



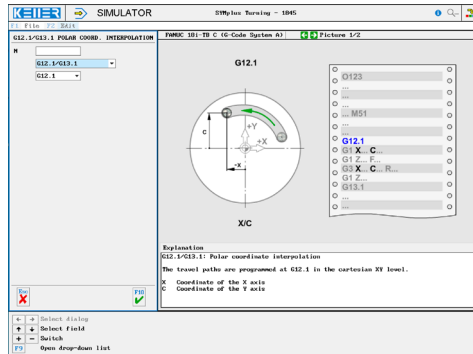
CONTROLS

Control simulator FANUC 18i C (G-Code A, incl. C axis)

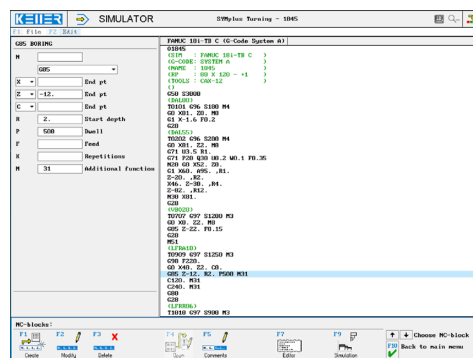


The control related simulator is an additional module for SYMplus. This simulator is used to learn the control system programming. A program generated by a postprocessor can also be edited and simulated.

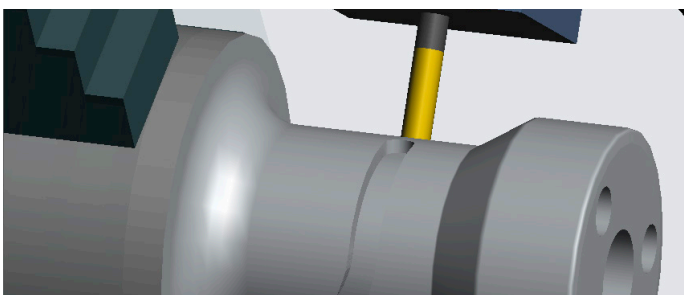
Help pictures and texts (for all input dialogues)



NC editor incl. input dialogue and syntax control



3D simulation with freely adjustable perspective, including continuous display of NC blocks



Keyboard information system: Getting familiar with the meaning of all keys of the control system by moving the mouse cursor over the keys



COMMANDS/ FUNCTIONS/CYCLES

G0	Rapid traverse
G1	Line
G2	Arc, clockwise
G3	Arc, counter-clockwise
G4	Dwell time
G7.1	Cylindric interpolation
G12.1(G13.1)	Polar coordinate interpolation
G28	Approach reference point
G32	Thread cutting
G40/G41/G42	Radius compensation
G50 S	Speed limitation
G50 Z	Set local coordinates
G52	Local coordinate system
G54-G59	Zero offset
G65	Macro call
#	Parameter
GOTO/IF/WHILE	Jumps and loops
G70	Finishing contour
G71	Finishing contour axial
G72	Finishing contour radial
G73	Repeating the contour
G76	Threading
G80	Finish cycle
G83	Deep hole drilling
G84	Tapping
G85	Boring
G87	Deep hole drilling (x axis)
G88	Tapping (x axis)
G89	Drilling (x axis)
G90	Longitudinal roughing
G92	Speed limitation
G94	Face roughing
G96	Constant cutting speed
G97	Constant speed
G98	Feed per minute
G99	Feed per revolution
Comment	Explanations
T	Tool call
M98	Program call
X/Z/F/S/M	Modal commands

O1845

(RP : 80 X 120 - +1)

(TOOLS : CAX-12)

()

G50 S3000

(DAL80)

T0101 G96 S180 M4

G0 X81. Z0. M8

G1 X-1.6 F0.2

G28

(DAL55)

T0202 G96 S200 M4

G0 X81. Z2. M8

G71 U3.5 R1.

G71 P20 Q30 U0.2 W0.1 F0.35

N20 G0 X52. Z0.

G1 X60. A95. ,R1.

Z-20. ,R2.

X46. Z-30. ,R4.

Z-82. ,R12.

N30 X81.

G28

(VBO20)

T0707 G97 S1200 M3

G0 X0. Z2. M8

G85 Z-22. F0.15

G28

M51

(LFRA10)

T0909 G97 S1250 M3

G98 F220.

G0 X40. Z2. C0.

G85 Z-12. R2. P500 M31

C120. M31

C240. M31

G80

G28

(LFRR06)

T1010 G97 S900 M3

G98 F240.

G0 X70.

G0 Z-46. C90.

G0 X50.

G1 X40. F120.

C180. ,R20. F240.

W-10. C220. ,R10.

C320. ,R10.

W10. C0. ,R20.

C90.

G0 X90.

G28

M50

M30

