
Heidenhain Cnc Pilot 4290 !FULL! Download

81 Removal of the rough contour and the diamond Geometric shapes The contour description without the diamond does not contain any information or instructions. It only contains the contour elements. The contour elements are programmed just as before. The diamond is programmed using the fgraphical description. The diamond is programmed as a diamond and not as a circle. In the following example, the contour is programmed into the diamond by writing the contour description in the contour block. The diamond is removed from the graph and is not displayed. 0 BEGIN PGM CONTOUR_DIAGONAL MM... 11 TAB 1 diamond call 12 LBL 1 Call subprogram 13 L X-30 Y+0 Z-80 R0 F max 14 DEP LEN10 15 LBL 0 End of subprogram, return to main program 16 L X-120 Y+30 LEN10 RL F L X 16 FL X F L X 17 FL X F L X 18 FLAN * X value, Y value and rise angle known HEIDENHAIN FUNDAMENTALS OF MILLING CONVERSATIONAL PROGRAMMING 81 76 4 The diamond shape Example for the diamond shape The diamond is the shape that is applied to an approximately rectangle-shaped workpiece. The diamond has the following dimensions. fPLANE 1 X+100 Y+100 Z-100 fPLANE 2 X+0 Y+0 Z-0.1 fPLANE 3 X-100 Y+100 Z-100 HEIDENHAIN FUNDAMENTALS OF MILLING CONVERSATIONAL PROGRAMMING 76 80 5 The diamond cutter The diamond shape is programmed using the diamond tool. The diamond cutter is programmed just like the roughing cutter. The milling depth is programmed via the milling depth for the diamond. The only difference is that the diamond is not programmed as a circle and is programmed as a diamond. The diamond is formed by programming all contour elements in the diamond. 0 BEGIN PGM CUTTER_DIAGONAL MM... 3 TOOL CALL 9 Z S3000 F2500 DL+0.3 DR+0.3 4 L Z+0.05 R0 FMAX 50 5 CALL LBL 1 Call subprogram 6 L Z-0.3 R0 FMAX 7 L Z-0.1 R0 FMAX 8 CALL LBL 1 Call subprogram 9 L Z-0.1 R0 FMAX 10 TOOL CALL 8 Z S3000 F500 Call diamond cutter CALL LBL 1 Call subprogram 11 L Z+0.1 R0 FMAX 12 L Z+0.2 R0 FMAX 13 L Z+0.3 R0 FMAX 14 L Z-0.2 R0 F MAX 15 CALL LBL 1 Call subprogram 16 L Z-0.2 R0 FMAX 17 L Z+0.3 R0 FMAX 18 L Z-0.1 R0 FMAX 19 APPR LT X-0 Y+100 LEN10 RL DEP LT LEN10 20 * - 25 LBL 0 End of subprogram, return to main program 26 END PGM CUTTER_DIAGONAL MM The diamond shape is displayed in the Test Run. 80 FUNDAMENTALS OF MILLING CONVERSATIONAL PROGRAMMING HEIDENHAIN

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