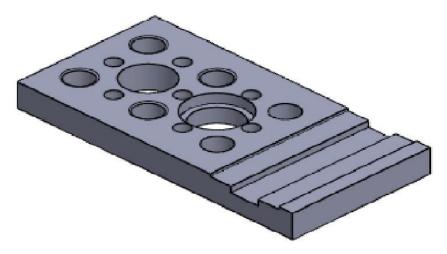
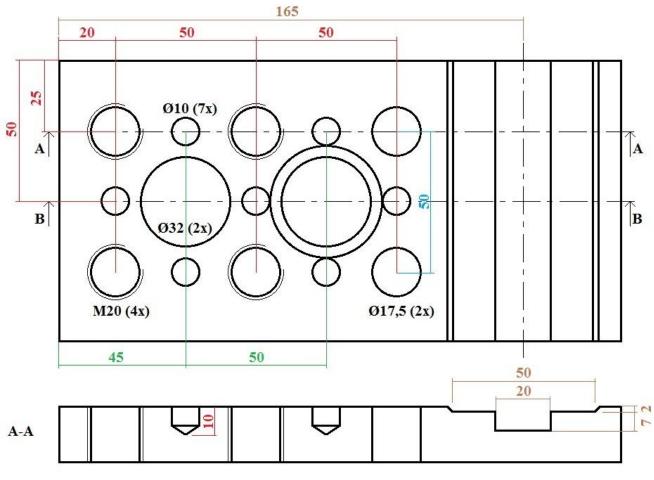
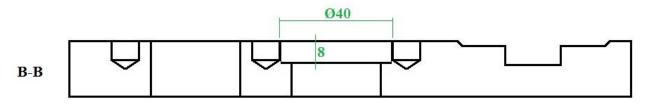
Example Drawing—Part Number 2458:







1st line to program:

Drill 6 holes 17.5 mm (of which 4 will be countersunk & threaded M20)

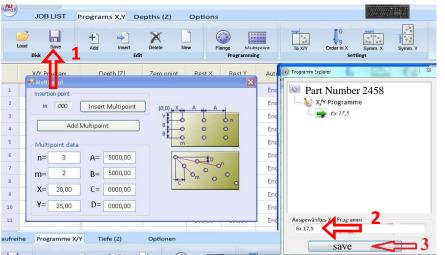
Win13	JOB LIST	Program	1 SXY De	pths (Z)	Optior	IS	2 2					
Los	· .	+ Add	Insert Edit	Delete	New		**** **** Itipoint ing	To 2	° (/Y	0 9 Order in X Setti	Symm. X	Symm. Y
	X/Y Program	Den	th (7)	Zero point	Rest X	Rest Y	Auto	X/Y poir	nt list			X
-	🖳 Multipoint					×		Delete	points	-In	sert points	
1	Insertion point						End	From	000 to	000	In 🔽	00
2	In 000	In 000 Insert Multipoint (0,0) X A A A					Enc	JOB name-X/Y Program				
Add Multipoint												
				в	0 0	0	Enc			Coord, X	Coord. Y	4th axis
5	Multipoint data	a -		-h 🔛	m		Enc		Punkt 1			0,000
6	n= 3	A= 5	5000,00	9	-		Enc			20,00	25,00	10 A 25 13 (6
7	3 _{m= 2}	B= 5	5000,00		20	-0 ⁿ	Enc	3	Punkt 2	20,00	75,00	0,000
8	m= 2			+	om o	° 。	Enc		Punkt 3	70,00	75,00	0,000
9	X = 20,00	C= 0	0000,00				Enc	3	Punkt 4	70,00	25,00	0,000
10	Y= 25,00	D= c	0000,00				Enc		Punkt 5	120,00	25,00	0,000
11							Enc		Punkt 6	120,00	75,00	0,000

- 1. Enter programs X / Y button (XY Empty list comes up)
- 2. Press button Insert Multipoint
- 3. Enter the **data** (see below)
- 4. Press button Add Multipoint (coordinates appear in the X / Y-list)

Meaning entered data:

- n = Number of holes in X-direction = 3
- m = Number of rows in Y direction = 2
- X = Position 1st hole in X measured from the part zero position = 20.00
- Y = Position 1st hole in Y measured from the part zero position = 25.00
- A = Hole spacing in X direction = 50.00
- B = Hole spacing in Y direction = 50.00

Save program



- 1. Press Save (List appears)
- 2. Add Logical Name (6x 17.5)
- 3. Press Save button.

Depth program (= type of machining)

JOB LIST PR	OGRAMS X,Y	Depths (Z)	Option		
Open Save Ordner	New	\hat{U}_1			
3 UNTERPOLATIO	2 DN milling				8
	K	×	Pre, Ye		

- 1 Press depth (Z)
- 2 Press NEW
- 3 Press Drilling

Menu appears: Drilling

NJ Win13	JOB LIST	Programs X,Y	Depths (Z) Options
	Load Save Disk	New	I Drilling
	X/Y Program	Depth (Z)	Depth program name
1	NUEVO 2	NUEVO 2	
2			Data A= 15330,00 C= 2600,00 B
3			
4			
5			P feed= 0,00
6			
7			Height between holes= 15342,00
8			Dwell= 0.0
9 10			Chips breaking system
10			Stops number= 01
11			Backward in mm.= 00,00
13			Backward till A

Enter data:

- A = **Product Height** above the table (= top clamping fixture + material thickness)
- B = **Safety distance** (with drilling it is 2-3 mm)
- C =**Depth** (in through holes material thickness + 0.3x drill diameter)
- P = Feed rate desired other than what is programmed in the tool library

example: helps with initial penetration without allowing the drill to walk/slip.

Program is saved as described in X / Y program, logical name is 17.5