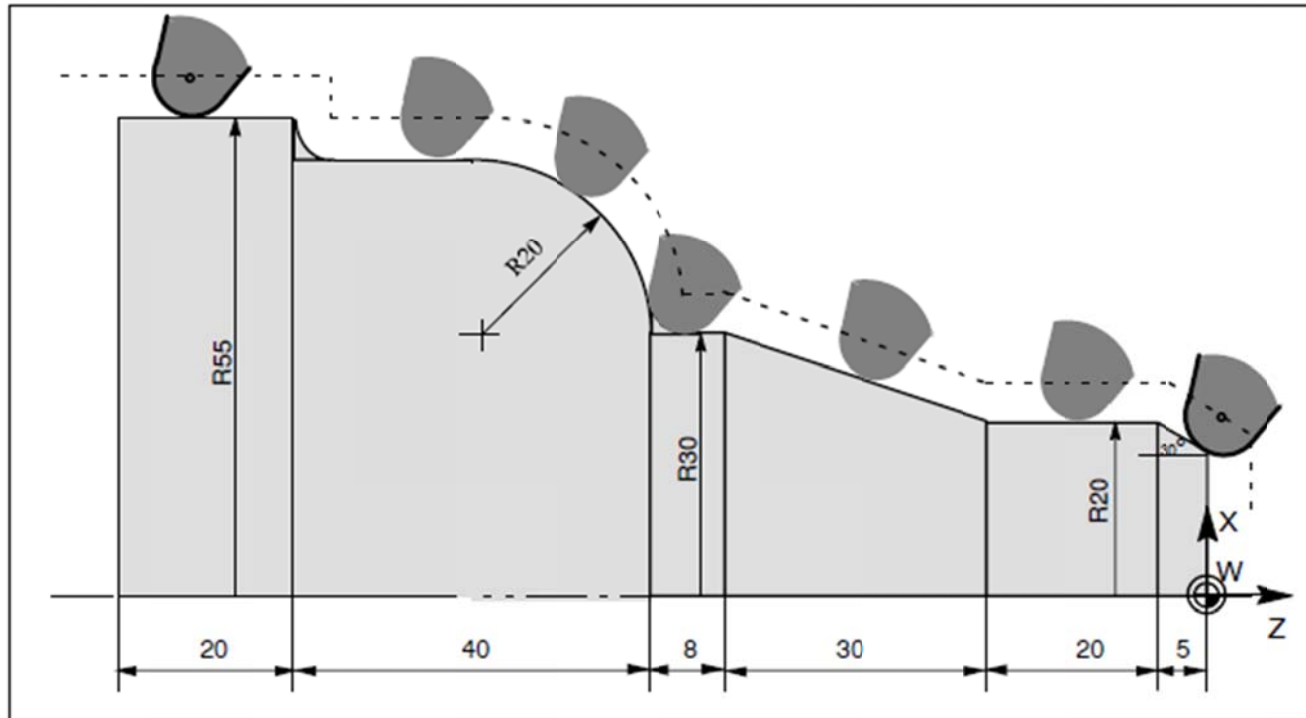


1. Example of tool radius compensation

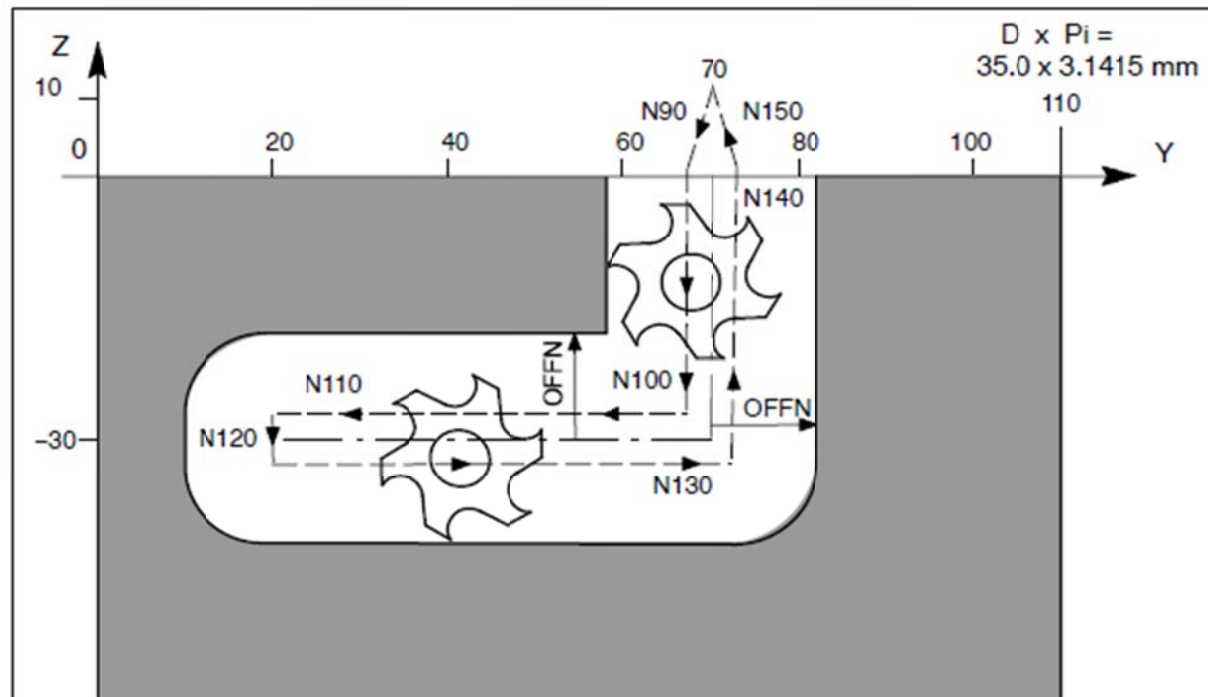


1.1. Programming example

```

N1                ;Section of the contour
N2 T1             ;Tool 1 with offset D1
N10 DIAMON F... S... M... ;Radius dimensioning, technological values
N15 G54 G0 G90 X100 Z15
N20 X0 Z6
N30 G1 G42 G451 X0 Z0 ;Start compensation mode
N40 G91 X20 CHF=(5* 1.1223 ) ;Insert chamfer, 30 degrees
N50 Z-25
N60 X10 Z-30
N70 Z-8
N80 G3 X20 Z-20 CR=20
N90 G1 Z-20
N95 X5
N100 Z-25
N110 G40 G0 G90 X100 ;Quit compensation mode
N120 M2
    
```

2. Milling on turning machines



2.1. Programming example

```

; Machining diameter of the cylinder at the slot base: 35.0 mm
; Desired total slot width: 24.8 mm, the cutter in use has a radius of: 10.123 mm
N10 T1 F400 G94 G54           ; Cutter tool, feedrate, feedrate type, work offset
N30 G0 X25 Z50 SPOS=200     ; Approach starting position
N35 SETMS(2)                 ; Master spindle is now the milling spindle
N40 TRACYL (35.0)           ; Activate TRACYL, machining diameter 35.0 mm
N50 G55 G19                 ; Work offset, plane selection: Y/Z plane
N60 S800 M3                 ; Activate milling spindle
N70 G0 Y70 Z10              ; Y / Z start position
N80 G1 X17.5                 ; Feed cutter to slot base
N70 OFFN=12.4                ; 12.4 slot side distance to slot center line
N90 G1 Y70 Z1 G42           ; Activate TRC, approach slot side
N100 Z-30                    ; Slot section parallel to cylinder axis
N110 Y20                     ; Slot section parallel to circumference
N120 G42 G1 Y20 Z-30        ; Restart TRC, approach other slot side,
; slot distance continues to be 12.4 mm to slot center line
N130 Y70 F600                ; Slot section parallel to the circumference
N140 Z1                      ; Slot section parallel to cylinder axis
N150 Y70 Z10 G40            ; Deactivate TRC
N160 G0 X25                 ; Retract cutter
N170 M5 OFFN=0              ; Deactivate milling spindle, clear slot side distance
N180 TRAFOOF                ; Deactivate TRACYL
N190 SETMS                  ; Master spindle is now main spindle again
N200 G54 G18 G0 X25 Z50 SPOS=200 ; Approach starting position
N210 M2

```