

M640MTPro WNo.103 (TEST)

UNO. MAT OD-MAX ID-MIN LENGTH WORK FACE RPM TR2-DIA
 0 CBN STL 1.5 0. 20. 0. 200

UNO.UNIT TYPE HEAD SPDL TURRET
 1 HEAD SIN 1 @ @

UNO. UNIT CHANGE-PT GEAR TOOL #
 2 M-MANUAL 1 1 END MILL 0.25 B
 SEQ G DATA-1 DATA-2 DATA-3 RADIUS RPM FEED M OFS
 1 OZ -3.5 B 90. @

UNO.UNIT SETUP-No. HEAD SPDL PUSH CHUCK
 3 TRANSFER BAR 1 2 5 @ 1

UNO.UNIT SETUP-No. HEAD SPDL PUSH CHUCK
 4 TRANSFER BAR 2 1 5 @ 1

UNO.UNIT MODE POS-B POS-C SRV-A SRV-R RGH FIN-A FIN-R
 5 LINE CTR ZC @ @ 0.25 0.25 4 0.063 @
 SNO. TOOL NOM-Ø # APRCH-1 APRCH-2 TYPE AFD DEP-A DEP-R C-SP FR M M
 R 1 END MILL 0.25B ? ? @ G01 0.063 @ 2000 0.002 8 154
 F 2 END MILL 0.25B ? ? @ G01 @ @ 2000 0.002 8 154
 FIG SHP SHIFT-R Z C RADIUS/Ø I J P CNR RGH
 1 LINE 0.5 3.5 0.
 2 LINE @ 13.5 4680.
 3 LINE @ 3.5 9360.

UNO.UNIT MODE POS-B POS-C SRV-A SRV-R RGH FIN-A FIN-R
 6 LINE RGT ZC @ @ 0.25 0.25 4 0.02 0.005
 SNO. TOOL NOM-Ø # APRCH-1 APRCH-2 TYPE AFD DEP-A DEP-R C-SP FR M M
 R 1 END MILL 0.25B ? ? @ G01 0.063 @ 600 0.002 8 154
 F 2 END MILL 0.25B ? ? @ G01 @ @ 600 0.002 8 154
 FIG SHP SHIFT-R Z C RADIUS/Ø I J P CNR RGH
 1 LINE 0.5 13.549 15.
 2 LINE @ 13.549 -15.

UNO.UNIT MODE POS-B POS-C SRV-A SRV-R RGH FIN-A FIN-R
 7 LINE LFT ZC @ @ 0.25 0.25 4 0.02 0.005
 SNO. TOOL NOM-Ø # APRCH-1 APRCH-2 TYPE AFD DEP-A DEP-R C-SP FR M M
 R 1 END MILL 0.25B 3.558 -33.838 @ G01 0.063 @ 600 0.002 8 154
 F 2 END MILL 0.25B 3.563 -33.838 @ G01 @ @ 600 0.002 8 154
 FIG SHP SHIFT-R Z C RADIUS/Ø I J P CNR RGH
 1 LINE 0.5 3.688 -15.
 2 LINE @ 3.688 15.

UNO.UNIT COUNTER RETURN WK.No. CONT. NUM. SHIFT
 8 END