



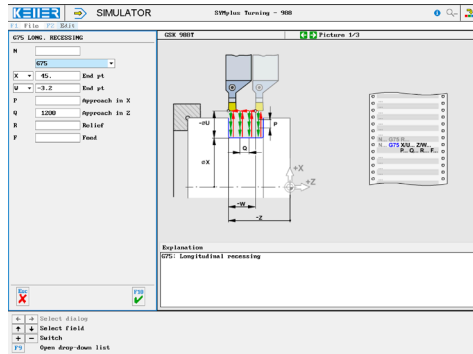
# CONTROLS

## Control simulator GSK 988T (turning)

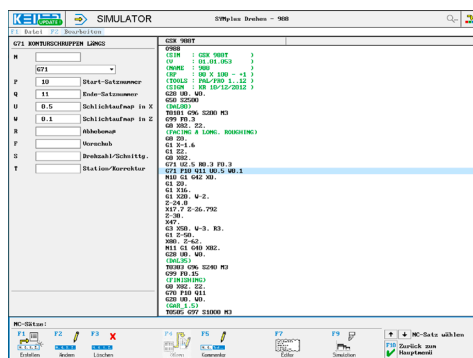


The control related simulator is an additional module for SYMplus. This simulator is used to learn the control system programming. A program generated by a postprocessor can also be edited and simulated.

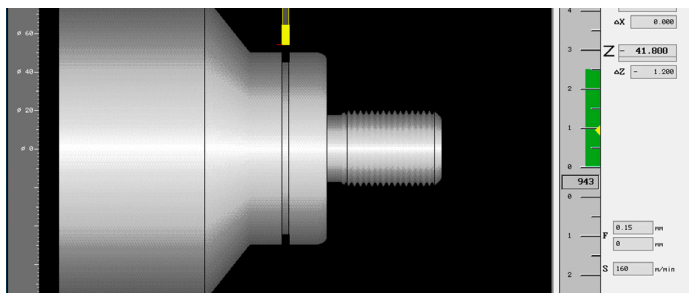
### Help pictures and texts (for all input dialogues)



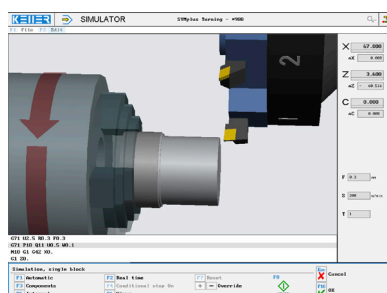
### NC editor incl. input dialogue and syntax control



### Perfect control due to simulation with position indicator (real time, fast mode, single block with path preview, measurement function, ...)



### 3D simulation with freely adjustable perspective



## COMMANDS/ FUNCTIONS/CYCLES

G00	Rapid traverse
G01	Line
G02	Arc, clockwise
G03	Arc, counter-clockwise
G04	Dwell time
G28	Approach reference point
G32	Threading
G40/G41/G42	Radius compensation
G50 S	Speed limitation
G50 Z	Set local coordinates
G52	Local coordinate system
G53	Machine coordinates
G54	Zero offset
G70	Finishing contour
G71	Longitudinal roughing of contour
G72	Face roughing of contour
G73	Parallel roughing of contour
G74	Face recessing
G75	Longitudinal recessing
G76	Threading
G90	Longitudinal roughing
G92	Threading cycle
G94	Face roughing
G96	Constant cutting speed
G97	Constant speed
G99	Feed per revolution
T	Tool call
M	Additional function
M98	Program call
XZ	Modal commands
Comment	Explanations