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矩形螺旋线

产品长度 200

产品宽度 120

刀具直径 10

刀具间距
百分比 0.75

Z加工深度 -5

Z粗刀加工
深度 1Z加工起
始点 0

刀具号 1

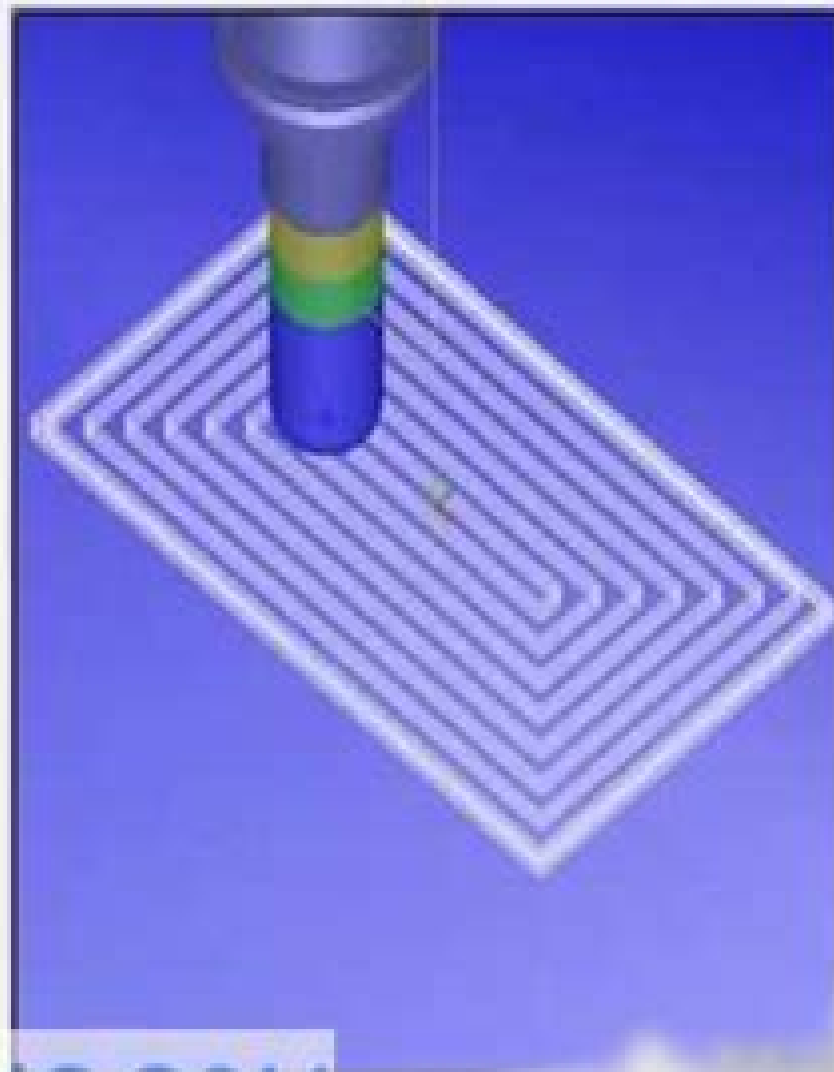
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切削进给 1000

生成程序

输出文件

```
%  
O0011  
#1=200  
#2=120  
#3=10  
#4=0.75  
#5=-5  
#6=1  
#10=0  
#14=5000  
#15=1000  
M51  
G54 G80 G00 X0 Y0  
M30#15  
G43M1Z30  
M0  
#11=#10-#6  
#10  
#20=#3*#4  
#21=#1/2-#2/2  
#22=0  
G00 I-#21 J-#22  
G02[#10*2]  
IF [#11 GE #5] GOTO 30  
G12H11F#14  
I#21  
WHILE[#21LT[#1/2-#3]]DO1  
G01Y[#22-#20]F#14  
I-[#21-#20]  
Y-[#22-#20]  
I[#21-#20]
```



Fanuc Horizontal Center Macro Programming

M Mark



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