SIEMENS

SINUMERIK 840D/840Di
SINUMERIK 810D/FM-NC

Short Guide   **10.2000 Edition**

Programming

User Documentation

SIEMENS

SINUMERIK 840D/840Di
SINUMERIK 810D/FM-NC

Short Guide
Programming

Valid for

Control	Software version
SINUMERIK 840D	6
SINUMERIK 840DE (Export version)	6
SINUMERIK 840Di	1
SINUMERIK 840DiE (Export version)	1
SINUMEbcK 810D	4
SINUMERIK 810DE (Export version)	4
SINUMERIK FM-NC	3

10.00 Edition

SINUMERIK® documentation

Printing history

Brief details of this edition and previous editions are listed below.

The status of each edition is shown by the code in the "Remarks" column.

Status code in the "Remarks" column:

A .... New documentation.
B .... Unrevised reprint with new Order No.
C .... Revised edition with new status.
If factual changes have been made on the page since the last edition, this is indicated by a new edition coding in the header of that page.

Edition	Order No.	Remark
11.94	6FC5298-0AB30-0BP0	A
04.95	6FC5298-2AB30-0BP0	C
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08.97	6FC5298-4AB30-0BP0	C
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This manual is included in the documentation available on CD-ROM **(DOCONC**D)

Edition	Order No.	Remark
10.00	**6FC5298-6CA00-0BG0**	**C**

Further information is available on the Internet under:
http://www.ad.siemens.de/sinumerik

This publication was produced with WinWord V 7.0 and Designer V 4.0

Other functions not described in this documentation might be executable in the control. This does not, however, represent an obligation to supply such functions with a new control or when servicing.

Subject to technical change without prior notice.

Introduction

How to use this booklet

This booklet is a programming guide describing all the main programming steps.

The aim is to provide the operator with some quick help and a memory aid especially for commands that are used infrequently or to offer a quick reference guide on various parameters.

The guide therefore has little text and is easily comprehensible.

First familiarize yourself with the symbols below so that you understand them better whenever they occur on the following pages.

The symbols

Gives you a tip or background information.

Points out hazards, sources of error or general problems.

Structure of the descriptions

The system used in these descriptions is based on the following scheme:

Programming of the function

Meaning of the parameters

Explanatory illustration with example workpiece

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List of sections

7. Predefined Switching and Auxiliary Functions   7-87

8. Program Key   8-91

1. What is at the Beginning of the Program

Absolute and incremental dimensions, G90, G91

Programming

```
N5 G0    G90 X25 Y15 Z2 LF
N20 G1   G91 X80 F300 LF
```

G90   Absolute dimension input, all data refers to the
             actual workpiece zero.
G91   Incremental dimension input, each dimension
             refers to the contour point last input.

You can change over from block to block as often as you
want between absolute and incremental data input.

Within a block, you can also change the type of input for
individual axes by specifying AC for absolute coordinates or
IC for incremental coordinates.
Example: X = AC (400)

Milling:


```
N5 G00 G90 X25 Y15 Z2 LF
N10 G01 Z-5 F300 LF
N20 G01 G91 X80 LF
```
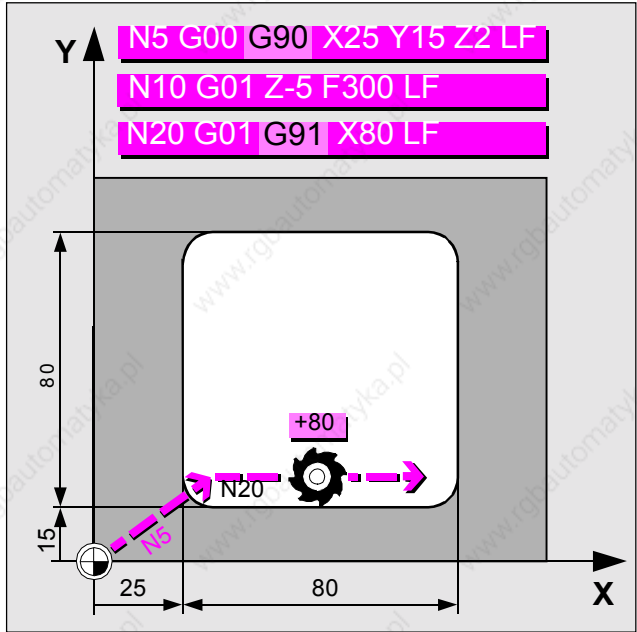
Change between absolute and incremental dimension programming

Absolute and incremental dimensions, G90, G91 (cont.)

Programming

```
N5 G0    G90 X25 Z1
N10 G1 Z-7.5 F0.2
N20 G1 X40 Z-15
N30 G1 G91 Z-10
N40 G1 G90 X60 Z-35
```

G90   Absolute dimension input, all data refers to the actual workpiece zero.

G91   Incremental dimension input, each dimension refers to the contour point last input.

Turning:
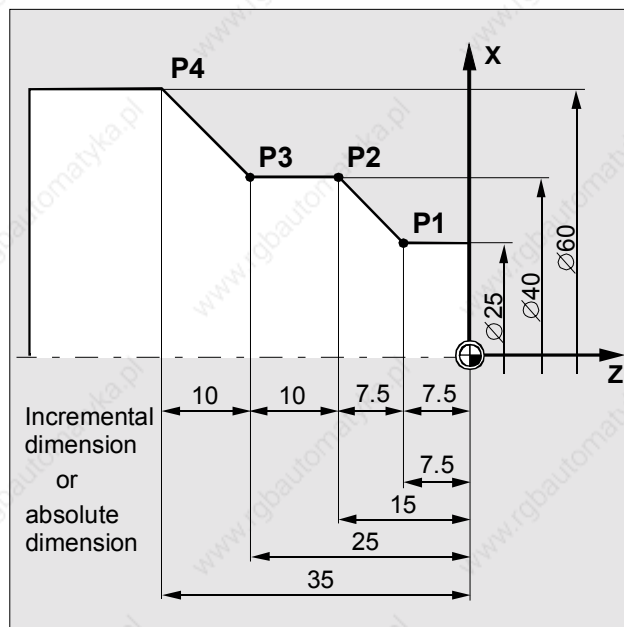
Dimensions: incremental or absolute dimensions

Zero offset, G54 to G57

Programming

```
N30...LF
N40 G54 LF
N50 G0 X30 Y75LF
```

Other zero offsets: G55...G57, G505…G599

Parameters   X,Y,Z   Coordinates of the zero offsets (definition of
                                   workpiece coordinate system). These must
                                   have been input via operator panel or universal
                                   interface into the control before programming.

With command G53, zero offsets can be suppressed block
by block; deactivate with G500.

Milling:
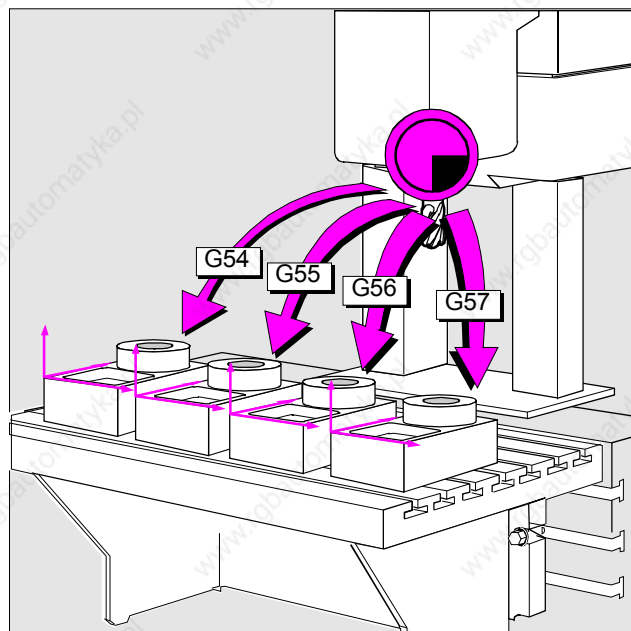
Zero offsets make multiple machining operations possible

Zero offset, G54 to G57 (cont.)

Programming
```
N10 G54
N20 G0 Z0.2
```

Parameter   Z   Coordinates of the zero offsets (definition of workpiece coordinate system). These must have been input via operator panel or universal interface into the control before programming.

In turning machines, a zero offset is generally advisable in the Z direction only.

Turning:
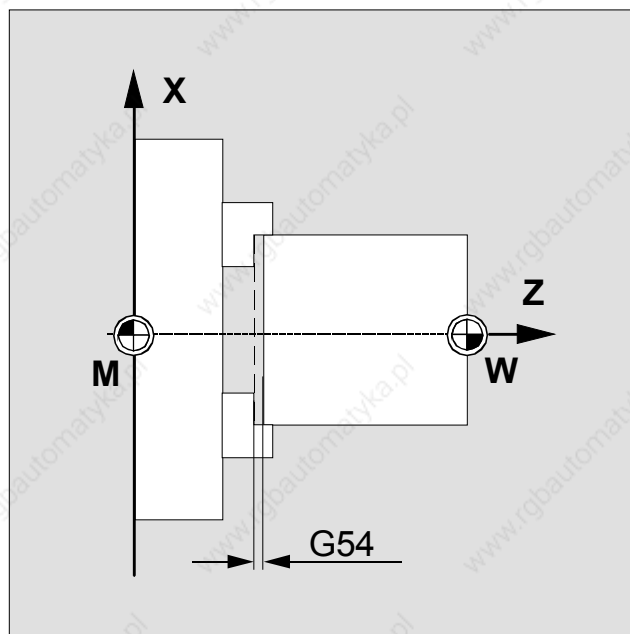
Zero offsets in the Z direction

Selection of working plane G17 to G19

Programming

`N10 G0 X50 Z50` `G17` `D1 F1000 LF`

Command	Working plane	Infeed axis
G17	X/Y	Z
G18	Z/X	Y
G19	Y/Z	X

Programming of the working plane is needed for computation of the tool offset data.
It is not possible to change the working plane when G41/G42 is active.

Milling:
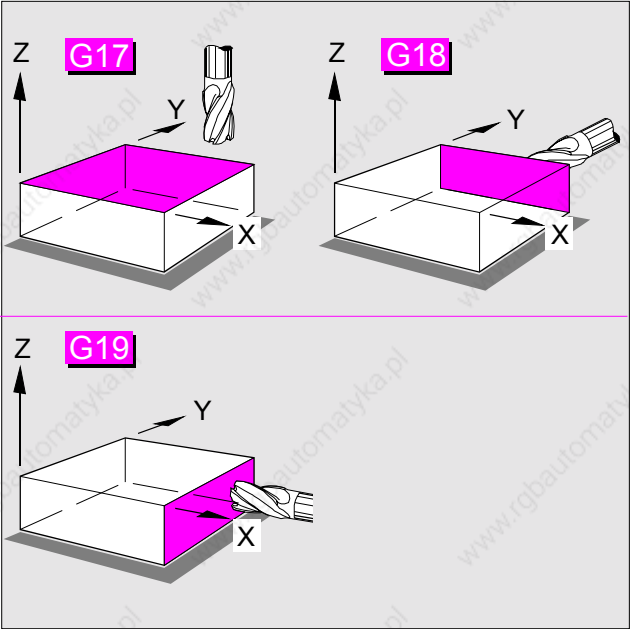
Selection of working planes for horizontal and vertical milling operations

Selection of working plane, G17 to G19 (cont.)

Programming   N10 G0 X10 Z20   G18 D1 F200

In the basic setting, G17 is preset for milling (X/Y plane)
and G18 for turning (Z/X plane).

Turning:
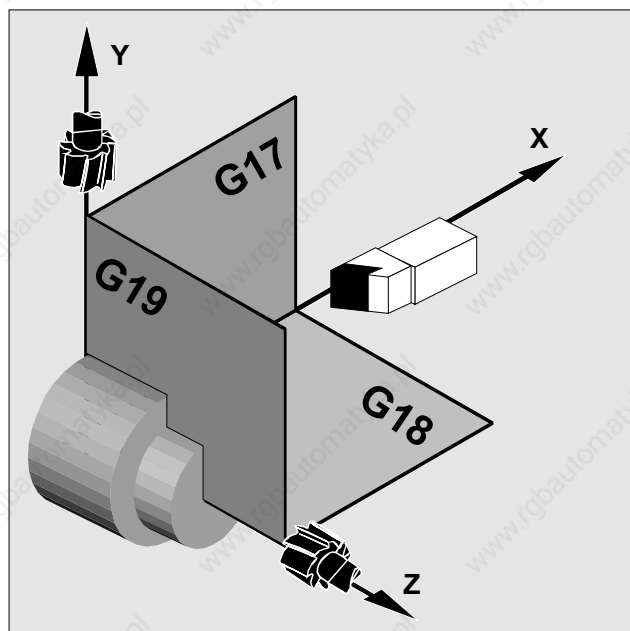
Selection of working planes for horizontal and vertical turning operations

2. Programming Motion Commands

Rapid traverse, G0

Programming   `N10` `G0` `X0 Y0Z3 LF`

Parameters   X, Y, Z   Coordinates of the target point

Milling:
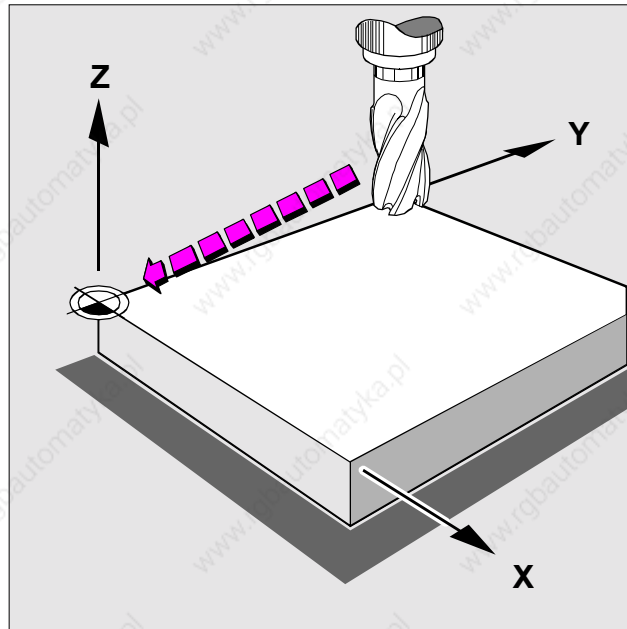
Fast tool positioning in rapid traverse for milling

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Rapid traverse, G0 (cont.)

Programming   N20   G0   X25 Z1

Parameters   X, Z   Coordinates of the target point

Turning:
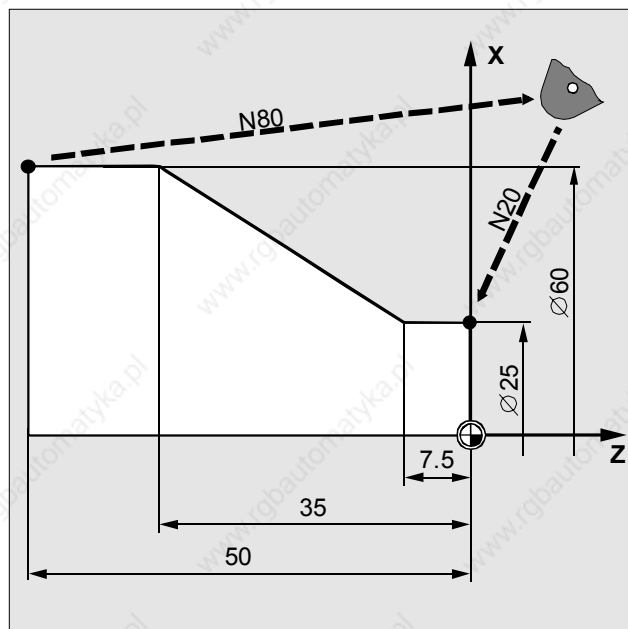
Fast tool positioning in rapid traverse for turning

Linear interpolation, G1

Programming	N10 G0 G90 X10 Y10 Z1 S800 M3 LF
	N20 G1 Z-12 F500 LF
	N30 X30 Y35 Z-3 F700 LF

Parameters	X, Y, Z	Coordinates of the target point
	F	Feedrate

Milling:
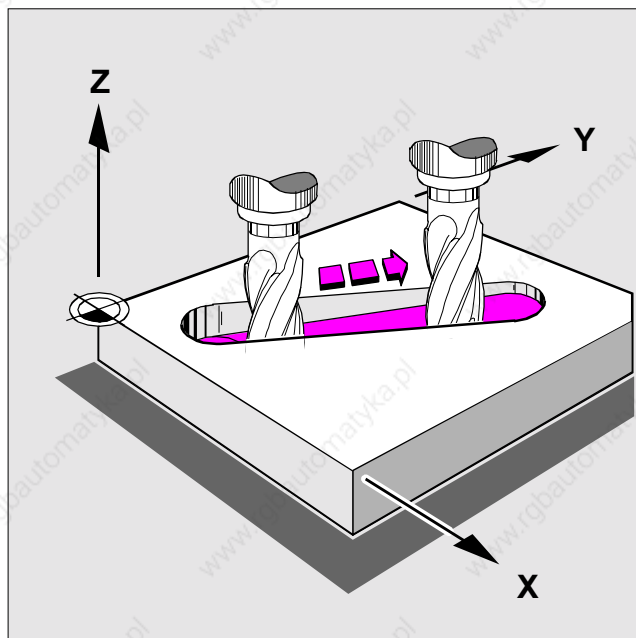
Making an inclined slot

Linear interpolation, G1 (cont.)

Programming

```
N10 G17 S400 M3
N20   G0    X40 Y-6 Z2
N30   G1    Z-3 F40
N40 X12 Y-20
```

Parameters   X, Y, Z   Coordinates of the target point
                   F   Feedrate

Turning/milling:
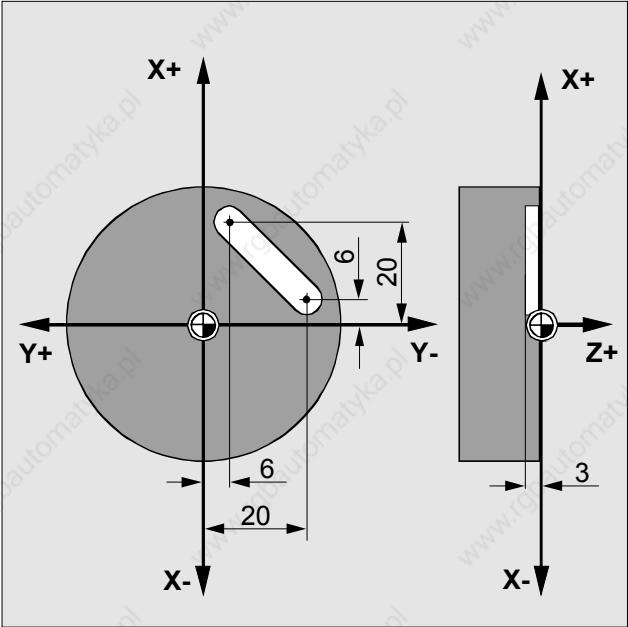
Making a slot

Circular interpolation, G2/G3

Programming	N5 G0 G90 X35 Y60 LF
	N10 G3 X50 Y45 I0 J-15 F500 LF

Parameters

X, Y, Z   Coordinates of the circle end point

I, J, K   Interpolation parameters (directions: I in X,
           J in Y, K in Z) for determining the circle center
           point

AR   Opening angle

With G2 the tool travels clockwise, with G3
counterclockwise. Viewing direction along the third
coordinate axis.
When programming with the opening angle
the circle center point or circle end point must also be
specified.

Milling:
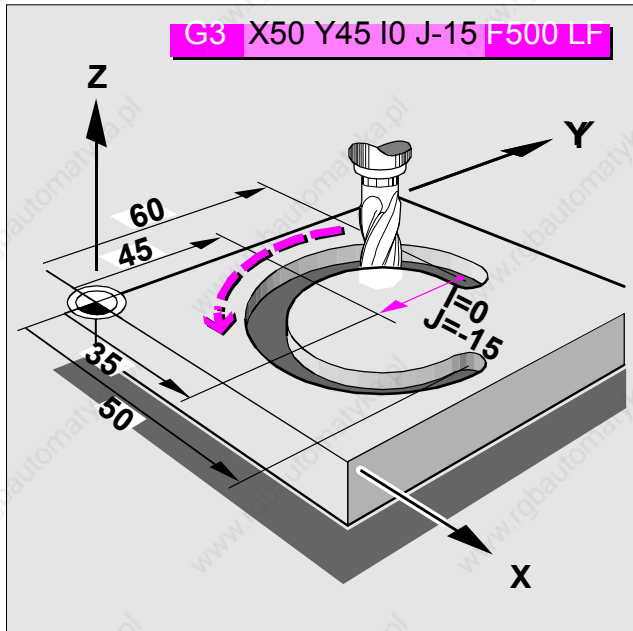
Making a circular slot

Circular interpolation, G2/G3 (cont.)

Programming	N10 G0 X12 Z0
	N20 G1 X40 Z-25 F0.2
	N30 G3 X70 Z-75 I-3.335 K-29.25

Parameters

X, Y, Z   Coordinates of the circle end point

I, K   Interpolation parameters (directions: I in X,
K in Z) for determining the circle center point

Turning:

Making a ball end bolt

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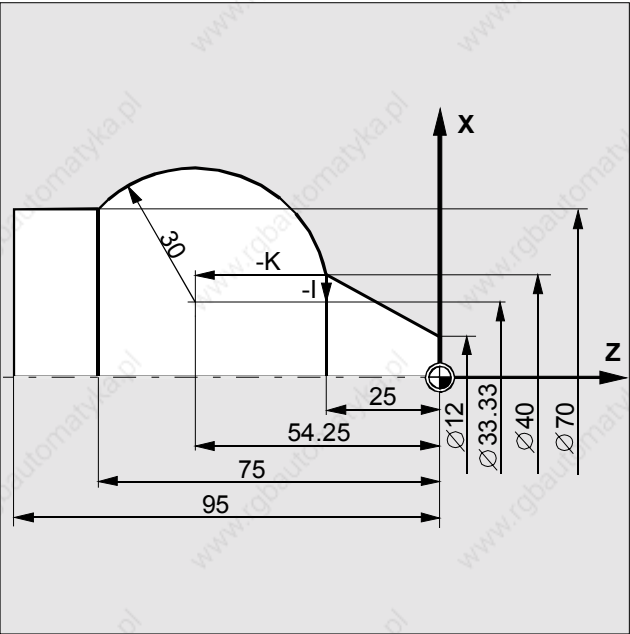
Radius programming, G2/G3

Programming	N20 G90 G0 X68 Z102
	N30 G90 G3 X20 Z150 CR=48 F300 LF

Parameters	CR	Circle radius
	CR+	Traversed angle ⇔ 180°
	CR-	Traversed angle > 180°
	X... Z...	Definition of end point

Radius programming is not allowed if the traversed angle is 360°.
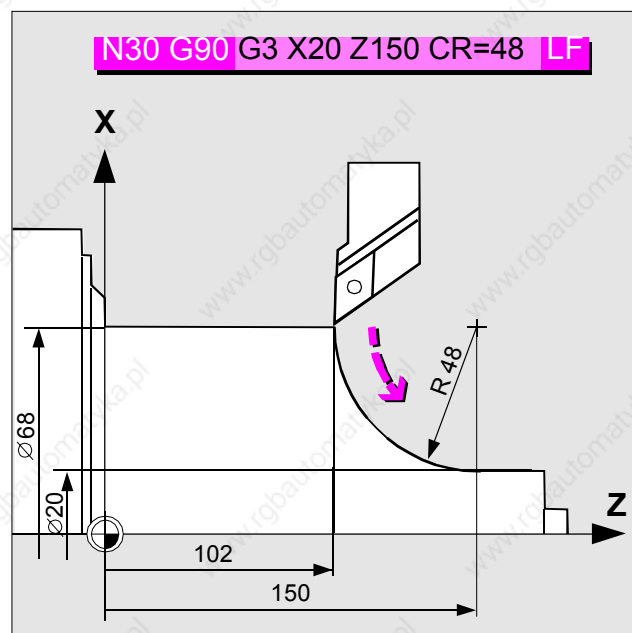
Radius programming from drawing

Circular interpolation through intermediate point, CIP

Programming	`N10` `CIP` `X87 Y20 I1=60 J1=35 LF`
Parameters	X, Y, Z Coordinates of the circle end point
	I1, J1, K1 Interpolation parameters for determining the intermediate point

If the circle parameter point is not given in the production drawing, you can program circular interpolations with CIP without additional calculations.
You can also use this function to program circles in space.

Milling:

Circular interpolation through intermediate point

2-25
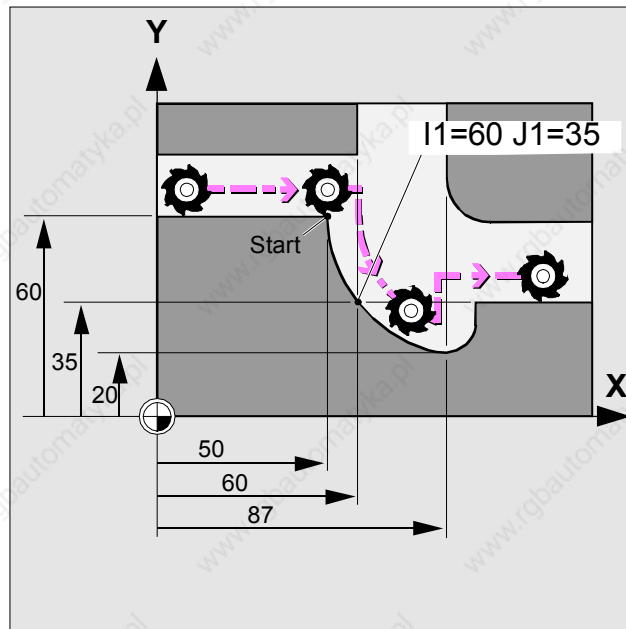
Circular interpol. through interm. point, CIP (cont.)

Programming	N90 G1 X40 Z-25
	N100 CIP X70 Z-75 I1=93.33 K1=-54.25

Parameters X, Z   Coordinates of the circle end point
I1, K1   Interpolation parameters for determining the
intermediate point

Turning:

Circular interpolation through intermediate point

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Thread cutting, G33

Programming	N20 G33 Z22 K2 LF

Parameters	Z, X	Thread end point
	K	Thread lead for cylindrical thread
	I	Thread lead for face thread
	I	Thread lead for taper thread (angle of taper > 45°)
	K	Thread lead for taper thread (angle of taper < 45°)
	SF	Start point offset in degrees

Right-hand or left-hand threads are programmed by specifying the direction of spindle rotation M3/M4. Spindle rotation and speed must be programmed in the block before G33.

For programming taper threads, enter the X and Z coordinates with G33. Multiple threads can be programmed with offset start points (SF=…).

N15 X38.7 LF
N20 G33 Z22 K2 LF

N50 X37.4 LF
N60 G33 Z22 K2 LF
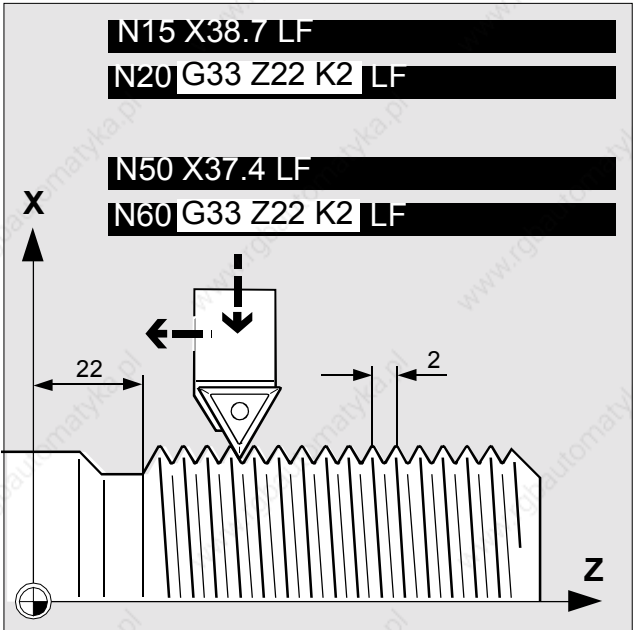
Making a longitudinal thread

Rigid tapping, G331/G332

Programming

```
N40    SPOS=0  LF
N50    G331 Z-50 K2 S500  LF
N60    G332 Z5 K2          LF
```

SPOS=0	Change spindle to position control and put into position
G331	Tapping
G332	Tapping with retraction. The spindle changes direction of rotation automatically

Parameters

X, Y, Z	Thread end point
I, J, K	Thread lead. Positive lead (e.g. K4) right-hand thread, negative lead (e.g. K-4) left-hand thread.

For this function, the spindle must be equipped with a pulse generator.
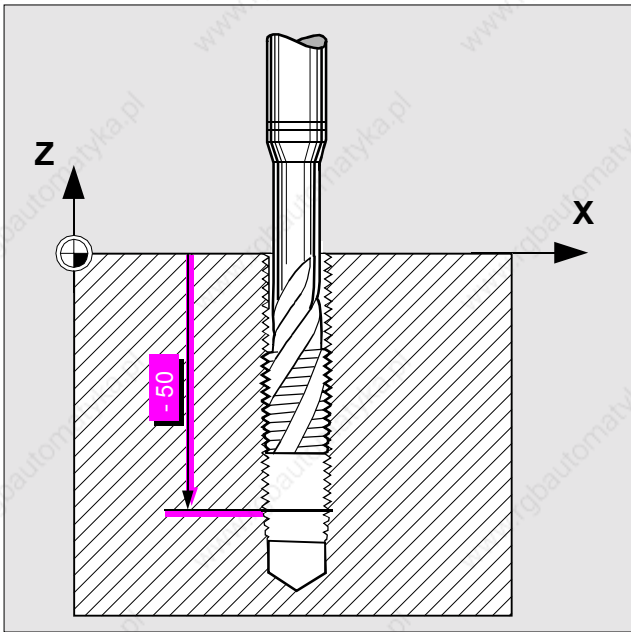
Tapping

Tapping with floating tapholder, G63

Programming

```
N10   G63 Z-50 M3 S...F...LF
N20   G63 Z4 M4    F...LF
```

G63   For the retraction movement, you program
        another block with G63 and the relevant
        direction of spindle rotation.

Parameters

S	Spindle speed
F	Feedrate
M3	Direction of rotation right
M4	Direction of rotation left

Calculation of feedrate:

F = Spindle speed x Thread lead

For this function, you need a tap in the floating tapholder. A
pulse generator is not needed for the spindle.
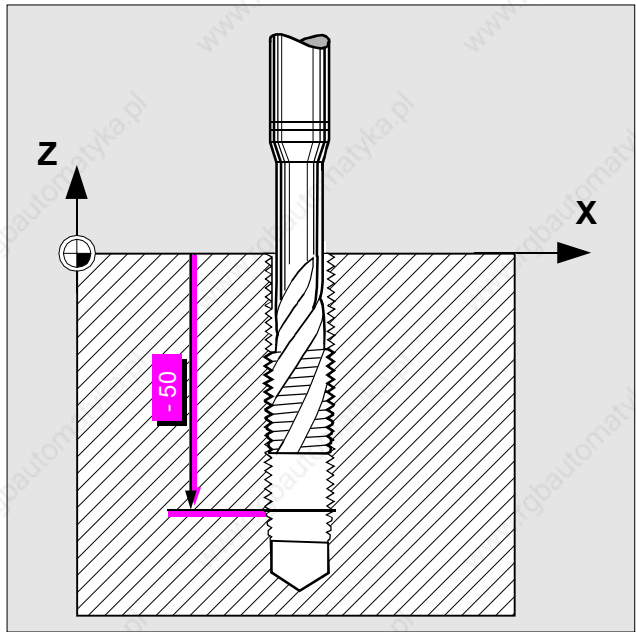
Tapping with floating tapholder

Polar coordinates G110, G111, G112

Programming	` N30   G111 X40 Y35 Z40 LF ` ` N40   G3 RP... AP...   LF `

G110	Definition of pole, referred to tool position last programmed
G111	Definition of pole, absolute in the workpiece coordinate system
G112	Definition of pole, referred to pole last valid

Parameters		
	X, Y, Z	Coordinates of the pole
	RP	Radius, distance between pole and target point
	AP	Angle between path between pole and target point and the angle reference axis (pole axis first named)

The pole (center point) can be defined in rectangular or polar coordinates.
When programming the circle, the pole is in the circle center point and RP corresponds to the circle radius.
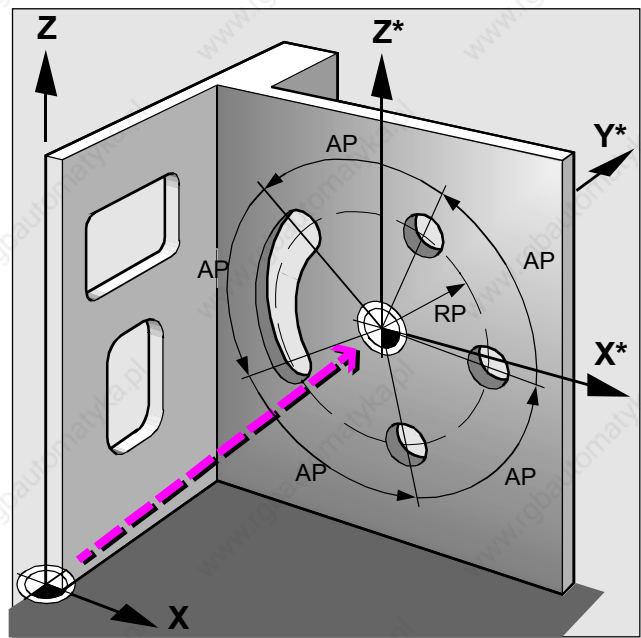
Description of travel paths using polar coordinates

3. Tool Offsets and Compensations

Tool call

Programming   N10 G18 T17 D8 LF

T...   Call tool number
D...   Call tool offset, activate tool length
              compensation

To make sure that the tool offset values are calculated
correctly in the axes, the machining level must be selected
before calling the tool.

Tool offset values can be exchanged in the course of the
NC run. The machining plane does not have to be
reprogrammed.

If no D number is to be input when the tool is called, a D
number can be specified via machine data.
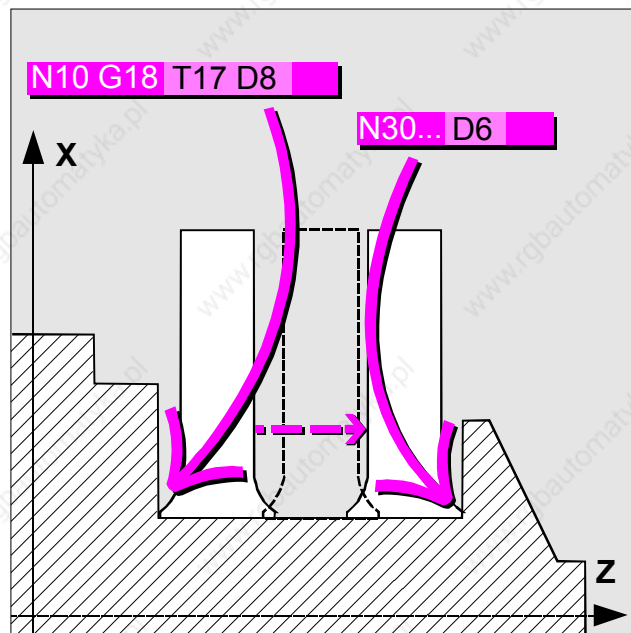
Offset values for left-hand and right-hand tool nose for recessing tool

Cutter radius path compensation, G41/G42

Programming   N10 G1 G17 G41 D8 X... Y... Z... F500 LF

G41   Call for cutter path compensation, tool in
             traversing direction left of contour
G42   Call for cutter path compensation, tool in
             traversing direction right of contour
G40   Deselection of cutter path compensation

The tool length compensation acts automatically after tool
offset D has been called.

In the NC block with G40/G41/G42 at least one axis of the
selected working plane (G17 to G19) must be programmed.

Selection and deselection of the CRC must be made in
a program block with G0 or G1.
The offset acts only in the programmed working plane
(G17 to G19).
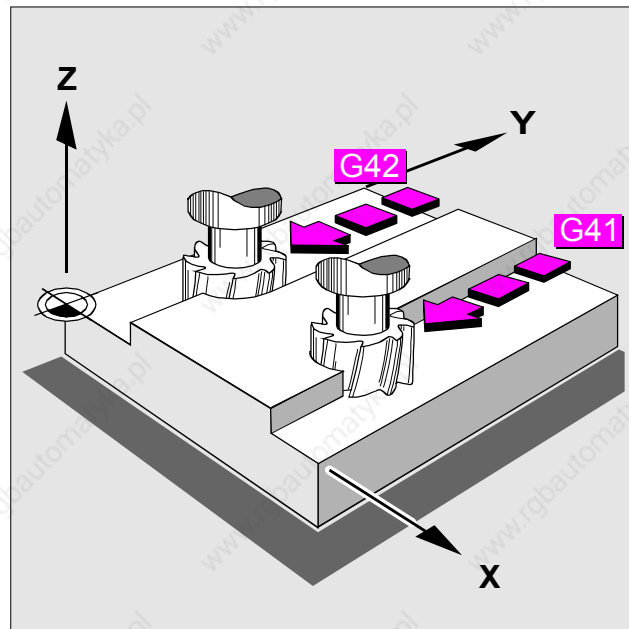
The control computes the tool path

3-33
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Tool nose radius compensation, G41/G42

Programming

N5 G90 G0 G18 G41 D... X... Y... Z... LF

G41	Call for radius compensation, tool motion in traversing direction left of workpiece
G42	Call for radius compensation, tool motion in traversing direction right of workpiece
G40	Deselection of radius compensation

In the NC block with G40/G41/G42 at least one axis of the selected working plane (G17 to G19) must be programmed.

Selection and deselection of the compensation must be made in a program block with G0 or G1. The compensation acts only in the programmed working plane (G17 to G19).

G42

Contour traversed without tool nose radius compensation

G41

Contour programmed and traversed with tool nose radius compensation
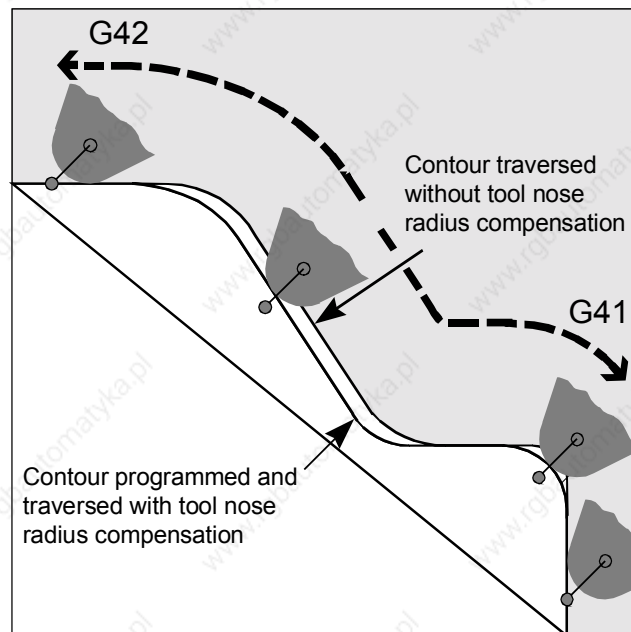
Tool nose radius compensation for machining slopes and circular arcs

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Activating/deactivating the collision detection

Programming   N10 G41 X...Y...Z... CDON LF

CDON Collision detection on
CDOF Collision detection off

The control detects and corrects critical machining
situations.
Example: For machining the inside corner, a tool radius has
been selected that is too high.
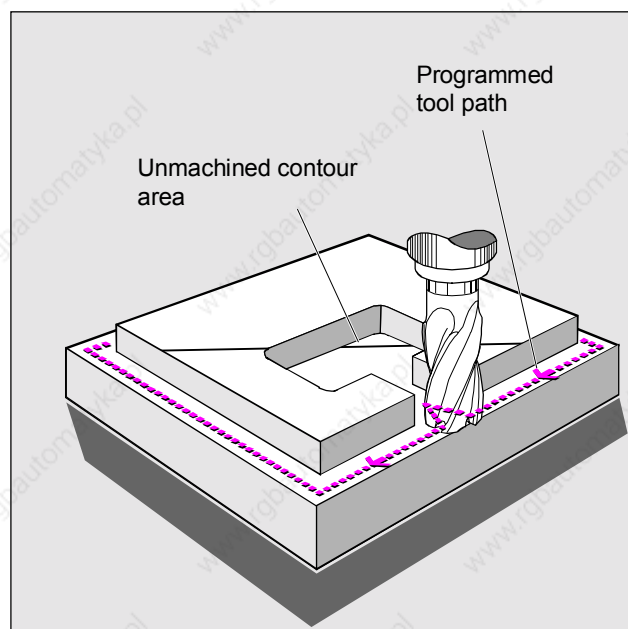
The control takes action in good time

3-35
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Approach and exit the contour, NORM/KONT

Programming	KONT G41 G450 X... Y... Z... LF

NORM	The tool travels directly along a straight line and is perpendicular to the contour point.
KONT	The tool travels around the contour point in accordance with the programmed behavior at corners G450/G451.

For KONT: If start point and contour point are on one side of a workpiece, the contour point is approached as with NORM directly along a straight line.
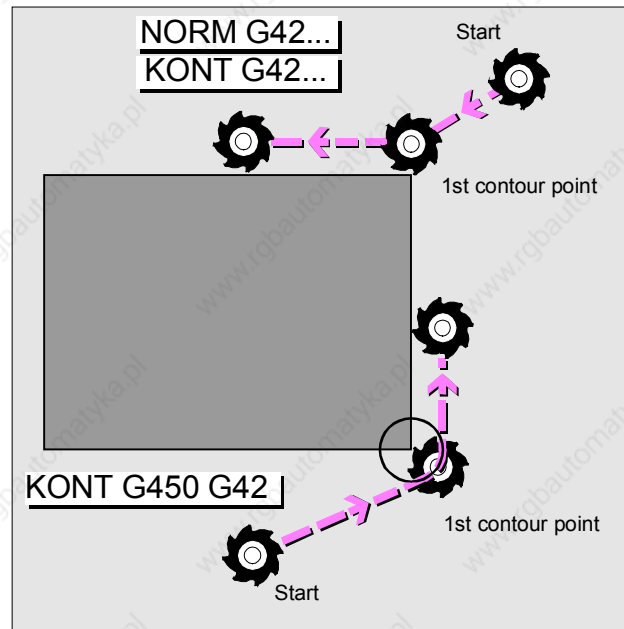
Programmable behavior for approach and exit

Programmable contour travel mode, G450/G451

Programming   N10 G41 G450 X... Y... Z... LF

G450   Transition circle, the tool travels around
            workpiece corners along a circular path with
            tool radius.
G451   Intersection point, the tool cuts free in the
            workpiece corner.

G450

Transition circle

G451

Intersection point
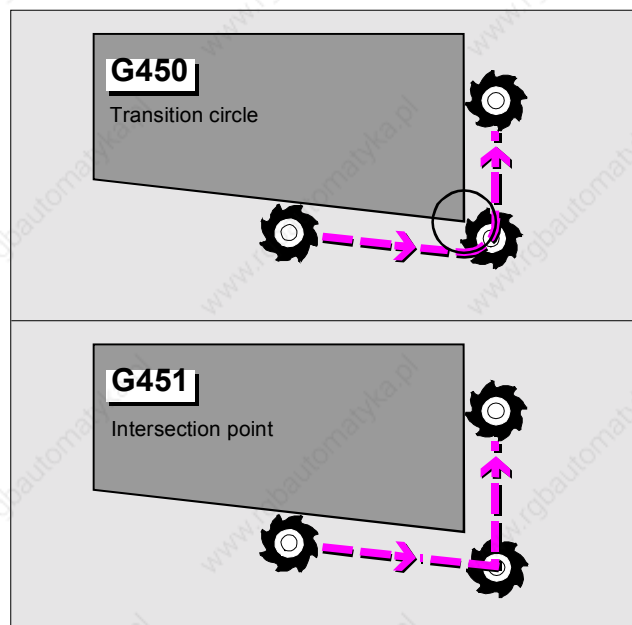
Tool travel behavior at workpiece corners

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3-37

4. Programming Aids Assist the Programmer

Overview of frame concept

Programming   For the three-dimensional description of the workpiece
                         coordinate system, the following functions are available.

                         TRANS/ATRANS   Translation of the zero point
                         ROT/AROT   Rotation
                         SCALE/ASCALE   Change of scale
                         MIRROR/AMIRROR   Mirroring

                         The actual coordinate system can be anywhere in space.
                         This also allows skew contours to be produced.

Milling:
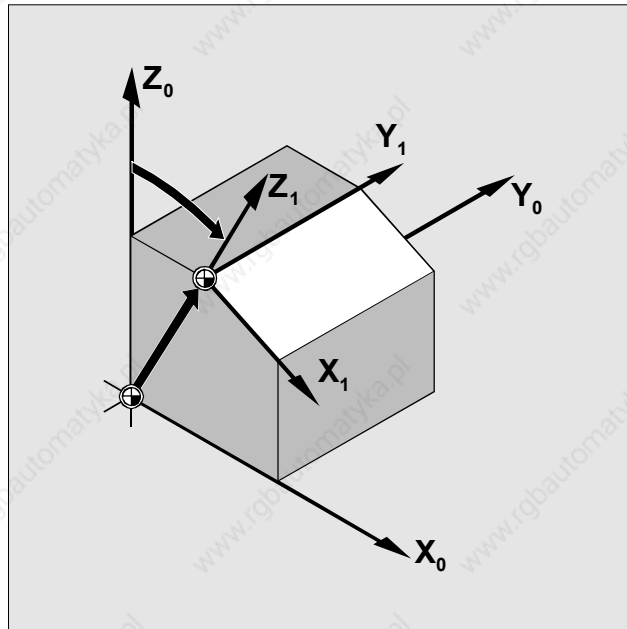
Programmable frames allow inclined contours to be machined

Overview of frame concept (cont.)

Turning:
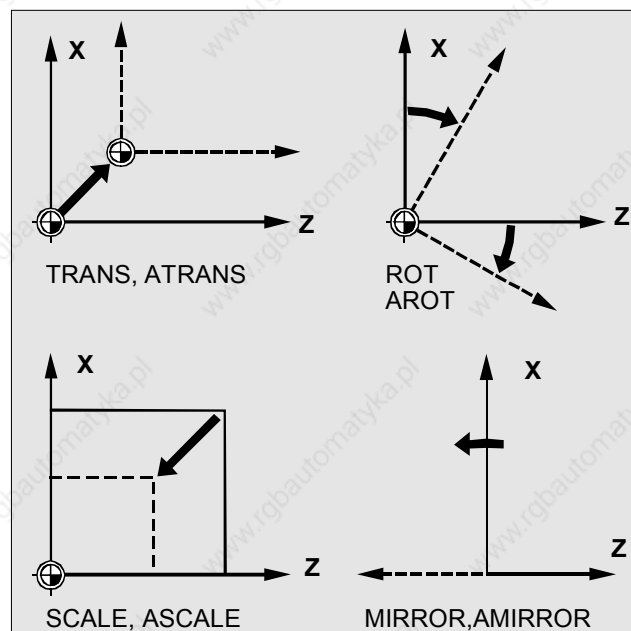
Programmable frames allow inclined contours to be machined

Translating/rotating the coordinate system, TRANS/ROT

Programming

```
N30...G54 LF
N40    G90 TRANS X40 Y40 Z30   LF
N50    G90 AROT Z 30   LF
```

To switch off ZO: TRANS (without specifying axis)

To switch off rotation: ROT (without specifying angle)

In all cases, the complete frame is deleted here!

TRANS	Absolute translation
ATRANS	Additive translation

Parameters

X, Y, Z	Coordinates of zero offset in axial direction
ROT	Absolute rotation
AROT	Additive rotation

Parameters

X, Y, Z	Coordinate axis about which rotation occurs in angular degrees (positives sign = counterclockwise rotation)

Milling:
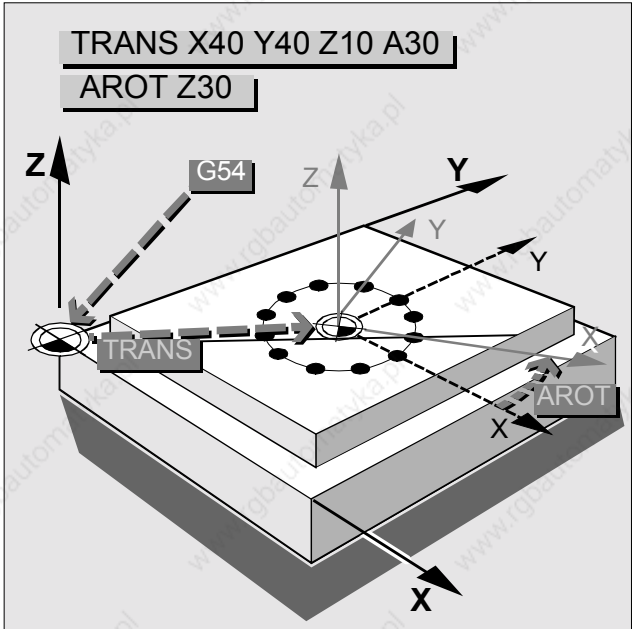
Changing the zero point for producing a drilling pattern

Translating/rotating the coordinate system, TRANS/ROT

Programming

```
N30...G54
N40    TRANS Z150
```

TRANS	Absolute translation
ATRANS	Additive translation

Parameter   Z   Coordinates of zero offset in axial direction

On turning machines, a zero offset is usually sensible in the Z direction only.

Turning:
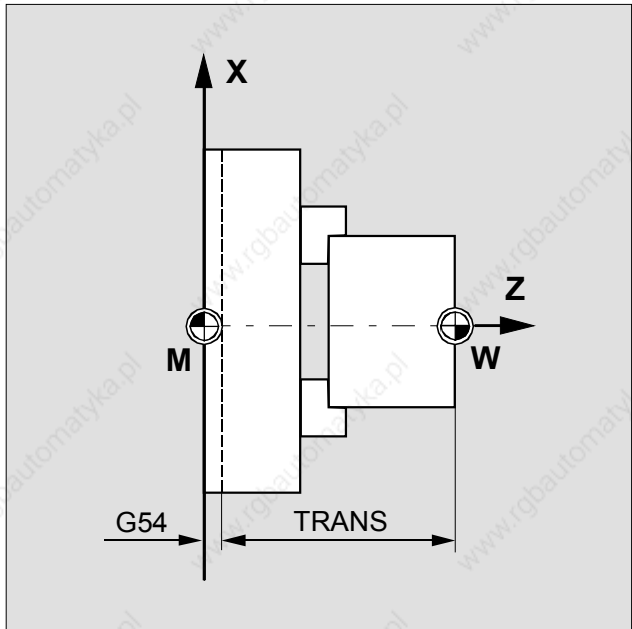
Changing the zero point in the Z direction

Mirroring on the coordinate axes, MIRROR

Programming

N10 MIRROR X0 LF

Switch off MIRROR (without defining axis)

In all cases, the complete frame is deleted here!

Parameters

MIRROR   Absolute mirroring
AMIRROR   Additive mirroring
X, Y, Z   Address with value 0 of the axis at which
            mirroring takes place.

When mirroring on a coordinate axis, the control changes
• the signs of the mirrored coordinates,
• the direction of rotation of circular interpolations and
• the machining directions (G41/G42).
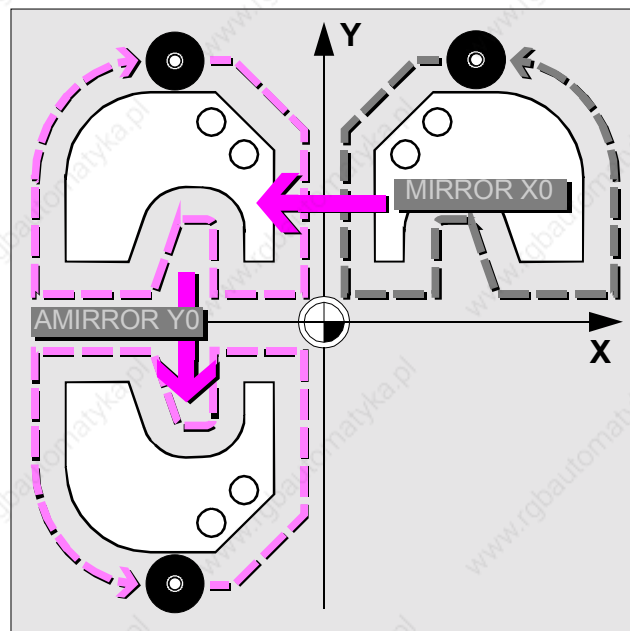
No additional programming for symmetrical contours

Increasing/reducing size of contour, SCALE

Programming   N10   SCALE X2 Y2   LF
                       Switch off SCALE (without defining axis)

In all cases, the complete frame is deleted here!

Parameters   SCALE   New scale factor
                  ASCALE   Additive scale factor
                  X, Y, Z   Axes with scale factor in the direction of which
                            the contour is to be increased or reduced in
                            size.

If transformation follows with ATRANS, the offset values are
also scaled.

Any contours that you wish to increase or reduce in size are
best defined in a subroutine.

You can define an individual scale factor for each axis.

SCALE X1.5 Y1.5 Z1.5
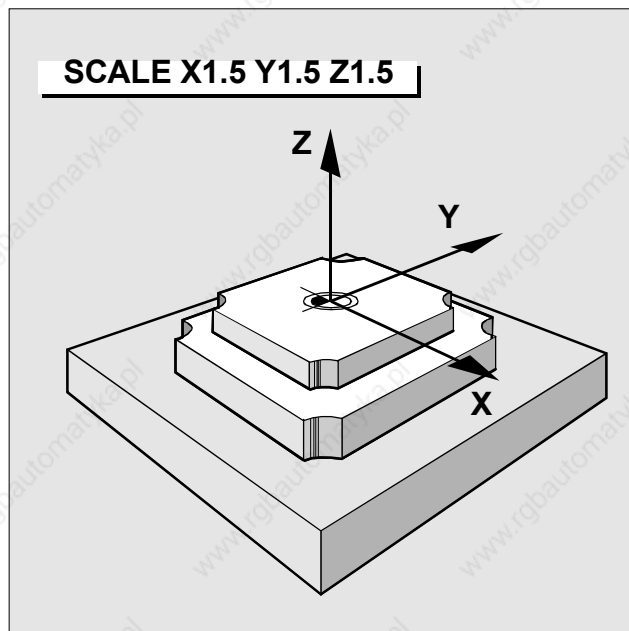
No additional programming for similar contours

5. Programming Preparatory Functions

Feedrate programming, G93 to G97

Programming

```
N5 G90 G00 X... Y... Z... LF
N10    G94 F500    G01...M3 LF
```

G93 F	Feedrate in 1/min (inverse time feedrate)
G94 F	Constant speed and feedrate in mm/min
G95 F	Constant speed and feedrate in mm/revolution
G96 S	Constant cutting velocity in m/min
F	Feedrate in mm/revolution
G97	Switch off G96, store the last speed setpoint of G96 as constant speed.

The maximum feedrates and speeds are defined by the machine manufacturer.
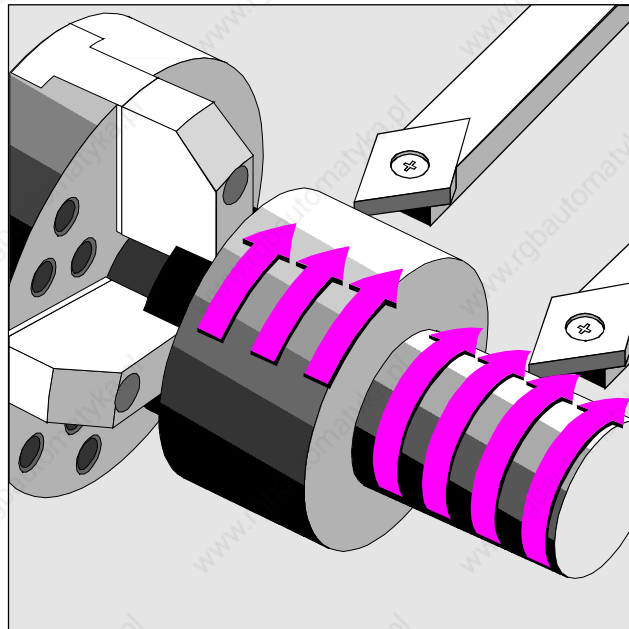
Automatic speed control for constant cutting velocity

Exact stop, G9/G60

Programming   G601 Exact positioning fine
                  G602 Exact positioning coarse
                  G603 Exact positioning at end of interpolation
                  G9   Exact positioning, active in the block
                  G60   Exact positioning, modal, active until deselected by
                        G64, G641.

The exact positioning functions are used in order to produce sharp outside corners or to finish inside corners to the required dimension.

The exact positioning limits are defined in the machine data.
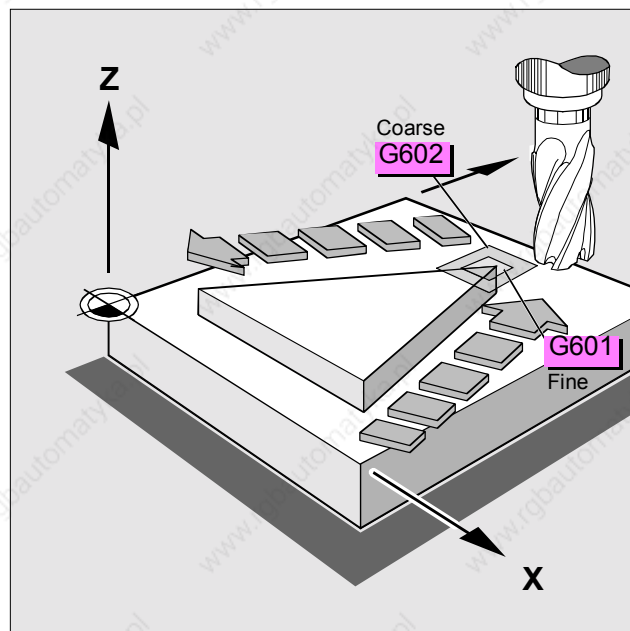
Producing sharp outside corners

Feedrate in continuous path mode, G64, G641

Programming   G64   Continuous path mode

G641   Block transition with contour transition rounding.
       The rounding distance (in mm) is programmed via
       ADIS =   for G1, G2, G3 or
       ADISPOS =   for G0.

Both functions work with "look ahead" velocity control.
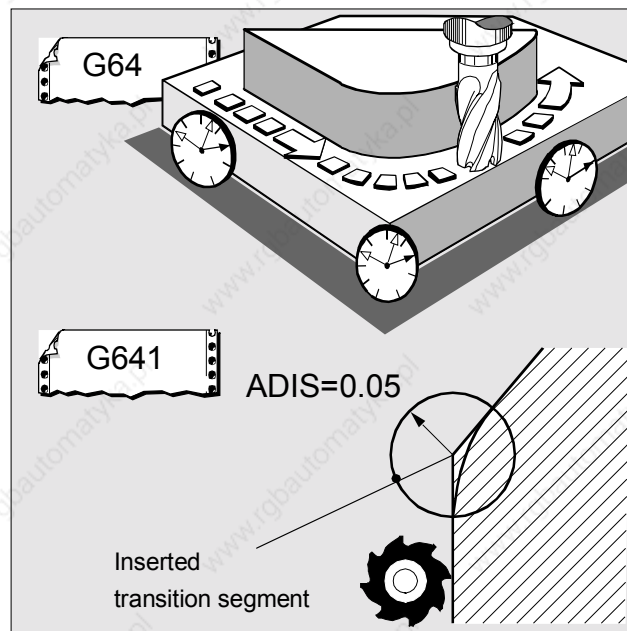
Optimization of the production results

Programming the spindle motion

Programming	N05 SETMS(2) LF
	N10 G1 F300 X70 Y20 S270 M3 LF

Parameters

S, Sn   Spindle speed in rpm
M3, Mn=3   Clockwise rotation
M4, Mn=4   Counterclockwise rotation
M5, Mn=5   Spindle stop
SETMS(n)   Spindle n becomes master spindle
n   Spindle number

If the M commands are programmed in a block with axial
motion, the commands before the axial motion are effective.
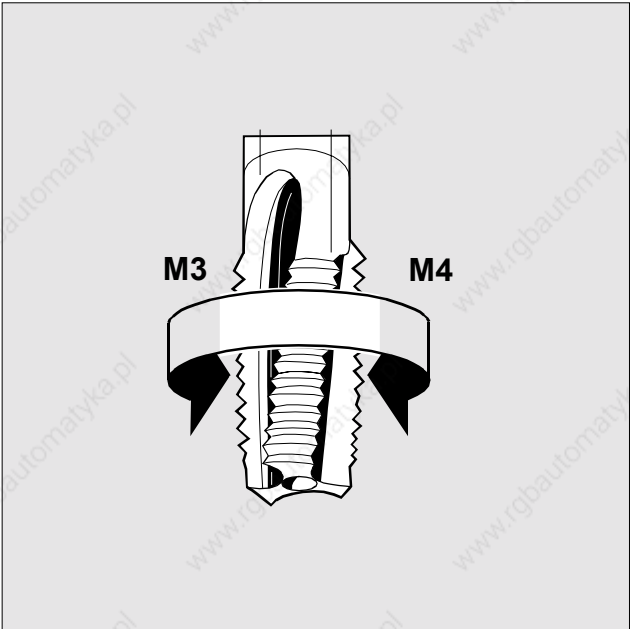
Programming the direction of spindle rotation

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6. Subroutine Technique and Cycles

Subroutine technique

Programming

```
N40 G0 X500 Y500 Z500 LF
N50    L230 P2  LF
```

L...   Subroutine call
P...   Number of repeats (max. 9999)

Subroutine nesting: nesting to a depth of eleven

The end of the subroutine and the return jump to the main
program is programmed with M17. The subroutine must be
called in a separate NC block.

Milling:
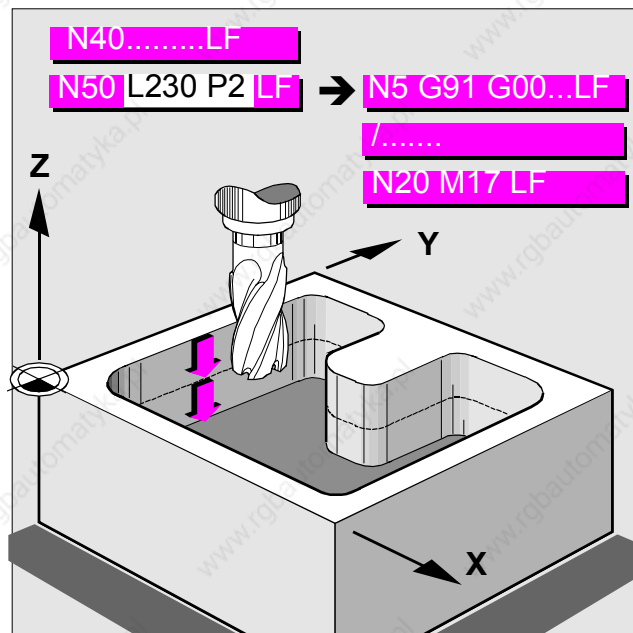
Machining in several steps

Subroutine technique (cont.)

Programming

```
N10 TRANS X0 Z150
N20    L20
N30 TRANS X0 Z140
N40    L20
N50 TRANS X0 Z130
N60    L20
```

L...   Subroutine call

Turning:

Machining in several steps

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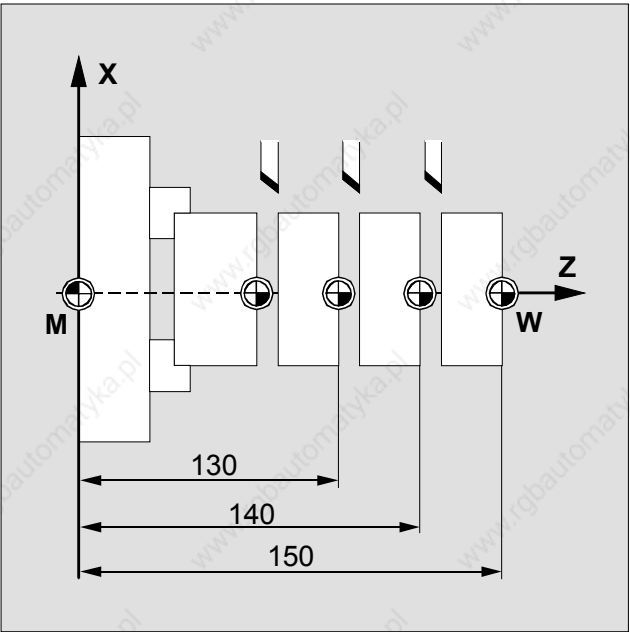
The use of cycles

Precondition   The machining plane (G17, G18, G19) feed and speed
                       must be defined before calling the cycle.

Cycle call   Cycle calls must always be in a separate block!

                       For example:
                       CYCLE81 (RTP, RFP, SDID, DP, DPR) L_F

Programming   The program editor in the control offers a programming
support   support function for generating cycle calls.
for cycles

                       You will find a detailed description of all cycles in the
                       Programming Guides for the technologies turning and
                       milling/drilling.

Explanation of parameters

Parameter	Explanation
AFSL	Angle for slot length (enter without sign)
ANG1	Flank angle 1: at the side of the groove defined by the start point (enter without sign)
	Values: 0<=ANG1<89.999 degrees
ANG2	Flank angle 2: at other side (enter without sign)
	Values: 0<=ANG2<89.999
APP	Run-in path (enter without sign)
CDIR	Direction of machining
	Values: 2 (for G2)
	3 (for G3)
CPA	Center point circle/pocket abscissa (absolute)
CPO	Center point circle/pocket, ordinate (absolute)
CRAD	Corner radius (enter without sign)
DAM	CYCLE95: Path length after which each roughing cut is interrupted for chip breaking
	CYCLE83: Amount of degression (enter without sign)
DBH	Distance between holes (enter without sign)
DIAG	Groove depth (enter without sign)
DIATH	Nominal thread diameter, outer diameter of thread
DM1	Diameter of thread at start point
DM2	CYCLE97: Diameter of thread at end point
	CYCLE98: Diameter at first intermediate point
DM3	Diameter at second intermediate point
DM4	Diameter at end point
DP	Final drilling depth/elongated hole depth/slot depth/pocket depth (absolute)
DPR	Final drilling depth/elongated hole depth/slot depth/pocket depth relative to reference plane (enter without sign)
DT	Dwell time for chip breaking during roughing
DTB	CYCLE82, -83, -86, -88, -89: Dwell time at final drilling depth (chip breaking)
	CYCLE93: Dwell time at recess base
	CYCLE84, -840: Dwell time at thread depth (chip breaking)
	CYCLE85: Dwell time at drilling depth (chip breaking)
DTS	Dwell time at start point and for stock removal
ENC	Tapping with/without encoder
	Values: 0 = with encoder
	1 = without encoder
FAL	Correct finishing allowance for contour (enter without sign)
FAL1	Finishing allowance at recess base
FAL2	Finishing allowance at edges
FALX	Finishing allowance in face axis (enter without sign)
FALZ	Finishing allowance in longitudinal axis (enter without sign)
FDEP	First drilling depth (absolute)

Explanation of parameters (cont.)

Parameter	Explanation
FDIS	Distance of first hole from reference point (enter without sign)
FDPR	First drilling depth relative to reference plane (enter without sign)
FF1	Feedrate for roughing without relief cut
FF2	Feedrate for insertion in relief cut elements
FF3	Feedrate for finishing
FFD	Feedrate for depth infeed
FFP1	Feedrate for surface machining
FFP2	Feedrate for final allowance
FFR	Feedrate
FORM	Definition of form

	CYCLE94:	E (for Form E)
		F (for Form F)
	CYCLE96:	A (for Form A)
		D (for Form D)

Parameter	Explanation
FPL	End point of thread in longitudinal axis
FRF	Feedrate factor for first drilling depth (enter without sign)
	Values: 0.001 ... 1
IANG	Insertion angle

	Values:	"+" (for edge infeed)
		"–" (for alternating edge infeed)

Parameter	Explanation
IDEP	Insertion depth (enter without sign)
INDA	Indexing angle
KDIAM	Core diameter, inside diameter of thread
LENG	Length of elongated hole/slot length/pocket length (enter without sign)
MID	Maximum insertion depth for insertion (enter without sign)
MIDF	Maximum insertion depth for final allowance
MPIT	Thread pitch as thread size
	CYCLE97: 3 (for M3) ... 60 (for M60)
	CYCLE84, -840: 3 (for M3) ... 48 (for M48)
NID	Number of noncuts (enter without sign)
NPP	Name of the contour subprogram
NRC	Number of roughing cuts (enter without sign)
NSP	Start point offset for first thread start (enter without sign)
NUM	Number of holes/elongated holes/slots
NUMTH	Number of thread starts (enter without sign)
PIT	Thread pitch; values: 0.001 ... 2000.000 mm
PRAD	Pocket radius (enter without sign)
PO1	Start point of thread in the longitudinal axis
PO2	First intermediate point in the longitudinal axis

Explanation of parameters (cont.)

Parameter	Explanation
PO3	Second intermediate point
PO4	End point of thread in the longitudinal axis
POSS	Spindle position for oriented spindle stop in cycle (in degrees)
PP1	Thread pitch 1 as value (enter without sign)
PP2	Thread pitch 2 as value (enter without sign)
PP3	Thread pitch 3 as value (enter without sign)
PRAD	Pocket radius (enter without sign)
RAD	Radius of circle (enter without sign)
RCI1	Radius/chamfer 1, inside: at start point side
RCI2	Radius/chamfer 2, inside
RCO1	Radius/chamfer 1, outside: at the side defined by the start point
RCO2	Radius/chamfer 2, outside
RFF	Return feedrate
RFP	Reference plane (absolute)
ROP	Exit path (enter without sign)
RPA	Return path in abscissa of the active plane (enter incrementally with sign)
RPAP	Return plane in the applicate (enter incrementally with sign)
RPO	Return path in the ordinate of the active plane (enter incrementally with sign)
RTP	Return plane (absolute)
SDAC	Direction of rotation after end of cycle Values: 3, 4 or 5
SDIR	Direction of rotation Values: 3 (for M3) 4 (for M4)
SDIS	Safety distance (enter without sign)
SDR	Direction of rotation for return Values: 0 (automatic reversal of direction of rotation) 3 or 4 (for M3 or M4)
SPCA	Abscissa of a reference point on a straight line (absolute)
SPCO	Ordinate of this reference point (absolute)
SPD	Start point in the facing axis (enter without sign)
SPL	Start point of contour/thread in the longitudinal axis
SSF	Speed during finishing
SST	Speed for tapping
SST1	Speed for return
STA1	Starting angle Values: -180 to 180 degrees
TDEP	Thread depth (enter without sign)
TYPTH	Thread type: values: 0=inside thread 1=outside thread

Explanation of parameters (cont.)

Parameter	Explanation
VARI	Machining mode
	SLOT1, SLOT2, POCKET1, POCKET2:
	0=complete machining
	1=solid machining to finishing allowance
	2=only machining of finishing allowance
	CYCLE83: 0=chip breaking
	1=stock removal
	CYCLE93: 1...8
	11...18
	CYCLE95: 1...12
	CYCLE97, CYCLE98: 1...4
WID	Slot width/pocket width (enter without sign)
WIDG	Slot width (enter without sign)

Drilling, centering, CYCLE81

Sequence	The "Drilling, centering" cycle produces a simple hole.
Programming	CYCLE81 (RTP, RFP, SDIS, DP, DPR)

RTP	Return plane (absolute)
RFP	Reference plane (absolute)
SDIS	Safety distance (enter without sign)
DP	Final drilling depth/elongated hole depth/slot depth/pocket depth (absolute)
DPR	Final drilling depth/elongated hole depth/slot depth/pocket depth relative to reference plane (enter without sign)
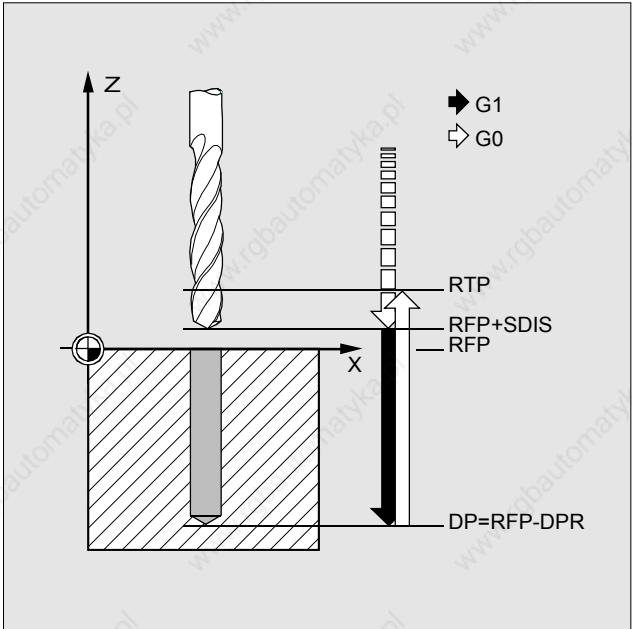
Sequence of motions and parameters in the "Drilling, centering" cycle

Drilling, counterboring, CYCLE82

Sequence   The "Drilling, counterboring" cycle produces a simple hole.
                      When the final drilling depth has been reached, a dwell
                      time can be activated.

Programming   CYCLE82 (RTP, RFP, SDIS, DP, DPR, DTB)

RTP   Return plane (absolute)
RFP   Reference plane (absolute)
SDIS   Safety distance (enter without sign)
DP   Final drilling depth/elongated hole depth/slot depth/pocket
             depth (absolute)
DPR   Final drilling depth/elongated hole depth/slot depth/pocket
             depth relative to reference plane (enter without sign)
DTB   CYCLE82: Dwell time at final drilling depth (chip breaking)

Sequence of motions and parameters in the "Drilling, counterboring" cycle

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Deep hole drilling, CYCLE83

Sequence   The "Deep-hole drilling" cycle produces holes up to the final
drilling depth by depth infeed in several steps the maximum
amount of which can be programmed.

The drill can either be withdrawn from the reference plane
after each infeed depth for stock removal or by 1 mm each
time for chip breaking.

Programming   CYCLE83 (RTP, RFP, SDIS, DP, DPR, FDEP, FDPR, DAM,
DTB, DTS, FRF, VARI)

RTP	Return plane (absolute)
RFP	Reference plane (absolute)
SDIS	Safety distance (enter without sign)
DP	Final drilling depth/elongated hole depth/slot depth/pocket depth (absolute)
DPR	Final drilling depth/elongated hole depth/slot depth/pocket depth relative to reference plane (enter without sign)
DTB	CYCLE82: Dwell time at final drilling depth (chip breaking)
FDEP	First depth (absolute)
	Other parameters: see Chapter "Explanation of parameters"
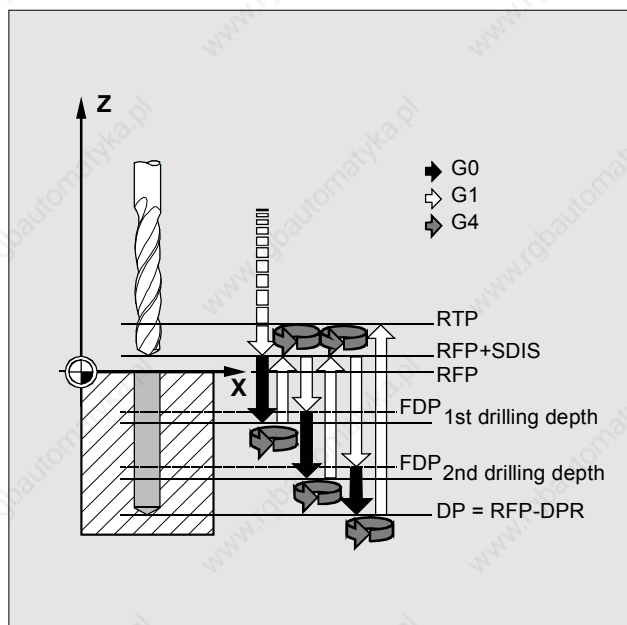
Sequence of motions and parameters in the "Deep-hole drilling" cycle with stock removal

Rigid tapping, CYCLE84

Sequence CYCLE84 produces tapped holes without using a floating tapholder.

This cycle can be applied only if the spindle designated for drilling is capable of working in the position-controlled spindle mode.

Programming CYCLE84 (RTP, RFP, SDIS, DP, DPR, DTB, SDAC, MPIT, PIT, POSS, SST, SST1)

RTP	Return plane (absolute)
RFP	Reference plane (absolute)
SDIS	Safety distance (enter without sign)
DP	Final drilling depth/elongated hole depth/slot depth/pocket depth (absolute)
DPR	Final drilling depth/elongated hole depth/slot depth/pocket depth relative to reference plane (enter without sign)
DTB	CYCLE82: Dwell time at final drilling depth (chip breaking) Other parameters: see Chapter "Explanation of parameters"
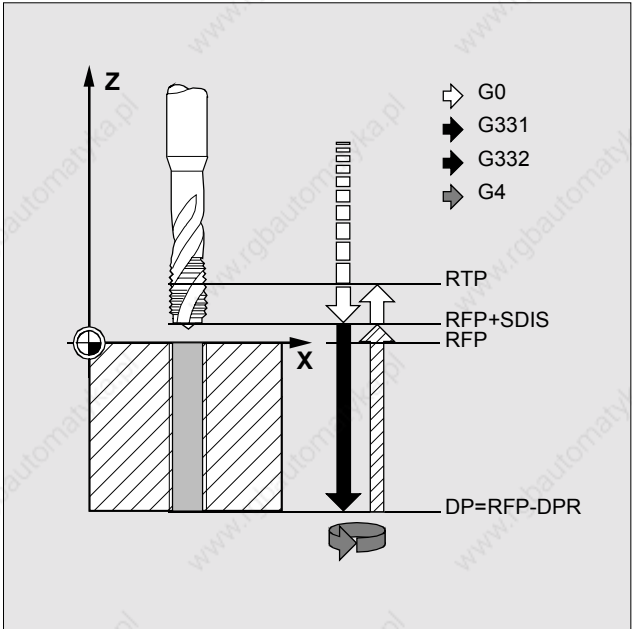
Sequence of motions and parameters in the "Rigid tapping" cycle

Tapping with floating tapholder, CYCLE840

Sequence   With this cycle, tapped holes can be produced with floating
tapholder
• without encoder and
• with encoder.

For tapping without floating tapholder (rigid taping) another
cycle is used (CYCLE84, see previous page).

Programming   CYCLE840 (RTP, RFP, SDIS, DP, DPR, DTB, SDR, SDAC,
ENC, MPIT, PIT)

RTP   Return plane (absolute)
RFP   Reference plane (absolute)
SDIS   Safety distance (enter without sign)
DP   Final drilling depth/elongated hole depth/slot depth/pocket
depth (absolute)
DPR   Final drilling depth/elongated hole depth/slot depth/pocket
depth relative to reference plane (enter without sign)
DTB   CYCLE82: Dwell time at final drilling depth (chip breaking)
Other parameters: see Chapter "Explanation of parameters"

Sequence of motions and parameters in the "Tapping with floating tapholder/encoder"
cycle

Bore 1, CYCLE85

Sequence In the "Bore 1" cycle, the inward and outward motions are performed at a feedrate that must be specified under the relevant parameters.

Programming CYCLE85 (RTP, RFP, SDIS, DP, DPR, DTB, FFR, RFF)

RTP	Return plane (absolute)
RFP	Reference plane (absolute)
SDIS	Safety distance (enter without sign)
DP	Final drilling depth/elongated hole depth/slot depth/pocket depth (absolute)
DPR	Final drilling depth/elongated hole depth/slot depth/pocket depth relative to reference plane (enter without sign)
DTB	CYCLE82: Dwell time at final drilling depth (chip breaking)
FFR	Feedrate
RFF	Return feedrate
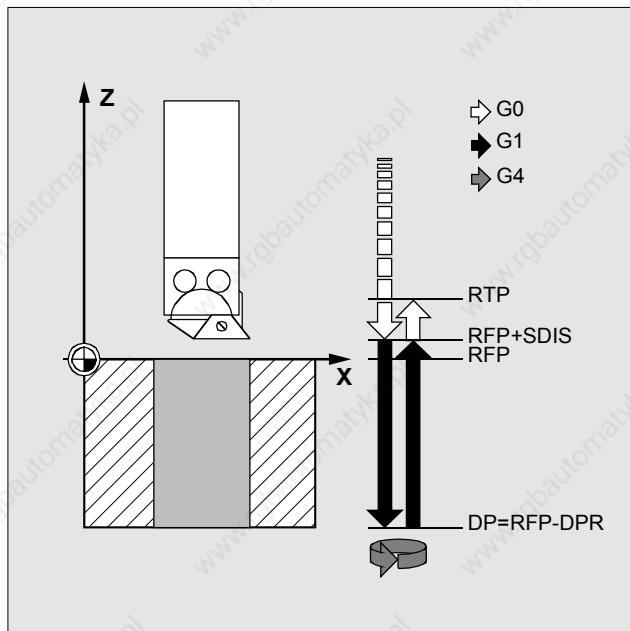
Sequence of motions and parameters in the "Bore 1" cycle

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Bore 2, CYCLE86

Sequence

In the "Bore 2" cycle, an oriented spindle stop is performed on reaching the drilling depth. The tool then travels at rapid traverse to the programmed return positions and from there to the return plane.

This cycle can only be used if the spindle designated for drilling is technically capable of operating in the position-controlled spindle mode.

Programming

CYCLE86 (RTP, RFP, SDIS, DP, DPR, DTB, SDIR, RPA, RPO, RPAP, POSS)

|	
RTP	Return plane (absolute)
RFP	Reference plane (absolute)
SDIS	Safety distance (enter without sign)
DP	Final drilling depth/elongated hole depth/slot depth/pocket depth (absolute)
DPR	Final drilling depth/elongated hole depth/slot depth/pocket depth relative to reference plane (enter without sign)
DTB	CYCLE82: Dwell time at Final drilling depth (chip breaking) Other parameters: see Chapter "Explanation of parameters"

Sequence of motions and parameters in the "Bore 2" cycle

Bore 3, CYCLE87

Sequence   In the "Bore 3" cycle, a spindle stop without orientation is effected on reaching the final drilling depth, followed by a programmed stop. By pressing the NC Start key, the upwards movement is continued at rapid traverse until the retraction plane is reached.

Programming   CYCLE87 (RTP, RFP, SDIS, DP, DPR, SDIR)

RTP	Return plane (absolute)
RFP	Reference plane (absolute)
SDIS	Safety distance (enter without sign)
DP	Final drilling depth/elongated hole depth/slot depth/pocket depth (absolute)
DPR	Final drilling depth/elongated hole depth/slot depth/pocket depth relative to reference plane (enter without sign)
SDIR	Direction of rotation 3 (for M3)
	4 (for M4)
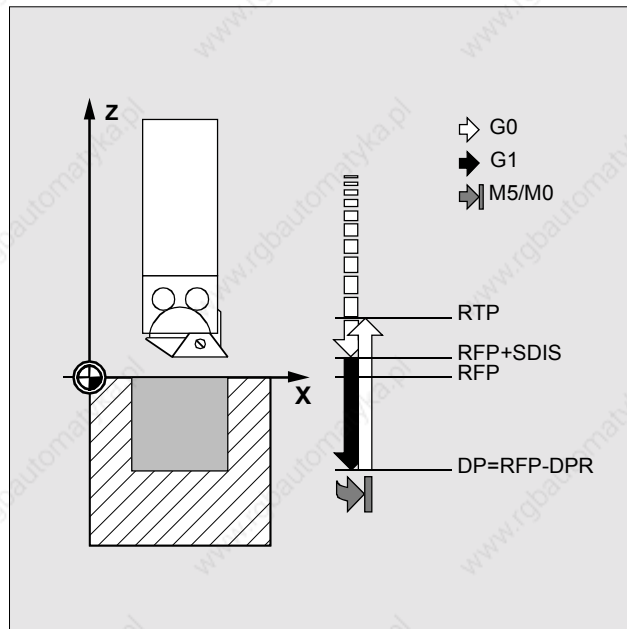
Sequence of motions and parameters in the "Bore 3" cycle

Bore 4, CYCLE88

Sequence	In the "Bore 4" cycle, a dwell time is effected on reaching the final drilling depth together with a spindle stop without orientation and a programmed stop. By pressing the NC Start key, the upwards movement is performed at rapid traverse until the retraction plane is reached.
Programming	CYCLE88 (RTP, RFP, SDIS, DP, DPR, DTB, SDIR)

|	
RTP	Return plane (absolute)
RFP	Reference plane (absolute)
SDIS	Safety distance (enter without sign)
DP	Final drilling depth/elongated hole depth/slot depth/pocket depth (absolute)
DPR	Final drilling depth/elongated hole depth/slot depth/pocket depth relative to reference plane (enter without sign)
DTB	Dwell time at final drilling depth (chip breaking)
SDIR	Direction of rotation 3 (for M3)
	4 (for M4)
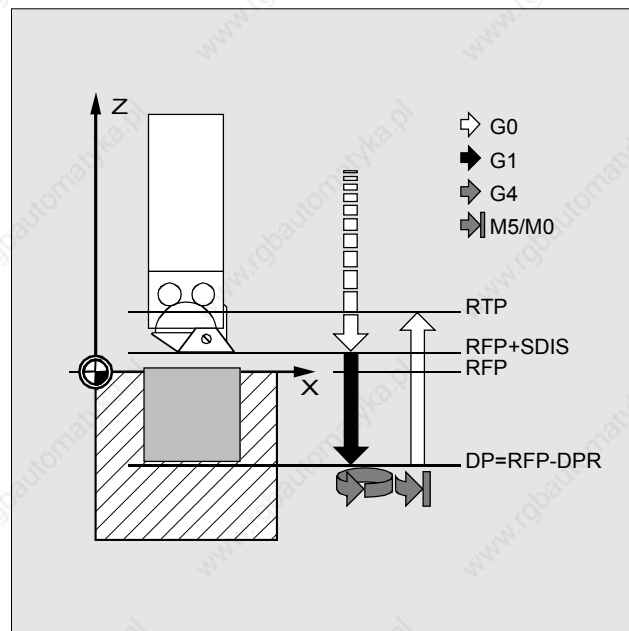
Sequence of motions and parameters in the "Bore 4" cycle

Bore 5, CYCLE89

Sequence   In the "Bore 5" cycle, the inwards and the upwards
                      movements are performed at the F value programmed
                      before the cycle call. On reaching the final drilling depth, a
                      dwell time can be effected.

Programming   CYCLE89 (RTP, RFP, SDIS, DP, DPR, DTB)

   RTP   Return plane (absolute)
   RFP   Reference plane (absolute)
   SDIS   Safety distance (enter without sign)
   DP   Final drilling depth/elongated hole depth/slot depth/pocket
   depth (absolute)
   DPR   Final drilling depth/elongated hole depth/slot depth/pocket
              depth relative to reference plane (enter without sign)
   DTB   CYCLE82: Dwell time at final drilling depth (chip breaking)

Sequence of motions and parameters in the "Bore 5" cycle

6-71

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Row of holes, HOLES1

Sequence	With this cycle, a row of holes can be produced on a straight line.
Programming	HOLES1 (SPCA, SPCO, STA1, FDIS, DBH, NUM)
SPCA	Abscissa of a reference point on the straight line (absolute)
SPCO	Ordinate of this reference point (absolute)
STA1	Starting angle
	Values: -180 to 180 degrees
FDIS	Distance to first hole from reference point (enter without sign)
DBH	Distance between holes (enter without sign)
NUM	Number of holes/elongated holes/slots
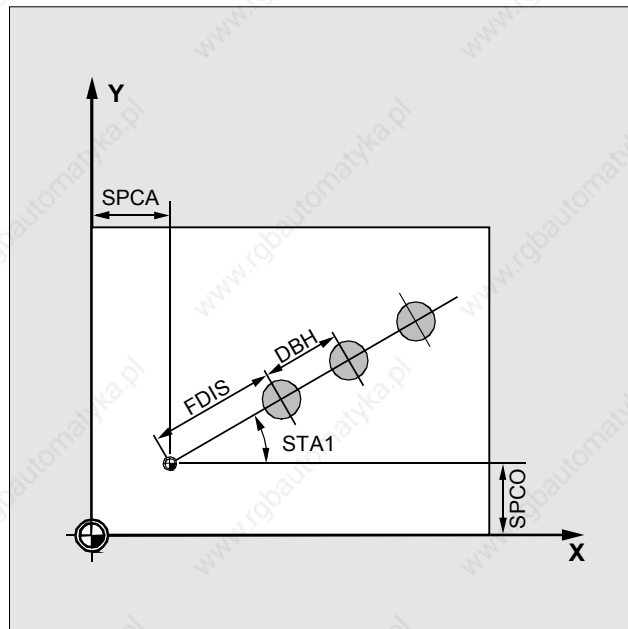
Parameters in the "Row of holes" drilling pattern

Hole circle, HOLES2

Sequence   With this cycle, a hole circle can be machined.

Programming   HOLES2 (CPA, CPO, RAD, STA1, INDA, NUM)

CPA   Center point circle/pocket, abscissa (absolute)
CPO   Center point circle/pocket, ordinate (absolute)
RAD   Radius of circle (enter without sign)
STA1   Starting angle
          Values: -180 to 180 degrees
INDA   Indexing angle
NUM   Number of holes/elongated holes/slots
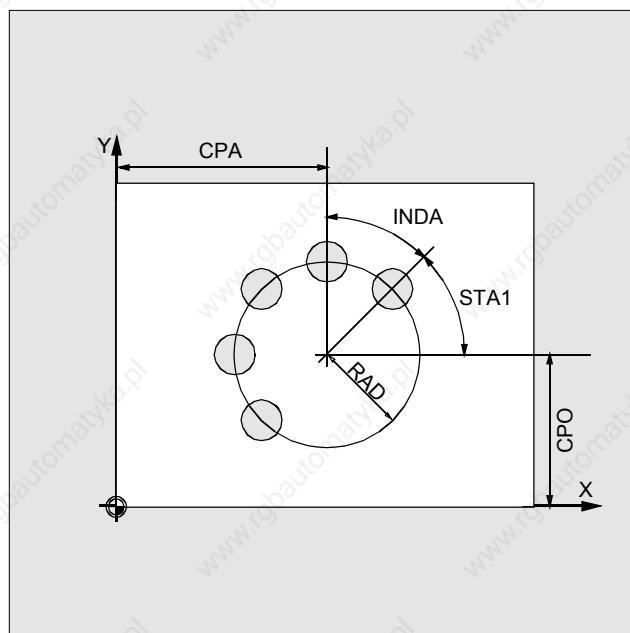
Parameters in the "Hole circle" drilling pattern

6-73
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Elongated holes on a circle, LONGHOLE

Sequence

With this cycle, elongated holes can be produced arranged on a circle.
The width of the elongated hole is determined by the tool diameter.

Programming

LONGHOLE (RTP, RFP, SDIS, DP, DPR, NUM, LENG, CPA, CPO, RAD, STA1, INDA, FFD, FFP1, MID)

RTP	Return plane (absolute)
RFP	Reference plane (absolute)
SDIS	Safety distance (enter without sign)
NUM	Number of holes/elongated holes/slots
LENG	Length of elongated hole/slot length/pocket length (without sign)
CPA	Center point circle/pocket, abscissa (absolute)
CPO	Center point circle/pocket, ordinate (absolute)
RAD	Radius of circle (enter without sign)
STA1	Starting angle
	Values: -180 to 180 degrees
INDA	Indexing angle
	Other parameters: see Chapter "Explanation of parameters"
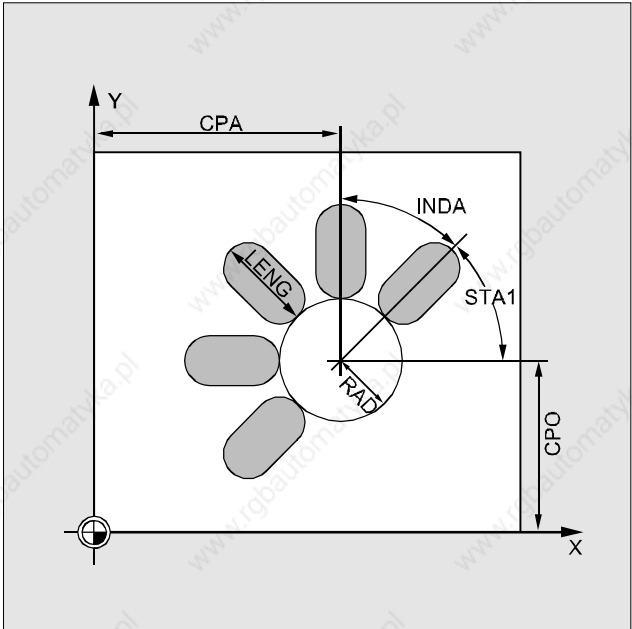
Parameters in the "Elongated holes on a circle" milling pattern

Slots on a circle, SLOT1

Sequence   With this cycle, slots can be produced arranged on a circle.
                      The longitudinal axis of the slots has a radial orientation In
                      contrast to the elongated hole, a value is specified for the
                      slot width.
                      The SLOT1 cycle is a combined roughing/finishing cycle.

Programming   SLOT1 (RTP, RFP, SDIS, DP, DPR, NUM, LENG, WID,
                      CPA, CPO, RAD, STA1, INDA, FFD, FFP1, MID, CDIR,
                      FAL, VARI, MIDF, FFP2, SSF)

LENG   Length of elongated hole/slot length/pocket length (without
              sign)
WID   Slot width/pocket width (enter without sign)
CPA   Center point circle/pocket, abscissa (absolute)
CPO   Center point circle/pocket, ordinate (absolute)
RAD   Radius of circle (enter without sign)
STA1   Starting angle, values: -180 to 180 degrees
INDA   Indexing angle
              Other parameters: see Chapter "Explanation of parameters"
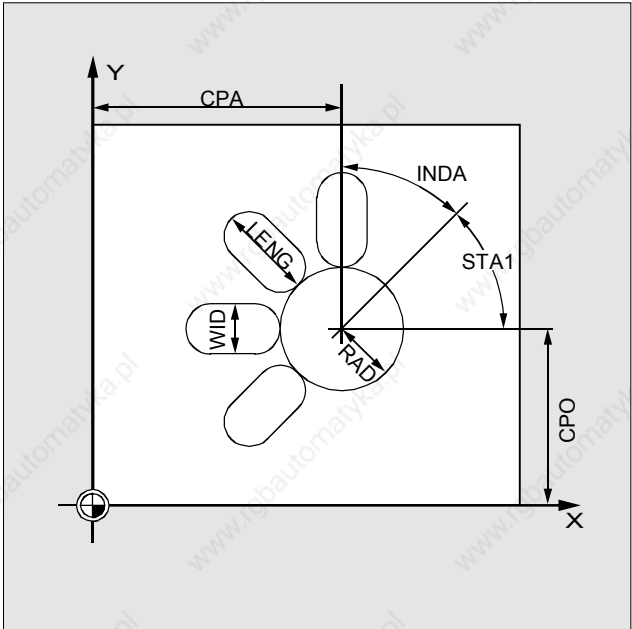
Parameters in the "Slots on a circle" milling pattern

6-75
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Circumferential slot, SLOT2

Sequence   With this cycle, circular slots can be produced arranged on a circle.
The SLOT2 cycle is a combined roughing/finishing cycle.

Programming   SLOT2 (RTP, RFP, SDIS, DP, DPR, NUM, AFSL, WID, CPA, CPO, RAD, STA1, INDA, FFD, FFP1, MID, CDIR, FAL, VARI, MIDF, FFP2, SSF)

LENG	Length of elongated hole/slot length/pocket length (without sign)
WID	Slot width/pocket width (enter without sign)
CPA	Center point circle/pocket, abscissa (absolute)
CPO	Center point circle/pocket, ordinate (absolute)
RAD	Radius of circle (enter without sign)
STA1	Starting angle, Values: -180 to 180 degrees
INDA	Indexing angle
AFSL	Angle for slot length (enter without sign)
	Other parameters: see Chapter "Explanation of parameters"
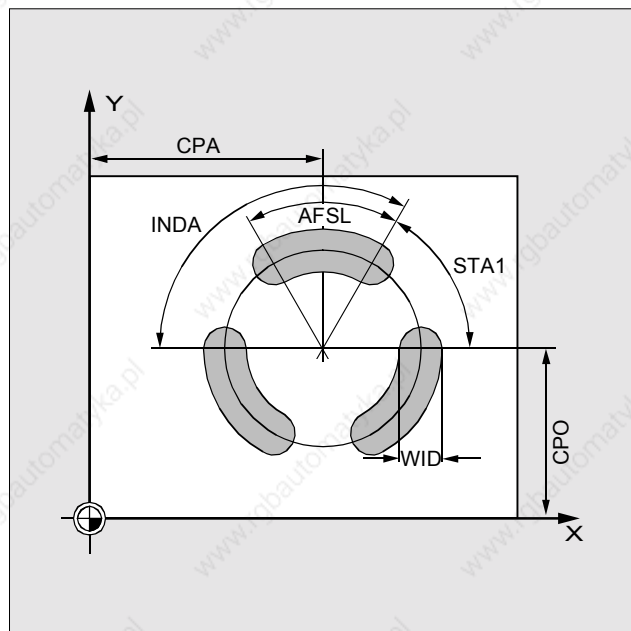
Parameters in the "Circumferential slot" milling pattern

Rectangular pocket milling, POCKET1

Sequence   With this cycle, rectangular pockets can be produced in any location in the machining plane.

The cycle is a combined roughing/finishing cycle.

Programming   POCKET1 (RTP, RFP, SDIS, DP, DPR, LENG, WID, CRAD, CPA, CPO, STA1, FFD, FFP1, MID, CDIR, FAL, VARI, MIDF, FFP2, SSF)

LENG	Length of elongated hole/slot length/pocket length (enter without sign)
WID	Slot width/pocket width (enter without sign)
CRAD	Corner radius (enter without sign)
CPA	Center point circle/pocket, abscissa (absolute)
CPO	Center point circle/pocket, ordinate (absolute)
STA1	Starting angle
	Values: -180 to 180 degrees
	Other parameters: see Chapter "Explanation of parameters"
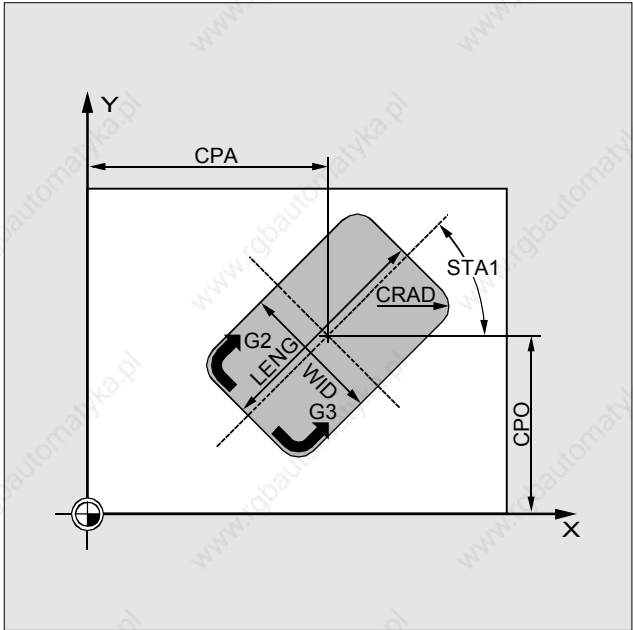
Parameters in the "Rectangular pocket" cycle

6-77
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Circular pocket milling, POCKET2

Sequence	With this cycle, circular pockets can be produced. The cycle is a combined roughing/finishing cycle.
Programming	POCKET2 (RTP, RFP, SDIS, DP, DPR, PRAD, CPA, CPO, FFD, FFP1, MID, CDIR, FAL, VARI, MIDF, FFP2, SSF)

RTP	Return plane (absolute)
RFP	Reference plane (absolute)
SDIS	Safety distance (enter without sign)
DP	Final drilling depth/elongated hole depth/slot depth/pocket depth (absolute)
DPR	Final drilling depth/elongated hole depth/slot depth/pocket depth relative to reference plane (enter without sign)
PRAD	Pocket radius (enter without sign)
CPA	Center point circle/pocket, abscissa (absolute)
CPO	Center point circle/pocket, ordinate (absolute)
FFD	Feedrate for depth infeed
FFP1	Feedrate for surface machining
MID	Maximum insertion depth (without sign)
CDIR	Direction of machining, 2 (for G2), 3 (for G3)
	Other parameters: see Chapter "Explanation of parameters"
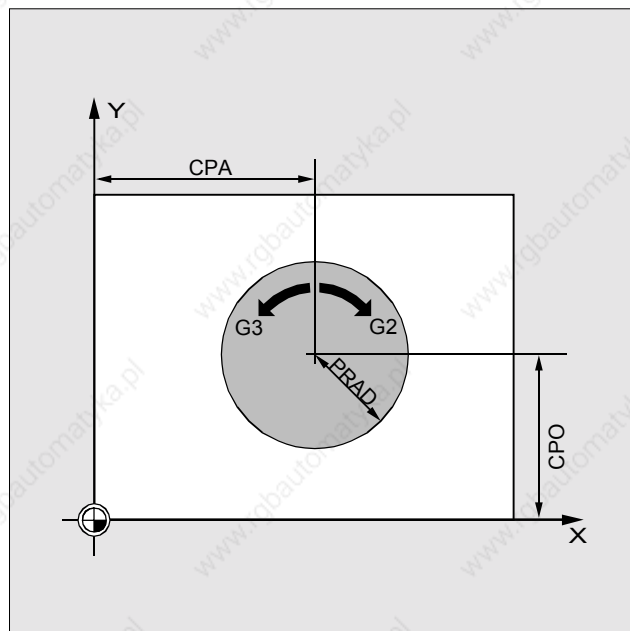
Parameters in the "circular pocket" cycle

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Thread cutting, CYCLE90

Sequence   With this cycle, internal and external threads can be
                      produced. The path in thread milling is based on helical
                      interpolation.
                      All three geometry axes of the present plane are involved in
                      this motion.

Programming   CYCLE90 (RTP, RFP, SDIS, DP, DPR, DIATH, KDIAM,
                      PIT, FFR, CDIR, TYPTH, CPA, CPO)

RTP   Return plane (absolute)
RFP   Reference plane (absolute)
SDIS   Safety distance (enter without sign)
DP   Final drilling depth/elongated hole depth/slot depth/pocket
          depth (absolute)
DPR   Final drilling depth/elongated hole depth/slot depth/pocket
          depth relative to reference plane (enter without sign)
DIATH   Nominal thread diameter, outside diameter of thread
CDIR   Direction of machining: 2 (for G2), 3 (for G3)
CPA   Center point circle/pocket, abscissa (absolute)
CPO   Center point circle/pocket, ordinate (absolute)
          Other parameters: see Chapter "Explanation of parameters"
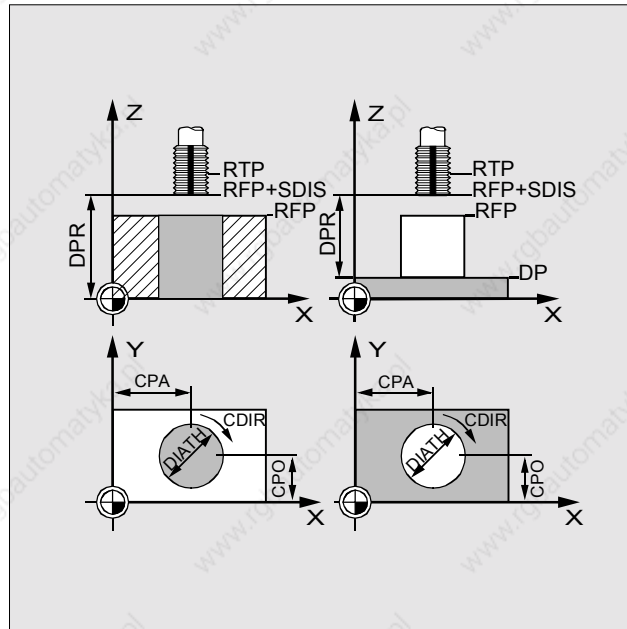
Parameters in the "Thread milling" cycle

Recessing cycle, CYCLE93

Sequence
The recessing cycle allows symmetrical and asymmetrical recesses to be produced for longitudinal and facing operations on any straight contour elements. Outside and inside recesses can be made.

Programming
CYCLE93 (SPD, SPL, WIDG, DIAG, STA1, ANG1, ANG2, RCO1, RCO2, RCI1, RCI2, FAL1, FAL2, IDEP, DTB, VARI)

SPD Start point in the facing axis (enter without sign)
SPL Start point of contour/of thread in the longitudinal axis
WIDG Slot width (enter without sign)
DIAG Slot depth (enter without sign)
ANG1 Flank angle 1: at side of insertion defined by the start point (enter without sign)
ANG2 Flank angle 2: at other side (without sign)
RCO1 Radius/chamfer 1, outside: at side defined by start point
RCO2 Radius/chamfer 2, outside
RCI1 Radius/chamfer 1, inside: at start point side
RCI2 Radius/chamfer 2, inside
Other parameters: see Chapter "Explanation of parameters"
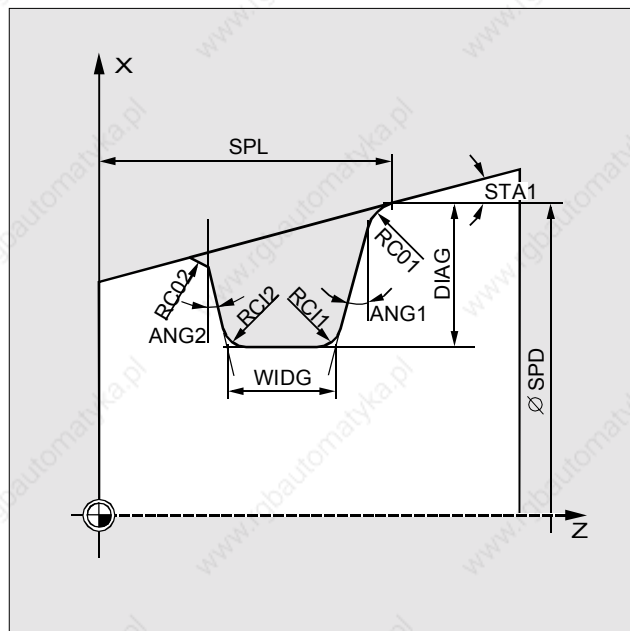
Parameters in the "Recessing" cycle for longitudinal machining

Undercut cycle, CYCLE94

Sequence   With this cycle, undercuts to DIN 509 of forms E and F can
                     be produced with usual loading for a finished part
                     diameter > 3 mm.

Programming   CYCLE94 (SPD, SPL, FORM)

    SPD   Start point in the facing axis (enter without sign)
    SPL   Start point of contour/of thread in the longitudinal axis
    FORM   Definition of form   E (for Form E)
                                                  F (for Form F)
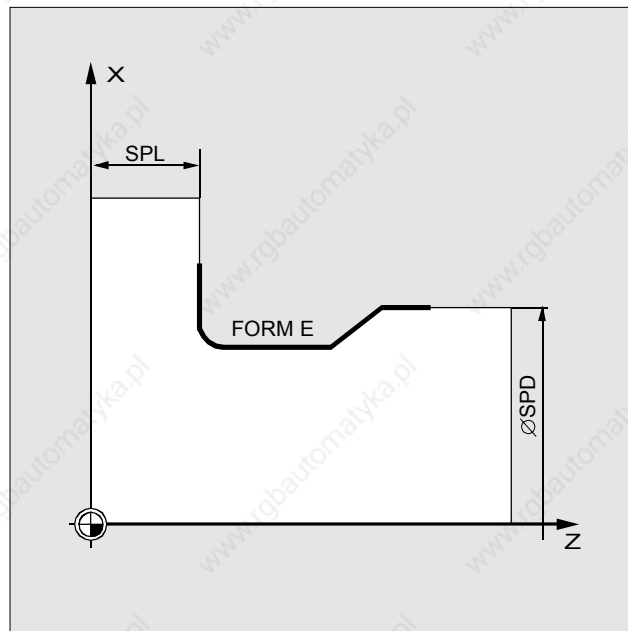
Parameters in the "Undercut" cycle

Stock removal cycle, CYCLE95

Sequence
With the "Stock removal" cycle, a contour programmed in a subroutine can be produced from a blank by means of paraxial stock removal.
The contour can include relief-cut elements.

The technology (roughing/finishing/complete machining) is selectable. The cycle can be called from any collision-free position.

Programming
CYCLE95 (NPP, MID, FALZ, FALX, FAL, FF1, FF2, FF3, VARI, DT, DAM)

NPP   Name of the contour program
MID   Maximum insertion depth (enter without sign)
FALZ   Finishing allowance in the longitudinal axis (without sign)
FALX   Finishing allowance in the facing axis (without sign)
FAL   Correct finishing allowance for contour (without sign)
        Other parameters: see Chapter "Explanation of parameters"
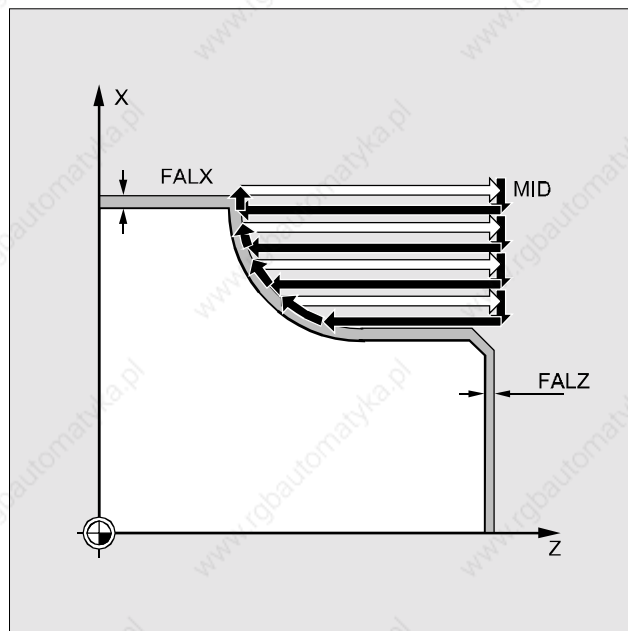
Sequence of motions and parameters in the "Stock removal" cycle

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Thread undercut, CYCLE96

Sequence   With this cycle, form A, B, C, D thread undercuts can be
produced in accordance with DIN 13 for parts with metric
ISO thread.

Programming   CYCLE96 (DIATH, SPL, FORM)

DIATH   Rated diameter, outside diameter of thread
SPL   Start point of contour/of thread in the longitudinal axis
FORM   Definition of form   E (for Form E)
                                            F (for Form F)
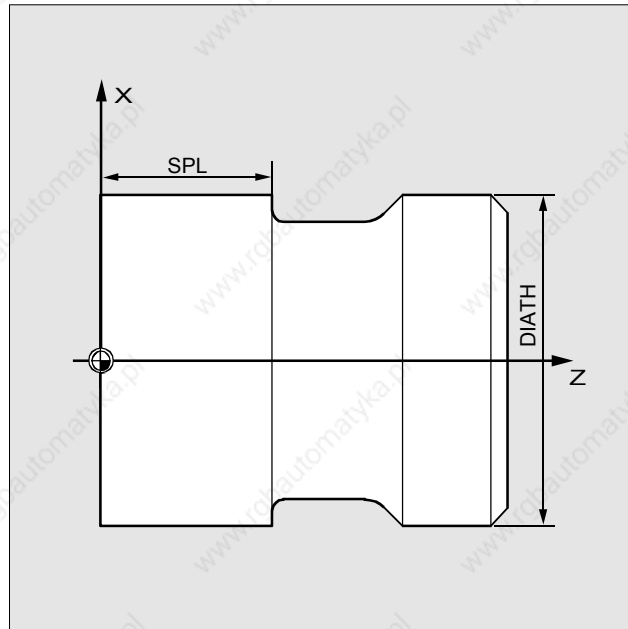
Parameters in the "Thread undercut" cycle

Thread cutting, CYCLE97

Sequence	With the "Thread cutting" cycle, cylindrical and tapered outside and inside threads can be produced in longitudinal and facing operations, both of the single thread and multiple thread type. A prerequisite for using this cycle is a speed-controlled spindle with position measuring system. In the case of multiple threads, the individual threads are machined one after the other.
Programming	CYCLE97 (PIT, MPIT, SPL, FPL, DM1, DM2, APP, ROP, TDEP, FAL, IANG, NSP, NRC, NID, VARI, NUMTH)
SPL	Start point of contour/thread in the longitudinal axis
FPL	End point of thread in the longitudinal axis
PIT	Pitch; Values: 0.001 ... 2000.000 mm
ROP	Exit path (enter without sign)
FAL	Correct finishing allowance for contour (enter without sign)
TDEP	Thread depth (enter without sign)
APP	Run-in path (enter without sign)
DM1	Diameter of thread at start point
DM2	Diameter of thread at end point
	Other parameters: see Chapter "Explanation of parameters"

Parameters in the "Thread cutting" cycle

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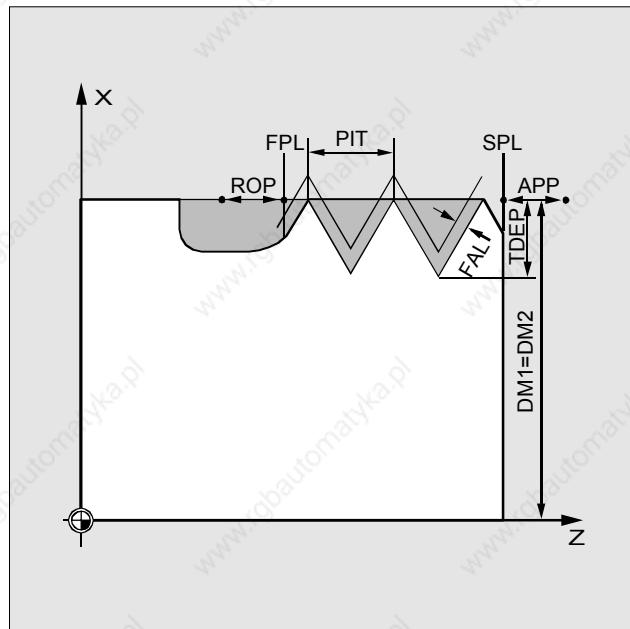
Chaining of threads, CYCLE98

Sequence   This cycle allows production in longitudinal and facing
                operations of several cylindrical or taper threads located
                one behind the other and possibly having different leads.

Programming   CYCLE98 (PO1, DM1, PO2, DM2, PO3, DM3, PO4, DM4,
                  APP, ROP, TDEP, FAL, IANG, NSP, NRC, NID, PP1, PP2,
                  PP3, VARI, NUMTH)

PO1	Start point of thread in the longitudinal axis
DM1	Diameter of thread at start point
PO2	First intermediate point in the longitudinal axis
DM2	Diameter at first intermediate point
PO3	Second intermediate point
DM3	Diameter at second intermediate point
PO4	End point of thread in the longitudinal axis
DM4	Diameter at end point
APP	Run-in path (enter without sign)
ROP	Exit path (enter without sign)
PP1 to PP3	Pitch 1 to 3 as value (enter without sign)

Other parameters: see Chapter "Explanation of parameters"
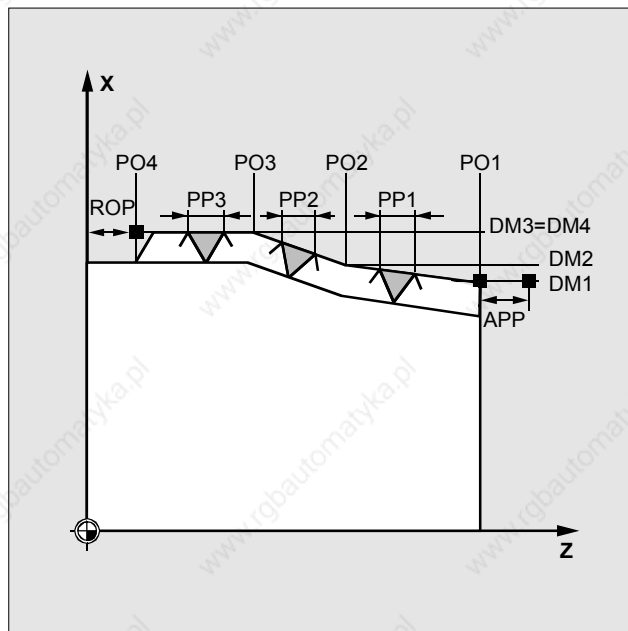
Parameters in the "Thread chaining" cycle

7. Predefined Switching and Auxiliary Functions

List of M commands

M0*	Programmed stop
M1*	Optional stop
M²*	End of program (main program)
M30*	End of program as M2
M17*	End of subroutine

M3	Spindle clockwise
M4	Spindle counterclockwise
M5	Spindle stop
M6	Tool change
M70	Change to axis mode

M40	Automatic gear change
M41	Gear stage 1
M42	Gear stage 2
M43	Gear stage 3
M44	Gear stage 4
M45	Gear stage 5

Extended address notation is not permissible for functions marked with an asterisk "".*

Machine manufacturer (MH7.1)

All free M function numbers can be assigned by the machine manufacturer. For example, with switching functions for controlling clamping devices or for activating/deactivating further machine functions.

Forms

You can enter your own user-specific functions here.

Forms

8. Program Key

List of G functions

Group 1: Modal motion commands				
Name	No.	Meaning	m/n	Def.
G0	1.	Rapid traverse motion	m	
G1	2.	Linear interpolation	m	Def.
G2	3.	Circular interpolation clockwise	m	
G3	4.	Circular interpolation counterclockwise	m	
CIP	5.	Circular interpolation through point	m	
ASPLINE #	6.	Akima spline	m	
BSPLINE #	7.	B spline	m	
CSPLINE #	8.	Cubic spline	m	
POLY ##	9.	Polynomial interpolation	m	
G33	10.	Thread cutting with constant lead	m	
G331	11.	Rigid tapping	m	
G332	12.	Return (rigid tapping)	m	
G58		Axial-programmable absolute zero offset	m	
G59		Axial-programmable additive zero offset	m	
OEMIPO1 ###	13.	OEM interpolation 1 *)	m	
OEMIPO2 ###	14.	OEM interpolation 2 *)	m	

*) The OEM user can include two additional types of interpolation. The OEM user can alter the names.
If no function has been programmed out of this group for modal G functions, the default setting (which can be altered by machine data) applies: $MC_GCODE_RESET_VALUES
Vocabulary word does **not** apply for SINUMERIK 810D; ## does **not** apply for SINUMERIK FM-NC/810D;
does **not apply for SINUMERIK 810D/FM-NC/NCU571**

Group 2: Non-modal motion commands, dwell time				
G4	1.	Dwell time preset	n	
G63	2.	Tapping without synchronization	n	
G74	3.	Reference point approach with synchronization	n	
G75	4.	Fixed point approach	n	
REPOSL	5.	Repositioning on contour, linear	n	
REPOSQ	6.	Repositioning on contour in quarter circle	n	
REPOSH	7.	Repositioning on contour in semi-circle	n	
REPOSA	8.	Repositioning on contour with all axes	n	
REPOSQA	9.	Repositioning on contour with all axes, geometry axis in quarter circle	n	
REPOSHA	10.	Repositioning on contour with all axes, geometry axes in semi-circle	n	

m: modal, n: non-modal, Def.: Default

List of G functions

Group 3: Write memory				
Name	No.	Meaning	m/n	Def.
TRANS	1.	TRANSLATION: translation, programmable	n	
ROT	2.	ROTATION: rotation, programmable	n	
SCALE	3.	SCALE: scaling, programming	n	
MIRROR	4.	MIRROR: mirroring, programmable	n	
ATRANS	5.	Additive translation, programmable	n	
AROT	6.	Additive rotation, programmable	n	
ASCALE	7.	Additive scaling, programmable	n	
AMIRROR	8.	Additive mirroring, programmable	n	
TOFRAME	9.	Place currently programmed frame on tool coordinate system	n	
G25	10.	Minimum working area limitation/spindle speed limitation	n	
G26	11.	Maximum working area limitation/spindle speed limitation	n	
G110	12.	Pole programming relative to the last programmed setpoint position	n	
G111	13.	Pole programming relative to the zero of the present WCS	n	
G112	14.	Pole programming relative to the last valid pole	n	

Group 4: FIFO				
STARTFIFO	1.	Execute and fill preprocessing buffer in parallel	m	Def.
STOPFIFO	2.	Stop processing: fill preprocessing memory	m	

Group 6: Plane selection				
G17	1.	Plane selection 1st - 2nd geometry axis	m	Def.
G18	2.	Plane selection 3rd - 1st geometry axis	m	
G19	3.	Plane selection 2nd - 3rd geometry axis	m	

m: modal
n: Non-modal
Def.: Default

List of G functions

Group 7: Tool radius compensation				
Name	No.	Meaning	m/n	Def.
G40	1.	No tool radius compensation	m	
G41	2.	Tool radius compensation left of contour	m	
G42	3.	Tool radius compensation right of contour	m	

Group 8: Settable zero offset				
G500	1.	Deselection G54 - G5xx, reset settable frame	m	Def.
G54	2.	1st settable zero offset	m	
G55	3.	2nd settable zero offset	m	
G56	4.	3rd settable zero offset	m	
G57	5.	4th settable zero offset	m	
G5xx	nth	nth settable zero offset	m	
G599	100.	100th settable zero offset	m	

Group 9: Frame suppression				
G53	1.	Suppression of current frame	n	
SUPA	2.	Suppression of current zero offset, including programmed and handwheel offsets (DRF), external zero offset and PRESET offset		

Group 10: Exact stop, continuous path mode				
G60	1.	Velocity reduction, exact positioning	m	Def.
G64	2.	Continuous path mode	m	
G641	3.	Continuous path mode with programmable rounding distance	m	

Group 11: Exact stop blockwise				
G9	1.	Velocity reduction, exact stop	n	

m: modal
n: Non-modal
Def.: Default

List of G functions

Group 12: Block change criteria at exact stop (G60/G09)				
Name	No.	Meaning	m/n	Def.
G601	1.	Block change at exact stop fine	m	**Def.**
G602	2.	Block change at exact stop coarse	m	
G603	3.	Block change at end of interpolation block	m	

Group 13: Workpiece dimensioning inch/metric				
G70	1.	Input system inch	m	
G71	2.	Input system metric	m	Def.

Group 14: Workpiece dimensioning absolute/incremental				
G90	1.	Absolute dimension input	m	Def.
G91	2.	Incremental dimension input	m	

Group 15: Feedrate type				
G93 #	1.	Inverse time feedrate coding	m	
G94	2.	Linear feedrate in mm/min, inch/min	m	Def.
G95	3.	Revolutional feedrate in mm/rev, inch/rev	m	
G96	4.	Constant cutting velocity ON		
G97	5.	Constant cutting velocity OFF		

The vocabulary word does **not** apply for SINUMERIK FM-NC/810D.

Group 16: Feed correction at inside and outside curvature				
CFC	1.	Constant feed at contour	m	Def.
CFTCP	2.	Constant feed in tool center point	m	
CFIN	3.	Constant feed at inside curvature	m	

m: modal
n: Non-modal
Def.: Default

List of G functions

Group 17: Approach/retraction behavior, tool compensation				
Name	No.	Meaning	m/n	Def.
NORM	1.	Normal position at start/end point	m	Def.
KONT	2.	Travel around contour at start/end point	m	

Group 18: Corner behavior, tool compensation				
G450	1.	Transition circle	m	Def.
G451	2.	Intersection of equidistances	m	

Group 19: Curve transition at beginning of spline				
BNAT #	1.	Natural curve transition at the first spline block	m	Def.
BTAN #	2.	Tangential curve transition to the first spline block	m	
BAUTO #	3.	Definition of the 1st spline section through the following 3 points	m	

Group 20: Curve transition at end of spline				
ENAT #	1.	Natural curve transition to the next traversing block	m	Def.
ETAN #	2.	Tangential curve transition at the beginning of spline	m	
EAUTO #	3.	Definition of the last spline section through the last 3 points	m	

Group 21: Acceleration profile				
BRISK	1.	Brisk non-smoothed path acceleration	m	Def.
SOFT	2.	Soft smoothed path acceleration	m	
DRIVE ##	3.	Velocity-related path acceleration	m	

m: modal
n: Non-modal
Def.: Default
The vocabulary word does **not** apply for SINUMERIK 810D.
The vocabulary word applies **only** for SINUMERIK FM-NC.

List of G functions

Group 22: Tool compensation type

Name	No.	Meaning	m/n	Def.
CUT2D	1.	2 1/2D tool compensation	m	Def.
CUT2DF	2.	2 1/2D tool compensation relative to current frame (inclined plane)	m	
CUT3DC #	3.	3D tool compensation peripheral milling	m	
CUT3DF #	4.	3D tool compensation peripheral milling	m	
CUT3DFS #	5.	3D tool compensation face milling with constant tool orientation, independent of active frame	m	
CUT3DFF #	6.	3D tool compensation face milling with constant tool orientation, independent of active frame	m	

The vocabulary word does **not** apply for SINUMERIK FM-NC/810D.

Group 23: Collision detection at inside contours

CDOF	1.	Collision detection off	m	Def.
CDON	2.	Collision detection on	m	

Group 24: Feedrate control

FFWOF	1.	Feedforward control off	m	Def.
FFWON	2.	Feedforward control on	m	

Group 25: Tool orientation

ORIWKS #	1.	Tool orientation in workpiece coordinate system	m	Def.
ORIMKS #	2.	Tool orientation in machine coordinate system	m	
ORIPATH #	3.	Tool orientation path	m	

The vocabulary word does **not** apply for SINUMERIK FM-NC/810D/NCU571.

Group 26: Repositioning point

RMB	1.	Return to start of block	m	
RMI	2.	Return to interruption point	m	Def.
RME	3.	Return to end of block	m	

m: modal
n: Non-modal
Def.: Default

List of G functions

Group 27: Tool compensation on change of orientation at outside corners				
Name	No.	Meaning	m/n	Def.
ORIC #	1.	Orientation changes are superimposed on the circle block to be inserted	m	Def.
ORID #	2.	Orientation changes are performed before the circle block	m	

Group 28: Working area limitation on/off				
WALIMON	1.	Working area limitation on	m	Def.
WALIMOF	2.	Working area limitation off	m	

Group 29: Radius – diameter				
DIAMOF	1.	Diameter programming off	m	Def.
DIAMON	2.	Diameter programming on	m	

Group 30: Compressor on/off				
COMPOF #	1.	Compressor off	m	Def.
COMPON #	2.	Compressor on	m	

Group 31: OEM - G group				
G810 #	1.	OEM G function		Def.
G811 #	2.	OEM G function		
G812 #	3.	OEM G function		
G813 #	4.	OEM G function		
G814 #	5.	OEM G function		
G815 #	6.	OEM G function		
G816 #	7.	OEM G function		
G817 #	8.	OEM G function		
G818 #	9.	OEM G function		
G819 #	10.	OEM G function		

Two groups are reserved for the OEM user who can use them to provide the end user with OEM functions in the final program. No.: Internal number for (e.g.) PLC interface. Def.: Default

The vocabulary word does **not** apply for SINUMERIK FM-NC/810D/NCU571.

m: Modal
n: Non-modal
Def.: Default

List of G functions

Group 32: OEM - G group				
G820 #	1.	OEM G function	**m/s**	**Def.**
G821 #	2.	OEM G function		Def.
G822 #	3.	OEM G function		
G823 #	4.	OEM G function		
G824 #	5.	OEM G function		
G825 #	6.	OEM G function		
G826 #	7.	OEM G function		
G827 #	8.	OEM G function		
G828 #	9.	OEM G function		
G829 #	10.	OEM G function		

Two groups are reserved for the OEM user who can use them to provide the end user with OEM functions in the final program.

No.: Internal number for (e.g.) PLC interface

m: Modal
n: Non-modal
Def.: Default

Group 33: Settable tool fine coding				
FTOCOF #	1.	Online active tool fine coding off	m	Def.
FTOCON #	2.	Online active tool fine coding on	m	

Group 34: Smoothing of tool orientation				
OSOF #	1.	Smoothing of tool orientation off	m	Def.
OSC #	2.	Constant smoothing of tool orientation	m	
OSS #	3.	Smoothing of tool orientation at end of block	m	
OSSE#	4.	Smoothing of tool orientation at beginning and end of block	m	

The vocabulary word does **not** apply for SINUMERIK FM-NC/810D/NCU571.

m: Modal
n: Non-modal
Def.: Default

List of G functions

Group 35: Punching and nibbling				
Name	No.	Meaning	m	Def.
SPOF #	1.	Punching, nibbling off	m	Def.
SON #	2.	Nibbling on	m	
PON #	3.	Punching on	m	
SONS #	4.	Nibbling on in IPO cycle	m	
PONS #	5.	Punching on in IPO cycle	m	

Group 36: Punching with delay				
PDELAYON #	1.	Punching with delay on	m	Def.
PDELAYOF #	2.	Punching with delay off	m	

Group 37: Feedrate profile				
FNORM #	1.	Feed normal in accordance with DIN66025	m	Def.
FLIN #	2.	Feed linear variable	m	
FCUB #	3.	Feed variable according to cubic spline		

Group 38: Assignment of high-speed NCK inputs/outputs for punching/nibbling				
SPIF1 #	1.	High-speed NCK inputs/outputs for punching/nibbling byte 1	m	Def.
SPIF2 #	2.	High-speed NCK inputs/outputs for punching/nibbling byte 2	m	

Group 39: Programmable contour accuracy				
CPRECOF	1.	Programmable contour accuracy off	m	Def.
CPRECON	2.	Programmable contour accuracy on	m	

The vocabulary word does **not** apply for SINUMERIK FM-NC/810D/NCU571.

No.: Internal number for (e.g.) PLC interface

m: Modal
n: Non-modal
Def.: Default

	Suggestions **Corrections**
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