alternative procedure for deactivating the firewall

The remote diagnosis via the TeleService PC software uses the **LSV2** service and this service must therefore be permitted in the firewall settings.

The following deviations from the firewall default settings are required:

- ▶ Set the method to **Permit some** for the **LSV2** service
- ▶ Enter the name of the service computer in the **Computer** column

The access security is ensured through the network settings. The network security is the responsibility of the machine tool builder or the respective network administrator.

#### Automatic installation of a session certificate

With an NC software installation a temporary certificate is automatically installed on the control. An installation, also in the form of an update, may only be carried out by a service technician from the machine tool builder.

### Manual installation of a session certificate

A new certificate must be installed if no valid session certificate is installed on the control. Clarify which certificate is needed with your service employee. He will then provide you with a valid certificate file if necessary.

- ▶ Open the task bar at the bottom edge of the screen
- ▶ Press the green HEIDENHAIN button to open the HEROS menu
- ▶ Select the **Settings** menu item
- ▶ Select the **Network** menu item
- > The control displays the **Network settings** dialog.
- ▶ Select the **Internet** tab. The settings in the **Remote maintenance** field are configured by the machine tool builder.
- ▶ Press the **Add** button
- ▶ Select the file in the selection menu
- ▶ Press the **Open** button
- > The certificate is opened.
- ▶ Press the **OK** soft key.
- ▶ It may be necessary to restart the control to load the settings

### Launching the service session

Proceed as follows to start the service session:

- ▶ Open the task bar at the bottom edge of the screen
- ▶ Press the green HEIDENHAIN button to open the HEROS menu
- ▶ Select the **Diagnostic** menu item
- ▶ Select the **RemoteService** menu item
- ▶ Enter the **Session key** of the machine tool builder

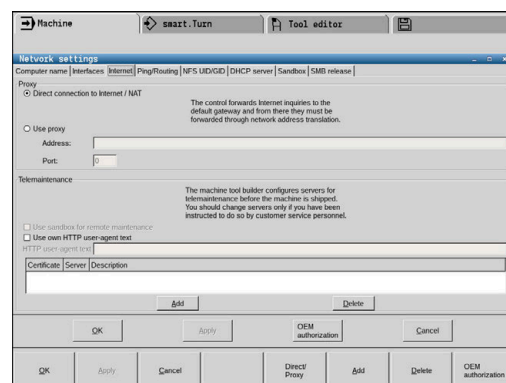
### Printers

The **Printer** function in the HeROS menu enables you to add and manage printers.

### Displaying the printer settings

Proceed as follows to access the printer settings:

- ▶ Open the task bar at the bottom edge of the screen
- ▶ Press the green HEIDENHAIN button to open the HEROS menu
- ▶ Select the **Settings** menu item
- ▶ Select the **Printer** menu item
- > The control opens the **Herros Printer Manager** pop-up window.



The name of the printer is displayed in the input field.

Soft key	Meaning
CREATE	Creates the printer named in the input field
CHANGE	Modifies the properties of the selected printer
COPY	Creates the printer named in the input field with the attributes of the selected printer This can be useful if printing both portrait and landscape formats on the same printer
DELETE	Deletes the selected printer
UP	Selects the desired printer
DOWN	
STATUS	Displays status information of the selected printer
PRINT TEST PAGE	Prints a test page on the selected printer

For each printer, the following attributes can be set:

Setting	Meaning
Name of the printer	The printer name can be changed here.
Connection	Here, you can select the connection type <ul style="list-style-type: none"> <li>■ USB: The USB connection can be assigned here. The name is displayed automatically.</li> <li>■ Network: Enter the network name or the IP address of the target printer here. In addition, specify the port of the network printer here (default: 9100)</li> <li>■ Printer not connected</li> </ul>
Timeout	Defines the delay to printing after the last change has been made to the file to be printed in PRINTER:. This can be useful if the file to be printed is populated with data by using FN functions, e.g. during probing.
Standard printer	Select to define the standard printer in case several printers are available. Is defined automatically when creating the first printer.
Settings for printing of text	These settings are applicable when printing text documents: <ul style="list-style-type: none"> <li>■ Paper size</li> <li>■ Number of copies</li> <li>■ Job name</li> <li>■ Font size</li> <li>■ Header</li> <li>■ Print options (black and white, color, duplex)</li> </ul>
Orientation	Portrait, landscape for all printable files
Expert options	Available only to authorized specialists

Print options:

- Copying of the file to be printed in PRINTER:  
The file to be printed is automatically forwarded to the standard printer and deleted from the directory after the print job has been executed

List of printable files:

- Text files
- Graphic files
- PDF files



The connected printer must be PostScript-enabled.

## State Reporting Interface (option 137)

### Introduction

With production lot sizes becoming ever smaller and products becoming increasingly customized, systems for production data acquisition are becoming increasingly important.

The operating resource data—as one of the most important parts of production data acquisition—describe the states of an operating resource along the time scale. For machine tools, the idle times and run times as well as information about pending faults are recorded. An evaluation per workpiece can also be made when the active NC programs are additionally taken into account.

One of the most common applications of production data acquisition is the determination of equipment effectiveness. The term Overall Equipment Effectiveness (OEE) is a measure of the value added of equipment. It provides information about the productivity of equipment as well as its losses at a glance.

With the **State Reporting Interface (SRI)**, HEIDENHAIN offers a simple and reliable interface for acquiring the operating states of your machine.

In contrast to other common interfaces, **SRI** also provides "historical" operating data. Even if your company network fails for several hours, your valuable operating data will not be lost.



A buffer memory that contains 2x 10 000 entries is available for storing the historical operating states. An entry corresponds to a status change in this context.



### Configuring the control

Adjusting the firewall settings:

The **State Reporting Interface** uses **TCP Port 19090** to transfer the acquired operating states.

Accesses to the SRI from the company network (X26 connection) must be permitted in the firewall settings.

- ▶ Allow **SRI**

**Further information:** "Firewall", Page 705



If the **SRI** is accessed locally via an IPC connected to the machine network (X116), eth0 (X26) can also remain locked.

### Activating the **State Reporting Interface**:

In the control's factory default setting, the **SRI** is deactivated.

- ▶ Press the **DIADUR** key to open the HEROS menu
- ▶ Select the **Settings** menu item
- ▶ Select the **State Reporting Interface** menu item
- ▶ Activate the **State Reporting Interface** in the **SRI** pop-up window



**Further information:** "Overview of taskbar", Page 689



To clear all previous operating states, use the **Clear historical data** button.

### Acquiring operating states

The **State Reporting Interface** uses the **Hypertext Transfer Protocol (HTTP)** to transfer the operating states.

With the following **URLs (Uniform Resource Locator)**, you can access the operating states of your control using any web browser.

- **http://<hostname>:19090/sri** for accessing all pieces of information (max. 20 000 entries)
- **http://<hostname>:19090/sri?lineno=<line>** for accessing the most recent pieces of information

Configuring **URL**:

- ▶ Replace the **<hostname>** by your control's network name
- ▶ Replace **<line>** by the first line to be retrieved
- ▶ The control transmits the requested data.

```
<html>
  <head></head>
  <body>
    <pre style="word-wrap: break-word; white-space: pre-wrap;">
      State Reporting Interface: 1.0.6
      HOST:      XXX
      HARDWARE: MC64XX 0.1
      SOFTWARE: 340590 09
      1 ; 2018-07-04 ; 09:52:22 ; TNC:\nc_prog\TS.h ; SUSPEND
      2 ; 2018-07-04 ; 09:52:28 ; TNC:\nc_prog\demo\Start_demo.h ; SUSPEND
      3 ; 2018-07-04 ; 09:52:30 ; TNC:\nc_prog\demo\Start_demo.h ; OPERATE
      4 ; 2018-07-04 ; 09:52:35 ; TNC:\nc_prog\demo\Start_demo.h ; ALARM
      5 ; 2018-07-04 ; 09:52:40 ; TNC:\nc_prog\demo\Start_demo.h ; SUSPEND
      6 ; 2018-07-04 ; 09:52:49 ; TNC:\nc_prog\demo\Start_demo.h ; SUSPEND
      7 ; 2018-07-04 ; 09:53:14 ; TNC:\nc_prog\demo\Start_demo.h ; SUSPEND
      8 ; 2018-07-04 ; 09:53:19 ; TNC:\nc_prog\demo\Start_demo.h ; OPERATE
      9 ; 2018-07-04 ; 09:53:24 ; TNC:\nc_prog\demo\Start_demo.h ; ALARM
    </pre>
  </body>
</html>
```

You will find the operating states in the **<body>** of the HTML file as **CSV contents (Comma Separated Values)**.

CSV contents:

- Header

Designation	Meaning
<b>State Reporting Interface:</b>	Version of the interface. The version number should be taken into account in the evaluation of the data to ensure downward compatibility in your application.
<b>SOFTWARE:</b>	Software of the connected control.
<b>HOST:</b>	Full network name of the connected control.
<b>HARDWARE:</b>	Hardware of the connected control.

- Operating data

Contents	Meaning
1	Consecutive number
2	
...	
2018-07-04	Date (yyyy-mm-dd)
09:52:22	Time (hh:mm:ss)
TNC:\nc_prog\TS.h	Selected or active NC program
States	Status:
<ul style="list-style-type: none"> <li><b>OPERATE</b></li> <li><b>SUSPEND</b></li> <li><b>ALARM</b></li> </ul>	<ul style="list-style-type: none"> <li>Program run is active</li> <li>Program run stopped without error</li> <li>Program stopped due to an error</li> </ul>

## VNC

Use the **VNC** function to configure the behavior of the various VNC clients. This includes, for example, operation via soft keys, mouse and the alphabetic keyboard.

The control provides the following options:

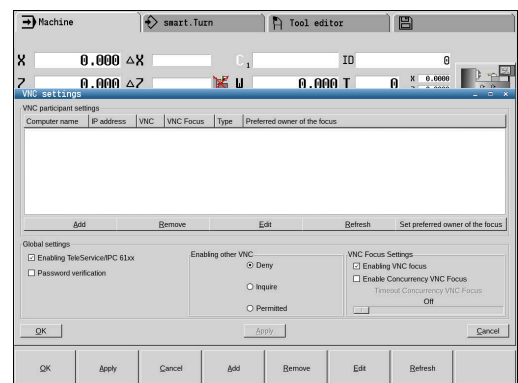
- List of permitted clients (IP address or name)
- Password for the connection
- Additional server options
- Additional settings for assigning the focus



Refer to your machine manual.

For multiple clients or operating units, the focus assignment procedure depends on the design and the operating situation of the machine.

This function must be adapted by your machine manufacturer.



### Opening the VNC settings

Proceed as follows to open the VNC settings:




- ▶ Open the task bar at the bottom edge of the screen
- ▶ Press the green HEIDENHAIN button to open the HEROS menu
- ▶ Select the **Settings** menu item
- ▶ Select the **VNC** menu item
- > The control opens the **VNC Settings** pop-up window.

The control provides the following options:

- Add: Add new VNC viewer/client
- Remove: Deletes the selected client. Only possible with manually entered clients.
- Edit: Edit the configuration of the selected client
- Update: Updates the display. Required with connection attempts during which the dialog is open.

### VNC settings

Dialog	Option	Meaning
VNC participant settings	<b>Computer name:</b>	IP address or computer name
	<b>VNC:</b>	Connection of the client to the VNC viewer
	<b>VNC Focus</b>	The client participates in the focus assignment
	<b>Model</b>	<ul style="list-style-type: none"> <li>■ Manual Manually entered client</li> <li>■ Denied This client is not permitted to connect</li> <li>■ Enable TeleService and IPC Client via TeleService connection</li> <li>■ DHCP Other computer that obtains an IP address from this computer</li> </ul>
Firewall warning		<p>Warnings and information about if the VNC protocol has not been authorized for all VNC clients due to firewall settings on the control.</p> <p><b>Further information:</b> "Firewall", Page 705.</p>
Global settings	<b>Enable TeleService and IPC</b>	Connection is always permitted
	<b>Password verification</b>	The client must enter a password for verification. If this option is active the password must be entered when the connection is established.

Dialog	Option	Meaning
Enabling other VNC	<b>Deny</b>	Access generally denied to all other VNC clients.
	<b>Inquire</b>	During connection attempts a corresponding dialog is opened.
	<b>Permitted</b>	Access is generally granted to all other VNC clients.
VNC Focus Settings	<b>Enabling VNC focus</b>	Enable focus assignment for this system. Otherwise there is no central focus assignment. In the default setting, the focus is actively reassigned by the owner of the focus by clicking the focus symbol. This means that the owner of the focus must first release the focus by clicking the focus symbol before any other client can retrieve the focus.
	<b>Enabling concurrency VNC focus</b>	In the default setting, the focus is actively reassigned by the owner of the focus by clicking the focus symbol. This means that the owner of the focus must first release the focus by clicking the focus symbol before any other client can retrieve the focus. If concurrency focus is selected, any client can retrieve the focus at any time without having to wait for the current owner of the focus to release it.
	<b>Timeout Concurrency VNC Focus</b>	Time period within which the current owner of the focus can object to the focus being withdrawn or can prevent the reassignment of the focus. If a client requests the focus, a dialog in which the reassignment of focus can be refused appears on all clients' screens.
Focus symbol		Current status of VNC focus on the respective client: Focus is owned by other client. Mouse and alphabetic keyboard are disabled.
		Current status of VNC focus on respective client: Focus is owned by current client. Entries can be made.
		Current status of VNC focus on the respective client: Request by the owner of the focus to give the focus to another client. Mouse and alphabetic keyboard are disabled until the focus is assigned unambiguously.

If **Enable concurrency VNC focus** is selected, a pop-up window appears. This dialog makes it possible to refuse that the focus be given to the requesting client. If this does not occur, the focus changes to the requesting client after the set time limit.

## Backup and restore

With the **NC/PLC Backup** and **NC/PLC Restore** functions you can back up and restore individual folders or the complete **TNC** drive. You can save the backup files locally, on a network drive, or to USB storage devices.

The backup program generates a **\*. tncbck** file that can also be processed by the PC tool TNCbackup (part of TNCremo). The Restore program can restore these files as well as those from existing TNCbackup programs. If you select a **\*. tncbck** file in the File Manager of the control, the **NC/PLC Restore** program will be launched automatically.

Backup and restore is subdivided into several steps. Navigate between these steps with the **FORWARD** and **BACK** soft keys. Specific actions for steps are selectively displayed as soft keys.

### Open NC/PLC Backup or NC/PLC Restore

Proceed as follows to open the functions:

- ▶ Open the task bar at the bottom edge of the screen
- ▶ Press the green HEIDENHAIN button to open the HEROS menu
- ▶ Select the **Tools** menu item
- ▶ Open the **NC/PLC Backup** or **NC/PLC Restore** menu item
- > The control opens the pop-up window.

**Backing up data**

To backup data from the control, proceed as follows:

- ▶ Select **NC/PLC Backup**
- ▶ Select type
  - Back up the **TNC** partition
  - Back up the directory tree: Select the directory for backup in the file management
  - Backup machine configuration (for machine tool builders only)
  - Complete backup (for machine tool builders only)
  - Comment: Freely configurable comment for the backup
- ▶ Select the next step with the **FORWARD** soft key
- ▶ Stop the control if required with the **STOP NC SOFTWARE** soft key
- ▶ Define the exclusion rules
  - User preset rules
  - Write own rules to the table
- ▶ Select the next step with the **FORWARD** soft key
- > The control generates a list of files for backing up.
- ▶ Check the list. Deselect files if necessary.
- ▶ Select the next step with the **FORWARD** soft key
- ▶ Enter the name of the backup file
- ▶ Select the storage path
- ▶ Select the next step with the **FORWARD** soft key
- > The control generates the backup file.
- ▶ Confirm with the **OK** soft key
- > The control concludes the backup process and restarts the NC software.

**Restore data****NOTICE****Caution: Data may be lost!**

When you restore data (Restore function), any existing data will be overwritten without a confirmation prompt. Existing data is not automatically backed up by the control before running the restore process. Power failures or other problems can interfere with the data restore process. As a consequence, data may be irreversibly damaged or deleted.

- ▶ Before starting the data restore process, make a backup of the existing data

To restore the data proceed as follows:

- ▶ Select **NC/PLC Restore**
- ▶ Select the archive to be restored
- ▶ Select the next step with the **FORWARD** soft key
- > The control generates a list of files for restoring.
- ▶ Check the list. Deselect files if necessary.
- ▶ Select the next step with the **FORWARD** soft key
- ▶ Stop the control if required with the **STOP NC SOFTWARE** soft key
- ▶ Extract the archive
- > The control restores the files.
- ▶ Confirm with the **OK** soft key
- > The control restarts the NC software.






## 10.4 Firewall

### Application

You can set up a firewall for the primary network interface of the control. It can be configured so that incoming network traffic is blocked and/or a message is displayed, depending on the sender and the service. The firewall cannot be started for the secondary network interface of the control.

Once the firewall has been activated, a symbol appears at the lower right in the taskbar. The symbol changes depending on the safety level that the firewall was activated with, and informs about the level of the safety settings:

Icon	Meaning
	Firewall protection does not yet exist although it has been activated according to the configuration. This can happen, for example, if PC names for which there are no equivalent IP addresses as yet were used in the configuration.
	Firewall active with medium security level
	Firewall active with high safety level. (all services except for SSH are blocked)



Have your network specialist check and, if necessary, change the standard settings.

### Configuring the firewall

- ▶ Use the mouse to open the taskbar at the bottom edge of the screen
- ▶ Press the green HEIDENHAIN button to open the HEROS menu
- ▶ Select the **Settings** menu item
- ▶ Select the **Firewall** menu item

HEIDENHAIN recommends activating the firewall with the prepared default settings:

- ▶ Select the **Active** option to enable the firewall
- ▶ Press the **Set standard values** button to activate the default settings recommended by HEIDENHAIN.
- ▶ Confirm the changes with **Apply**
- ▶ Close the dialog with **OK**.

## Firewall settings

Option	Meaning
Active	Switching the firewall on and off
Interface	Selection of the <b>eth0</b> interface usually corresponds to X26 of the MC main computer. <b>eth1</b> corresponds to X116. You can check this in the network settings on the Interfaces tab. For main computer units with two Ethernet interfaces, the DHCP server for the machine network is active for the second (non-primary) interface by default. With this setting the firewall cannot be activated for <b>eth1</b> because the firewall and DHCP server mutually exclude each other.
Report other inhibited packets	Firewall active with high safety level. (all services except for SSH are blocked)
Inhibit ICMP echo answer	If this option is set, the control no longer responds to a PING request
Service	<p>This column contains the short names of the services that are configured with this dialog. For the configuration it is not important here whether the services themselves have been started</p> <ul style="list-style-type: none"> <li>■ <b>LDAPS</b> includes the server on which the user data and the user administration configuration are saved.</li> <li>■ <b>LSV2</b> includes the functionality for <b>TNCremo</b> and Teleservice, as well as the HEIDENHAIN DNC interface (ports 19000 to 19010)</li> <li>■ <b>SMB</b> only refers to incoming SMB connections, i.e. if a Windows share is created on the NC. Outgoing SMB connections (i.e. if a Windows share is connected on the NC) cannot be prevented.</li> <li>■ <b>SRI</b> refers to the connections that are used in conjunction with the acquisition of operating states through the <b>State Reporting Interface</b> option.</li> <li>■ <b>SSH</b> stands for the Secure Shell protocol (port 22). As of HEROS 504, LSV2 can be executed securely via this SSH protocol while user administration is active. <b>Further information:</b> "DNC connection with user authentication", Page 737</li> <li>■ <b>VNC</b> protocol means access to the screen contents. If this service is blocked, the screen content can no longer be accessed, not even with the TeleService programs from HEIDENHAIN (e.g. screenshot). If this service is blocked, the VNC configuration dialog shows a warning from HEROS that VNC is disabled in the firewall.</li> </ul>
Method	Use <b>Method</b> to configure whether the service is inaccessible for all ( <b>Prohibit all</b> ), accessible for all ( <b>Permit all</b> ) or only accessible for individuals ( <b>Permit some</b> ). If you set <b>Permit some</b> you must also specify the computer (under Computer) that you wish to grant access to the respective service. If you do not specify any computer under <b>Computer</b> , the setting <b>Prohibit all</b> will automatically become active when the configuration is saved.
Log	If <b>Log</b> is activated, a <b>red</b> message is output if a network packet for this service was blocked. A (blue) message is output if a network packet for this service was accepted

Option	Meaning
Calculator	If the setting <b>Permit some</b> is selected under <b>Method</b> , the relevant computers can be specified here. The computers can be entered with their IP addresses or host names separated by commas. If a host name is used, the system checks upon closing or saving of the dialog whether the host name can be translated into an IP address. If this is not the case, an error message is displayed and the dialog does not terminate. If a valid host name is specified, this host name is translated into an IP address each time the control is started. If a computer that was entered with its name changes its IP address, you may have to restart the control or formally change the firewall configuration to ensure that the control uses the new IP address for a host name in the firewall.
Advanced options	These settings are only intended for your network specialists
Set standard values	Resets the settings to the default values recommended by HEIDENHAIN

## 10.5 Software for data transfer

For data transfer to or from the control, you should use the **TNCremo** software. With **TNCremo**, data transfer is possible with all HEIDENHAIN controls via the Ethernet interface.



You can download the current version of the **TNCremo** software from the HEIDENHAIN homepage.

System requirements for TNCremo:

- PC with 486 processor or higher
- Windows XP, Windows Vista, Windows 7, Windows 8 operating system
- 16 MB RAM
- 5 MB free memory space on your hard disk
- An available serial interface or connection to the TCP/IP network

Installation under Windows

- ▶ Open the file manager (Explorer) and start the SETUPEXE installer
- ▶ Follow the setup program instructions

Starting TNCremo under Windows

- ▶ Click <Start>, <Programs>, <HEIDENHAIN Applications>, <**TNCremo**>

When you start **TNCremo** for the first time, **TNCremo** automatically tries to set up a connection with the control.

### Data transfer between the control and TNCremo

Check whether the control is connected to the correct serial port on your PC or to the network.

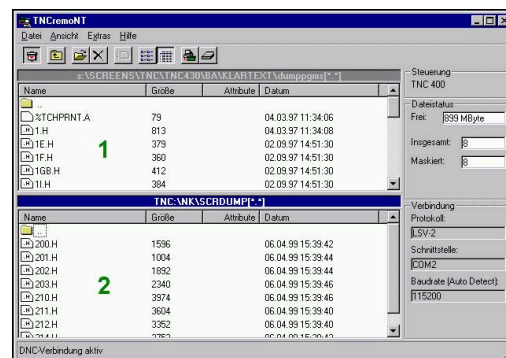
Once you have started the **TNCremo** software, you will see a list of all files that are stored in the active directory in the upper section of the main window **1**. Using <File>, <Change directory>, you can select any drive or another directory on your PC.

If you want to control data transfer from the PC, establish the connection with your PC in the following manner:

- ▶ Select <File>, <Setup connection>. **TNCremo** now receives the file and directory structure from the control and displays this in the lower part of the main window **2**
- ▶ To transfer a file from the control to the PC, select the file in the control window per mouse click and move the highlighted file into the PC window while holding down the mouse button **1**
- ▶ To transfer a file from the PC to the control, select the file in the PC window per mouse click and move the highlighted file into the control window while holding down the mouse button **2**

If you want to control data transfer from the control, establish the connection with your PC in the following manner:

- ▶ Select <Extras>, <TNCserver>. **TNCremo** then starts in server mode and can receive data from the control or send data to the control
- ▶ You can now call the file management functions on the control by pressing the **PGM MGT** key in order to transfer the desired files



**End TNCremo**

Select <File>, <Exit>



You can open the context-sensitive help function of the **TNCremo** software by pressing the **F1** key.

## 10.6 Ethernet interface (for software 548328-xx)

Network configuration settings:

- **Control name:** Computer name of the control
- **DHCP** (Dynamic Host Configuration Protocol)
  - ON: The network settings are automatically configured by a DHCP server
  - OFF: The other network settings have to be configured manually:
    - (Static) IP address
    - Subnet mask
    - Broadcast
    - Gateway

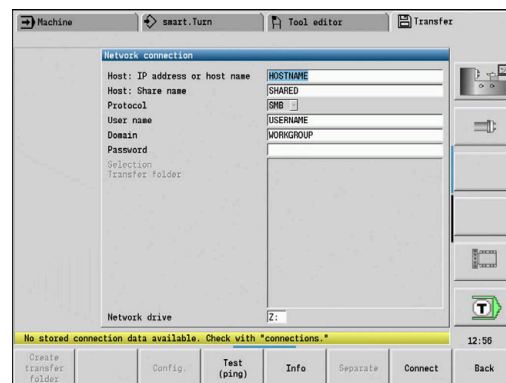
Network connection settings (SMB):

- **Protocol:** SMB – Windows network
- **Host: IP address or host name:** Computer name or IP address of the target computer
- **Host: Share name:** Share name of the target computer
- **User name** for logging on to the target computer.
- **Workgroup / domain:** Name of the workgroup or domain
- **Password** for logging on to the target computer








Network connection settings (NFS):

- **Protocol:** NFS
- **Host IP address:** IP address of the target computer
- **Host: Share name:** Share name of the target computer
- **rsize**
- **wsize**
- **time0**
- **soft**

**Select project folder:** The control reads and writes all the data to/ from a predefined project folder. Each project folder mirrors the folder structure on the control. Select the project folder you want to connect to. If no project folder exists in the target path, the folder is created when connecting.



### Network configuration soft keys

Soft key	Meaning
	Create a folder of the specified name in the target path when a connection has been established
	Open the <b>Network configuration</b> dialog
	Open the <b>Network connection</b> dialog and start to <b>PING</b> the specified target
	Display all the network information in a list box
	Terminate an existing network connection. When a USB storage device is active, the control switches to the USB connection
	Establish the connection and open the last project folder you selected
	Return to the Transfer soft-key menu

## 10.7 Ethernet interface (for software 548431-05)

### Introduction

The control is shipped with a standard Ethernet card to connect the control as a client in your network.

The control transmits data via the Ethernet card with:

- The **SMB** protocol (Server Message Block) for Windows operating systems, or
- The **TCP/IP** protocol family (Transmission Control Protocol/Internet Protocol) and with support from the **NFS** (Network File System). The control also supports the **NFS V3** protocol, which permits higher data transfer rates

### Connection possibilities

You can connect the Ethernet card in your control to your network over the **RJ45** connection, or directly to a PC. The connection is metalically isolated from the control electronics.

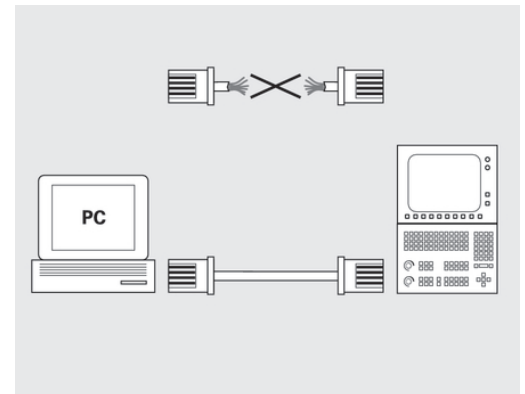


The maximum cable length between control and a node depends on the quality grade of the cable, the sheathing and the type of network.

If you connect the control directly with a PC you must use a crossover cable.

Have a network specialist configure the control.

Please note that the control performs an automatic restart if you change the IP address of the control.





Calling the general network settings:

- ▶ Press the **DEFINE NET** soft key to enter the general network settings
- ▶ The **Computer name** tab is active

Setting	Meaning
<b>Primary interface</b>	Name of the Ethernet interface to be integrated in your company network. Only active if a second, optional Ethernet interface is available on the control hardware
<b>Computer name</b>	Name displayed for the control in your company network

<b>Host file</b>	<b>Only required for special applications!</b> Name of a file in which the assignments of IP addresses to computer names are defined
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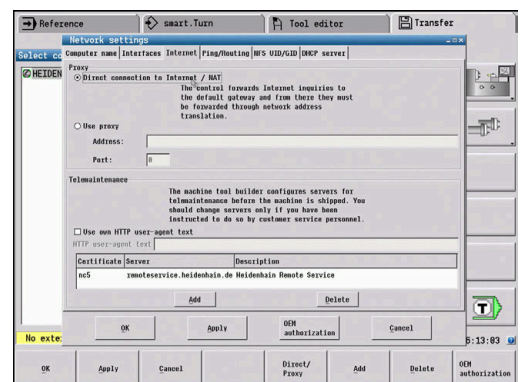
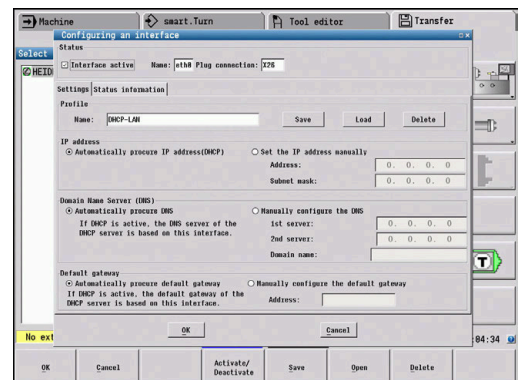
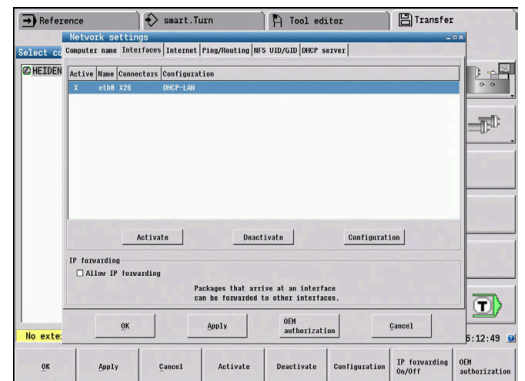
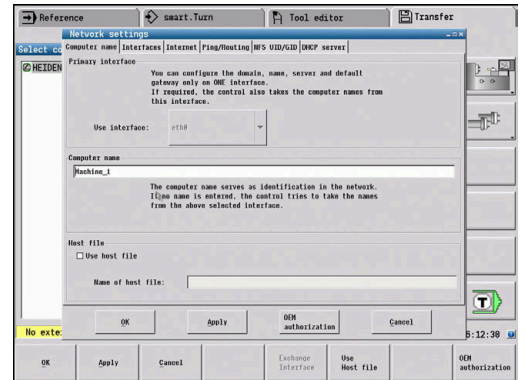
- ▶ Select the **Interfaces** tab to enter the interface settings

Setting	Meaning
<b>Interface list</b>	List of the active Ethernet interfaces. <ul style="list-style-type: none"> <li>▶ Select one of the listed interfaces (by mouse or arrow keys)</li> <li>■ <b>Activate</b> button: Activate the selected interface (X appears in the Active column)</li> <li>■ <b>Deactivate</b> button: Deactivate the selected interface (- appears in the Active column)</li> <li>■ <b>Configuration</b> button: Open the configuration menu</li> </ul>

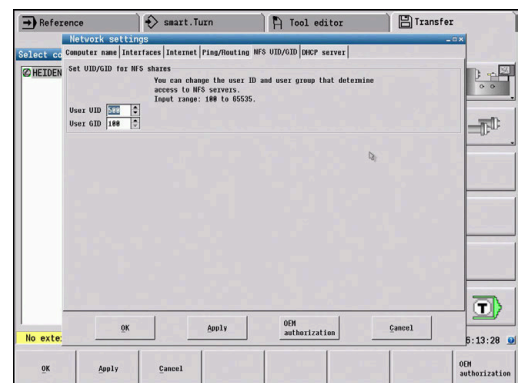
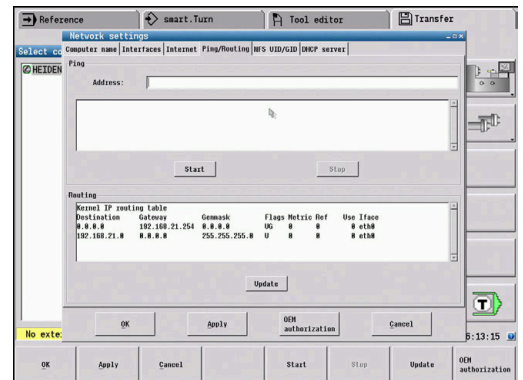
<b>Allow IP forwarding</b>	<b>This function must be inactive by default!</b> Only activate this function if external access via the second, optional Ethernet interface of the control is necessary for diagnostic purposes. Only do so after instruction by our Service Department
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- ▶ Press the **CONFIGURE** button to open the Configuration menu

Setting	Meaning
<b>Status</b>	<ul style="list-style-type: none"> <li>■ <b>Interface active:</b> Connection status of the selected Ethernet interface</li> <li>■ <b>Name:</b> Name of the interface you are currently configuring</li> <li>■ <b>Plug connection:</b> Number of the plug connection of this interface on the logic unit of the control</li> </ul>



Setting	Meaning
<b>Profile</b>	<p>Here you can create or select a profile in which all settings shown in this window are stored. HEIDENHAIN provides two standard profiles:</p> <ul style="list-style-type: none"> <li>■ <b>DHCP-LAN:</b> Settings for the standard Ethernet interface; should work in a standard company network</li> <li>■ <b>MachineNet:</b> Settings for the second, optional Ethernet interface; for configuration of the machine network</li> </ul> <p>Press the corresponding buttons to save, load and delete profiles</p>
<b>IP address</b>	<ul style="list-style-type: none"> <li>■ <b>Automatically procure IP address</b> option: The control is to procure the IP address from the DHCP server</li> <li>■ <b>Set the IP address manually</b> option: Manually define the IP address and subnet mask. Input: Four numerical values separated by periods, e.g. <b>160.1.180.20</b> and <b>255.255.0.0</b></li> </ul>
<b>Domain Name Server (DNS)</b>	<ul style="list-style-type: none"> <li>■ <b>Automatically procure DNS</b> option: The control is to automatically obtain the IP address of the domain name server</li> <li>■ <b>Manually configure the DNS</b> option: Manually enter the IP addresses of the servers and the domain name</li> </ul>

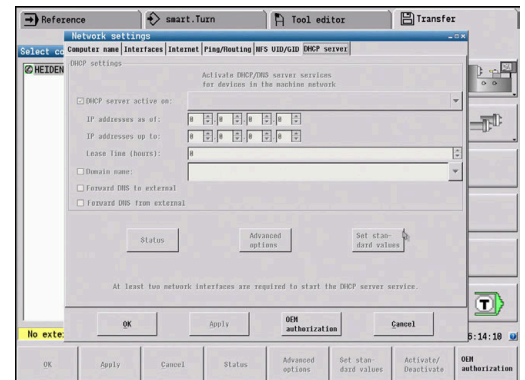


Setting	Meaning
<b>Default gateway</b>	<ul style="list-style-type: none"> <li>■ <b>Automatically procure default gateway</b> option: The control is to automatically obtain the default gateway</li> <li>■ <b>Manually configure the default gateway</b> option: Manually enter the IP addresses of the default gateway</li> </ul>

▶ Press **OK** to confirm the changes

▶ Alternative: Discard the changes with the **Cancel** button

▶ Select the **Internet** tab



Setting	Meaning
<b>Proxy</b>	<ul style="list-style-type: none"> <li>■ <b>Direct connection to Internet / NAT:</b> The control forwards Internet requests to the default gateway. From there, they must be forwarded through network address translation (e.g. if a direct connection to a modem is available)</li> <li>■ <b>Use proxy:</b> Define the address and port of the Internet router in your network; ask your network administrator for the correct address and port</li> </ul>
<b>Telemaintenance</b>	<p>The machine manufacturer configures the server for telemaintenance here.</p> <p><b>Changes must always be made in agreement with your machine tool builder!</b></p>

- ▶ Select the **Ping/Routing** tab to enter the ping and routing settings

Setting	Meaning
<b>Ping</b>	<ul style="list-style-type: none"> <li>▶ In the <b>Address:</b> field, enter the IP number for which you want to check the network connection</li> <li>▶ Input: Four numerical values separated by periods, e.g. <b>160.1.180.20</b></li> <li>▶ As an alternative, you can enter the name of the computer whose connection you want to check</li> <li>■ <b>START</b> button: Start the test; the control shows the status information in the Ping field</li> <li>■ <b>STOP</b> button: Conclude the test</li> </ul>
<b>Routing</b>	<p><b>For network specialists!</b></p> <p>Status information of the operating system for the current routing process</p> <ul style="list-style-type: none"> <li>■ <b>Update</b> button: Refresh the routing information</li> </ul>

- ▶ Select the **NFS UID/GID** tab to enter the user and group identifications

Setting	Meaning
<b>Set UID/ GID for NFS shares</b>	<ul style="list-style-type: none"><li>■ <b>User ID:</b> Definition of which user identification the end user uses to access files in the network. Ask your network specialist for the proper value</li><li>■ <b>Group ID:</b> Definition of the group identification with which you access files in the network. Ask your network specialist for the proper value</li></ul>
▶	Select the <b>DHCP server</b> tab to configure the DHCP server settings of the machine network



Refer to your machine manual.

The configuration of the DHCP server is protected by password. Please refer to your machine tool builder for all relevant information.

Setting	Meaning
DHCP server active on	<ul style="list-style-type: none"> <li>■ <b>IP addresses from:</b> Define the IP address as of which the control is to derive the pool of dynamic IP addresses. The control transfers the values that appear dimmed from the static IP address of the defined Ethernet interface; these values cannot be edited</li> <li>■ <b>IP addresses to:</b> Define the IP address up to which the control is to derive the pool of dynamic IP addresses</li> <li>■ <b>Lease Time (hours):</b> Time within which the dynamic IP address is to remain reserved for a client. If a client logs on within this time, the control reassigns the same dynamic IP address</li> <li>■ <b>Domain name:</b> Here, you can define a name for the machine network if required. This is necessary if the same names are assigned in the machine network and in the external network, for example</li> <li>■ <b>Forward DNS to external:</b> If <b>IP Forwarding</b> is active (<b>Interfaces</b> tab) and this option is active, you can specify that the name resolution for devices in the machine network can also be used by the external network.</li> <li>■ <b>Forward DNS from external:</b> If <b>IP Forwarding</b> is active (<b>Interfaces</b> tab) and this option is active, you can specify that the control is to forward DNS requests from devices within the machine network to the name server of the external network as well if the DNS server of the MC cannot answer the request.</li> <li>■ <b>Status</b> button: Call an overview of the devices that are provided with a dynamic IP address in the machine network. You can also select settings for these devices</li> <li>■ <b>Advanced options</b> button: Additional settings for the DNS/DHCP server</li> <li>■ <b>Set standard values</b> button: Set factory default settings</li> </ul>

## Device-specific network settings

Calling the device-specific network settings:



- ▶ Press the **Network** soft key to enter the network settings for a specific device
- ▶ You can define any number of network settings, but only 7 can be managed at a time

Setting	Meaning
---------	---------

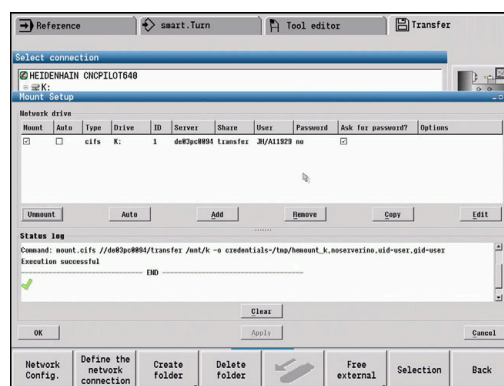
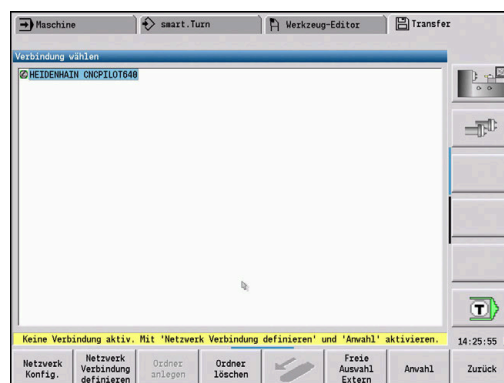
### Network drive

List of all connected network drives. The control shows the respective status of the network connections in the columns:

- **Mount:** Network drive connected or not connected
- **Auto:** Network drive is to be connected automatically or manually
- **Type:** Type of network connection. cifs and nfs are possible
- **Drive:** Designation of the drive on the control
- **ID:** Internal ID that identifies if a mount point has been used for more than one connection
- **Server:** Name of the server
- **Share:** Name of the directory on the server that the control is to access
- **User:** User name with which the user logs on to the network
- **Password:** Network password protected or not
- **Ask for password?:** Ask / do not ask for a password during connection
- **Options:** Display additional connection options

To manage the network drives, use the screen buttons.

To add network drives, use the **Add** button: The control then starts the connection wizard, which guides you by dialog through the required definitions



## 10.8 SELinux security software

**SELinux** is an extension for Linux-based operating systems. SELinux is an additional security software package based on Mandatory Access Control (MAC) and protects the system against the running of unauthorized processes or functions and therefore protects against viruses and other malware.

MAC means that every action must be explicitly permitted, otherwise it will not be executed by the control. The software is intended as protection in addition to the normal access restriction in Linux. Certain processes and actions can only be executed if the standard functions and access control of SELinux permit it.



The SELinux installation of the control has been prepared to permit running only programs installed with the HEIDENHAIN NC software. Other programs cannot be run with the standard installation.

The access control of SELinux under HEROS 5 is regulated as follows:

- The control executes only applications that are installed with the HEIDENHAIN NC software
- Files in connection with the security of the software (SELinux system files, HEROS 5 boot files, etc.) may only be changed by programs that are selected explicitly
- New files generated by other programs must never be executed
- USB data carriers cannot be deselected
- There are only two processes that are permitted to execute new files:
  - Starting a software update: A software update from HEIDENHAIN can replace or change system files
  - Starting the SELinux configuration: The configuration of SELinux is usually password-protected by your machine manufacturer; refer here to the relevant machine manual



HEIDENHAIN recommends activating SELinux because it provides additional protection against attacks from outside.

## 10.9 User administration

### Introduction to user administration



Refer to your machine manual.

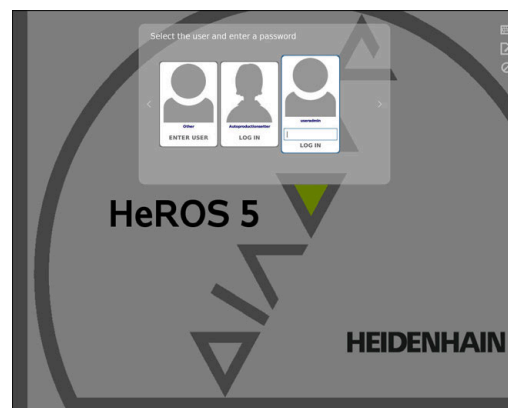
Some user administration areas are configured by the machine tool builder.

User administration is inactive in the control's factory default setting. This status is called **legacy mode**. In **legacy mode**, the control's behavior is identical to that of older software versions without user administration.

It is not mandatory that you use the user administration feature, but it is essential for the implementation of an IT security system.

User administration supports you in the following fields of security, based on the requirements of the IEC 62443 series of standards:

- Application security
- Network security
- Platform security



User administration enables you to define users with different access rights.

**The following options are available for saving your user data:**

- **Local LDAP database**
  - Using the user administration feature on one single control
  - Setting up a central LDAP server for more than one control
  - Exporting an LDAP server configuration file if the exported database is to be used by more than one control
- **LDAP database on remote computer**
  - Importing an LDAP server configuration file
- **Connection to a Windows domain**
  - Integrating the user administration feature on more than one control
  - Using different roles on different controls



Parallel operation of Windows users and users from an LDAP database is possible.



## Configuring the user administration

User administration is inactive in the control's factory default setting. This status is called **legacy mode**.

Before user administration can be used, you need to configure it.

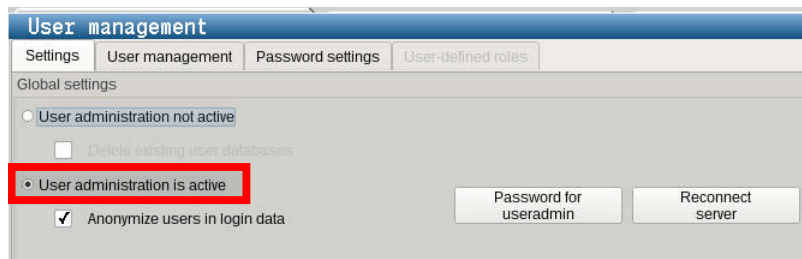
Perform the following steps for configuration:

1. Activate the user administration and create the **useradmin** user
2. Set up a database
  - **Further information:** "Local LDAP database", Page 723
  - **Further information:** "LDAP on remote computer", Page 724
  - **Further information:** "Connection to a Windows domain", Page 725
3. Creating further users

**Further information:** "Creating further users", Page 728

Proceed as follows to call the user administration:

- ▶ Select the **HEROS** menu icon
- ▶ Select the **Settings** menu item
- ▶ Select the **UserAdmin** menu item
- > The control opens the **User management** window.



The purpose of the **Anonymize users in login data** function is data privacy; this function is active by default. While this function is active, user data in all log files of the control will be anonymized.

## NOTICE

### Caution: Unwanted data transfer is possible!

If you deactivate the **Anonymize users in login data** function, the system will show personalized user data in all log files. If servicing becomes necessary or if the log files need to be transmitted for another reason, the contracting party will be able to view this user data. In this case, it is your responsibility to ensure that any data protection provisions have been made at your company.

In order to prevent unwanted data transfers, make sure that the **Anonymize users in login data** function remains activated or reactivate it.

- ▶ Select **Password for useradmin**
- > The control opens the **Password for user 'useradmin'** pop-up window.
- ▶ Set the password for the **useradmin** user
- ▶ Select **Set new password**
- > The message **Settings and password for 'useradmin' were changed** appears.



For reasons of security, passwords should comply with the following criteria:

- Eight characters minimum
- Letters, numbers and special characters
- Avoid using whole words or a sequence of characters, e.g. Anna or 123

The **useradmin** user is comparable to the local administrator of a Windows system.

The **useradmin** account provides the following functions:

- Creating databases
- Assigning the password data
- Activating the LDAP database
- Exporting LDAP server configuration files
- Importing LDAP server configuration files
- Emergency access if the user database was destroyed
- Retroactive change of the database connection
- Deactivating the user administration

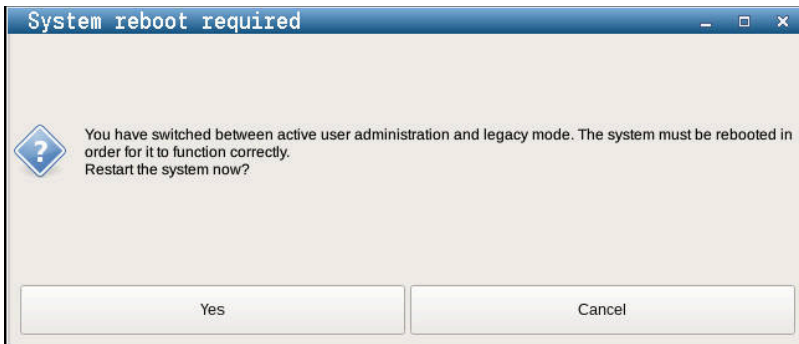


The **useradmin** user automatically receives the **HEROS.Admin** role. This allows him to manage users in the user administration, provided that he knows the LDAP database password. The **useradmin** user is a function user who has been predefined by HEIDENHAIN. You can neither add roles to function users, nor delete their roles.

**Further information:** "Definition of roles", Page 732  
HEIDENHAIN recommends permitting more than one person to access an account with the **HEROS.Admin** role. This ensures that necessary changes to the user administration can also be made in the administrator's absence.

Proceed as follows to set up the database:

- ▶ Select the database for saving the user data
- ▶ Set up a database
- ▶ Press **USE** soft key.
- ▶ Press the **END** soft key
- > The control opens the **System reboot required** window.
- ▶ Press **Yes** to restart the system
- > The control restarts.



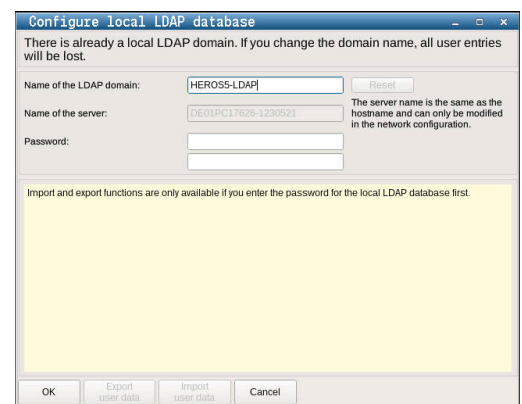
## Local LDAP database

Before you can use the **Local LDAP database** function, the following requirements must be met:

- The user administration is active
- The **useradmin** user has been configured

Proceed as follows to set up a **local LDAP database**:

- ▶ Call the user administration
- ▶ Select the **LDAP user database** function
- > The control enables the dimmed area for editing the LDAP user database.
- ▶ Select the **Local LDAP database** function
- ▶ Select the **Configure** function
- > The control opens the **Configure local LDAP database** window
- ▶ Enter the name of the **LDAP domain**
- ▶ Enter password
- ▶ Repeat password
- ▶ Press the **OK** soft key
- > The control closes the **Configure local LDAP database** window



**i** Before you can start editing the user administration, the control prompts you to enter the password of your local LDAP database.

Passwords must not be trivial and must be known only to the administrators.

**Further information:** "Creating further users", Page 728

## LDAP on remote computer

### Requirements

Before you can use the **LDAP on remote computer** function, the following requirements must be met:

- The user administration is active
- The **useradmin** user has been configured
- An LDAP database has been set up in the company network
- A server configuration file of an existing LDAP database must be stored on the control or on a PC in the network
- The PC with the existing configuration file is running.
- The PC with the existing configuration file is accessible in the network

### Providing a server configuration file

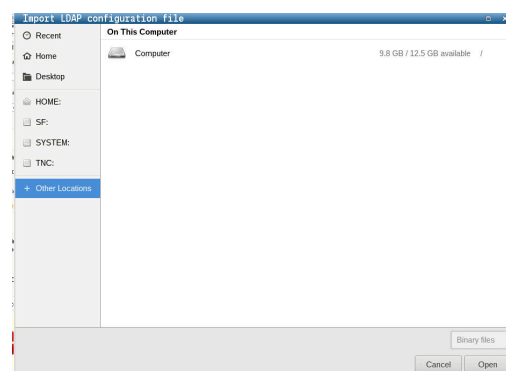
Proceed as follows to provide an LDAP database with a server configuration file:

- ▶ Call the user administration
- ▶ Select the LDAP user database function
- > The control enables the dimmed area for editing the LDAP user database.
- ▶ Select the **Local LDAP database** function
- ▶ Select the **Export server configuration** function
- > The control opens the **Export LDAP configuration file** window
- ▶ Enter the name for the server configuration file into the name field
- ▶ Save the file to the desired folder
- > The server configuration file was exported successfully

### Using the LDAP database on another computer

Proceed as follows to use the **LDAP on remote computer** function:

- ▶ Call the user administration
- ▶ Select the LDAP user database function
- > The control enables the dimmed area for editing the LDAP user database
- ▶ Select the **LDAP on remote computer** function
- ▶ Select the **Import server configuration** function
- > The control opens the **Import LDAP configuration file** window
- ▶ Select the existing configuration file
- ▶ Select **Open**
- ▶ Press **USE** soft key.
- > The configuration file was imported.



## Connection to a Windows domain

### Requirements

Before you can use the **Connection to Windows domain** function, the following requirements must be met:

- The user administration is active
- The **useradmin** user has already been configured
- There is a Windows Active Domain Controller in the network
- You have access to the password of the domain controller
- You have access to the user interface of the domain controller or you are supported by an IT administrator
- The domain controller is accessible in the network

### Setting up logins

Proceed as follows to set up the **Connection to Windows domain** function:

- ▶ Call the user administration
- ▶ Select the **Connection to Windows domain** function
- ▶ Select the **Find domain** function
- > The control recognizes the found domain.



Use the **Configure** function to define various settings of your connection:

- Deactivate the function **Map SIDs to Unix UIDs**
- You can define a special group of Windows users to whom you want to restrict the connection to this control
- You can modify the organizational unit in which the HEROS role names are stored
- You can change the prefix in order to manage users from different workshops, for example. Each prefix given to a HEROS role name can be changed, e.g. HEROS hall 1 and HEROS hall 2
- You can change the separator within the HEROS role name

- ▶ Press **USE** soft key.
- > The control opens the **Connect to domain** window.



With the **Organizational unit for computer account** function, you can specify in which of the already existing organizational units you want to create the access, e.g.

- ou = controls
- cn = computers

The values you enter must match the conditions of the domain. The terms are not exchangeable.

- ▶ Enter the user name of the domain controller
- ▶ Enter the password of the domain controller
- > The control connects to the Windows domain found.

- > The control checks whether all of the required roles have been created in the domain as groups.



If not all of the required roles have been created in the domain as groups, the control issues a warning.

If the control issues a warning, proceed in one of the two following ways:

- ▶ Press the **ADD ROLE DEFINITION** soft key

- Select the **Add** function

You can enter the roles directly into the domain in this case.

- Select the **Export** function

You can output the roles externally to a file in .ldif format in this case.

- > All of the required roles have been created in the domain as groups.

Anmeldung an Windows Domäne

Domäne: KDC:  
LDAP-ID-Mapping: Ja

HEROS-Rollen Basis:

Konfigurieren Domäne suchen  
Rollen def. ergänzen

### Creating groups

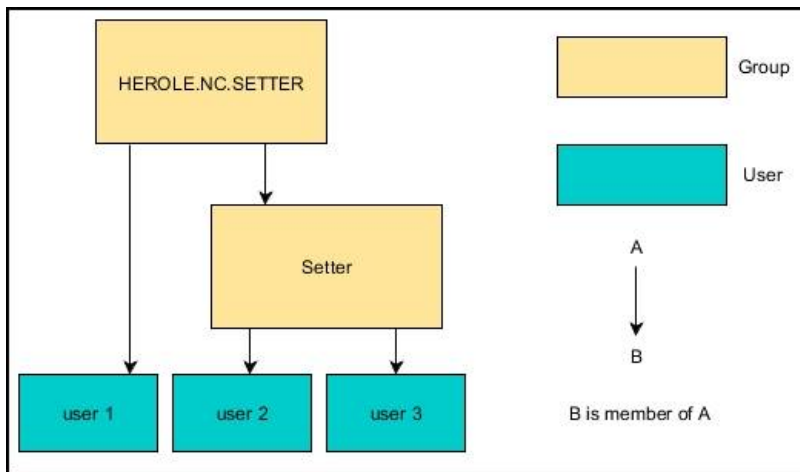
There are the following ways to create groups corresponding to the different roles:

- Automatically when entering the Windows domain by specifying a user with administrator rights
- By importing an import file in .Idif format into the Windows server

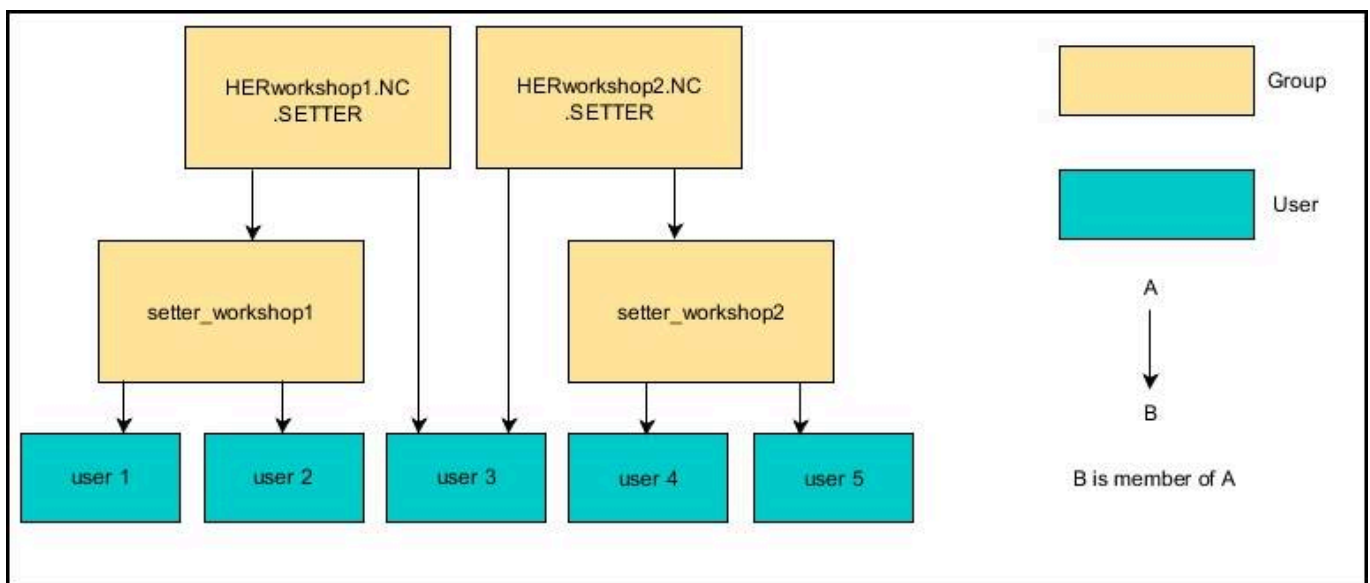
The users need to be added manually by the Windows administrator to the roles (security groups) on the domain controller.

Two suggestions describing how the groups can be structured by the Windows administrator are given by HEIDENHAIN below:

- Suggestion 1: The user is a direct or indirect member of the respective group:



- Suggestion 2: Users from various sectors (workshops) are members of groups with different prefixes:



## Creating further users

After configuring the user administration, you can create further users.

Before you can create further users, you must have configured and selected an LDAP database.

Proceed as follows to create further users:

- ▶ Call the user administration
- ▶ Select the **User management** tab



The **User management** tab is only effective for the following databases:

- **Local LDAP database**
- **LDAP on remote computer**

If **Connection to Windows domain** is used, you need to configure the users in the Windows domain.

**Further information:** "Connection to a Windows domain", Page 725

- ▶ Press the **EDIT ON** soft key
- ▶ The control prompts you to enter the password of your user database.



This step is only needed if you have restarted your control after configuring the database.

- ▶ After you have entered the password, the control opens the **User management** menu.

You can edit the existing users or create new users.

Proceed as follows to create a new user:

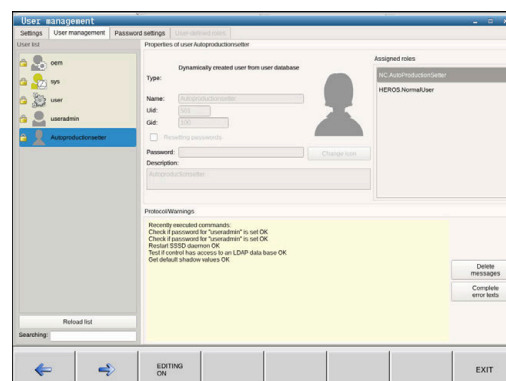
- ▶ Press the **CREATE NEW USER** soft key
- ▶ The control opens a window for creating a user.
- ▶ Enter the user name
- ▶ Enter a password for the user



The user must change the password when logging in for the first time.

**Further information:** "Login to user administration", Page 741

- ▶ You can optionally also create a user description
- ▶ Press the **ADD ROLE** soft key
- ▶ In the selection window, select the roles corresponding to your user
- ▶ **Further information:** "Definition of roles", Page 732
- ▶ Confirm your selection with the **ADD** soft key







Two additional soft keys are available in the menu:

- **ADD REMOTE LOGIN:**

Adds **Remote.HEROS.Admin** in place of **HEROS.Admin**, for example.

This role is only enabled for remote logon to the system.

- **ADD LOCAL LOGIN**

Adds **Local.HEROS.Admin** in place of **HEROS.Admin**, for example.

This role is only enabled for local logon at the control's screen.

- ▶ Press the **CLOSE** soft key
- > The control closes the window for creating a user.
- > Press the **OK** soft key
- ▶ Press **USE** soft key.
- > The changes you made are applied.
- ▶ Press the **END** soft key
- > The control closes the user administration.



If you have not restarted your control after configuring the database, the control prompts you to restart for the changes to take effect.

**Further information:** "Configuring the user administration", Page 721

### Adding profile images

You can optionally also assign images to your users. The **default user icons** from HEIDENHAIN are available for this. You can also load your own images in JPEG or PNG format to the control. Then you can use these image files as profile images.

Proceed as follows to define profile images:

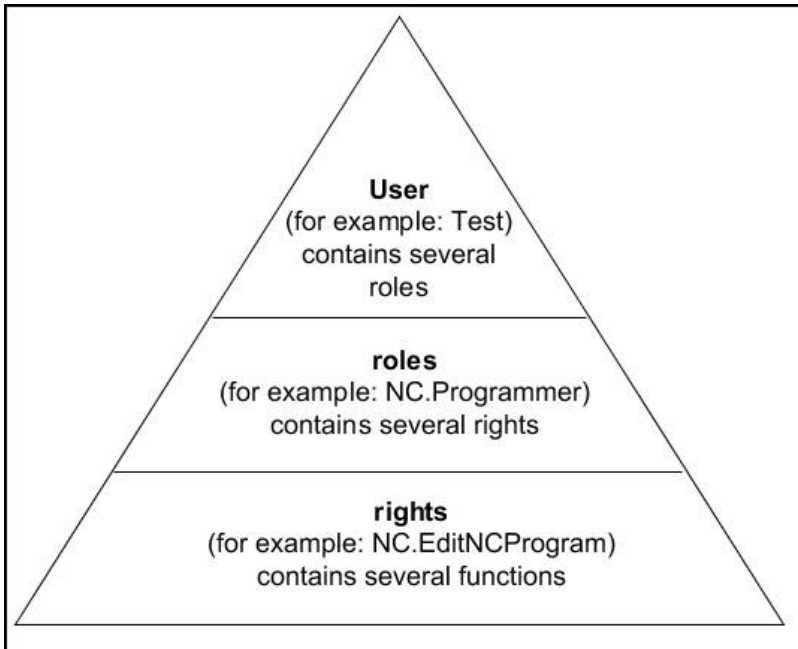
- ▶ Log on the user with **HEROS.Admin** role, e.g. **useradmin**
- Further information:** "Login to user administration", Page 741
- ▶ Call the user administration
  - ▶ Select the **User management** tab
  - ▶ Press the **EDIT USER** soft key
  - ▶ Press the **CHANGE ICON** soft key
  - ▶ Select image
  - ▶ Use the **CHOOSE ICON** soft key to select an image
  - ▶ Press the **OK** soft key
  - ▶ Press **USE** soft key.
  - > The control adopts the changes.



You can also directly add profile images when creating the users.

## Access rights

The user administration is based on the Unix rights management. Access to the control is controlled by means of rights.



The user administration differentiates between the following terms:

### ■ User

- **Function user** pre-defined by HEIDENHAIN
- **Function user** defined by the machine tool builder
- Self-defined users

A user can be pre-defined in the control or he can be defined by the end user. A user contains all the roles that have been assigned to him.



Your machine tool builder defines function users who are required for machine maintenance, for example. Depending on the task assigned, you can use one of the pre-defined function users or you have to create a new user. The access rights of HEIDENHAIN function users are already pre-defined in the control's factory default setting.

### Roles

Roles consist of a combination of rights that cover certain functions provided by the control.

- **Operating system roles**
- **NC operator roles**
- **Machine tool builder (PLC) roles**

All of these roles are pre-defined in the control.

You can assign more than one role to a user.

## Privileges

If more than one role is assigned to a user, he will be granted all rights contained in these roles.

- HEROS rights
- NC rights
- PLC rights (OEM)

Rights consist of a combination of functions that cover a task area of the control, e.g. editing the tool table.



Ensure that every user is only assigned the access rights he needs. The access rights result from the actions a user performs on the control.

## HEIDENHAIN function users

HEIDENHAIN function users are pre-defined users that are automatically created when the user administration is activated. Function users cannot be edited.

HEIDENHAIN provides four different function users in the control's factory default setting.

### ■ **oem**

The **oem** function user is intended for the machine tool builder. With **oem**, you can access the PLC partition of the control.

### ■ **Function user defined by the machine tool builder**



Refer to your machine manual.

The users defined by the machine tool builder can differ from those pre-defined by HEIDENHAIN.

The machine tool builder's function users can already be active in **legacy mode** and replace code numbers.

By entering code numbers or passwords that replace code numbers, you can temporarily enable rights of **oem** function users.

**Further information:** "Current User", Page 745

### ■ **sys**

With the **sys** function user, you can access the system partition of the control. This function user is reserved for use by the JH Service department.

### ■ **user**

In **legacy mode**, the **user** function user is automatically logged on to the system during control start-up. When the user administration is active, the **user** function user has no effect. The logged-on user of the type **user** cannot be changed in **legacy mode**.

### ■ **useradmin**

The **useradmin** function user is automatically created when the user administration is activated. With **useradmin**, you can configure and edit the user administration.



## Definition of roles

HEIDENHAIN combines several rights for individual task areas to roles. Different pre-defined roles that you can use to assign rights to your users are available. The tables below describe the individual rights of the different roles.



Every user should have at least one role from the operating system area and at least one role from the programming area.

You can enable a role either for local login or for remote login. With local login, the user directly logs on to the control at the control's screen. A remote login (DNC) is a connection via SSH.

You can therefore also make the rights of a user dependent on the access used to operate the control.

If a role is only enabled for local login, **Local.** is added to the role name, e.g. **Local.HEROS.Admin** instead of **HEROS.Admin**.

If a role is only enabled for remote login, **Remote.** is added to the role name, e.g. **Remote.HEROS.Admin** instead of **HEROS.Admin**.

Advantages of classification in roles:

- Simplified administration
- Different rights are compatible between different software versions of the control and different machine manufacturers.



Various applications require access to certain interfaces. Where required, the administrator also needs to set up rights to access the required interfaces as well as rights to access certain functions and additional programs. These rights are granted by the **operating system roles**.



The following contents can change in the following software versions of the control:

- HEROS role names
- Unix groups
- Basic ID number

## Operating system roles:

Role	Privileges			
	HEROS role name	UNIX group	Basic ID number	
<b>HEROS.RestrictedUser</b>	Role for a user with minimum rights on the operating system.			
	■ HEROS.MountShares	■ mnt	■ 332	
	■ HEROS.Printer	■ lp	■ 9	
<b>HEROS.NormalUser</b>	Role for a normal user with limited rights on the operating system.			
	This role grants the rights of the <b>RestrictedUser</b> role, as well as the following rights:			
	■ HEROS.SetShares	■ mntcfg	■ 331	
	■ HEROS.ControlFunctions	■ ctrlfct	■ 337	
<b>HEROS.LegacyUser</b>	With the <b>legacy user</b> role, the behavior regarding the operating system of the control is identical to that of older software versions without user administration. The user administration remains active.			
	This role grants the rights of the <b>NormalUser</b> role, as well as the following rights:			
	■ HEROS.BackupUsers	■ userbck	■ 334	
	■ HEROS.PrinterAdmin	■ lpadmin	■ 16	
	■ HEROS.SWUpdate	■ swupdate	■ 338	
	■ HEROS.SetNetwork	■ netadmin	■ 333	
	■ HEROS.SetTimezone	■ tz	■ 330	
	■ HEROS.VMSharedFolders	■ vboxsf	■ 1000	
	<b>HEROS.Admin</b>	The configuration of the network and the configuration of the user administration are some of the rights granted by this role.		
		This role grants the rights of the <b>LegacyUser</b> role, as well as the following rights:		
■ HEROS.UserAdmin		■ useradmin	■ 336	

## NC operator roles:

Role	Privileges		
	HEROS role name	UNIX group	Basic ID number
<b>NC.Operator</b>	This role allows you to run NC programs.		
	■ NC.OPModeProgramRun	■ NCOpPgmRun	■ 302
<b>NC.Programmer</b>	This role grants the rights of NC programming.		
	This role grants the rights of the <b>Operator</b> role, as well as the following rights:		
	■ NC.EditNCProgram	■ NCEdNCProg	■ 305
	■ NC.EditPalletTable	■ NCEdPal	■ 309
	■ NC.EditPresetTable	■ NCEdPreset	■ 308
	■ NC.EditToolTable	■ NCEdTool	■ 306
	■ NC.OPModeMDi	■ NCOpMDI	■ 301
	■ NC.OPModeManual	■ NCOpManual	■ 300
<b>NC.Setter</b>	This role allows you to edit the pocket table.		
	This role grants the rights of the <b>Programmer</b> role, as well as the following rights:		
	■ NC.ApproveFsAxis	■ NCApproveFsAxis	■ 319
	■ NC.EditPocketTable	■ NCEdPocket	■ 307
	■ NC.SetupDrive	■ NCSetupDrv	■ 315
	■ NC.SetupProgramRun	■ NCSetupPgRun	■ 303
<b>NC.AutoProductionSetter</b>	This role allows you to execute all NC functions, including programming a scheduled NC program start.		
	This role grants the rights of the <b>Setter</b> role, as well as the following rights:		
	■ NC.ScheduleProgramRun	■ NCSchedulePgRun	■ 304
<b>NC.LegacyUser</b>	With the <b>legacy user</b> role, the control's behavior regarding NC programming is identical to that of older software versions without user administration. The user administration remains active. The <b>LegacyUser</b> has the same rights as the <b>AutoProductionSetter</b> .		
<b>NC.AdvancedEdit</b>	This role allows you to use special functions of the NC and table editors.		
	■ <b>FN 17</b> and editing the table head		
	Replacement for code number <b>555343</b>		
	■ NC.EditNCProgramAdv	■ NCEditNCPgmAdv	■ 327
	■ NC.EditTableAdv	■ NCEditTableAdv	■ 328
<b>NC.RemoteOperator</b>	This role allows NC program start via the DNC interface.		
	■ NC.RemoteProgramRun	■ NCRemotePgmRun	■ 329

**Machine tool builder (PLC) roles:**

Role	Privileges		
	HEROS role name	UNIX group	Basic ID number
<b>PLC.ConfigureUser</b>	This role grants the rights on code number <b>123</b> .		
	■ NC.ConfigUserAdv	■ NCConfigUserAdv	■ 316
	■ NC.SetupDrive	■ NCSetupDrv	■ 315
<b>PLC.ServiceRead</b>	This role allows read-only access during servicing.		
	This role can be used to display various types of diagnostic information		
	■ NC.Data.AccessServiceRead	■ NCDAServiceRead	■ 324



Refer to your machine manual.

The machine tool builder can adapt the PLC roles.

When the **machine tool builder (PLC) roles** are adapted by the machine tool builder, the following contents may change:

- The names of the roles
- The number of roles
- The functionality of the roles

## Privileges

The table below lists all of the individual rights.

### Rights:

HEROS role name	Description
HEROS.Printer	Data output to network printers
HEROS.PrinterAdmin	Configuration of network printers
NC.OPModeManual	Operation of the machine in the <b>Manual Operation</b> and <b>Electronic handwheel operating modes</b>
NC.OPModeMDi	Working in the <b>Positioning w/ Manual Data Input</b> operating mode
NC.OPModeProgramRun	Execution of NC programs in <b>Program Run Full Sequence</b> or <b>Program run, single block</b> operating mode
NC.SetupProgramRun	Probing in the <b>Manual Operation</b> and <b>Electronic handwheel</b> operating modes
NC.ScheduleProgramRun	Program a scheduled NC program start
NC.EditNCProgram	Editing NC programs
NC.EditToolTable	Editing the tool table
NC.EditPocketTable	Edit Pocket Table
NC.EditPresetTable	Editing the preset table
NC.EditPalletTable	Editing pallet tables
NC.SetupDrive	Adjustment of drives by the end user
NC.ApproveFsAxis	Confirming test position of safe axes
NC.EditNCProgramAdv	Additional NC functions, e.g. <b>FN 17</b>
NC.EditTableAdv	Additional table programming functions, e.g. editing the table head
HEROS.SetTimezone	Adjustment of time and date, time zone, and time synchronization via NTP and HEROS menu
HEROS.SetShares	Configuration of network shares mounted by the control
HEROS.MountShares	Connecting and disconnecting network shares with the control
HEROS.SetNetwork	Configuration of network and relevant settings for data security
HEROS.BackupUsers	Data backup on the control—for all users configured on the control
HEROS.BackupMachine	Backup and restoring data of the entire machine configuration
HEROS.UserAdmin	Configuration of user administration on the control This includes creating, deleting and configuring local users
HEROS.ControlFunctions	Control function of the operating system <ul style="list-style-type: none"> <li>■ Auxiliary functions, such as starting and stopping NC software.</li> <li>■ Telemaintenance</li> <li>■ Advanced diagnostic functions, such as log data</li> </ul>
HEROS.SWUpdate	Installation of software updates for the control
HEROS.VMSharedFolders	Access to shared folders of a virtual machine Only relevant when running a programming station within a virtual machine



HEROS role name	Description
NC.RemoteProgramRun	Start of NC program via remote interface, e.g. <b>DNC</b>
NC.ConfigUserAdv	Configuration access to the contents that have been enabled through code number <b>123</b>
NC.Data.AccessServiceRead	Read-only access to the PLC partition during servicing

## DNC connection with user authentication

### Introduction

If user administration is active, DNC applications also need to authenticate a user for the correct rights to be assigned.

To do this, the connection is routed over an SSH tunnel. This method assigns the remote user to a user set up on the control, granting the remote user this user's rights.

Besides, the encryption used with the SSH tunnel protects the communication from attackers.

### Concept of transmission through an SSH tunnel

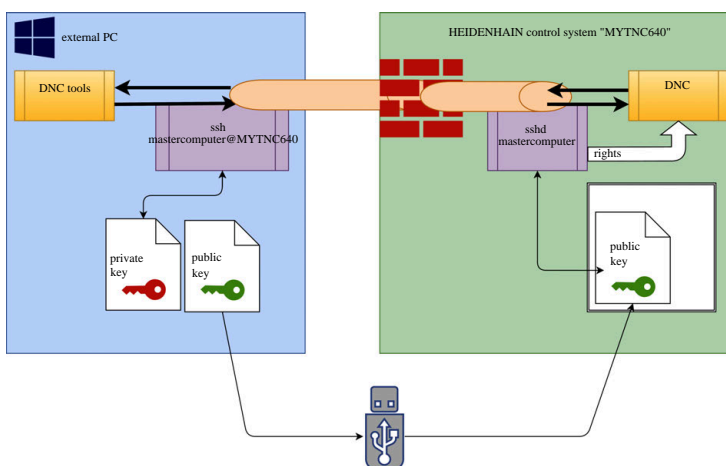
Prerequisites:

- TCP/IP network
- The remote computer acts as SSH client
- The control acts as SSH server
- Key pair consisting of
  - Private key
  - Public key

An SSH connection is always set up between an SSH client and an SSH server.

A key pair is used to protect the connection. This key pair is generated on the client. The key pair consists of a private key and a public key. The private key remains with the client. During setup, the public key is transferred to the server and assigned to a certain user.

The client tries to connect to the server using the pre-defined user name. The server can use the public key to verify that the requester of the connection holds the associated private key. If yes, the server accepts the SSH connection and assigns it to the user that has been used for the login. Communication can then be "tunneled" through this SSH connection.



**Use in DNC tools**

The PC tools available from HEIDENHAIN, such as **TNCremo** with version **v3.3** or higher, provide all functions for setting up, building up, and managing secure connections through an SSH tunnel.

When the connection is set up, the required key pair is generated in **TNCremo** and the public key is transferred to the control.

**i** Once the connection configurations created in **TNCremo** have been set up, they can be shared among all PC tools for building up a connection.

This also applies to applications that are using the HEIDENHAIN DNC component from RemoTools SDK for communication. There is no need to adapt existing customer applications.

**i** In order to expand the connection configuration using the associated **CreateConnections** tool, you need to update to **HEIDENHAIN DNC v1.7.1**. A modification of the application source code is not required.

Proceed as follows to set up a secure connection for the logged-on user:

- ▶ Select the **HEROS** menu item
- ▶ Select the **Settings** menu item
- ▶ Select the **Current User** menu item
- ▶ Press the **CERTIFICATES AND KEYS** soft key
- ▶ Select the **Allow password authentication** function
- ▶ Press the **STORE AND RESTART SERVER NOW** soft key
- ▶ Use the **TNCremo** application to set up the secure connection (TCP secure).

**i** For detailed information on how to proceed, please refer to the integrated help system of **TNCremo**.

- > The public key has been stored on the control by **TNCremo**.

**i** In order to ensure maximum security, the **Allow password authentication** function is to be deactivated after the public key has been stored.

- ▶ Deselect the **Allow password authentication** function
- ▶ Press the **STORE AND RESTART SERVER NOW** soft key
- > The control has adopted your changes.

**i** In addition to using the PC tools for setup with password authentication, you can also import the public key into the control by using a USB stick or a network drive. However, this is not described in detail in this document.

Proceed as follows to delete a key in the control so that a user can no longer use the secure DNC connection:

- ▶ Select the **HEROS** menu item
- ▶ Select the **Settings** menu item
- ▶ Select the **Current User** menu item
- ▶ Press the **CERTIFICATES AND KEYS** soft key
- ▶ Select the key to be deleted
- ▶ Press the **DELETE SSH KEY** soft key
- > The control deletes the selected key.

### Disabling insecure connections in the firewall

The DNC protocols LSV2 and RPC can be disabled in the firewall to ensure that the control's IT security is really improved through the use of SSH tunnels.

This requires that the following parties change to secure connections:

- Machine tool builders with all additional applications, e.g. pick-and-place robots



If the additional application is connected via **machine network X116**, there is no need to switch to an encrypted connection.

- End users with existing DNC connections

If you have ensured that the connections of all parties are secure, the DNC protocol can be disabled in the firewall.

Proceed as follows to disable the DNC protocol in the firewall:

- ▶ Select the **HEROS** menu item
- ▶ Select the **Settings** menu item
- ▶ Select the **Firewall** menu item
- ▶ Select the **Prohibit all** method for **LSV2**
- ▶ Press the **Apply** button
- > The control saves your changes.
- ▶ Close the window with **OK**

## Login to user administration

The login dialog appears in the following situations:

- If user administration is active, the dialog appears immediately after the control has booted
- After the **User logout** function has been executed
- After the **Switch user** function has been executed
- After the screen has been locked by the screensaver

The login dialog provides the following options:

- Users who logged in at least once
- **Other** user

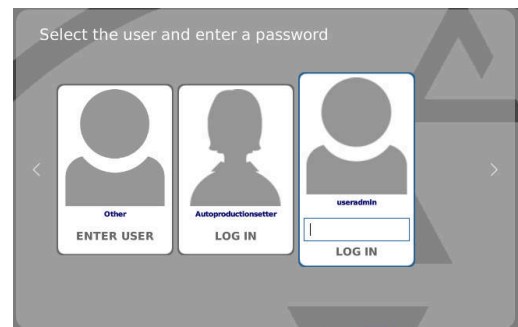
To log on as a user who is already displayed in the login dialog, proceed as follows:

- ▶ Select the respective user in the login dialog
- > The control enlarges the user icon you selected.
- ▶ Enter the user password.
- > The control uses the selected user to log you in.

To log on a user for the first time, you need to use **Other**.

To log on a user as **Other** for the first time, proceed as follows:

- ▶ Select **Other** in the login dialog
- > The control enlarges the user icon you selected.
- ▶ Enter the user name
- ▶ Enter the user's password
- > The control recognizes the user.
- > The control opens a window with the **Password expired** message. **Change the password now.**
- ▶ Enter the current password
- ▶ Enter the new password
- ▶ Repeat the new password
- > The control uses the new user to log you in.
- > The user is shown in the login dialog.



For reasons of security, passwords should comply with the following criteria:

- Eight characters minimum
- Letters, numbers and special characters
- Avoid using whole words or a sequence of characters, e.g. Anna or 123

Keep in mind that an administrator can define the requirements to be met by a password. The password requirements include:

- Minimum length
- Minimum number of different types of characters
  - Capital letters
  - Small letters
  - Numbers
  - Special characters
- Maximum length of character strings, e.g. 54321 = string of five characters
- The number of characters must match the dictionary check
- Minimum number of characters changed compared to previous password

If the new password does not meet the requirements, an error message will be issued. This means that you have to enter a different password.

## Switching or logging out users

Use the **Switch off** HEROS menu item or the icon of the same name at bottom right in the menu bar to open the **Switch off and restart** window.

The control provides the following options:

- **Switch-off:**
  - The control stops and ends all additional programs and functions
  - The system is shut down
  - The control is switched off
- **Restart:**
  - The control stops and ends all additional programs and functions
  - The system is restarted
- **Log out:**
  - The control ends all additional programs
  - The user is logged out
  - The login window appears

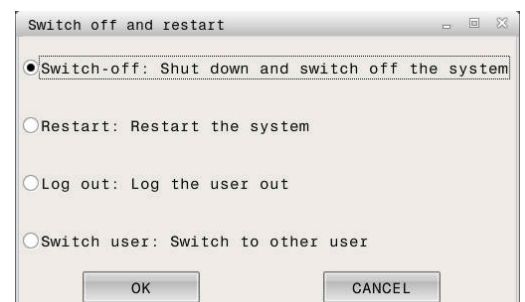


To continue, you need to log in a new user and enter his password.  
The NC program continues running under the previously logged-on user.

- **Switch user:**
  - The login window appears
  - The user is not logged out



You can close the login window with **Cancel** without entering a password.  
All additional programs and the NC programs started by the logged-on user continue running.



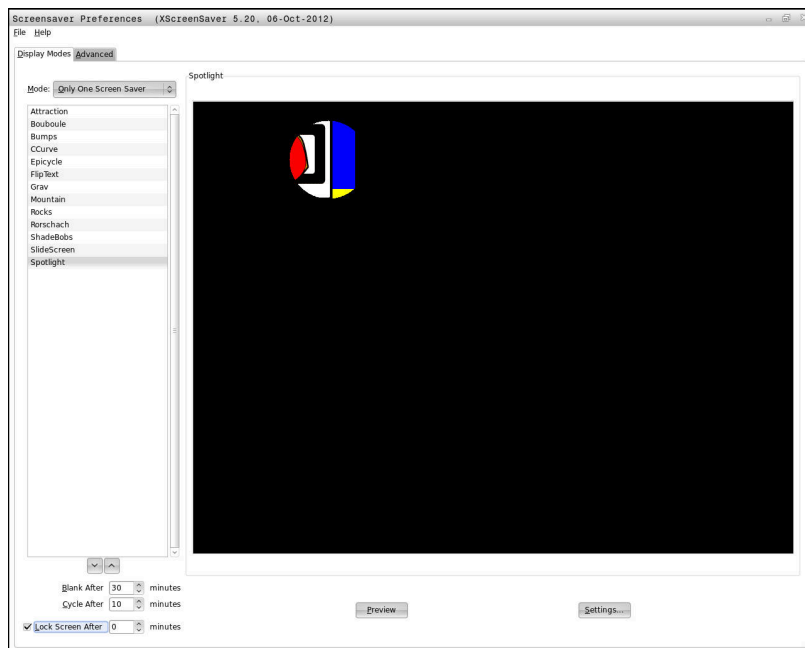
## Screensaver with lockout

You can use the screensaver to lock the control. NC programs that have already been started continue running during this period.



You need to enter a password to unlock the screensaver again.

**Further information:** "Login to user administration", Page 741



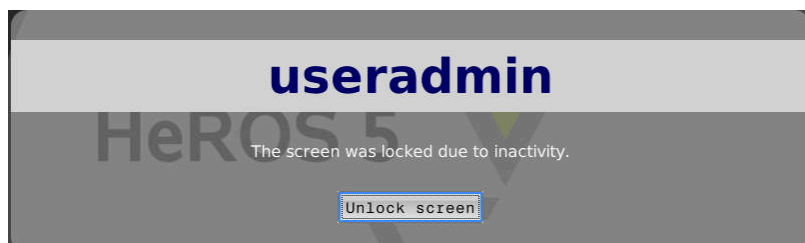
Proceed as follows to access the screensaver settings in the HEROS menu:

- ▶ Select the **HEROS** menu item
- ▶ Select the **Settings** menu item
- ▶ Select the **Screensaver** menu item

The screensaver provides the following options:

- Use the **Blank After** setting to define after how many minutes the screensaver should turn on.
- Use the **Lock Screen After** setting to activate the lock with password protection.
- The time value behind **Lock screen after** defines the delay after which the lock will take effect after the screensaver has been turned on. A value of **0** means that the lock becomes effective immediately after the screensaver has been turned on.

When the lock is active and you use one of the input devices (e.g. the mouse), the screensaver disappears and the lock screen appears.

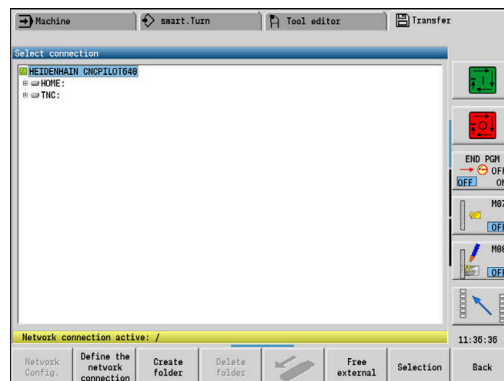


Use **Unlock screen** or **Enter** to call the login window again.

## HOME directory

When user administration is active, a private **HOME:** directory, to which you can save your private programs and files, is available to every user.

The **HOME:** directory can be viewed by the logged-on user.





## Current User

With **Current User**, you can view the group rights of the currently logged-on user in the **HEROS** menu.



In legacy mode, the **user** function user is automatically logged on to the system during control start-up. When user administration is active, the **user** function user has no effect.

**Further information:** "HEIDENHAIN function users", Page 731

Calling the **Current User**:

- ▶ Select the **HEROS** menu icon
- ▶ Select the **Settings** menu icon
- ▶ Select the **Current User** menu icon

The user administration allows you to temporarily increase the current user's rights by adding the rights of a user you selected.

Proceed as follows to temporarily increase a user's rights:

- ▶ Call **Current User**
- ▶ Press the **Add rights** soft key
- ▶ Select a user
- ▶ Enter the selected user's user name
- ▶ Enter the selected user's password
- ▶ The control temporarily increases the logged-on user's rights by adding the rights of the user entered in **Add rights**.



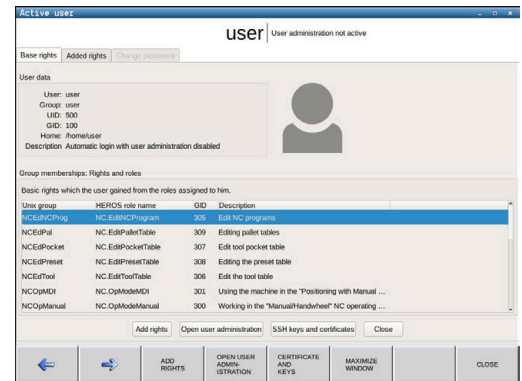
By entering code numbers or passwords that replace code numbers, you can temporarily enable rights of **oem** function users.

You have the following options to remove the rights that have temporarily been added:

- Enter the code number **0**
- User logout
- Press the **REMOVE ADDED RIGHTS** soft key

Proceed as follows to select the **REMOVE ADDED RIGHTS** soft key:

- ▶ Call **Current User**
- ▶ Select the **Added rights** tab
- ▶ Press the **REMOVE ADDED RIGHTS** soft key



### Changing the current user's password

In the **Current User** menu item, you can change your current user's password.

Proceed as follows to change your current user's password:

- ▶ Call **Current User**
- ▶ Select the **Change password** tab
- ▶ Enter the old password
- ▶ Press the **VERIFY OLD PASSWORD** soft key
- > The control checks whether you have correctly entered your old password.
- > If the password is correct, the fields **New password** and **Repeat password** are enabled.
- ▶ Enter the new password
- ▶ Repeat the new password
- ▶ Press the **SET NEW PASSWORD** soft key
- > The control compares the requirements defined for passwords by the administrator to the password you entered.

**Further information:** "Login to user administration", Page 741

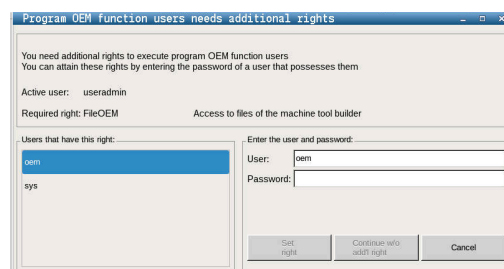
- > The message **Password was changed successfully** appears.

### Dialog for requesting additional rights

If you do not have the rights required for a specific HEROS menu item, the control opens the window for requesting additional rights:

In this window, you can temporarily obtain more rights by adding another user's rights.

In the **Users that have this right:** field, the control lists all existing users that have the right to this function.



If **Connection to Windows domain** is used, only users that were recently logged on are shown in the selection menu.

To attain the rights of users that are not shown, enter their user data. The control will then recognize those users that are contained in the user database.

### Obtaining more rights

To temporarily add another user's rights to your rights, proceed as follows:

- ▶ Select the user whose rights you need
- ▶ Enter the user's name
- ▶ Enter the user's password
- ▶ Press the **SET RIGHT** soft key
- > The control adds the entered user's rights to your rights.

**Further information:** "Current User", Page 745

## 10.10 Changing the HEROS conversational language

The HEROS conversational language is internally based on the NC conversational language. Therefore the HEROS menu and the control cannot permanently be set to two different conversational languages.

When you change the NC conversational language and restart the control, the HEROS conversational language will be adapted to the NC conversational language.



In order to change the HEROS conversational language, the **Allow NC to change HEROS config files** function must be activated in the **SELinux** menu.

**Further information:** "SELinux security software", Page 719

The following link provides information on how to change the NC conversational language:

**Further information:** "Parameter editor", Page 614

You can change the language layout of the keyboard for HEROS applications.



The language layout for the control and the HEIDENHAIN keyboard always remains in English, even after the language has been changed. Changing the language layout is therefore only reasonable for additional keyboards.

Proceed as follows to change the language layout of the keyboard for HEROS applications:

- ▶ Select the HEROS menu icon
- ▶ Select **Settings**
- ▶ Select **Language/Keyboards**
- > The control opens the **helocale** window.
- ▶ Select the **Keyboards** tab
- ▶ Select the desired keyboard layout
- ▶ Select **Apply**
- ▶ Select **OK**
- ▶ Press **Apply**
- > The changes are applied.



# 11

**Tables and  
overviews**

## 11.1 Thread

### Thread parameters

To determine the thread parameters, the control uses the following table.

Where:

- **F: Thread pitch** is calculated from the diameter, depending on the thread type, where an asterisk \* is given  
**Further information:** "Thread", Page 750
- **P: Thread depth**
- **R: Thread width**
- **A: Thread angle, left**
- **W: Thread angle, right**

Calculation formula:  $Kb = 0.26384 * F - 0.1 * \# F$

Thread backlash **ac** (depending on the **Thread pitch**):

- **Thread pitch**  $\leq 1$  : **ac** = 0.15
- **Thread pitch**  $\leq 2$  : **ac** = 0.25
- **Thread pitch**  $\leq 6$  : **ac** = 0.5
- **Thread pitch**  $\leq 13$  : **ac** = 1

Sort of thread Q		F	P	R	A	W
Q = 1 Metric ISO fine-pitch thread	External	–	$0.61343 * F$	<b>F</b>	30°	30°
	Internal	–	$0.54127 * F$	<b>F</b>	30°	30°
Q = 2 Metric ISO thread	External	*	$0.61343 * F$	<b>F</b>	30°	30°
	Internal	*	$0.54127 * F$	<b>F</b>	30°	30°
Q = 3 Metric ISO tapered thread	External	–	$0.61343 * F$	<b>F</b>	30°	30°
Q = 4 Metric ISO tapered fine-pitch thread		–	$0.61343 * F$	<b>F</b>	30°	30°
Q = 5 Metric ISO trapezoid thread	External	–	$0.5 * F + ac$	$0.633 * F$	15°	15°
	Internal	–	$0.5 * F + ac$	$0.633 * F$	15°	15°
Q = 6 Flat metric trapezoid thread	External	–	$0.3 * F + ac$	$0.527 * F$	15°	15°
	Internal	–	$0.3 * F + ac$	$0.527 * F$	15°	15°
Q = 7 Metric buttress thread	External	–	$0.86777 * F$	$0.73616 * F$	3°	30°
	Internal	–	$0.75 * F$	<b>F – Kb</b>	30°	3°
Q = 8 Cylindrical round thread	External	*	$0.5 * F$	<b>F</b>	15°	15°
	Internal	*	$0.5 * F$	<b>F</b>	15°	15°
Q = 9 Cylindrical Whitworth thread	External	*	$0.64033 * F$	<b>F</b>	27.5°	27.5°
	Internal	*	$0.64033 * F$	<b>F</b>	27.5°	27.5°
Q = 10 Tapered Whitworth thread	External	*	$0.640327 * F$	<b>F</b>	27.5°	27.5°
Q = 11 Whitworth pipe thread	External	*	$0.640327 * F$	<b>F</b>	27.5°	27.5°
	Internal	*	$0.640327 * F$	<b>F</b>	27.5°	27.5°
Q = 12 Nonstandard thread		–	–	–	–	–
Q = 13 UNC US coarse thread	External	*	$0.61343 * F$	<b>F</b>	30°	30°
	Internal	*	$0.54127 * F$	<b>F</b>	30°	30°

Sort of thread Q		F	P	R	A	W
Q = 14 UNF US fine-pitch thread	External	*	0.61343 * F	F	30°	30°
	Internal	*	0.54127 * F	F	30°	30°
Q = 15 UNEF US extra-fine-pitch thread	External	*	0.61343 * F	F	30°	30°
	Internal	*	0.54127 * F	F	30°	30°
Q = 16 NPT US taper pipe thread	External	*	0.8 * F	F	30°	30°
	Internal	*	0.8 * F	F	30°	30°
Q = 17 NPTF US taper dryseal pipe thread	External	*	0.8 * F	F	30°	30°
	Internal	*	0.8 * F	F	30°	30°
Q = 18 NPSC U.S. cylindrical pipe thread with lubricant	External	*	0.8 * F	F	30°	30°
	Internal	*	0.8 * F	F	30°	30°
Q = 19 NPFS U.S. cylindrical pipe thread without lubricant	External	*	0.8 * F	F	30°	30°
	Internal	*	0.8 * F	F	30°	30°

**Thread pitch****Q = 2****Metric ISO thread**

Diameter (in mm)	Thread pitch
1	0.25
1.1	0.25
1.2	0.25
1.4	0.3
1.6	0.35
1.8	0.35
2	0.4
2.2	0.45
2.5	0.45
3	0.5
3.5	0.6
4	0.7
4.5	0.75
5	0.8
6	1
7	1
8	1.25
9	1.25
10	1.5
11	1.5
12	1.75
14	2
16	2
18	2.5
20	2.5
22	2.5
24	3
27	3
30	3.5
33	3.5
36	4
39	4
42	4.5
45	4.5
48	5
52	5

Diameter (in mm)	Thread pitch
56	5.5
60	5.5
64	6
68	6

**Q = 8****Cylindrical round thread**

Diameter (in mm)	Thread pitch
12	2.54
14	3.175
40	4.233
105	6.35
200	6.35

**Q = 9****Cylindrical Whitworth thread**

Thread designation	Diameter (in mm)	Thread pitch
1/4"	6.35	1.27
5/16"	7.938	1.411
3/8"	9.525	1.588
7/16"	11.113	1.814
1/2"	12.7	2.117
5/8"	15.876	2.309
3/4"	19.051	2.54
7/8"	22.226	2.822
1"	25.401	3.175
1 1/8"	28.576	3.629
1 1/4"	31.751	3.629
1 3/8"	34.926	4.233
1 1/2"	38.101	4.233
1 5/8"	41.277	5.08
1 3/4"	44.452	5.08
1 7/8"	47.627	5.645
2"	50.802	5.645
2 1/4"	57.152	6.35
2 1/2"	63.502	6.35
2 3/4"	69.853	7.257



**Q = 10**  
**Tapered Whitworth thread**

Thread designation	Diameter (in mm)	Thread pitch
1/16"	7.723	0.907
1/8"	9.728	0.907
1/4"	13.157	1.337
3/8"	16.662	1.337
1/2"	20.995	1.814
3/4"	26.441	1.814
1"	33.249	2.309
1 1/4"	41.91	2.309
1 1/2"	47.803	2.309
2"	59.614	2.309
2 1/2"	75.184	2.309
3"	87.884	2.309
4"	113.03	2.309
5"	138.43	2.309
6"	163.83	2.309

**Q = 11**  
**Whitworth pipe thread**

Thread designation	Diameter (in mm)	Thread pitch
1/8"	9.728	0.907
1/4"	13.157	1.337
3/8"	16.662	1.337
1/2"	20.995	1.814
5/8"	22.911	1.814
3/4"	26.441	1.814
7/8"	30.201	1.814
1"	33.249	2.309
1 1/8"	37.897	2.309
1 1/4"	41.91	2.309
1 3/8"	44.323	2.309
1 1/2"	47.803	2.309
1 3/4"	53.746	1.814
2"	59.614	2.309
2 1/4"	65.71	2.309
2 1/2"	75.184	2.309
2 3/4"	81.534	2.309
3"	87.884	2.309
3 1/4"	93.98	2.309
3 1/2"	100.33	2.309
3 3/4"	106.68	2.309
4"	113.03	2.309
4 1/2"	125.73	2.309
5"	138.43	2.309
5 1/2"	151.13	2.309
6"	163.83	2.309

**Q = 13**  
**UNC US coarse thread**

Thread designation	Diameter (in mm)	Thread pitch
0.073"	1.8542	0.396875
0.086"	2.1844	0.453571428
0.099"	2.5146	0.529166666
0.112"	2.8448	0.635
0.125"	3.175	0.635
0.138"	3.5052	0.79375
0.164"	4.1656	0.79375
0.19"	4.826	1.058333333
0.216"	5.4864	1.058333333
1/4"	6.35	1.27
5/16"	7.9375	1.411111111
3/8"	9.525	1.5875
7/16"	11.1125	1.814285714
1/2"	12.7	1.953846154
9/16"	14.2875	2.116666667
5/8"	15.875	2.309090909
3/4"	19.05	2.54
7/8"	22.225	2.822222222
1"	25.4	3.175
1 1/8"	28.575	3.628571429
1 1/4"	31.75	3.628571429
1 3/8"	34.925	4.233333333
1 1/2"	38.1	4.233333333
1 3/4"	44.45	5.08
2"	50.8	5.644444444
2 1/4"	57.15	5.644444444
2 1/2"	63.5	6.35
2 3/4"	69.85	6.35
3"	76.2	6.35
3 1/4"	82.55	6.35
3 1/2"	88.9	6.35
3 3/4"	95.25	6.35
4"	101.6	6.35

**Q = 14**  
**UNF US fine-pitch thread**

Thread designation	Diameter (in mm)	Thread pitch
0.06"	1.524	0.3175
0.073"	1.8542	0.352777777
0.086"	2.1844	0.396875
0.099"	2.5146	0.453571428
0.112"	2.8448	0.529166666
0.125"	3.175	0.577272727
0.138"	3.5052	0.635
0.164"	4.1656	0.705555555
0.19"	4.826	0.79375
0.216"	5.4864	0.907142857
1/4"	6.35	0.907142857
5/16"	7.9375	1.058333333
3/8"	9.525	1.058333333
7/16"	11.1125	1.27
1/2"	12.7	1.27
9/16"	14.2875	1.411111111
5/8"	15.875	1.411111111
3/4"	19.05	1.5875
7/8"	22.225	1.814285714
1"	25.4	1.814285714
1 1/8"	28.575	2.116666667
1 1/4"	31.75	2.116666667
1 3/8"	34.925	2.116666667
1 1/2"	38.1	2.116666667

**Q = 15**  
**UNEF US extra-fine-pitch thread**

Thread designation	Diameter (in mm)	Thread pitch
0.216"	5.4864	0.79375
1/4"	6.35	0.79375
5/16"	7.9375	0.79375
3/8"	9.525	0.79375
7/16"	11.1125	0.907142857
1/2"	12.7	0.907142857
9/16"	14.2875	1.058333333
5/8"	15.875	1.058333333
11/16"	17.4625	1.058333333
3/4"	19.05	1.27
13/16"	20.6375	1.27
7/8"	22.225	1.27
15/16"	23.8125	1.27
1"	25.4	1.27
1 1/16"	26.9875	1.411111111
1 1/8"	28.575	1.411111111
1 3/16"	30.1625	1.411111111
1 1/4"	31.75	1.411111111
1 5/16"	33.3375	1.411111111
1 3/8"	34.925	1.411111111
1 7/16"	36.5125	1.411111111
1 1/2"	38.1	1.411111111
1 9/16"	39.6875	1.411111111
1 5/8"	41.275	1.411111111
1 11/16"	42.8625	1.411111111
1 3/4"	44.45	1.5875
2"	50.8	1.5875

**Q = 16**  
**NPT US taper pipe thread**

Thread designation	Diameter (in mm)	Thread pitch
1/16"	7.938	0.94074074
1/8"	10.287	0.94074074
1/4"	13.716	1.411111111
3/8"	17.145	1.411111111
1/2"	21.336	1.814285714
3/4"	26.67	1.814285714
1"	33.401	2.208695652
1 1/4"	42.164	2.208695652
1 1/2"	48.26	2.208695652
2"	60.325	2.208695652
2 1/2"	73.025	3.175
3"	88.9	3.175
3 1/2"	101.6	3.175
4"	114.3	3.175
5"	141.3	3.175
6"	168.275	3.175
8"	219.075	3.175
10"	273.05	3.175
12"	323.85	3.175
14"	355.6	3.175
16"	406.4	3.175
18"	457.2	3.175
20"	508	3.175
24"	609.6	3.175

**Q = 17**  
**NPTF US taper dryseal pipe thread**

Thread designation	Diameter (in mm)	Thread pitch
1/16"	7.938	0.94074074
1/8"	10.287	0.94074074
1/4"	13.716	1.411111111
3/8"	17.145	1.411111111
1/2"	21.336	1.814285714
3/4"	26.67	1.814285714
1"	33.401	2.208695652
1 1/4"	42.164	2.208695652
1 1/2"	48.26	2.208695652
2"	60.325	2.208695652
2 1/2"	73.025	3.175
3"	88.9	3.175

**Q = 18**  
**NPSC U.S. cylindrical pipe thread with lubricant**

Thread designation	Diameter (in mm)	Thread pitch
1/8"	10.287	0.94074074
1/4"	13.716	1.411111111
3/8"	17.145	1.411111111
1/2"	21.336	1.814285714
3/4"	26.67	1.814285714
1"	33.401	2.208695652
1 1/4"	42.164	2.208695652
1 1/2"	48.26	2.208695652
2"	60.325	2.208695652
2 1/2"	73.025	3.175
3"	88.9	3.175
3 1/2"	101.6	3.175
4"	114.3	3.175

**Q = 19**  
**NPFS U.S. cylindrical pipe thread without lubricant**

Thread designation	Diameter (in mm)	Thread pitch
1/16"	7.938	0.94074074
1/8"	10.287	0.94074074
1/4"	13.716	1.411111111
3/8"	17.145	1.411111111
1/2"	21.336	1.814285714
3/4"	26.67	1.814285714
1"	33.401	2.208695652

## 11.2 Undercut parameters

### DIN 76 – undercut parameters

The control determines the parameters for the thread undercut (**Undercut DIN 76**) from the thread pitch. The undercut parameters are in accordance with DIN 13 for metric threads.

#### External thread

Thread pitch	I	K	R	W
0.2	0.3	0.7	0.1	30°
0.25	0.4	0.9	0.12	30°
0.3	0.5	1.05	0.16	30°
0.35	0.6	1.2	0.16	30°
0.4	0.7	1.4	0.2	30°
0.45	0.7	1.6	0.2	30°
0.5	0.8	1.75	0.2	30°
0.6	1	2.1	0.4	30°
0.7	1.1	2.45	0.4	30°
0.75	1.2	2.6	0.4	30°
0.8	1.3	2.8	0.4	30°
1	1.6	3.5	0.6	30°
1.25	2	4.4	0.6	30°
1.5	2.3	5.2	0.8	30°
1.75	2.6	6.1	1	30°
2	3	7	1	30°
2.5	3.6	8.7	1.2	30°
3	4.4	10.5	1.6	30°
3.5	5	12	1.6	30°
4	5.7	14	2	30°
4.5	6.4	16	2	30°
5	7	17.5	2.5	30°
5.5	7.7	19	3.2	30°
6	8.3	21	3.2	30°

#### Internal thread

Thread pitch	I	K	R	W
0.2	0.1	1.2	0.1	30°
0.25	0.1	1.4	0.12	30°
0.3	0.1	1.6	0.16	30°
0.35	0.2	1.9	0.16	30°
0.4	0.2	2.2	0.2	30°
0.45	0.2	2.4	0.2	30°
0.5	0.3	2.7	0.2	30°
0.6	0.3	3.3	0.4	30°
0.7	0.3	3.8	0.4	30°
0.75	0.3	4	0.4	30°
0.8	0.3	4.2	0.4	30°
1	0.5	5.2	0.6	30°
1.25	0.5	6.7	0.6	30°
1.5	0.5	7.8	0.8	30°
1.75	0.5	9.1	1	30°
2	0.5	10.3	1	30°
2.5	0.5	13	1.2	30°
3	0.5	15.2	1.6	30°
3.5	0.5	17.7	1.6	30°
4	0.5	20	2	30°
4.5	0.5	23	2	30°
5	0.5	26	2.5	30°
5.5	0.5	28	3.2	30°
6	0.5	30	3.2	30°

For internal threads, the control calculates the depth of the thread undercut according to the following formula:

$$\text{Undercut depth} = (N + I - K) / 2$$

Where:

- **I: Undercut depth**
- **K: Undercut width**
- **R: Undercut radius**
- **W: Undercut angle**
- **N: Nominal diameter of the thread**
- **I: From the table**
- **K: Core diameter of the thread**

### DIN 509 E – undercut parameters

Diameter	I	K	R	W
≤ 1.6	0.1	0.5	0.1	15°
> 1.6 – 3	0.1	1	0.2	15°
> 3 – 10	0.2	2	0.2	15°
> 10 – 18	0.2	2	0.6	15°
> 18 – 80	0.3	2.5	0.6	15°
> 80	0.4	4	1	15°

The undercut parameters are determined from the cylinder diameter.

Where:

- **I: Undercut depth**
- **K: Undercut width**
- **R: Undercut radius**
- **W: Undercut angle**

### DIN 509 F – undercut parameters

Diameter	I	K	R	W	P	A
≤ 1.6	0.1	0.5	0.1	15°	0.1	8°
> 1.6 – 3	0.1	1	0.2	15°	0.1	8°
> 3 – 10	0.2	2	0.2	15°	0.1	8°
> 10 – 18	0.2	2	0.6	15°	0.1	8°
> 18 – 80	0.3	2.5	0.6	15°	0.2	8°
> 80	0.4	4	1	15°	0.3	8°

The undercut parameters are determined from the cylinder diameter.

Where:

- **I: Undercut depth**
- **K: Undercut width**
- **R: Undercut radius**
- **W: Undercut angle**
- **P: Trav.dpth**
- **A: Trav.angle**

## 11.3 Technical information

### Specifications

Components	<ul style="list-style-type: none"> <li>■ MC 7410T main computer with</li> <li>■ CC 61xx controller unit</li> <li>■ 12.1-inch TFT color flat-panel display with soft keys</li> <li>■ 15.6-inch TFT color flat-panel display with touchscreen</li> </ul>
Operating system	<ul style="list-style-type: none"> <li>■ HEROS real-time operating system for machine control</li> </ul>
Memory	<ul style="list-style-type: none"> <li>■ 1.8 GB (on CFR compact flash memory card) for NC programs</li> </ul>
Input resolution	<ul style="list-style-type: none"> <li>■ X axis: 0.5 <math>\mu\text{m}</math>, diameter: 1 <math>\mu\text{m}</math></li> <li>■ Z and Y axes: 1 <math>\mu\text{m}</math></li> <li>■ U, V and W axes: 1 <math>\mu\text{m}</math></li> <li>■ C axis: 0.001°</li> <li>■ B axis: 0.0001°</li> </ul>
Display step	<p>Configurable for each axis</p> <ul style="list-style-type: none"> <li>■ Linear axes: to 0.1 <math>\mu\text{m}</math></li> <li>■ C and B axes: up to 0.00001°</li> </ul>
Interpolation	<ul style="list-style-type: none"> <li>■ Straight line: In 2 principal axes, optional in 3 principal axes (max. <math>\pm 100</math> m)</li> <li>■ Circle: In 2 axes (radius max. 999 m), optional additional linear interpolation in the third axis</li> <li>■ C axis: Interpolation in the linear axes X and Z with the C axis</li> </ul>
Feed rate	<ul style="list-style-type: none"> <li>■ mm/min or mm/rev</li> <li>■ Constant surface speed</li> <li>■ Max. feed rate (60 000/pole pairs <math>\times</math> ball screw pitch) at fPWM = 5000 Hz</li> </ul>
Spindle	<ul style="list-style-type: none"> <li>■ max. 60 000 rpm (with 2 pole pairs)</li> </ul>
Axis feedback control	<ul style="list-style-type: none"> <li>■ Integrated digital drive control for synchronous and asynchronous motors</li> <li>■ Position loop resolution: Signal period of the position encoder/1024</li> <li>■ Position control clock pulse: 0.2 ms</li> <li>■ Speed control clock pulse: 0.2 ms</li> <li>■ Current control: 0.1 ms</li> </ul>
Error compensation	<ul style="list-style-type: none"> <li>■ Linear and nonlinear axis error, backlash, reversal peaks during circular movements</li> <li>■ Static friction</li> </ul>
Data interfaces	<ul style="list-style-type: none"> <li>■ 1000 BaseT Gigabit Ethernet interface</li> <li>■ 4x USB 3.0 on the rear, 1x USB 2.0 on the front</li> </ul>
Diagnostics	<ul style="list-style-type: none"> <li>■ Fast and simple troubleshooting through integrated diagnostic aids</li> </ul>
Ambient temperature	<ul style="list-style-type: none"> <li>■ Operation: 5 °C to 40 °C</li> <li>■ Storage: -20 °C to +60 °C</li> </ul>

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**User functions**


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Configuration	<ul style="list-style-type: none"> <li>■ Basic version: X and Z axis, spindle</li> <li>■ Y axis (optional)</li> <li>■ Driven tool (optional)</li> <li>■ C axis (optional)</li> <li>■ B axis (optional)</li> <li>■ Digital current and speed control</li> <li>■ Rear-face machining with the counter spindle (optional)</li> </ul>
<b>Machine</b> operating mode	<ul style="list-style-type: none"> <li>■ Manual slide movement through manual direction keys or electronic handwheel</li> <li>■ Graphic support for entering and running Teach-in cycles without saving the machining steps in alternation with manual machine operation</li> <li>■ Thread reworking (thread repair) in a second workpiece setup (optional)</li> </ul>
<b>Teach-in</b> submode	<ul style="list-style-type: none"> <li>■ Sequential linking of Teach-in cycles, where each machining cycle is run immediately after input, or is graphically simulated and subsequently saved.</li> </ul>
<b>Program run</b> submode	<p>All are possible in Single-Block and Full-Sequence modes:</p> <ul style="list-style-type: none"> <li>■ DINplus programs</li> <li>■ smart.Turn programs (optional)</li> <li>■ Teach-in programs (optional)</li> </ul>
Setup functions	<ul style="list-style-type: none"> <li>■ Setting the workpiece datum</li> <li>■ Defining the tool change point</li> <li>■ Defining the protection zone</li> <li>■ Measurement of the tool by touch-off, touch probe, or optical gauge</li> </ul> <hr/>



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**User functions**


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Programming – teach-in (optional)	<ul style="list-style-type: none"> <li>■ Turning cycles for simple and complex contours, and contours described with ICP</li> <li>■ Contour-parallel turning cycles</li> <li>■ Recessing cycles for simple or complex contours, as well as contours defined with ICP</li> <li>■ Repetitions with recessing cycles</li> <li>■ Recess turning cycles for simple and complex contours, and contours described with ICP</li> <li>■ Undercut and parting cycles (optional)</li> <li>■ Engraving cycles</li> <li>■ Threading cycles for single or multi-start longitudinal, taper or API threads</li> <li>■ Cycles for axial and radial drilling, deep drilling, and tapping operations with the C axis</li> <li>■ Thread milling with the C axis</li> <li>■ Axial and radial milling cycles for slots, figures, single and centric polygon surfaces, and for complex contours described with ICP for machining with the C axis</li> <li>■ Helical slot milling with the C axis</li> <li>■ Linear and circular patterns for drilling and milling operations with the C axis</li> <li>■ Context-sensitive help graphics</li> <li>■ Transfer of cutting values from technology database</li> <li>■ Use of DIN macros in the Teach-in program</li> <li>■ Conversion of Teach-in programs to smart.Turn programs</li> </ul>
Interactive Contour Programming (ICP) (optional)	<ul style="list-style-type: none"> <li>■ Contour definition with linear and circular contour elements</li> <li>■ Immediate display of entered contour elements</li> <li>■ Calculation of missing coordinates, points of intersection, etc.</li> <li>■ Graphic display of all solutions for selection by the user if more than one solution is possible</li> <li>■ Chamfers, rounding arcs, and undercuts available as form elements</li> <li>■ Input of form elements immediately during contour creation or by superimposition later</li> <li>■ Changes to existing contours can be programmed</li> <li>■ Programming of the rear face for full-surface machining with the C and Y axes</li> </ul>
C-axis machining on face and lateral surface	<ul style="list-style-type: none"> <li>■ Description of individual holes and hole patterns</li> <li>■ Description of figures and figure patterns for milling operations</li> <li>■ Creation of freely definable milling contours</li> </ul>
Y-axis machining in the XY and ZY planes	<ul style="list-style-type: none"> <li>■ Description of individual holes and hole patterns</li> <li>■ Description of figures and figure patterns for milling operations</li> <li>■ Creation of freely definable milling contours</li> </ul>
B-axis machining (optional)	<ul style="list-style-type: none"> <li>■ Machining with the B axis</li> <li>■ Tilting the working plane, rotating the machining position of the tool</li> </ul>
DXF import	<ul style="list-style-type: none"> <li>■ Importing contours for turning</li> <li>■ Importing contours for milling</li> </ul>

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## User functions

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smart.Turn programming (optional)	<ul style="list-style-type: none"> <li>■ The basis is the "unit," which is the complete description of a machining block (geometry, technology and cycle data)</li> <li>■ Dialog boxes divided into overview and detail forms</li> <li>■ Fast navigation between the fillable forms and input groups via the smart.Turn keys</li> <li>■ Context-sensitive help graphics</li> <li>■ Start unit with global settings</li> <li>■ Transfer of global values from the start unit</li> <li>■ Transfer of cutting values from technology database</li> <li>■ Units for all lathe and recessing operations</li> <li>■ Use of the contours described with ICP for turning and recess turning operations</li> <li>■ Units for all milling and drilling operations with the C axis</li> <li>■ Use of the patterns and contours described with ICP for C-axis operations</li> <li>■ Units for activating and deactivating the C axis</li> <li>■ Units for all milling and drilling operations with the Y axis</li> <li>■ Use of the patterns and contours described with ICP for Y-axis operations</li> <li>■ Special units for subprograms and program part repeats</li> <li>■ Verification graphics for blank and finished part and for C and Y axis contours</li> <li>■ Turret assignment, magazine assignment and other setup information in the smart.Turn program</li> <li>■ Parallel programming</li> <li>■ Parallel simulation</li> </ul>
DINplus programming	<ul style="list-style-type: none"> <li>■ Programming in DIN 66025 format</li> <li>■ Extended command format (<b>IF... THEN ... ELSE...</b>)</li> <li>■ Simplified geometry programming (calculation of missing data)</li> <li>■ Powerful fixed cycles for turning, recessing, recess turning and thread machining</li> <li>■ Powerful fixed cycles for drilling and milling with the C axis (optional)</li> <li>■ Powerful fixed cycles for drilling and milling with the Y axis (optional)</li> <li>■ Subprograms</li> <li>■ Programming with variables</li> <li>■ Contour description with ICP (optional)</li> <li>■ Program verification graphics for workpiece blank and finished part</li> <li>■ Turret assignment, magazine assignment and other setup information in the DINplus program</li> <li>■ Conversion of smart.Turn units into DINplus command sequences (optional)</li> <li>■ Parallel programming</li> <li>■ Parallel simulation</li> </ul>

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**User functions**


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Test graphics	<ul style="list-style-type: none"> <li>■ Graphic simulation of Teach-in cycle sequence, Teach-in, smart.Turn or DINplus program</li> <li>■ Display of the tool paths as pencil-trace or cutting-path graphics, special identification of the rapid traverse paths</li> <li>■ Motion simulation (2-D material-removal graphic)</li> <li>■ Display of programmed contours</li> <li>■ Side or face view, or 2-D view of cylindrical surface for verification of C-axis machining</li> <li>■ View of face (XY plane) and YZ plane for verification of Y-axis machining</li> <li>■ Shifting and magnifying functions</li> <li>■ 3-D graphics for display of workpiece blank and finished part as solid-model view</li> </ul>
Machining time analysis	<ul style="list-style-type: none"> <li>■ Calculation of machining times and idle times</li> <li>■ Consideration of switching commands triggered by the CNC</li> <li>■ Representation of time per individual cycle or per tool change</li> </ul>
TURN PLUS	<ul style="list-style-type: none"> <li>■ Automatic generation of smart.Turn programs</li> <li>■ Automatic cutting limitation through the definition of chucking equipment</li> <li>■ Automatic tool selection and turret assignment/magazine assignment</li> </ul>
Tool database	<ul style="list-style-type: none"> <li>■ For 250 tools</li> <li>■ For 999 tools (optional)</li> <li>■ Tool description can be entered for every tool</li> <li>■ Automatic inspection of tool-tip position with respect to the contour</li> <li>■ Compensation of tool-tip position in the X/Y/Z plane</li> <li>■ High-precision correction via handwheel, capturing compensation values in the tool table</li> <li>■ Automatic tool-tip and cutter radius compensation</li> <li>■ Tool monitoring for lifetime of the insert (tool tip) or the number of workpieces produced</li> <li>■ Tool monitoring with automatic tool change after tool insert wear (optional)</li> <li>■ Management of multipoint tools (multiple inserts or reference points)</li> </ul>
Technology database (optional)	<ul style="list-style-type: none"> <li>■ Access to cutting data after definition of workpiece material, cutting material and machining mode. The control distinguishes between 16 machining modes. Each workpiece-material/tool-material combination includes the cutting speed, the main and secondary feed rates, and the infeed for 16 machining modes.</li> <li>■ Automatic determination of the machining modes from the cycle or the machining unit</li> <li>■ The cutting data are entered in the cycle or in the unit as default values.</li> <li>■ 9 workpiece-material/tool-material combinations (144 entries)</li> <li>■ 62 workpiece-material/tool-material combinations (992 entries) (optional)</li> </ul>

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## User functions

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Conversational languages	<ul style="list-style-type: none"> <li>■ ENGLISH</li> <li>■ GERMAN</li> <li>■ CZECH</li> <li>■ FRENCH</li> <li>■ ITALIAN</li> <li>■ SPANISH</li> <li>■ PORTUGUESE</li> <li>■ SWEDISH</li> <li>■ DANISH</li> <li>■ FINNISH</li> <li>■ DUTCH</li> <li>■ POLISH</li> <li>■ HUNGARIAN</li> <li>■ RUSSIAN</li> <li>■ CHINESE</li> <li>■ CHINESE_TRAD</li> <li>■ SLOVENIAN</li> <li>■ KOREAN</li> <li>■ NORWEGIAN</li> <li>■ ROMANIAN</li> <li>■ SLOVAK</li> <li>■ TURKISH</li> </ul>
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## Accessories

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Electronic handwheels	<ul style="list-style-type: none"> <li>■ HR 180 panel-mounted handwheel with connection to position encoder inputs, plus</li> <li>■ One HR 130 serial panel-mounted handwheel or an HR 410 portable serial handwheel</li> <li>■ HR 550FS wireless handwheel with display</li> <li>■ HR 520 handwheel with display</li> </ul>
Touch probe	<ul style="list-style-type: none"> <li>■ TS 120: workpiece touch probe with cable connection</li> <li>■ TS 220: workpiece touch probe with cable connection</li> <li>■ TS 440: workpiece touch trigger probe with infrared transmission</li> <li>■ TS 444: battery-free workpiece touch trigger probe with infrared transmission</li> <li>■ TS 640: workpiece touch trigger probe with infrared transmission</li> <li>■ TS 740: High-precision workpiece touch probe with infrared transmission</li> <li>■ TS 460: workpiece touch probe with radio and infrared transmission</li> <li>■ TT 140: touch trigger probe for tool measurement with cable connection</li> <li>■ TT 449: touch trigger probe for tool measurement with infrared transmission</li> </ul>



For measuring workpieces to be machined using the MANUALplus620 control, HEIDENHAIN recommends the TS 460 workpiece touch probe.

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**Accessories**

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DataPilot CP 640, MP 620

Control software for PCs for programming, archiving, and training for the MANUALplus620 control:

- Full version with license for single station or multiple stations
- Demo version (free of charge)

## Software options

Option-number	Option	ID	Description
0 to 7	<b>Additional axis</b>	<ul style="list-style-type: none"> <li>■ 354540-01</li> <li>■ 353904-01</li> <li>■ 353905-01</li> <li>■ 367867-01</li> <li>■ 367868-01</li> <li>■ 370291-01</li> <li>■ 353292-01</li> <li>■ 353293-01</li> </ul>	Additional control loops
8	<b>Software option 1</b>	632226-01	Cycle programming <ul style="list-style-type: none"> <li>■ Contour description with ICP</li> <li>■ Cycle programming</li> <li>■ Technology database with 9 workpiece-material/tool-material combinations</li> </ul>
9	<b>Software option 2</b>	632227-01	smart.Turn <ul style="list-style-type: none"> <li>■ Contour description with ICP</li> <li>■ Programming with smart.Turn</li> <li>■ Technology database with 9 workpiece-material/tool-material combinations</li> </ul>
10	<b>Software option 3</b>	632228-01	Tools and technology <ul style="list-style-type: none"> <li>■ Tool database expanded to 999 entries</li> <li>■ Technology database expanded to 62 workpiece-material/tool-material combinations</li> <li>■ Tool life monitoring with exchange tools</li> </ul>
11	<b>Software option 4</b>	632229-01	Thread <ul style="list-style-type: none"> <li>■ Thread recutting</li> <li>■ Handwheel superimposition during thread cutting</li> </ul>
17	<b>Touch probe functions</b>	632230-01	Tool measurement and workpiece measurement <ul style="list-style-type: none"> <li>■ Determining tool-setting dimensions with a touch probe</li> <li>■ Determining tool-setting dimensions with an optical gauge</li> <li>■ Automatically measuring workpieces</li> </ul>
18	<b>HEIDENHAIN DNC</b>	526451-01	Communication with external PC applications over COM component
42	<b>DXF import</b>	632231-01	DXF import <ul style="list-style-type: none"> <li>■ Loading of DXF contours</li> </ul>
54	<b>B-axis machining</b>	825742-01	Machining with the B axis <ul style="list-style-type: none"> <li>■ Rotating the machining position of the tool</li> </ul>
55	<b>C-axis machining</b>	633944-01	C-axis machining
63	<b>TURN PLUS</b>	825743-01	Automatic generation of smart.Turn programs
70	<b>Y-axis machining</b>	661881-01	Y-axis machining
77	<b>4 additional axes</b>	634613-01	4 additional control loops

<b>Option-number</b>	<b>Option</b>	<b>ID</b>	<b>Description</b>
78	<b>8 additional axes</b>	634614-01	8 additional control loops
94	<b>Parallel axes</b>	661881-01	Support of parallel axes (U, V, W)
101 to 130	<b>OEM option</b>	579651-01 to 579651-30	Options of the machine tool builder
131	<b>Spindle synchronism</b>	806270-01	Synchronization (of two or more spindles)
132	<b>Opposing spindle</b>	806275-01	Counter spindle (spindle synchronism, rear-face machining)
133	<b>Remote Desktop Manager</b>	894423-01	Display and operation of external computer units (e.g. a Windows PC)
135	<b>Synchronizing functions</b>	1085731-01	Expanded synchronization of axes and spindles
137	<b>State Reporting Interface</b>	1232242-01	Provision of operating states
143	<b>Load Adaptive Control (LAC)</b>	800545-01	LAC: Dynamic adaptation of the control parameters
151	<b>Load monitoring</b>	1111843-01	Monitoring of the tool load

## 11.4 Compatibility in DIN programs

The format of DIN programs of the CNC PILOT 4290 predecessor control differs from the format of the MANUALplus 620. However, you can use the program converter to adapt programs of the predecessor control to the new control.

When opening an NC program, the control recognizes the programs of the predecessor control. The program concerned will be converted after a confirmation prompt. **CONV\_...** will be prefixed to the program name. The program converter is also part of **Transfer** submodule (**Organization** mode of operation).

When converting DIN programs, it is also important to keep in mind that the predecessor controls use different solutions for tool management, parameter management, programming with variables and PLC programming.

Remember the following when converting DIN programs of the CNC PILOT 4290:

Tool call (**T** commands of the **TURRET** section):

- **T** commands containing a reference to the tool database are left unchanged (example: **T1 ID"342-300.1"**)
- **T** commands containing tool data cannot be converted

Variable programming:

- **D** variables (# variables) are replaced by # variables of the new syntax. Depending on the range of numbers, **#c** or **#l** or **#n** oder **#i** variables will be used.
- Special conversion rules: **#0** is converted to **#c30**, **#30** is converted to **#c51**
- **V** variables are replaced by **#g** variables. Braces used in assignments are removed. Braces used in expressions are changed to parentheses.
- Variable accesses to tool data, machine dimensions, **D** compensation values, parameter data and events cannot be converted. These program sequences have to be adapted. Exception: The **Start blk search active E90[1]** event is converted to **#i6**
- Remember that – unlike the CNC PILOT 4290 – the interpreter of the control re-evaluates the lines every time the program is executed.



M functions:

- **M30** with **NS..** is converted to **M0 M99 NS**
- **M97** is removed for single-channel controls
- All other **M** functions are left unchanged

G functions:

- Currently, the control does not support the following **G** functions: **G98, G204, G710, G906, G907, G915, G918, G975**
- The following **G** functions are not supported by single-channel controls: **G62, G63, G162**
- A warning will be issued if the following **G** functions are used in a contour description: **G10, G38, G39, G52, G95, G149**. These functions are now modal
- Warnings may occur for the thread functions **G31, G32, G33**; it is recommended to test these functions
- The **Contour mirroring/shifting G121** function is converted to **G99** but the principle of function is compatible
- A warning will be issued for **G48** because the principle of function has changed.
- A warning will be issued for **G916, G917** and **G930** because the principle of function has changed. Functions must be supported by the PLC

Names of external subprograms:

- When an external subprogram is called, the converter prefixes **CONV\_...** to the name

Multichannel programs on single-channel controls:

- On single-channel controls, programs for two slides are converted to a single slide and the Z-axis movements of the second slide are converted to **G1 W...** or **G701 W...**
  - In the program head, **#SLIDE \$1\$2** is replaced by **#SLIDE \$1**
  - \$ statements preceding the block number are removed
  - **\$2 G1 Z...** is converted to **G1 W...** and **G701 Z...** to **G701 W...**
  - The word **SLIDE ALLOCATION** is removed (but remembered internally for converting the subsequent blocks)
  - Synchronization statements **\$1\$2 M97** are removed
  - Datum shifts for slide 2 are saved as comments; paths of traverse are provided with a warning.

Nonconvertible elements:

- If the DIN program contains nonconvertible elements, the corresponding NC block is saved as a comment. The word **Warning** is inserted in front of this comment. Depending on the situation, the nonconvertible command is taken into the comment line, or the nonconvertible NC block follows the comment.

### **NOTICE**

#### **Danger of collision!**

Converted NC programs may have incorrectly converted contents (machine-dependent) or nonconvertible contents. Danger of collision during machining!

- ▶ Adapt converted NC programs to the current control
- ▶ Test the NC program in **Simulation** submode, using the graphic displayed there.

## 11.5 Syntax elements provided by the control

Meaning of the symbols used in the table:

- ✓ Compatible behavior; if necessary, the program converter converts the functions so that they are compatible with the control.
- X Behavior changed; the program has to be tested in the individual case
- Function is not available or is replaced by different functionality
- ★ This function is available for controls with multichannel capability.
- ◆ This function is planned for future software versions and will initially be required for controls with multichannel capability only

### Section codes

Program head	<b>PROGRAM HEAD</b>	✓
	<b>PLATE MAGAZINE</b>	✓
	<b>TURRET</b>	✓
	<b>MAGAZINE</b>	✓
	<b>CHUCKING EQUIPMENT</b>	X
Contour definition	<b>CONTOUR / Contour group</b>	X
	<b>BLANK</b>	✓
	<b>FINISHED PART</b>	✓
	<b>TEMPORARY</b>	✓
C-axis contours	<b>FRONT</b>	✓
	<b>REAR SIDE</b>	✓
	<b>LATERAL</b>	✓
Workpiece machining	<b>MACHINING</b>	✓
	<b>SLIDE ALLOCATION</b>	★
	<b>END</b>	✓
Subprograms	<b>SUBROUTINE</b>	✓
	<b>Return</b>	✓
Others	<b>CONST</b>	✓
Y-axis contours	<b>FRONT_Y</b>	✓
	<b>REAR SIDE_Y</b>	✓
	<b>LATERAL_Y</b>	✓

**G commands for turning contours**

Workpiece-blank definition	<b>G20-Geo</b> Chuck part, cylinder/tube	✓
	<b>G21-Geo</b> Cast part	✓
Basic contour elements	<b>G0-Geo</b> Starting point of contour	✓
	<b>G1-Geo</b> Line segment	✓
	<b>G2-Geo</b> Circular arc with incremental center dimensioning	✓
	<b>G3-Geo</b> Circular arc with incremental center dimensioning	✓
	<b>G12-Geo</b> Circular arc with absolute center dimensioning	✓
	<b>G13-Geo</b> Circular arc with absolute center dimensioning	✓
	Contour form elements	<b>G22-Geo</b> Recess (standard)
<b>G23-Geo</b> Recess/relief turn		✓
<b>G24-Geo</b> Thread with undercut		✓
<b>G25-Geo</b> Undercut contour		✓
<b>G34-Geo</b> Thread (standard)		✓
<b>G37-Geo</b> Thread (general)		✓
<b>G49-Geo</b> Bore hole at turning center		✓
Help commands for contour definition	<b>G7-Geo</b> Precision stop on	✓
	<b>G8-Geo</b> Precision stop off	✓
	<b>G9-Geo</b> Precision stop blockwise	✓
	<b>G10-Geo</b> Peak-to-valley height	X
	<b>G38-Geo</b> Feed rate reduction	X
	<b>G39-Geo</b> Attributes for superimposed elements	–
	<b>G52-Geo</b> Blockwise oversize	X
	<b>G95-Geo</b> Feed per revolution	X
	<b>G149-Geo</b> Additive compensation	X

**G commands for C-axis contours**

Overlapping contours	<b>G308-Geo</b> Start of pocket/island	✓
	<b>G309-Geo</b> End of pocket/island	✓
Front and rear face contours	<b>G100-Geo</b> Starting point of face contour	✓
	<b>G101-Geo</b> Line segment on front face	✓
	<b>G102-Geo</b> Circular arc on front face	✓
	<b>G103-Geo</b> Circular arc on front face	✓
	<b>G300-Geo</b> Bore hole on front face	✓
	<b>G301-Geo</b> Linear slot on front face	✓
	<b>G302-Geo</b> Circular slot on front face	✓
	<b>G303-Geo</b> Circular slot on front face	✓
	<b>G304-Geo</b> Full circle on front face	✓
	<b>G305-Geo</b> Rectangle on front face	✓
	<b>G307-Geo</b> Eccentric polygon on front face	✓
	<b>G401-Geo</b> Linear pattern on front face	✓
	<b>G402-Geo</b> Circular pattern on front face	✓
	Lateral surface contours	<b>G110-Geo</b> Starting point of lateral surface contour
<b>G111-Geo</b> Line segment on lateral surface		✓
<b>G112-Geo</b> Circular arc on lateral surface		✓
<b>G113-Geo</b> Circular arc on lateral surface		✓
<b>G310-Geo</b> Bore hole on lateral surface		✓
<b>G311-Geo</b> Linear slot on lateral surface		✓
<b>G312-Geo</b> Circular slot on lateral surface		✓
<b>G313-Geo</b> Circular slot on lateral surface		✓
<b>G314-Geo</b> Full circle on lateral surface		✓
<b>G315-Geo</b> Rectangle on lateral surface		✓
<b>G317-Geo</b> Eccentric polygon on lateral surface		✓
<b>G411-Geo</b> Linear pattern on lateral surface		✓
<b>G412-Geo</b> Circular pattern on lateral surface		✓

**G commands for Y-axis contours**

XY plane	<b>G170-Geo</b> Starting point of contour	✓
	<b>G171-Geo</b> Line segment	✓
	<b>G172-Geo</b> Circular arc	✓
	<b>G173-Geo</b> Circular arc	✓
	<b>G370-Geo</b> Hole	✓
	<b>G371-Geo</b> Linear slot	✓
	<b>G372-Geo</b> Circular slot	✓
	<b>G373-Geo</b> Circular slot	✓
	<b>G374-Geo</b> Full circle	✓
	<b>G375-Geo</b> Rectangle	✓
	<b>G376-Geo</b> Single surface	✓
	<b>G377-Geo</b> Eccentric polygon	✓
	<b>G471-Geo</b> Linear pattern	✓
	<b>G472-Geo</b> Circular pattern	✓
	<b>G477-Geo</b> Centric polygon	✓
YZ plane	<b>G180-Geo</b> Starting point of contour	✓
	<b>G181-Geo</b> Line segment	✓
	<b>G182-Geo</b> Circular arc	✓
	<b>G183-Geo</b> Circular arc	✓
	<b>G380-Geo</b> Hole	✓
	<b>G381-Geo</b> Linear slot	✓
	<b>G382-Geo</b> Circular slot	✓
	<b>G383-Geo</b> Circular slot	✓
	<b>G384-Geo</b> Full circle	✓
	<b>G385-Geo</b> Rectangle	✓
	<b>G387-Geo</b> Eccentric polygon on lateral surface	✓
	<b>G481-Geo</b> Linear pattern	✓
	<b>G482-Geo</b> Circular pattern	✓
	<b>G386-Geo</b> Single surface	✓
	<b>G487-Geo</b> Centric polygon	✓

**G commands for machining**

Tool positioning without machining	<b>G0</b> Positioning at rapid traverse	✓
	<b>G14</b> Move to the tool change position	✓
	<b>G701</b> Rapid traverse to machine coordinates	✓
Simple linear and circular movements	<b>G1</b> Linear movement	✓
	<b>G2</b> Circular movement with incremental center dimensioning	✓
	<b>G3</b> Circular movement with incremental center dimensioning	✓
	<b>G12</b> Circular movement with absolute center dimensioning	✓
	<b>G13</b> Circular movement with absolute center dimensioning	✓
Feed rate and spindle speed	<b>Gx26</b> Speed limitation	✓
	<b>G48</b> Reduce rapid traverse	X
	<b>G64</b> Interrupted feed	✓
	<b>G192</b> Feed per minute for rotary axis	–
	<b>Gx93</b> Feed per tooth	✓
	<b>G94</b> Feed per minute	✓
	<b>Gx95</b> Feed per revolution	✓
	<b>Gx96</b> Constant surface speed	✓
	<b>Gx97</b> Speed	✓
Tool-tip radius compensation	<b>G40</b> Switch off TRC/MCRC	✓
	<b>G41</b> TRC/MCRC, left	✓
	<b>G42</b> TRC/MCRC, right	✓
Datum shifts	<b>G51</b> Relative datum shift	✓
	<b>G53</b> Parameter-dependent datum shift	✓
	<b>G54</b> Parameter-dependent datum shift	✓
	<b>G55</b> Parameter-dependent datum shift	✓
	<b>G56</b> Additive datum shift	✓
	<b>G59</b> Absolute datum shift	✓
	<b>G121</b> Contour mirroring/shifting	✓
	<b>G152</b> Datum shift, C axis	✓
	<b>G920</b> Deactivate datum shift	✓
	<b>G921</b> Deactivate datum shift, tool dimensions	✓
	<b>G980</b> Activate datum shift	✓
<b>G981</b> Activate datum shift, tool dimensions	✓	

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**G commands for machining**


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Oversizes	<b>G50</b> Switch off oversize	✓
	<b>G52</b> Switch off oversize	✓
	<b>G57</b> Axis-parallel oversize	✓
	<b>G58</b> Contour-parallel oversize	✓
Safety clearances	<b>G47</b> Set safety clearances	✓
	<b>G147</b> Safety clearance (milling cycles)	✓
Tools, types of compensation	<b>T</b> Tool call	✓
	<b>G148</b> Switching the tool edge compensation	✓
	<b>G149</b> Additive compensation	✓
	<b>G150</b> Compensation of right-hand tool tip	✓
	<b>G151</b> Compensation of left-hand tool tip	✓
	<b>G710</b> Adding tool dimensions	◆



**Cycles for turning**

Simple turning cycles	<b>G80</b> End of cycle	✓
	<b>G81</b> Simple longitudinal roughing	✓
	<b>G82</b> Simple face roughing	✓
	<b>G83</b> Simple contour repeat cycle	✓
	<b>G85</b> Undercut	✓
	<b>G86</b> Simple recessing cycle	✓
	<b>G87</b> Transition radii	✓
	<b>G88</b> Chamfers	✓
Drilling cycles	<b>G36</b> Tapping	✓
	<b>G71</b> Simple drilling cycle	✓
	<b>G72</b> Counterboring, countersinking, etc.	✓
	<b>G73</b> Tapping cycle	✓
	<b>G74</b> Deep hole drilling cycle	✓
Contour-based turning cycles	<b>G810</b> Longitudinal roughing cycle	✓
	<b>G820</b> Face roughing cycle	✓
	<b>G830</b> Contour-parallel roughing cycle	✓
	<b>G835</b> Contour-parallel with neutral tool	✓
	<b>G860</b> Universal recessing cycle	✓
	<b>G866</b> Simple recessing cycle	✓
	<b>G869</b> Recess turning cycle	✓
Thread cycles	<b>G890</b> Finishing cycle	✓
	<b>G31</b> Thread cycle	✓
	<b>G32</b> Single thread cycle	✓
	<b>G33</b> Single thread cut (Thread single path)	✓
	<b>G933</b> Thread switch	–
	<b>G799</b> Thread milling, axial	✓
	<b>G800</b> Thread milling in XY plane	✓
<b>G806</b> Thread milling in YZ plane	✓	

**Synchronization commands**

Assigning contour to operation	<b>G98</b> Assignment of spindle to workpiece	–
	<b>G99</b> Workpiece group	X
Slide synchronization	<b>G62</b> One-sided synchronization	★
	<b>G63</b> Synchronous start of slides	★
	<b>G162</b> Synchronization marking	★
Contour follow-up	<b>G702</b> Storing/loading Contour follow-up	✓
	<b>G703</b> Contour follow-up ON/OFF	✓
	<b>G706</b> K default branch	–
Spindle synchronization, workpiece transfer	<b>G30</b> Converting and mirroring	✓
	<b>G121</b> Contour mirroring/shifting	✓
	<b>G720</b> Spindle synchronization	✓
	<b>G905</b> Measuring C-angle offset	–
	<b>G906</b> Measuring angular offset during spindle synchronization	–
	<b>G916</b> Traversing to a fixed stop	✓
	<b>G917</b> Controlled parting using lag error monitoring	✓
	<b>G991</b> Controlled parting using spindle monitoring	–
<b>G992</b> Values for controlled parting	–	

**C-axis machining**

C axis	<b>G119</b> No. of C axis	✓
	<b>G120</b> Reference diameter for lateral-surface machining	✓
	<b>G152</b> Datum shift, C axis	✓
	<b>G153</b> Standardize C axis	✓
Front/rear-face machining	<b>G100</b> Rapid traverse, front face	✓
	<b>G101</b> Synchronous start of slides	✓
	<b>G102</b> Circular arc on front face	✓
	<b>G103</b> Circular arc on front face	✓
Milling cycles	<b>G799</b> Thread milling, axial	✓
	<b>G801</b> Engraving on front face	✓
	<b>G802</b> Engraving on lateral surface	✓
	<b>G840</b> Contour milling	✓
	<b>G845</b> Pocket milling, roughing	✓
	<b>G846</b> Pocket milling, finishing	✓
Lateral-surface machining	<b>G110</b> Rapid traverse, lateral surface	✓
	<b>G111</b> Linear path on lateral surface	✓
	<b>G112</b> Circular arc on lateral surface	✓
	<b>G113</b> Circular arc on lateral surface	✓

### Variable programming, program branches

Programming with variables	<b># variables</b> Evaluation during program conversion	✓
	<b>V variables</b> Evaluation during program run	✓
Program branches, program repeats	<b>IF..THEN..</b> Program branching	✓
	<b>WHILE..</b> Program repeat	✓
	<b>SWITCH..</b> Program branching	✓
Special functions	<b>\$</b> Slide code	✓
	<b>/</b> Skip level	✓
Data input and data output	<b>INPUT</b> Input (# variables)	✓
	<b>WINDOW</b> Open output window (# variables)	✓
	<b>PRINT</b> Output (# variables)	✓
	<b>INPUTA</b> Input (V variables)	✓
	<b>WINDOWA</b> Open output window (V variables)	✓
	<b>PRINTA</b> Output (V variables)	✓
Subprograms	<b>L</b> Subprogram call	✓

### Measuring functions, load monitoring

In-process measrmt.	<b>G910</b> Activate In-process measrmt.	✓
	<b>G912</b> Actual value capture for In-process measrmt.	✓
	<b>G913</b> Deactivate In-process measrmt.	✓
	<b>G914</b> Switch off probe monitoring	✓
Post-process measuring	<b>G915</b> Post-process measuring	◆
Load monitoring	<b>G995</b> Specifying the monitoring zone	✓
	<b>G996</b> Type of load monitoring	✓

**Other G codes**

Other G codes	<b>G4</b> Dwell time	✓
	<b>G7</b> Precision stop on	✓
	<b>G8</b> Precision stop off	✓
	<b>G9</b> Precision stop (blockwise)	✓
	<b>G15</b> Move rotary axes	–
	<b>G60</b> Deactivate protection zone	✓
	<b>G65</b> Display chucking equipment	✓
	<b>G66</b> Component position	◆
	<b>G204</b> Waiting for time	◆
	<b>G717</b> Updating nominal values	–
	<b>G718</b> Move lag error	–
	<b>G901</b> Actual values in variables	✓
	<b>G902</b> Datum shift in variables	✓
	<b>G903</b> Lag error in variables	✓
	<b>G907</b> Block speed monitoring off	◆
	<b>G908</b> Feed rate override 100 %	✓
	<b>G909</b> Interpreter stop	✓
	<b>G918</b> Feedforward control	–
	<b>G919</b> Spindle override 100 %	✓
	<b>G920</b> Deactivate datum shift	✓
	<b>G921</b> Deactivate datum shifts, tool lengths	✓
	<b>G922</b> Spindle speed at constant V	–
	<b>G930</b> Sleeve monitoring	✓
	<b>G940</b> Internal T number	–
	<b>G941</b> Transfer pocket compensation values	–
	<b>G975</b> Servo lag limit	◆
	<b>G980</b> Activate datum shift	✓
	<b>G981</b> Activate datum shifts, tool lengths	✓















## B-axis and Y-axis machining

Working planes	<b>G16</b> Tilting working plane	✓
	<b>G17</b> XY plane (front or rear face)	✓
	<b>G18</b> XZ plane (turning)	✓
	<b>G19</b> YZ plane (plan view / lateral surface)	✓
Tool positioning without machining	<b>G0</b> Positioning at rapid traverse	✓
	<b>G14</b> Move to the tool change position	✓
	<b>G600</b> Preselect tool	✓
	<b>G701</b> Rapid traverse to machine coordinates	✓
	<b>G714</b> Insert magazine tool	◆
	<b>G712</b> Define tool position	◆
Milling cycles	<b>G841</b> Area milling, roughing	✓
	<b>G842</b> Area milling, finishing	✓
	<b>G843</b> Centric polygon milling, roughing	✓
	<b>G844</b> Centric polygon milling, finishing	✓
	<b>G845</b> Pocket milling, roughing	✓
	<b>G846</b> Pocket milling, finishing	✓
	<b>G800</b> Thread milling in XY plane	✓
	<b>G806</b> Thread milling in YZ plane	✓
	<b>G803</b> Engraving in XY plane	✓
	<b>G804</b> Engraving in YZ plane	✓
	<b>G808</b> Hobbing	✓
Simple linear and circular movements	<b>G1</b> Linear path	✓
	<b>G2</b> Circular arc with incremental center coordinates	✓
	<b>G3</b> Circular arc with incremental center coordinates	✓
	<b>G12</b> Circular arc with absolute center coordinates	✓
	<b>G13</b> Circular arc with absolute center coordinates	✓

# 12










**Overview of cycles**

## 12.1 Workpiece blank cycles and single cut cycles
















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









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







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









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# HEIDENHAIN

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## DR. JOHANNES HEIDENHAIN GmbH

Dr.-Johannes-Heidenhain-Straße 5

**83301 Traunreut, Germany**

☎ +49 8669 31-0

FAX +49 8669 32-5061

E-mail: [info@heidenhain.de](mailto:info@heidenhain.de)

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**Technical support** FAX +49 8669 32-1000

**Measuring systems** ☎ +49 8669 31-3104

E-mail: [service.ms-support@heidenhain.de](mailto:service.ms-support@heidenhain.de)

**NC support** ☎ +49 8669 31-3101

E-mail: [service.nc-support@heidenhain.de](mailto:service.nc-support@heidenhain.de)

**NC programming** ☎ +49 8669 31-3103

E-mail: [service.nc-pgm@heidenhain.de](mailto:service.nc-pgm@heidenhain.de)

**PLC programming** ☎ +49 8669 31-3102

E-mail: [service.plc@heidenhain.de](mailto:service.plc@heidenhain.de)

**APP programming** ☎ +49 8669 31-3106

E-mail: [service.app@heidenhain.de](mailto:service.app@heidenhain.de)

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[www.heidenhain.de](http://www.heidenhain.de)

