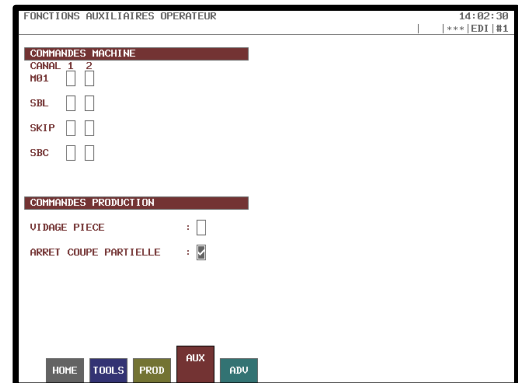

Partial cut ISO Machines

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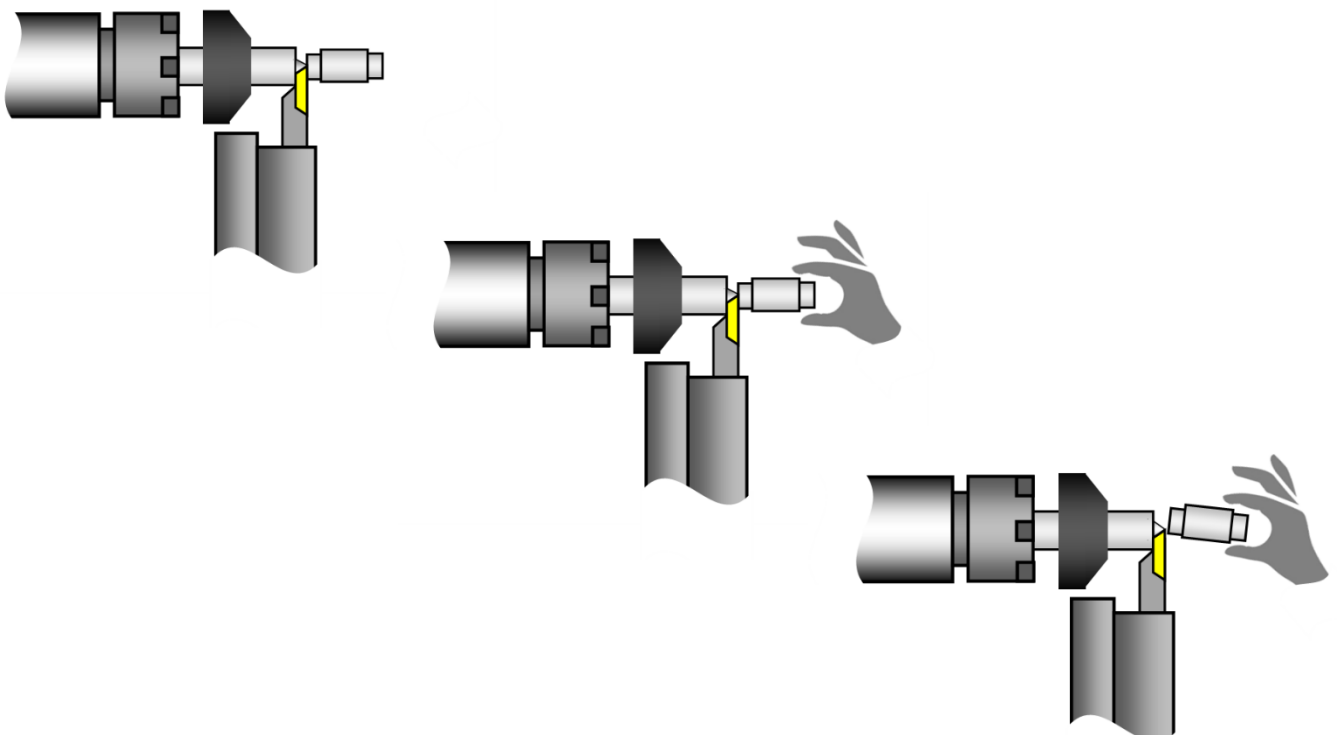
1 Manually retrieve your parts at the guidebush !

If there is a problem well known to bar turning makers who make very small parts, it is the recovery of the last machined part. The ability to retrieve this last part is of paramount importance, because it allows the precise setting of the ratings to ensure the continuation of production. Now it is possible to manually retrieve the part at the guidebush, with the new function "Partial cut stop".



2 The principle

The principle is to interrupt the initial cut (G910) just before the part is completely cut. It is so possible to manually grab the last part of the machined part and detach it from the bar.



3 The sequences

Here are the sequences of use:

- 1) Machining a partial part in main operation
- 2) Press RESET at the desired time (before cutting part)
- 3) Check the box "Partial cut stop" in T-MI
- 4) Start the program
- 5) The cycle marks a stop once the cutter has reached an intermediate cutting position
- 6) Open the door and grasp the part by manually detaching it
- 7) Measure the desired dimensions
- 8) Adapt the tool wears/geometrie if necessary
- 9) Disable the box "Partial cut stop" in T-MI
- 10) Close the door and press start (the cycle will continue normally by reactivating spindle and oil)

4 The programming

No specific prior programming is necessary.

That said, it is possible to set the diameter at which the machine marks its stop thanks to the X argument of the G910. By default, a diameter of 0.2 or 0.3 mm is considered.

