HEIDENHAIN

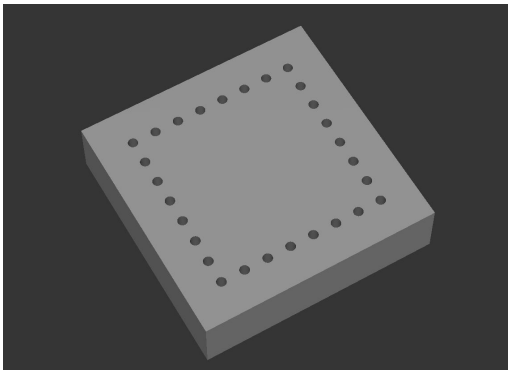
NC Solutions

Description of NC program 1105

English (en)
4/2017

1 Description of the NC program 1105_en.h

NC program for defining a point pattern as a rectangular frame.

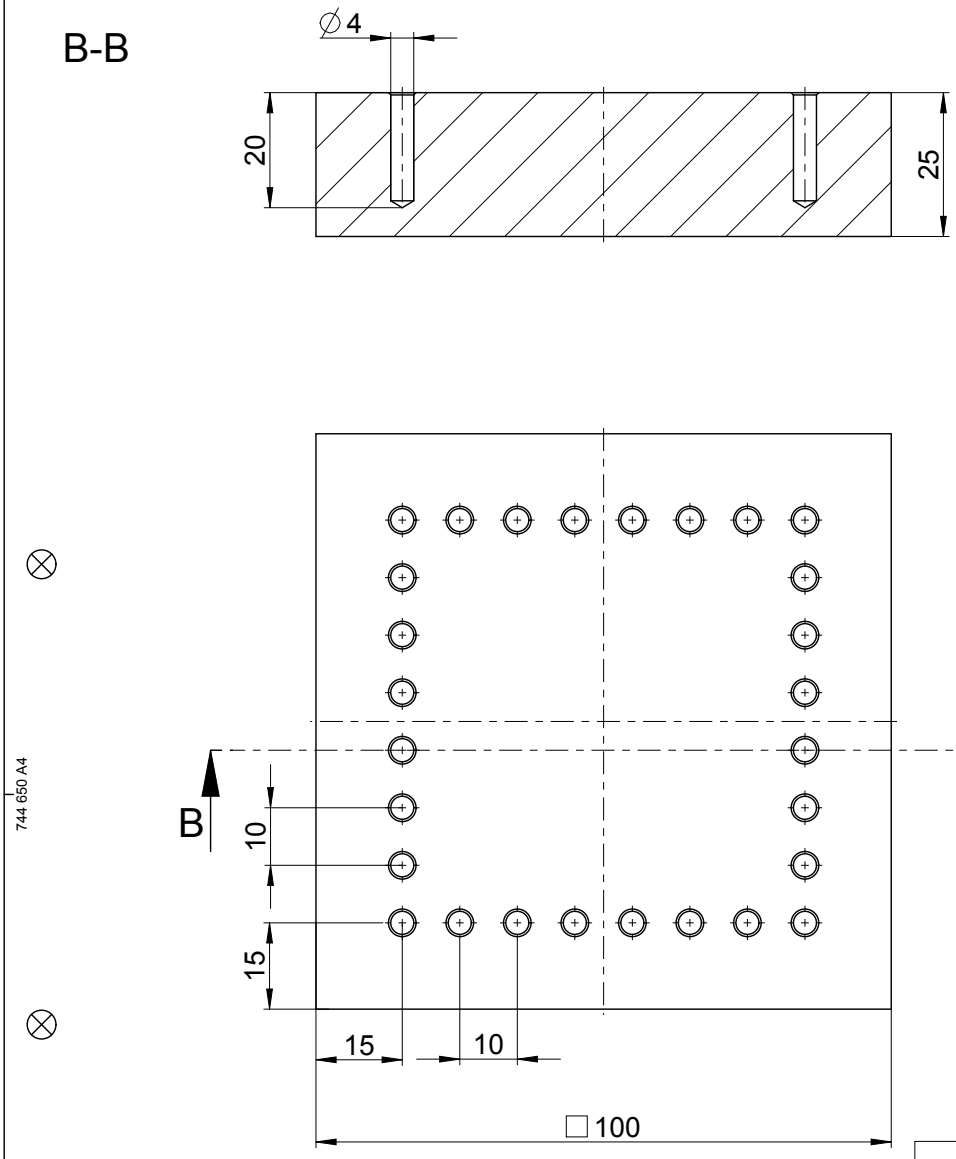


Description

With this NC program the control generates a point pattern in the form of a rectangular frame. The control calls a machining cycle at the calculated positions, enabling you to simply select the type of machining.

In the first part of the NC program you define all parameters required for the calculation, the tool, and the machining cycle executed by the control at the calculated positions. The control then calls a subprogram. The control executes all calculations and positioning movements in this subprogram. The control calculates the positions so that it approaches these positions in a peripheral path and executes the machining. Define the position of the first machining via the parameters. After the last machining step the control retracts the tool and terminates the program.

Parameter	Name	Meaning
Q1	STARTING POINT IN THE X AXIS	X coordinate at which the control executes the first machining step
Q2	STARTING POINT IN THE Y AXIS	Y coordinate at which the control executes the first machining step
Q30	NUMBER OF MACHINING STEPS IN X	Number of operations the control executes in each row in the X axis
Q31	NUMBER OF MACHINING STEPS IN Y	Number of operations the control executes in each column in the Y axis
Q32	DISTANCE OF MACHINING STEPS IN X	Incremental clearance of the operations in the X axis
Q33	DISTANCE OF MACHINING STEPS IN Y	Incremental clearance of machining in the Y axis
Q7	ROTATION	Rotation of the coordinate system around the first machining position
Q8	SAFETY CLEARANCE	Z clearance between the tool and workpiece surface approached by the control in rapid traverse before machining is executed



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Text:			Change No. C000941-10 Phase: Nicht-Serie
	Original drawing Scale: 1:1 / Format: A4	Platte Plate Einzelteilzeichnung / Component Drawing	Werkstoff: Material:
RoHS			●blanke Flächen/Blank surfaces
Maße in mm / Dimensions in mm			
Werkstückkanten nach ISO 13715 Workpiece edges ISO 13715 -0.3 +0.3	Allgemeintoleranzen ISO 2768-mH ≦6mm: ±0,2 General tolerances ISO 2768-mH ≦6mm: ±0,2	Tolerierung nach ISO 8015 Tolerances as per ISO 8015 Oberflächenbehandlung: Surface treatment:	Oberflächen nach ISO 1302 Surfaces as per ISO 1302

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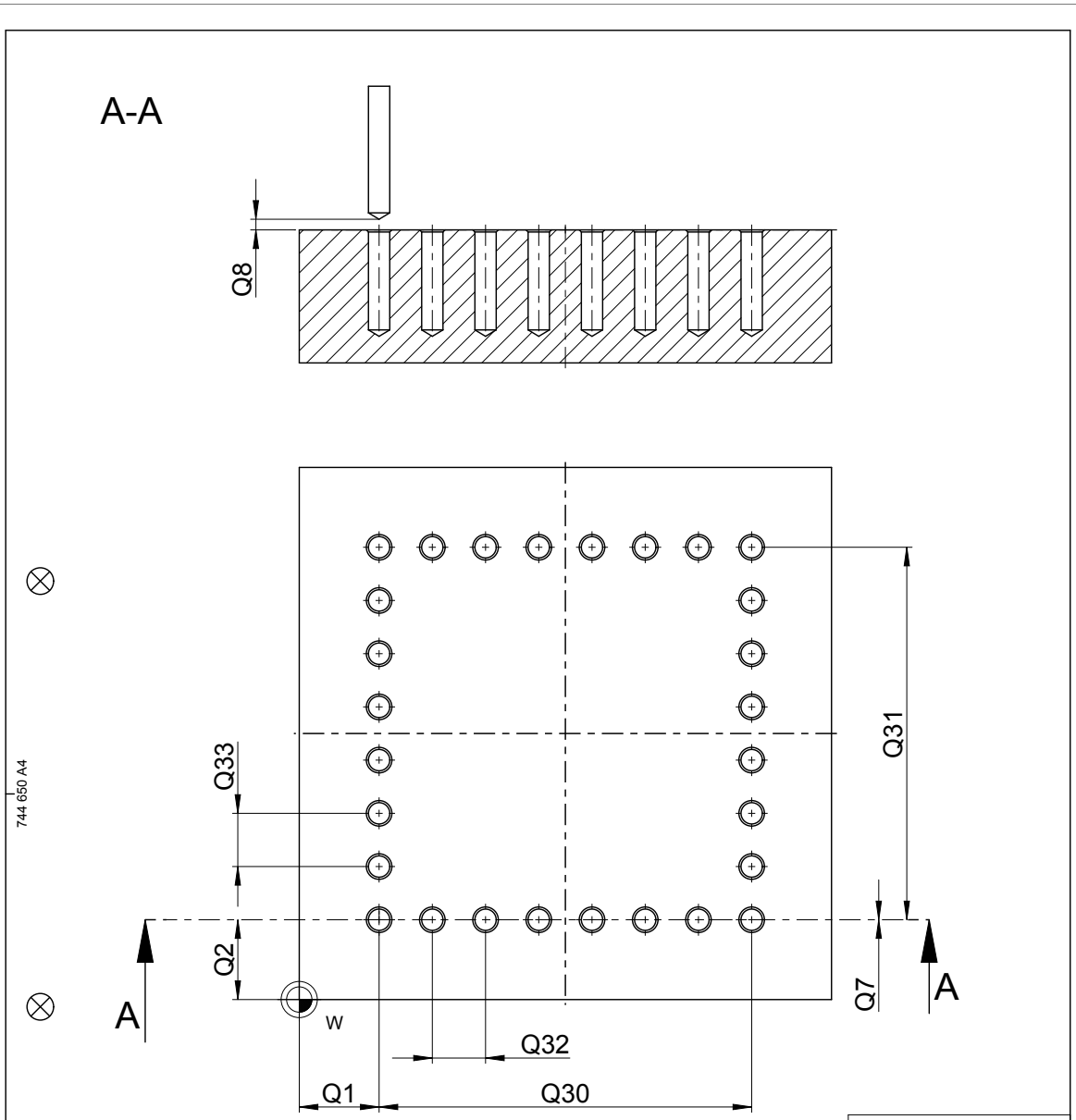

			ID number
Text:			Change No. C000941-10 Phase: Nicht-Serie
	Original drawing Scale / Format	Bausatz Assembly kit Montage-ZZ / Assembly Drawing	Werkstoff: Material:
RoHS	1:1 / A4		
Maße in mm / Dimensions in mm			●blanke Flächen/Blank surfaces
Werkstückkanten nach ISO 13715 Workpiece edges ISO 13715 -0.3 +0.3	Allgemeintoleranzen ISO 2768-mH ≦6mm: ±0,2 General tolerances ISO 2768-mH ≦6mm: ±0,2	Tolerierung nach ISO 8015 Tolerances as per ISO 8015 Oberflächenbehandlung: Surface treatment:	Oberflächen nach ISO 1302 Surfaces as per ISO 1302

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