

JOB SHEET PROGRAM CNC TU-2A

MATA KULIAH CNC DASAR



Oleh:

W i d a r t o

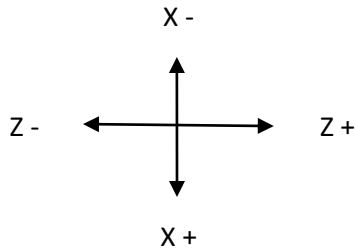
PENDIDIKAN TEKNIK MESIN

FAKULTAS TEKNIK

UNIVERSITAS NEGERI YOGYAKARTA

2003

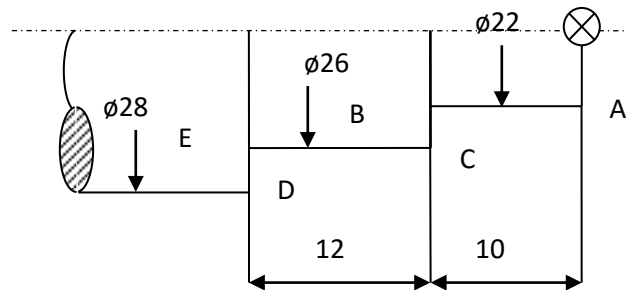
1. Penentuan Koordinat X; Z pada System Absolut:



Koord. arah sumbu X dinyatakan dalam ukuran diameter benda kerja.

Koord. arah sumbu Z diukur jaraknya dari titik referensi (0,0)

Contoh:



Titik	Koord. X	Koord. Z
O	00	00
A	2200	00
B	2200	-1000
C	2600	-1000
D	2600	-2200
E	2800	-2200
A'	-2200	00
B'	-2200	-1000
C'	-2600	-1000
D'	-2600	-2200
E'	-2800	-2200

2. Bahasa Program:

G00 = gerak lurus tidak menyayat

G01 = gerak lurus untuk menyayat

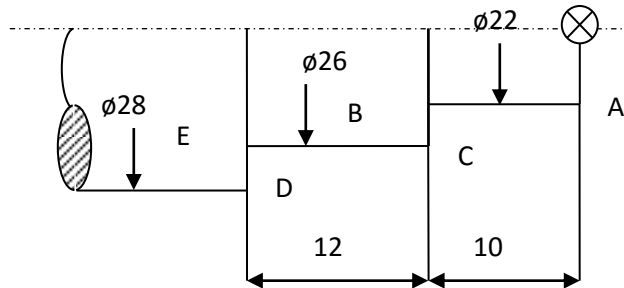
G02 = gerak radius cekung

G03 = gerak radius cembung

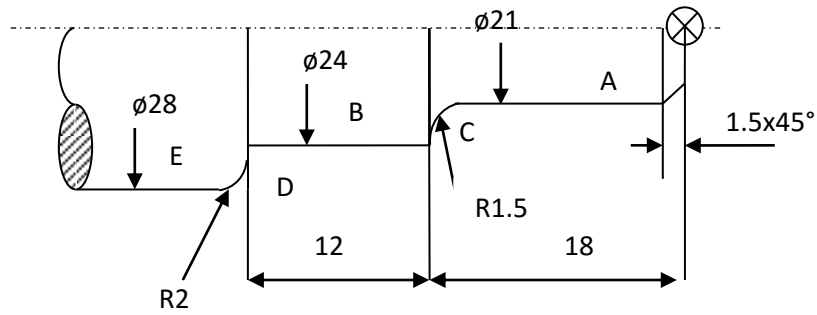
G84 = gerak siklus

G92 = set register

N	G	X	Z	F	H
00	92	3200	200		



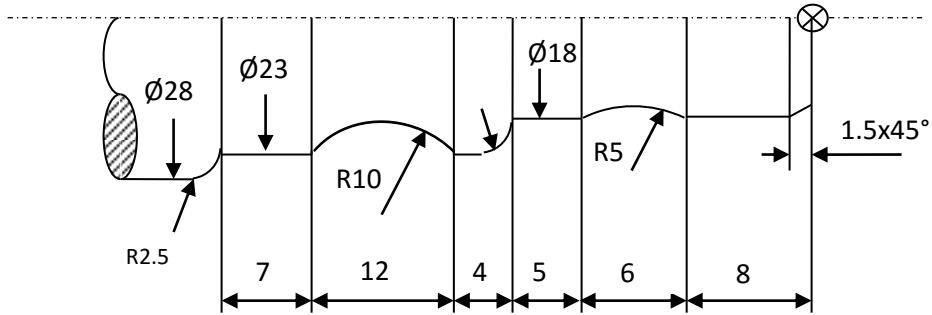
N	G	X	Z	F	H
00	92	3200	200		
01	M03				
02	00	2800	200		
03	84	2600	-2200	60	50
04	00	2600	200		
05	84	2200	-1000	60	50
06	01	2200	00	30	
07	01	2200	-1000	30	
08	01	2600	-1000	30	
09	01	2600	-2200	30	
10	01	2800	-2200	30	
11	M05				
12	00	3200	200		
13	M30				



N	G	X	Z	F	H
00	92	3200	200		
01	MO3				
02	00	2800	200		
03	84	2420	-3000	60	50
04	00	2420	200		
05	84	2120	-1650	60	50
06	01	1800	00	30	
07	01	2100	-150	30	
08	01	2100	-1650	30	
09	02	2400	-1800	30	
10	01	2400	-3000	30	
11	03	2800	-3200	30	
12	M05				
13	00	3200	200		
14	M30				

I adalah jarak proyeksi dari starting point ke pusat lingkaran arah sumbu x.

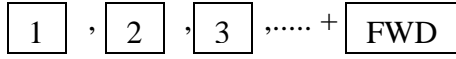
K adalah jarak proyeksi dari starting point ke pusat lingkaran arah sumbu y.



N	G	X	Z	F	H
00	92	3200	200		
01	M03				
02	00	2800	200		
03	84	2320	-4200	60	
04	00	2320	200		
05	84	1820	-1900		
06	01	1500	00	30	
07	01	1800	-150	30	
08	01	1800	-800	30	
09	02	1600	-1100	30	
10	M99	I=400	K=300		
11	02	1800	-1400	30	
12	M99	I=500	K=00		
13	01	1800	-1900	30	
14	01	2000	-1900	30	
15	03	2300	-2050	30	
16	01	2300	-2300	30	
17	01	2100	-2900	30	
18	01	2300	-3500	30	
19	00	2300	-2300		
20	02	1900	-2900	30	
21	M99	I=800	K=600		
22	02	2300	-3500	30	
23	M99	I=1000	K=00		
24	01	2300	-4200	30	
25	03	2800	-4450	30	
26	M05				
27	00	3200	200		
28	M30				

Mengganti Pahat :

- Secara Manual

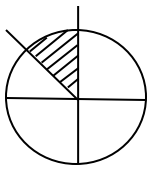


- Secara CNC

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N   G   X   Z   F   H
... 00 4500 -2000
... M06 ...   T02
... 00
    
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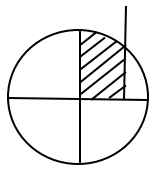
Setting Pahat :



Pahat Rata

X → del

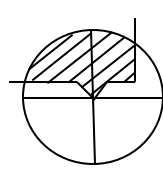
Y → del



Pahat Alur

X → catat

Y → catat

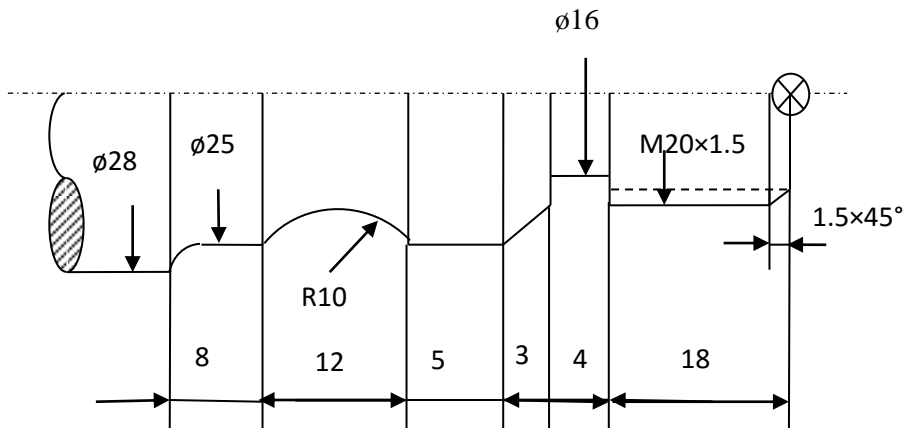


Pahat Ulir

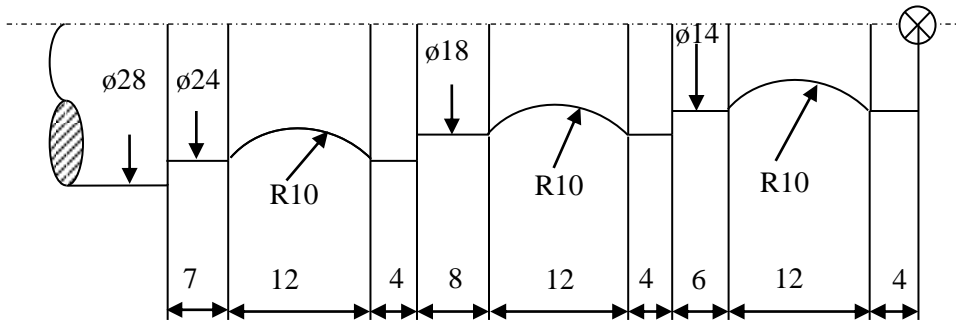
X → catat

Y → catat

Pahat	X	Z
Rata	0	0
Alur	-338	692
Ulir	-101	-542



N	G	X	Z	F	H
00	92	3200	200		
01	M03				
02	00	2800	200		
03	84	2520	-4850	60	50
04	00	2520	200		
05	84	2020	-2200	60	50
06	01	1700	00	30	
07	01	2000	-150	30	
08	01	2000	-2200	30	
09	01	2500	-2500	30	
10	01	2500	-3000	30	
11	01	2300	-3600	30	
12	01	2500	-4200	30	
13	01	2500	-3000	30	
14	02	2100	-3600	30	
15	M99	I=800	K=600		
16	02	2500	-4200	30	
17	M99	I=1000	K=00		
18	01	2500	-4850	30	
19	02	2800	-5000	30	
20	00	4500	-2000		
21	M06	<input type="text"/>	<input type="text"/>	T02	
22	00	2200	-1800		
23	86	1600	-2200	10	310
24	00	4500	-2000		
25	M06	<input type="text"/>	<input type="text"/>	T02	
26	00	2000	200		
27	78	1760	-2000	K150	05
28	78	1760	-2000	K150	00
29	78	1760	-2000	K150	00
30	78	1760	-2000	K150	00
31	00	4500	-2000		
32	M06	00	00	T02	
33	00	3200	200		
34	M05				
35	M30				



N	G	X	Z	F	H
00	92	3200	200		
01	M03				
02	00	2800	200		
03	84	2420	-6900	60	50
04	00	2420	200		
05	84	1820	-4600	60	50
06	00	1820	200		
07	84	1420	-2200	60	50
08	01	1400	00	30	
09	25			L=21	
10	01	1400	-2200	30	
11	01	1800	-2200	30	
12	25			L=21	
13	01	1800	-4600	30	
14	01	2400	-4600	40	
15	25			L=21	
16	01	2400	-6900	30	
17	01	2800	-6900	30	
18	M05				
19	00	3200	200		
20	M30				
21	91				
22	01	00	-400	30	
23	01	-100	-600	30	
24	01	100	-600	30	
25	00	00	1200		
26	02	-200	-600	30	
27	M99	I=800	K=600		
28	02	200	-600	30	
29	M99	I=1000	K=00		
30	90				
31	M17				