ISO 4343:2000-10 (E)

Industrial automation systems - Numerical control of machines - NC processor output; Post processor commands

Contents

Page

Foreword viii

Introduction ix

1 Scope 1

2 Normative references 1

3 Co-ordinate system 1
3.1 Part program reference 1
3.2 Machine program reference 1
3.3 Units of measure 2

4 General structure of post processor commands 2
4.1 NC processor 2
4.2 CLDATA 2
4.3 Post processor 3

5 General language 6
5.1 General comments 6
5.2 The ADAPTV command 8
5.3 The AIR command 9
5.4 The APPLY command 10
5.5 The AUXFUN command 11
5.6 The BREAK command 12
5.7 The CALSUB command 13
5.8 The CLAMP command 14
5.9 The CLDATA command 15
5.10 The COUPLE command 16
5.11 The CUTCOM command 17
5.12 The DEFSUB command 18
5.13 The DELAY command 19
5.14 The DISPLY command 20
5.15 The END command 21
5.16 The ENDSUB command 22
5.17 The FEDRAT command 23
5.18 The GOHOME command 26
5.19 The GOPARK command 27
5.20 The HOMEPT command 28
5.21 The INCLUD command 29
5.22 The INSERT command 30
5.23 The LEADER command 31
5.24 The LIMIT command 32
5.25 The LOCATE command 33
5.26 The LPRINT command 34
5.27 The MACHIN command 35
5.28 The MATERL command 36
5.29 The MCHFIN command 37
5.30 The MCHTOL command 38
5.31 The MODE command 39
5.32 The MOVETO command 43

5.33 The OPSKIP command 44
5.34 The OPSTOP command 45
5.35 The ORIGIN command 46
5.36 The PARKPT command 47
5.37 The PARTNO command 48
5.38 The PPFUN command 49
5.39 The PPRINT command 50
5.40 The PPTIME command 51
5.41 The PREFUN command 52
5.42 The RAPID command 53
5.43 The RESET command 54
5.44 The REWIND command 55
5.45 The SAFPOS command 56
5.46 The SEQNO command 57
5.47 The STOP command 58
5.48 The SYNCTR command 59
5.49 The TLLIFE command 61
5.50 The TMARK command 62
5.51 The TRANS command 63

6 Die sinking EDM language 64
6.1 General comments 64
6.2 The APPLY command 65
6.3 The CUTCOM command 66
6.4 The FLUSH command 69
6.5 The GENRTR command 72
6.6 The LOAD command 73
6.7 The OP command 74
6.8 The SELECT command 78
6.9 The SPINDL command 79
6.10 The TOOLNO command 83
6.11 The UNLOAD command 84

7 Flame cutting language 85
7.1 General comments 85
7.2 The APPLY command 86
7.3 The ASSIST command 87
7.4 The CLDIST command 88
7.5 The PIERCE command 89
7.6 The TORCH command 90

8 Grinding language 91
8.1 General comments 91
8.2 The APPLY command 92
8.3 The DRESS command 93

9 Laser-beam machining language 94
9.1 General comments 94
9.2 The APPLY command 95
9.3 The ASSIST command 96
9.4 The CLDIST command 97
9.5 The CYCLE command 98
9.6 The PIERCE command 101

10 Milling and drilling language 102
10.1 General comments 102
10.2 The APPLY command 103
10.3 The ARCSLP command 104
10.4 The CLAMP command 105
10.5 The CLEARP command 106
10.6 The COOLNT command 107
10.7 The CUTCOM command 108

10.8 The CYCLE command 111
10.9 The HEAD command 133
10.10 The INDPOS command 134
10.11 The LINTOL command 135
10.12 The LOAD command 136
10.13 The ORIGIN command 137
10.14 The RETRCT command 140
10.15 The ROTATE command 141
10.16 The SELECT command 142
10.17 The SPINDL command 143
10.18 The TOOLNO command 147
10.19 The UNLOAD command 148

11 Punching and forming language 149
11.1 General comments 149
11.2 The APPLY command 150
11.3 The CLAMP command 151
11.4 The CYCLE command 152
11.5 The LOAD command 163
11.6 The PIERCE command 164
11.7 The SELECT command 165
11.8 The TOOLNO command 166
11.9 The UNLOAD command 168

12 Turning language 169
12.1 General comments 169
12.2 The APPLY command 171
12.3 The BARFED command 172
12.4 The CATCHR command 173
12.5 The CHUCK command 174
12.6 The CLAMP command 176
12.7 The COOLNT command 179
12.8 The COUPLE command 180
12.9 The CUTCOM command 181
12.10 The DEFCON command 182
12.11 The LOAD command 183
12.12 The MODE command 184
12.13 The OP command 185
12.14 The PITCH command 195
12.15 The SAFETY command 196
12.16 The SELECT command 197
12.17 The SPINDL command 198
12.18 The STAN command 202
12.19 The STDYRS command 203
12.20 The TLSTCK command 204
12.21 The TOOLNO command 205
12.22 The TURRET command 206
12.23 The UNLOAD command 207

13 Wire EDM language 208
13.1 General comments 208
13.2 The APPLY command 209
13.3 The CLDIST command 210
13.4 The CUTCOM command 211
13.5 The CYCLE command 212
13.6 The FLUSH command 215
13.7 The GENRTR command 218
13.8 The LOAD command 219
13.9 The ORIGIN command 220
13.10 The SELECT command 221
13.11 The STAN command 222
13.12 The TOOLNO command 223

13.13 The UNLOAD command 224

14 Probing language 225
14.1 General comments 225
14.2 The APPLY command 226
14.3 The LOAD command 227
14.4 The MODE command 228
14.5 The PROBE command 231
14.6 The SELECT command 237
14.7 The TOOLNO command 238
14.8 The UNLOAD command 239
14.9 The VERIFY command 240

15 Drafting and plotting language 250
15.1 General comments 250
15.2 The DRAFT command 251
15.3 The LETTER command 252
15.4 The OVPLOT command 253
15.5 The PENDWN command 254
15.6 The PENUP command 255
15.7 The PPLOT command 256

Annex A (normative) Rules used in the syntax definitions 258

Annex B (normative) List of keywords 259