



IL PROGETTO DI E-LEARNING DI MITSUBISHI ELECTRIC
PER LA FORMAZIONE TECNICA E PROFESSIONALE NELLE SCUOLE

Modulo specialistico di:

Automazione Industriale - Percorso CNC

Attività di SMARTWORKING: dalla teoria alla pratica

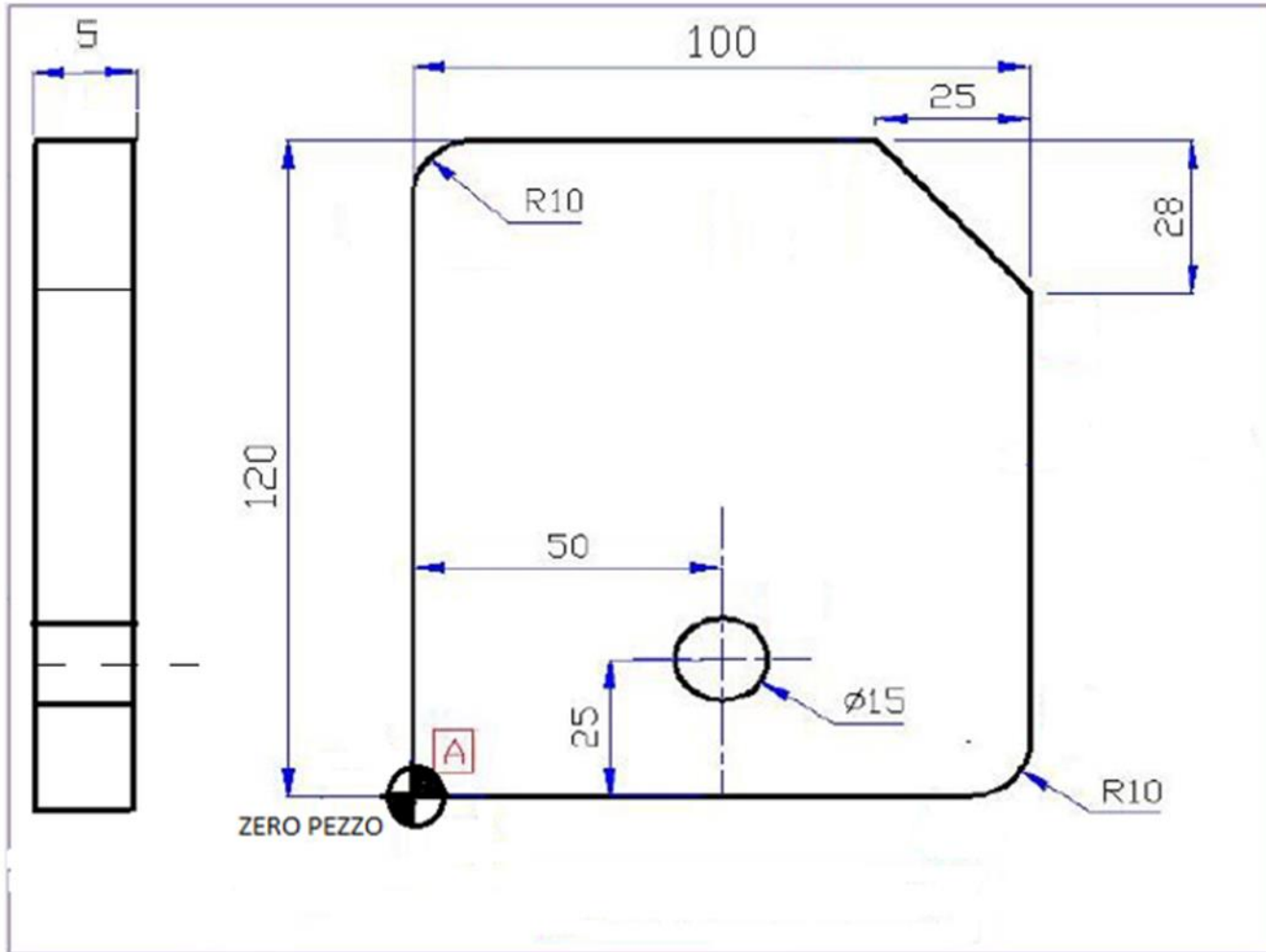
ALLEGATO B - DOCENTE – ESEMPIO PROGRAMMA ISO



**Automating
the World**

Vimercate 13/05/2024

Programma ISO per la contornatura e foratura del pezzo



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G90 G54  
T01 M6 G43H1  
S1500 M3  
G0 X200 Y100 Z100  
G41 G0 X0 Y0 Z2 F100 M8  
G1 Z-15  
G1 X0 Y110  
G2 X10 Y120 R10  
G1 X75  
G1 X100 Y92  
G1 Y10  
G2 X90 Y0 R10  
G1 X0  
G0 Z100 M05 M9  
T02 M6 G40  
M3 S1500 G43H2  
G0 X50 Y25 Z2  
G1 Z-20 M8 F100  
G0 Z100 M05  
G0 X200 Y100 M9  
M30
```

Programma ISO: descrizione delle funzioni utilizzate



G90 G54	(G54=1° origine/G90=coord. Assolute)
T01 M6 G43H1	(richiamo ut. 1, M6= comando cambio ut. G43 H= compensaz. lunghezza)
S1500 M3	(giri mandrino =1500, M3= giri mandrino orario)
G0 X200 Y100 Z100	(G0=movimento rapido)
G41 D1 G0 X0 Y0 Z2 F100 M8	(G41 D1= compensaz. raggio ut. , F=velocità avanzam., M8 refrigerante on)
G1 Z-15	(G1=lavorazione lineare)
G1 X0 Y110	(G1=lavorazione lineare)
G2 X10 Y120 R10	(G2=interpolazione oraria raggio 10)
G1 X75	(G1=lavorazione lineare)
G1 X100 Y92	(G1=lavorazione lineare)
G1 Y10	(G1=lavorazione lineare)
G2 X90 Y0 R10	(G2=interpolazione oraria raggio 10)
G1 X0	(G1=lavorazione lineare)
G0 Z100 M05 M9	(G0=movimento rapido, M05=stop mandrino, M9=stop refrigerante)
T02 M6 G40	(richiamo ut. 2, M6= comando cambio ut. G40 cancellazione compensaz.)
M3 S1500 G43H2	(giri mandrino =1500, M3= mandrino orario, G43 H= compensaz. lunghezza)
G0 X50 Y25 Z2	(G0=movimento rapido)
G1 Z-20 M8 F100	(G1=lavorazione lineare M8=refrigerante on, F100=vel avanzamento.)
G0 Z100 M05	(G0=movimento rapido, M05=stop mandrino)
G0 X200 Y100 M9	(G0=movimento rapido, M09=stop refrigerante.)
M30	(fine programma)

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