

Bi-Directional Turning Cycle

Bi-Directional Turning Cycle

Milltronics Bi-Direction Conversational Turning:

- Improves productivity by up to 60%.
- Increases tool life.
- Improves surface finish.

Improve turning speed and efficiency while taking advantage of the latest insert technology allowing for cutting forward and reverse, down to and up from. Your Milltronics Control on the Cutting Edge!

RunTime 0:00:51 **Enabled** FeedHold SingleBlk Opt Stop Blk-Skip

	Current	Target	Machine
X	+00.7231	+00.6721	-09.2769
Z	-01.5120	-01.5033	-20.2120

Main-Verify-Display-Graphics

CutterComp Off
ActiveTool 1
XLength 03.0000
ZLength 03.0000
Radius 00.0800
WorkCoord (G54) 1
ZClearance 00.1000
FeedRate 000.0500 ipr
(0%) 000.0000 ipm
Spindle (100%) 2000 rpm Off

Cycle None
Dwell 000.0
Coolant
- Part# 0038 + 0
Time 2:29:06 PM

TURN(New)

```
G1 X 0.672116 Z -1.503338  
G1 X 0.671149 Z -1.503138  
G1 X 0.621613 Z -1.490923  
G1 X 0.620470 Z -1.490642  
G1 X 0.619564 Z -1.490380  
G1 X 0.579653 Z -1.477046  
G1 X 0.577156 Z -1.476046  
G1 X 0.574693 Z -1.475024  
G1 X 0.572284 Z -1.473971  
G1 X 0.569912 Z -1.472898  
G1 X 0.567577 Z -1.471804  
G1 X 0.565299 Z -1.470680  
G1 X 0.563060 Z -1.469536  
G1 X 0.560862 Z -1.468374
```

Block #4994 G1 X 0.672116 Z -1.503338 00001 Line#4974

F1 Rotate F2 Pan F3 Position F4 Auto F5 Zoom - F6 Zoom + F7 SwLimits F8 Slice F9 Stock Sz F10 Mode F11 Frame Esc Exit



MILLTRONICS USA
LET'S INVENT