



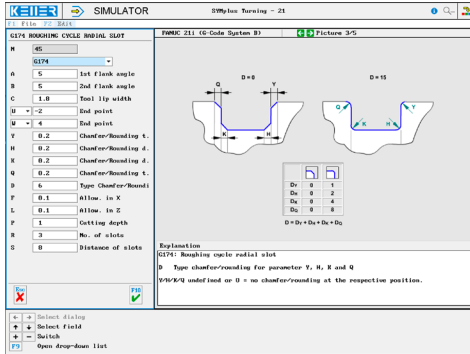
CONTROLS

Control simulator FANUC 21i (turning, G-Code system B)

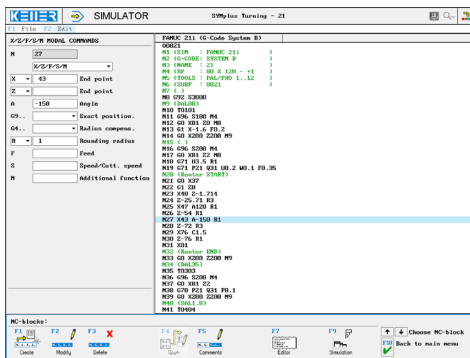


The control related simulator is an additional module for SYMplus. This simulator is used to learn the control system programming. A program generated by a postprocessor can also be edited and simulated.

Help pictures and texts (for all input dialogues)



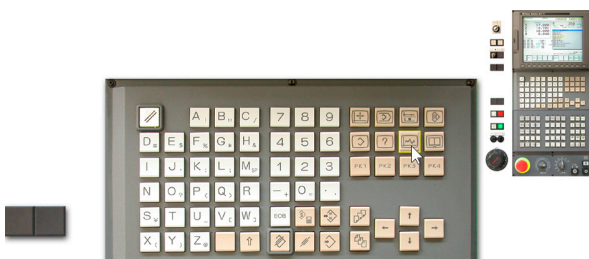
NC editor incl. input dialogue and syntax control



Optimal control through simulation with position display (real time, fast run, single block with path preview etc.)

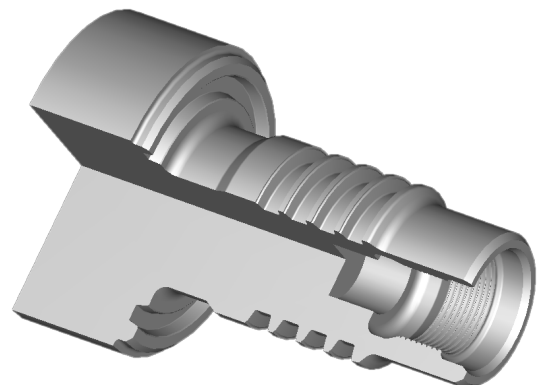


Keyboard information system: Getting familiar with the meaning of all keys of the control system by moving the mouse cursor over the keys



COMMANDS/ FUNCTIONS/CYCLES

- G0 Rapid traverse
- G1 Line
- G2 Arc, clockwise
- G3 Arc, counter-clockwise
- G4 Dwell time
- G28 Approach referenc point
- G33 Threading
- G40/G41/G42 Radius compensation
- G52 Zero offset
- G54-G59 Zero offset
- G70 Contour finishing
- G71 Contour roughing axial
- G72 Contour roughing radial
- G73 Contour repetition
- G76 Thread cutting cycle
- G80 Cycle deselection
- G83 Deep-hole drilling cycle
- G84 Tapping cycle
- G90/G91 Dimensional reference
- G92 Speed limitation
- G96/G97 Spindle mode
- G174 Roughing cycle radial slot
- G175 Finishing cycle radial slot
- G176 Roughing cycle axial slot
- G177 Finishing cycle axial slot
- Comment Explanations
- T Tool call
- M98 Sub-program call
- X/Z/F/S/M Modal commands





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O0021
N1 (RP      : 80 X 120 - +1)
N2 (TOOLS  : PAL/PRO 1..12)
N3 (SUBP   : 8021)
N4 ( )
N5 G92 S3000
N6 (DAL80)
N7 T0101
N8 G96 S180 M4
N9 G0 X81 Z0 M8
N10 G1 X-1.6 F0.2
N11 G0 X200 Z200 M9
N12 ( )
N13 G96 S200 M4
N14 G0 X81 Z2 M8
N15 G71 U3.5 R1
N16 G71 P18 Q28 U0.2 W0.1 F0.35
N17 (Contour START)
N18 G0 X37
N19 G1 Z0
N20 X40 Z-1.714
N21 Z-25.71 R3
N22 X47 A120 R1
N23 Z-54 R1
N24 X43 A-150 R1
N25 Z-72 R3
N26 X76 C1.5
N27 Z-76 R1
N28 X81
N29 (Contour END)
N30 G0 X200 Z200 M9
N31 (DAL35)
N32 T0303
N33 G96 S200 M4
N34 G0 X81 Z2
N35 G70 P18 Q28 F0.1
N36 G0 X200 Z200 M9
N37 (SAL1.8)
N38 T0404
N39 G96 S180 M4
N40 G0 X50 Z-51
N41 G1 X48 F0.2 M8
N42 G174 A5 B5 C1.8 U-2 W4 Y0.2 H0.2 K0.2 Q0.2
D6 F0.1 L0.1 P1 R3 S8
N43 G0 X50 Z-51
N44 G1 X48
N45 G175
N46 G0 X200 Z200 M9
N47 (VBO20)
N48 T0606
N49 G97 S1200 M3
N50 G0 X0 Z2 M8
N51 G1 Z-43 F0.15
N52 G4 U0.5
N53 G0 Z2
N54 G0 X80 Z200 M9

N55 (DIL80)
N56 T0707
N57 G96 S120 M4
N58 G0 X20 Z2 M8
N59 G71 U3 R1
N60 G71 P61 Q67 U-0.1 W0.1 F0.3
N61 G0 X33
N62 G1 Z0
N63 X31 Z-1.714
N64 G1 Z-8.57 C1
N65 X27 C1.5
N66 Z-30
N67 X20
N68 G0 X200 Z200 M9
N69 (DIL55)
N70 T0808
N71 G96 S120 M4
N72 G0 X20 Z2 M8
N73 G70 P61 Q67 F0.1
N74 G0 Z-21.425
N75 X25
N76 M98 P8021
N77 G0 Z2
N78 G0 X200 Z200 M9
N79 (GIL_1.5)
N80 G97 S800 T1111 M4
N81 G0 X25 Z2
N82 G0 Z-6 M8
N83 G97 S800 M4
N84 G76 P010060 Q20 R0.01
N85 G76 X28 Z-24 P919 Q200 F1.5
N86 G0 Z200 M9
N87 G0 X200
N88 (SIL1.8)
N89 T1010
N90 G96 S120 M4
N91 G0 X18 M0
N92 Z-41 M8
N93 G1 X19
N94 G174 A10 B10 C1.8 U1.5 W3 Y0.1 H0.1 K0.1
Q0.1 D6 F0.1 L0.1 P1.5
N95 G175
N96 G0 X18
N97 G0 Z200 M9
N98 G0 X200
N99 M30

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