
uniPro 80 G codes

Posted by nairepoc - 2008/02/19 10:05

Preparatory function

G0 Positioning in rapid traverse
G1 Linear interpolation
G2 Circular interpolation, clockwise
G3 Circular interpolation, counter-clockwise
G4 Dwell time, used with X-word (0.01 - 99.99sec)
G10 Constant feed rate
G11 Adapted feed rate
G17 Plane selection XY
G18 Plane selection XZ
G19 Plane selection YZ
G38 Transition arc
G39 Intersection calculation
G40 Cancel cutter compensation
G41 Cutter compensation, left
G42 Cutter compensation, right
G43 Cutter compensation positive (only with G90)
G44 Cutter compensation negative (only with G90)
G45 Cutter radius compensation positive x1
G46 Cutter radius compensation negative x1
G47 Cutter radius compensation positive x2
G48 Cutter radius compensation negative x2 (G45 - G48 only with G91)
G53 Cancel zero point shift
G54 Zero point shift 1
G55 Zero point shift 2
G56 Zero point shift 3
G57 Zero point shift 4
G58 Zero point shift 5
G59 Zero point shift 6
G60 Cancel tapping/accurate positioning
G62 Tapping with reversing chuck
G63 Tapping with balancing chuck
G64 Continuous cutter path control
G70 Dimensions in Imperial
G71 Dimensions in Metric
G90 Absolute Dimensions
G91 Incremental Dimensions

Re:uniPro 80 G codes

Posted by satishbrao - 2010/03/15 04:58

Dear Sir,

I have recently brought a used Heller BEA2, YOM 1991, with Additional Tool magazine, and am unable to start the machine. Referencing does not take place. All the 3 axes are moving manually. Pl. help.

Also, i am not having programming, operation and electrical manuals. Can you provide the same.

Thanking You.

- Satish Rao,
Deltran Diesel Sales & Services,
Kolhapur, Maharashtra, India.

Re:uniPro 80 G codes

Posted by edufer - 2011/01/26 07:07

Hi,

I need manuals for unipro 90 (maasuring probe, variables, jumps, etc)

I have to programing renishaw probe to sure the correct position the part, so I need take a point when the part is in correct position or the probe don't touch anything when the part is in wrong position, in booth cases sendit a operator message "Part in correct position" or "Part is in wrong position, put it again"

Regards.
