

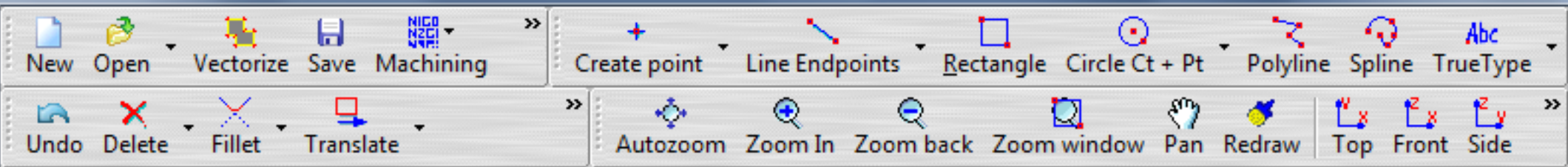
Il profilo per la lavorazione Tornio deve essere generato seguendo queste semplici regole.  
La forma deve essere disegnata in modo tale che:  
L'asse tornio X+ è disegnato nella direzione Y+ di SimplyCam  
L'asse tornio Z+ è disegnato nella direzione X+ di SimplyCam.  
I percorsi utensile saranno convertiti nelle coordiante standard del tornio quando si esegue il postprocessor.

Click per proseguire

X: -21.1 Y: 12.921

2.014 mm

SNAP OFF 90° [Grid] [Snap] [Zoom] [View] [Stop] [Check] Livello corrente: 0



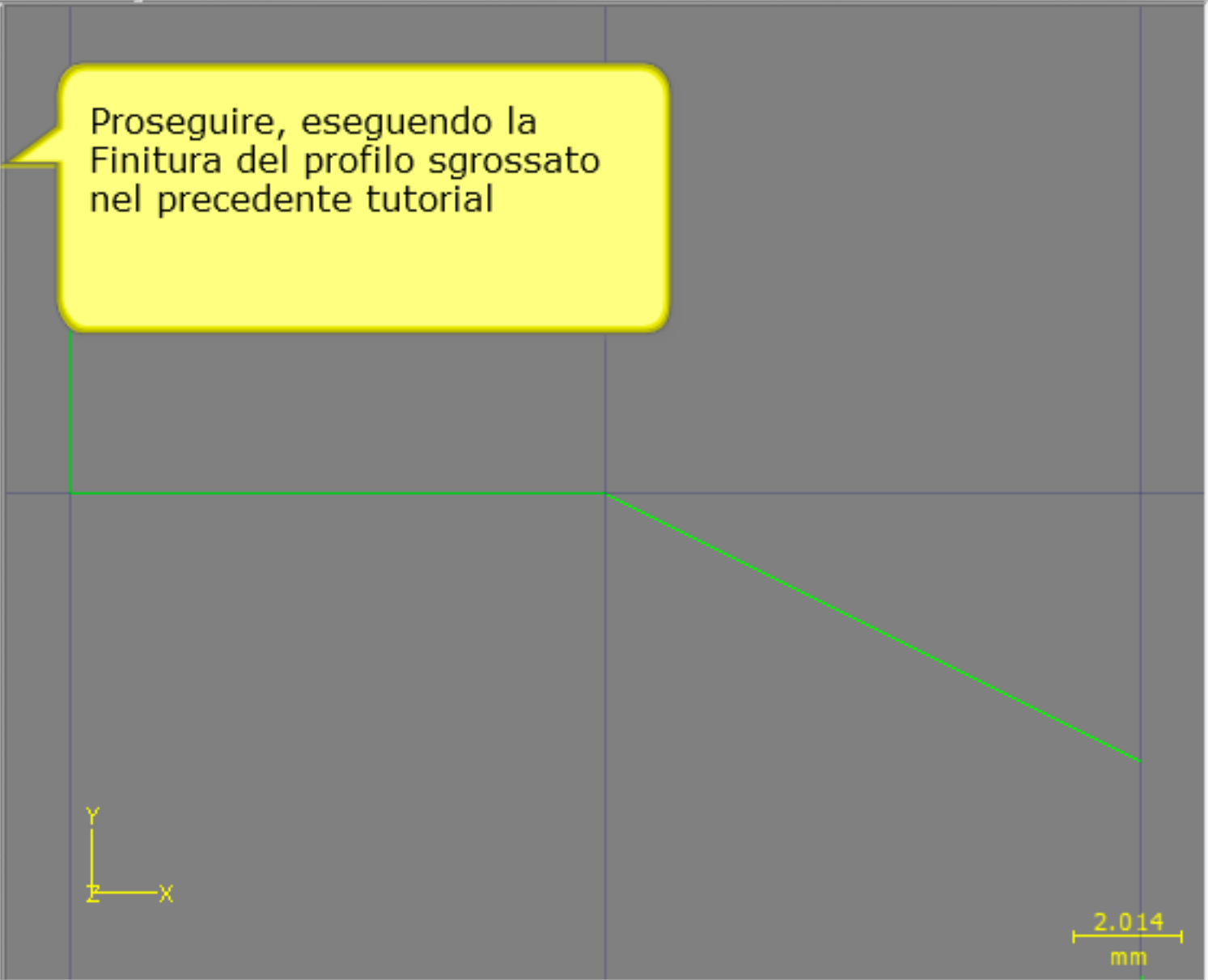
Geometry | Toolpath

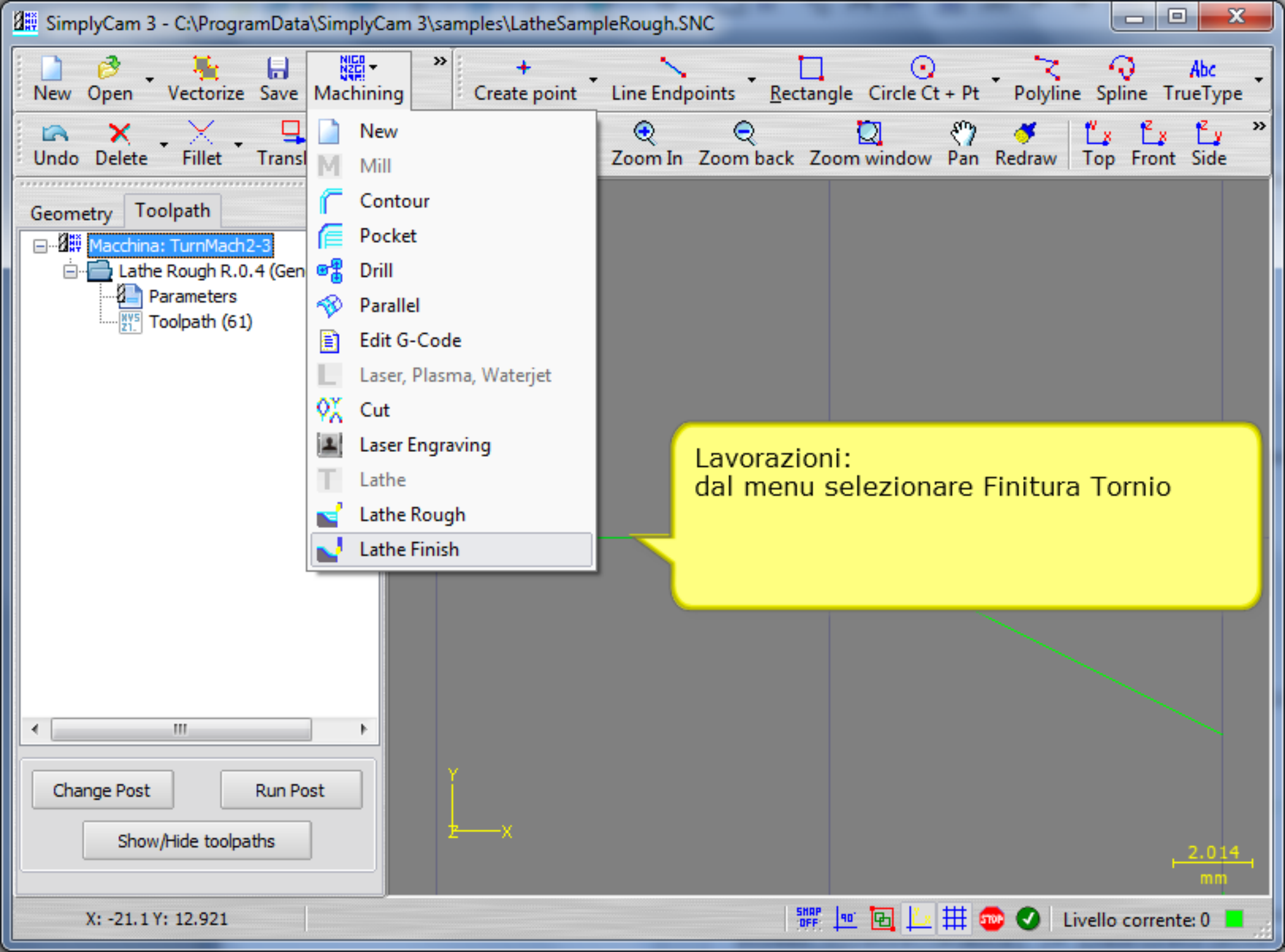
- Macchina: TurnMach2-3
  - Lathe Rough R.0.4 (Generic OD 0...
    - Parameters
    - Toolpath (61)

Change Post    Run Post

Show/Hide toolpaths

Proseguire, eseguendo la Finitura del profilo sgrossato nel precedente tutorial





Lavorazioni:  
dal menu selezionare Finitura Tornio

X: -21.1 Y: 12.921

Livello corrente: 0

### Lathe Finish

Tools

Profiles

Parameters

Tools List:

C:\ProgramData\SimplyC... \Lathe\_mm.rlb

Generic OD 04 15° (Radius 0.4)

Generic OD 08 15° (Radius 0.8)

Generic OD 04 30° (Radius 0.4)

Generic OD 08 30° (Radius 0.8)

Generic ID 04 5° (Radius 0.4)

Generic ID 08 5° (Radius 0.8)

Click sullo stesso  
utensile

Spindle Off

Feed rate: 0.1

mm/giro

mm/min

Coolant

Tool geometry



Name: Generic OD 04 15°

Type: General OD turning

Corner radius: 0.4

Compensation: Tip

Open library

Save library

Add to lib.

Modify in lib.

Change Post

Run Post

Show/Hide toolpaths



2.014  
mm

X: -21.1 Y: 12.921

Define tool, speed and feeds

SHARP  
OFF

90°

Grid

Grid

STOP

Checkmark

Livello corrente: 0

### Lathe Finish

Tools

Profiles

Parameters

Profiles definition:

Layer p

Definizione del profilo

Select

WinSelect

Chain

Reverse

Unselect last

Unselect all

Chains Manager

Cutter Compensation:

Offset Side: Right

Cutter compensation in Cnc (G41/G42)

Change Post

Run Post

Show/Hide toolpaths



X: -21.1 Y: 12.921

Select the profile, cutter compensation and Entry/Exit

SNAP OFF

90°

Grid

Grid

Grid

STOP

Checkmark

Livello corrente: 0

2.014 mm

### Lathe Finish

Tools Profiles Parameters


Profiles definition:


Layer priority


 Last


 Select

 Chain

 Reverse

 Unselect last

 Unselect all

 Chains Manager

Cutter Compensation:

Offset Side: Right

Cutter compensation in Cnc (G41/G42)

Ultimo: definisce il profilo usato nella precedente operazione

Change Post

Run Post

Show/Hide toolpaths



2.014 mm

X: -21.1 Y: 12.921

Select the profile, cutter compensation and Entry/Exit



Livello corrente: 0

### Lathe Finish

Tools Profiles Parameters

Profiles definition:

Layer priority

Go To

Last All

Select WinSelect

Chain Reverse

Unselect last Unselect all Chains Manager

1 open chain

Cutter Compensation:

Offset Side: Right

- Off
- Right
- Left

Cutter compensation in Cnc (G41/G42)

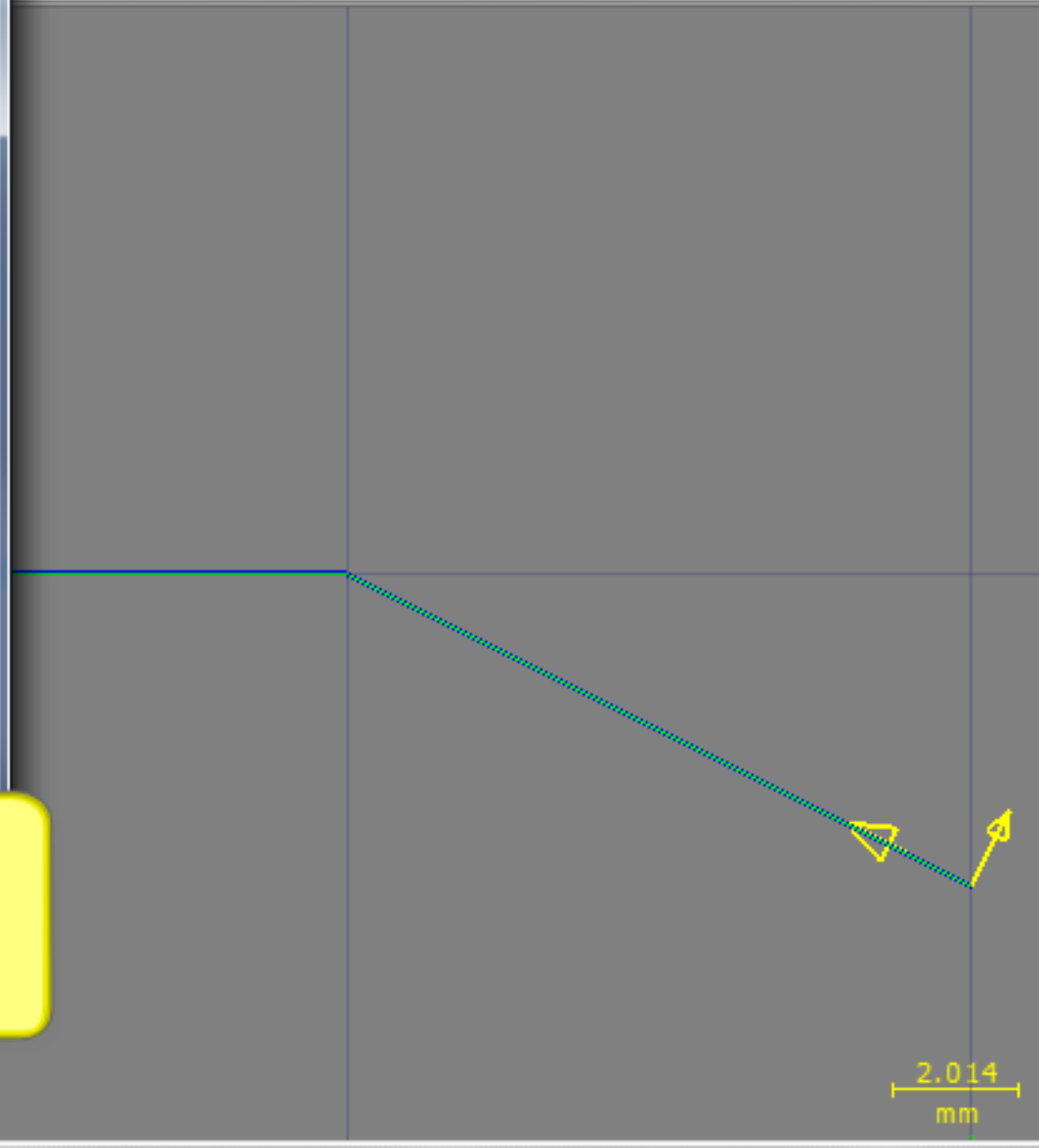
Definizione della compensazione utensile (a destra del profilo concatenato)

Change

Show/Hide toolpaths

Line Endpoints Rectangle Circle Ct + Pt Polyline Spline TrueType

Zoom In Zoom back Zoom window Pan Redraw Top Front Side



X: -21.1 Y: 12.921

Select the profile, cutter compensation and Entry/Exit

SHARP OFF 90°

Livello corrente: 0

2.014 mm

### Lathe Finish

Tools

Profiles

Parameters

Profiles definition:

Layer priority

Go To

Last

All

Select

WinSelect

Chain

Reverse

Unselect last

Unselect all

Chains Manager

1 open chain

Cutter Compensation:

Offset Side:

- Right
- Off
- Right
- Left

Cutter compensation in Cnc (G41/G42)

Change Post

Run Post

Show/Hide toolpaths



Freccia grande= Direzione passata  
Freccia piccola= Direzione compensazione

X: -21.1 Y: 12.921

Select the profile, cutter compensation and Entry/Exit

OFF 90

Livello corrente: 0



Lathe Finish

Tools

Profiles

Parameters

Finish parameters:

Face toolpath

Lead in... (0)

Lead out... (0 @ 0°)

Stock to leave: 0

N. 1

Finish cut size: 0

Home position: X40, Z5

Calculate

Cancel

Parametri

Change Post

Run Post

Show/Hide toolpaths

X: -21.1 Y: 12.921

Set the cutting parameters and press the 'Calculate' button

SNAP OFF

90°

Grid

Layers

Grid

STOP

Check

Livello corrente: 0

2.014 mm

### Lathe Finish

Tools Profiles Parameters

Finish parameters:

Face toolpath

Lead in... (0 @ 0°)

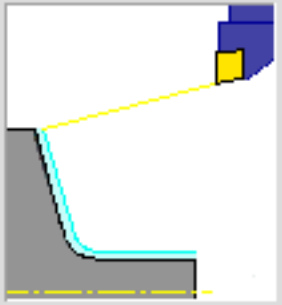
Lead out... (0 @ 0°)

Stock to leave: 0

N. 1

Finish cut size: 0

Home position: X40, Z5



Calculate

Calcolo lavorazione

Change Post

Run Post

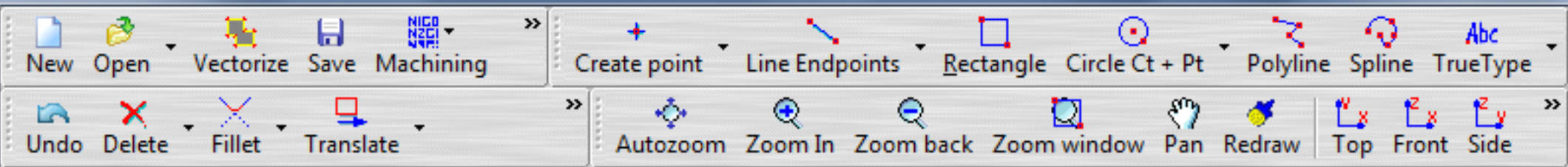
Show/Hide toolpaths



2.014 mm

X: -21.1 Y: 12.921

Set the cutting parameters and press the 'Calculate' button



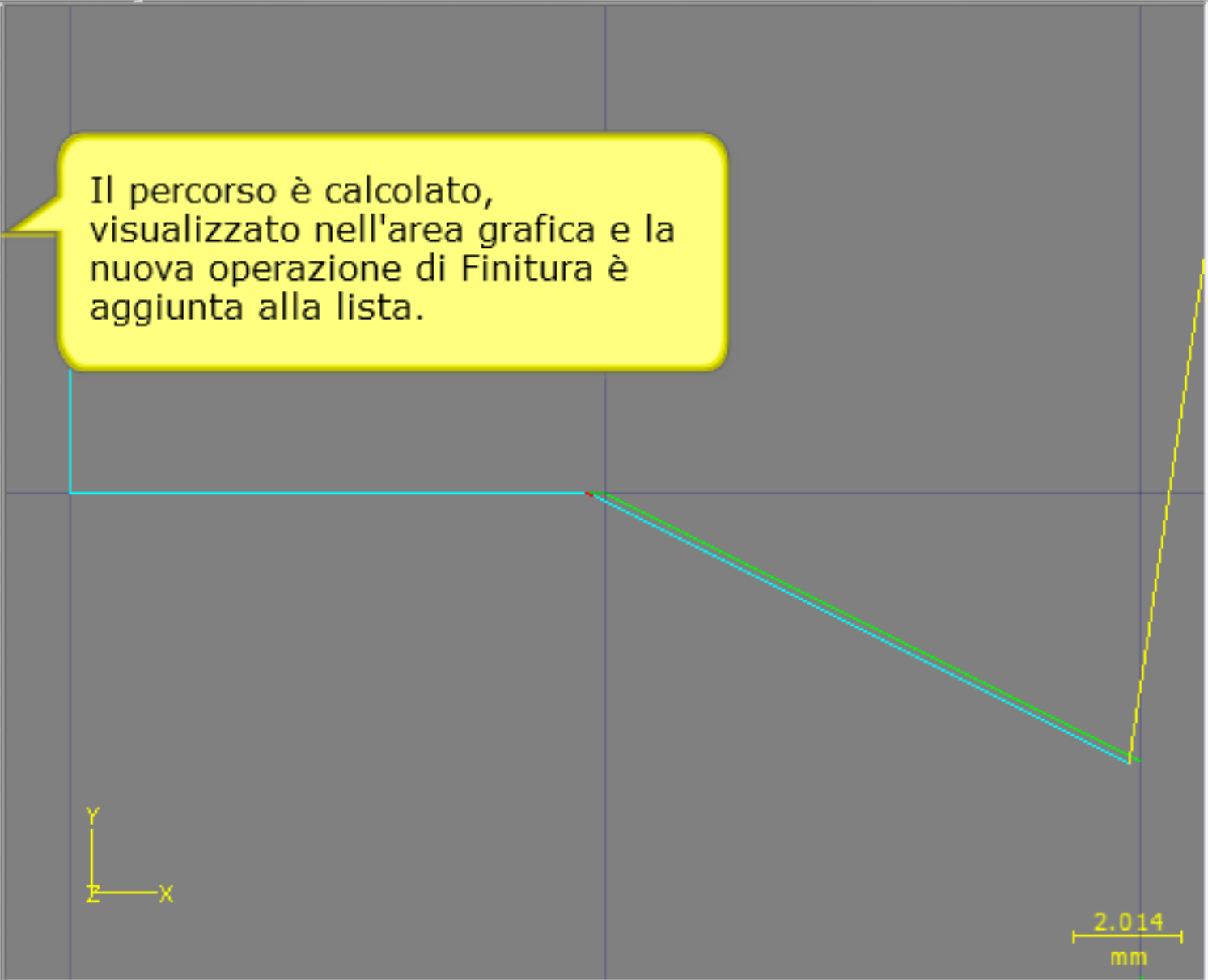
Geometry Toolpath

- Macchina: TurnMach2-3
  - Lathe Rough R.0.4 (Generic OD 0...
    - Parameters
    - Toolpath (61)
  - Lathe Finish R.0.4 (Generic OD 04...
    - Parameters
    - Toolpath (5)

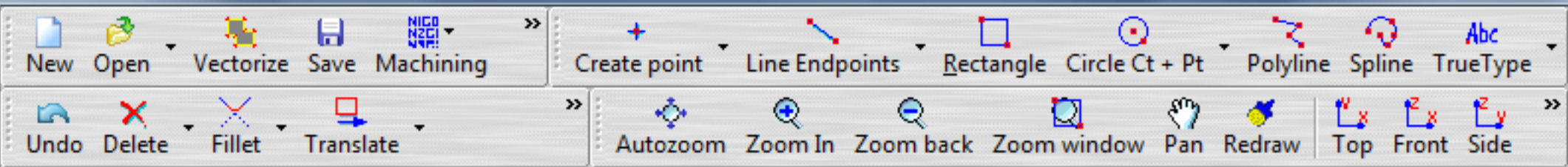
Change Post Run Post

Show/Hide toolpaths

Il percorso è calcolato, visualizzato nell'area grafica e la nuova operazione di Finitura è aggiunta alla lista.



X: -21.18 Y: 6.676



Geometry Toolpath

- Macchina: TurnMach2-3
  - Lathe Rough R.0.4 (Generic OD 0)
    - Parameters
    - Toolpath (61)
  - Lathe Finish R.0.4 (Generic OD 0)
    - Parameters
    - Toolpath (5)

Change Post Run Post Show/Hide toolpaths

Doppio Click su Percorso Utensile per aprire il dialogo di Simulazione



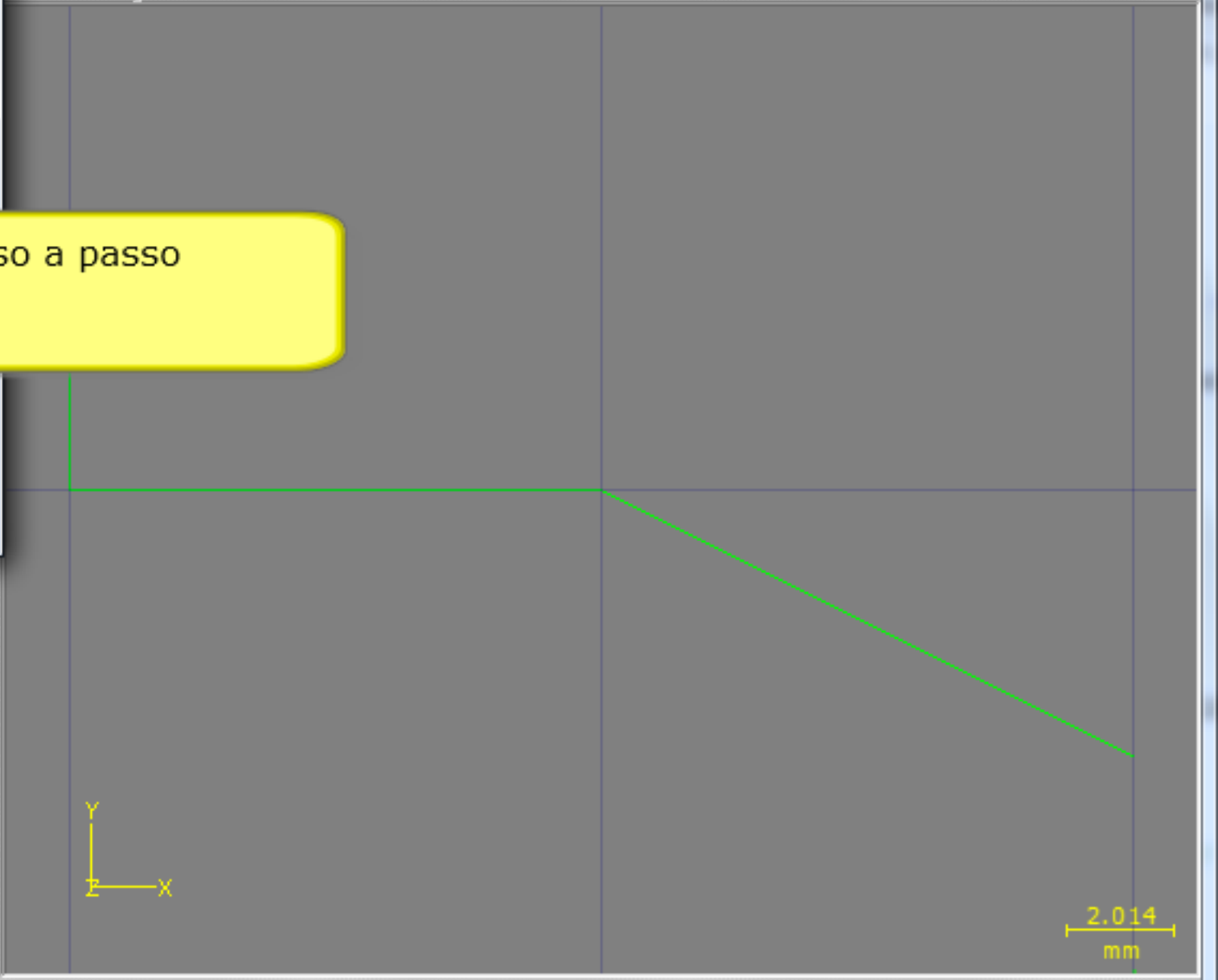
X: -21.18 Y: 6.676

Navigation and drawing toolbar with icons for: New, Open, Vectorize, Save, Machining, Create point, Line Endpoints, Rectangle, Circle Ct + Pt, Polyline, Spline, TrueType, Autozoom, Zoom In, Zoom back, Zoom window, Pan, Redraw, Top, Front, Side.

Simulation control panel with a progress bar, 'Line:0/5' indicator, and checkboxes for 'Show Tool', 'Solid simulation', and 'GCode simulation'. A yellow callout bubble points to the right arrow button.

Passo a passo

Post-processor control panel with buttons for 'Change Post', 'Run Post', and 'Show/Hide toolpaths'.



New Open Vectorize Save Machining
Create point Line Endpoints Rectangle Circle Ct + Pt Polyline Spline TrueType
Autozoom Zoom In Zoom back Zoom window Pan Redraw Top Front Side

.....

.....

Line: 1/5

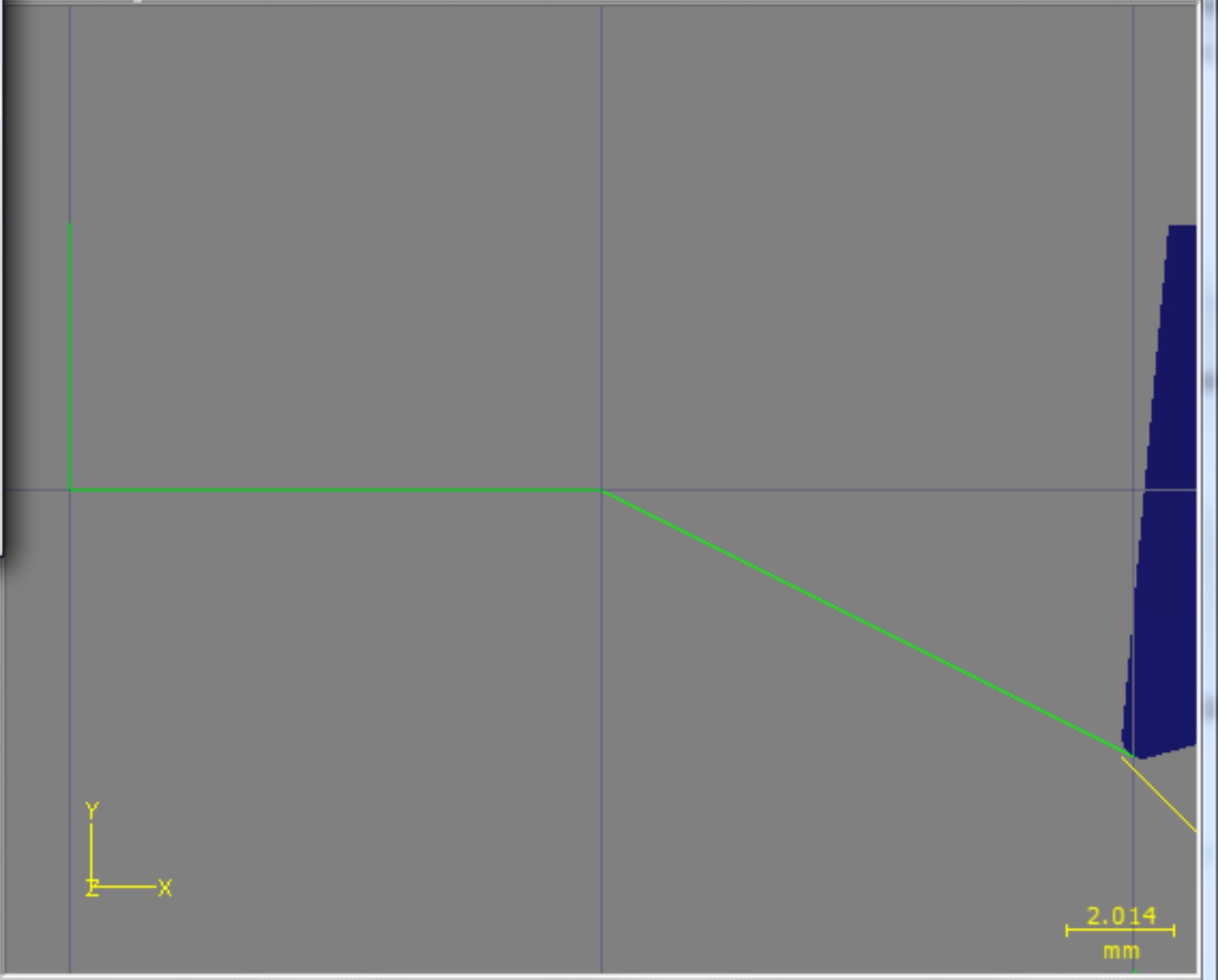
⏪ ⏩ ▶ ⏭

Step (F5)

Show Tool  
 Solid simulation  
 GCode simulation

Change Post Run Post

Show/Hide toolpaths



New
 Open
 Vectorize
 Save
 Machining

Create point
 Line Endpoints
 Rectangle
 Circle Ct + Pt
 Polyline
 Spline
 TrueType

Autozoom
 Zoom In
 Zoom back
 Zoom window
 Pan
 Redraw
 Top
 Front
 Side

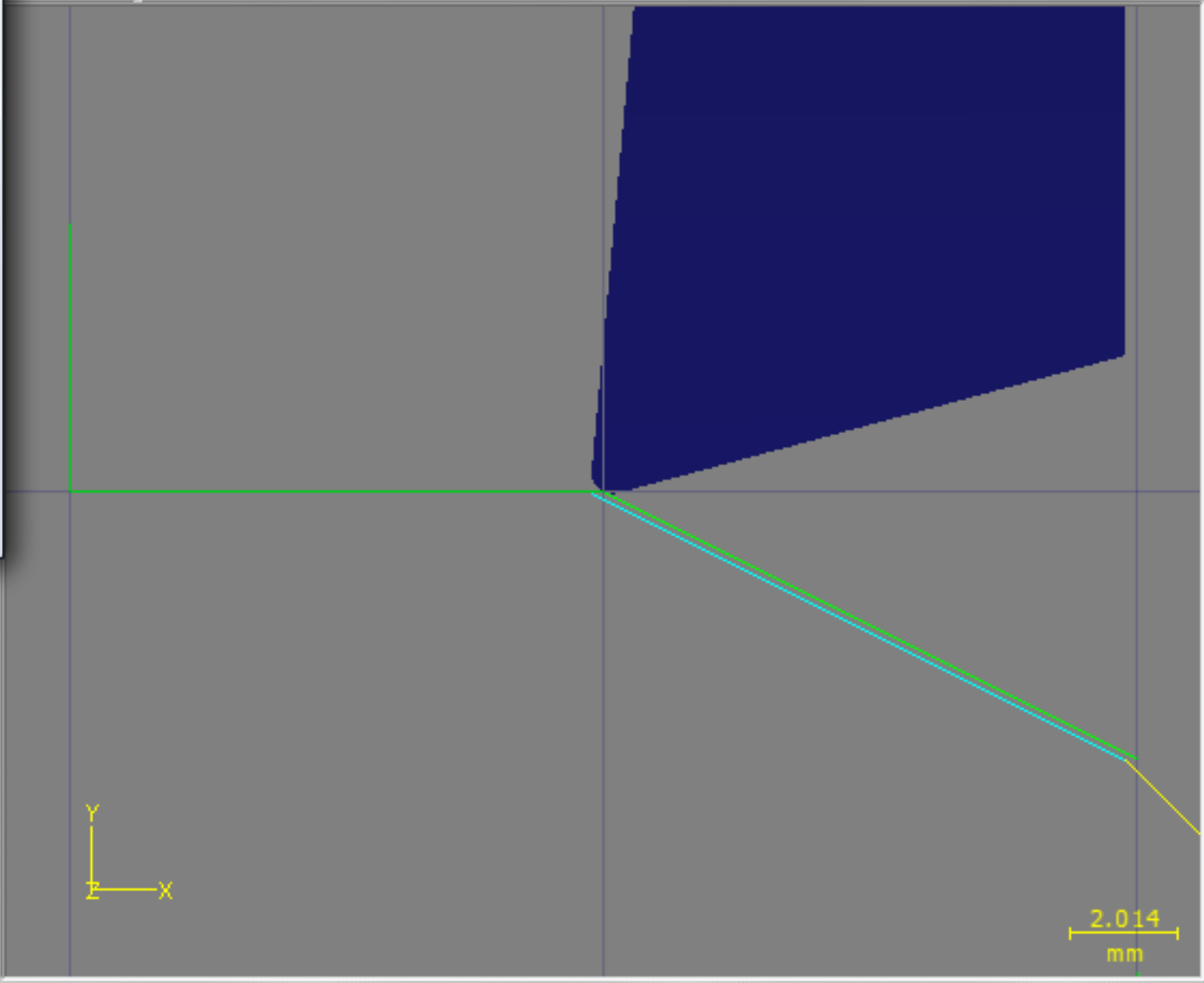
.....

.....

Line: 2/5

Step (F5)

Show Tool  
 Solid simulation  
 GCode simulation



Change Post
 Run Post

Show/Hide toolpaths

X: -21.18 Y: 6.676

SNAP OFF
 90°
 


 Livello corrente: 0

New
 Open
 Vectorize
 Save
 Machining

Create point
 Line Endpoints
 Rectangle
 Circle Ct + Pt
 Polyline
 Spline
 TrueType

Autozoom
 Zoom In
 Zoom back
 Zoom window
 Pan
 Redraw
 Top
 Front
 Side

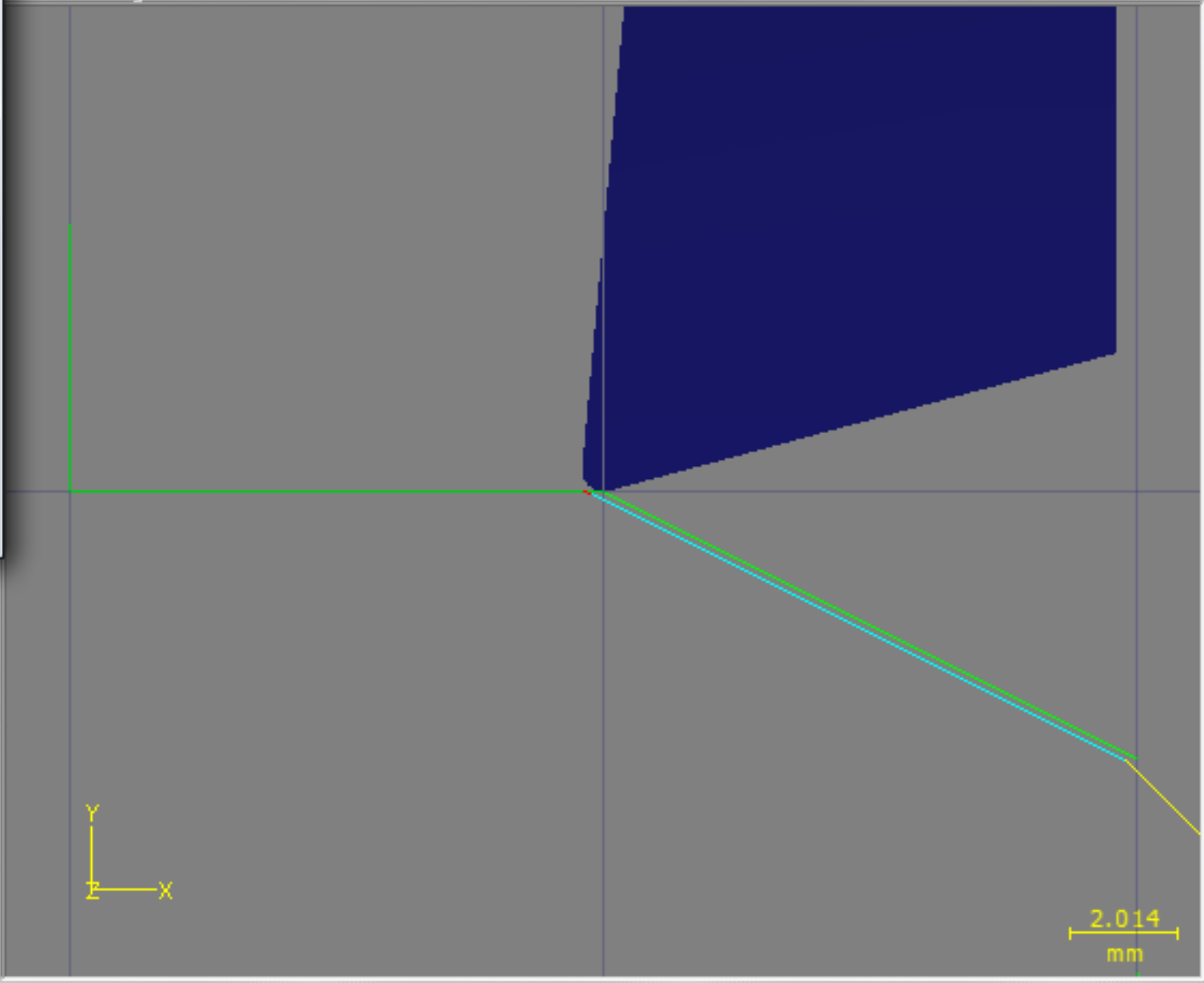
.....

.....

Line:3/5

Step (F5)

Show Tool  
 Solid simulation  
 GCode simulation



Change Post
 Run Post

Show/Hide toolpaths

X: -21.18 Y: 6.676

SNAP OFF
 90°
 


 Livello corrente: 0

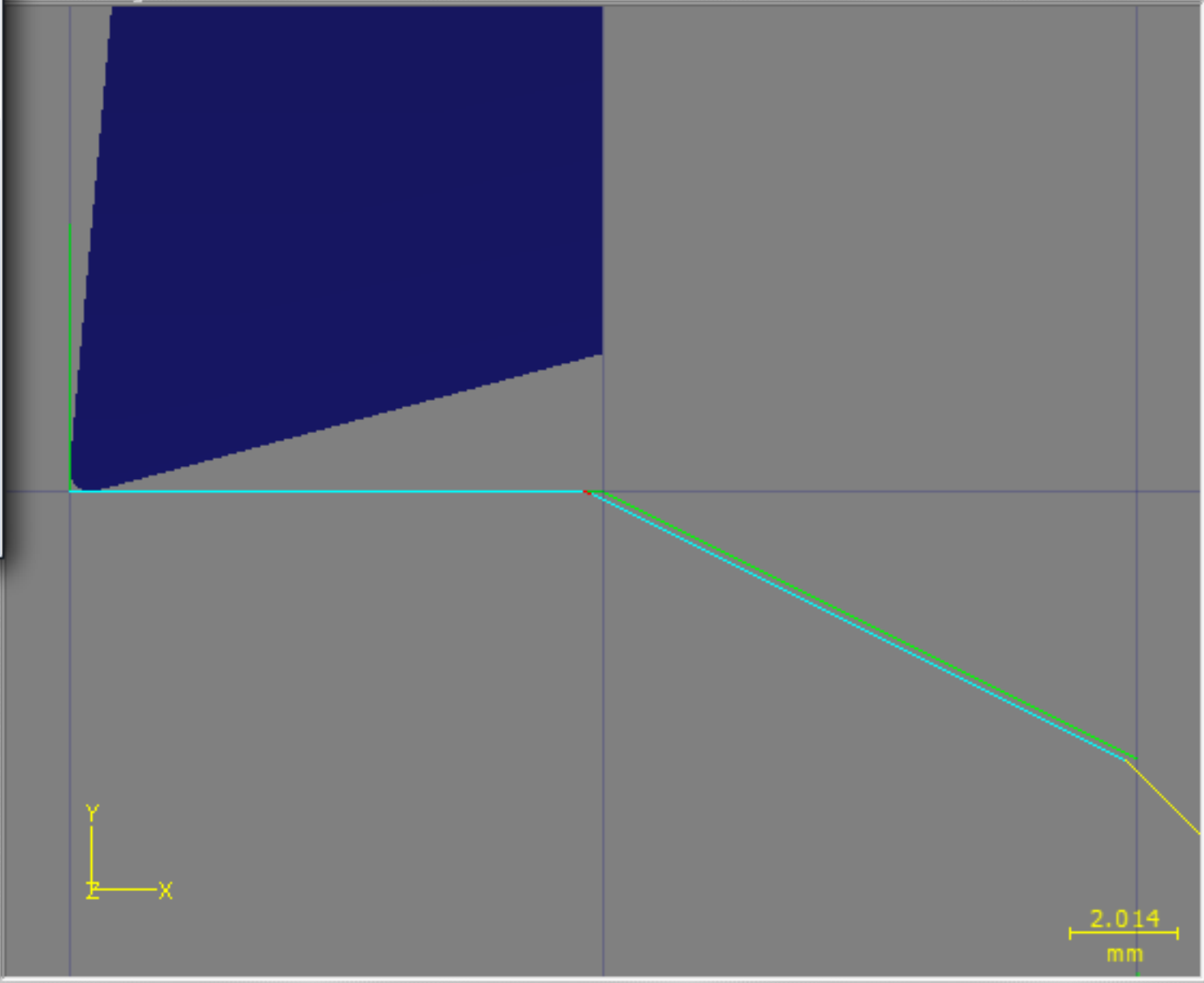


New
 Open
 Vectorize
 Save
 Machining

Create point
 Line Endpoints
 Rectangle
 Circle Ct + Pt
 Polyline
 Spline
 TrueType

Autozoom
 Zoom In
 Zoom back
 Zoom window
 Pan
 Redraw
 Top
 Front
 Side

\*\*\*\*\*  
 \*\*\*\*\*  
 Line:4/5  
  
 Step (F5)  
 Show Tool  
 Solid simulation  
 GCode simulation



Change Post
 Run Post  
 Show/Hide toolpaths

X: -21.18 Y: 6.676

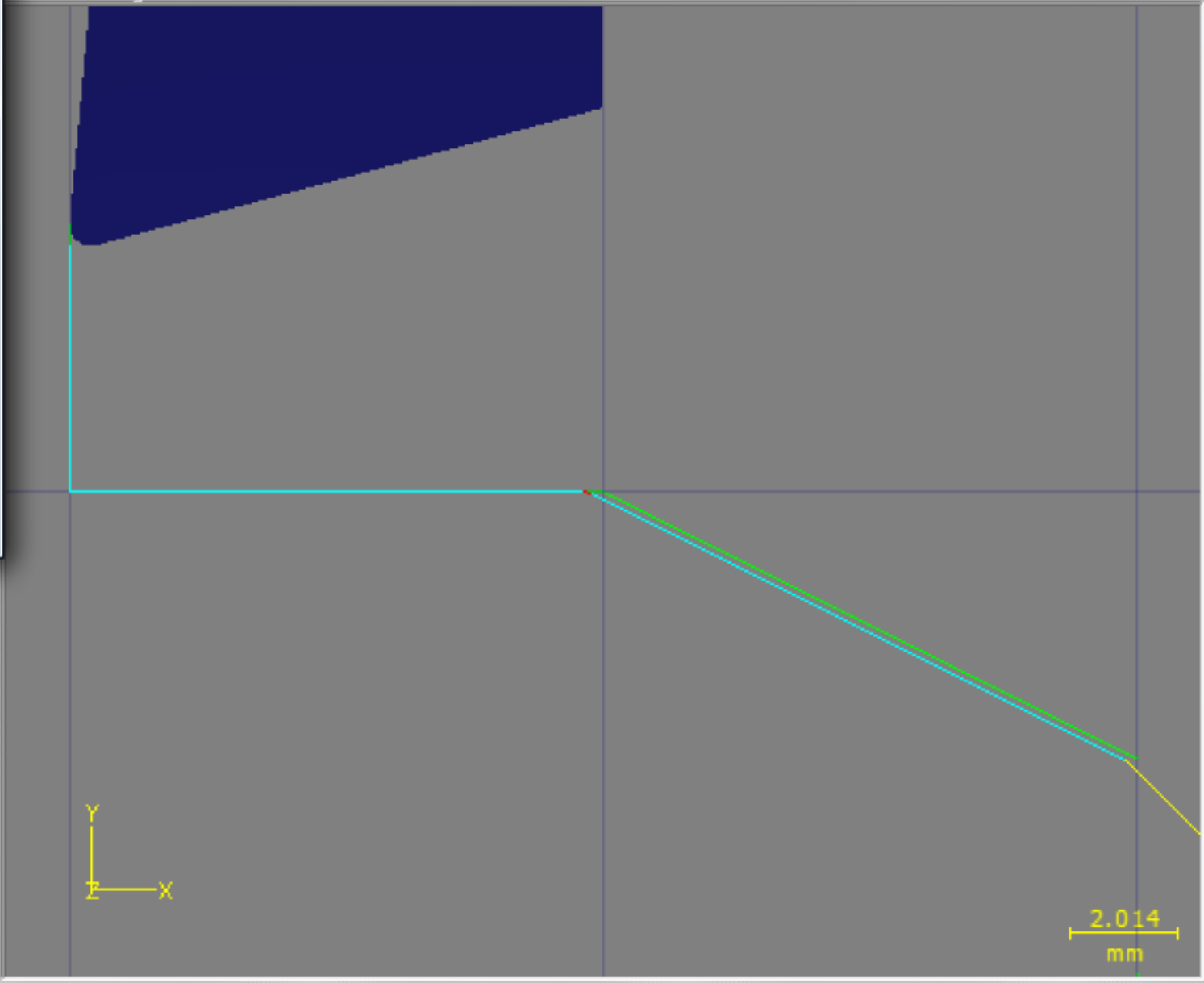
SNAP OFF
 90°
 Grid
 Snap
 STOP
 ✓
 Livello corrente: 0

New
 Open
 Vectorize
 Save
 Machining

Create point
 Line Endpoints
 Rectangle
 Circle Ct + Pt
 Polyline
 Spline
 TrueType

Autozoom
 Zoom In
 Zoom back
 Zoom window
 Pan
 Redraw
 Top
 Front
 Side

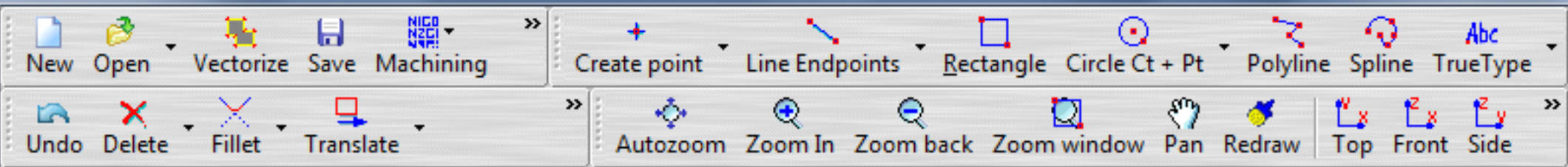
\*\*\*\*\*  
 \*\*\*\*\*  
 Line:5/5  
  
 Step (F5)  
 Show Tool  
 Solid simulation  
 GCode simulation



Change Post
 Run Post  
 Show/Hide toolpaths

X: -21.18 Y: 6.676

SNAP OFF
 90°
 Grid
 STOP
 ✓
 Livello corrente: 0



Geometry Toolpath

- Macchina: TurnMach2-3
  - Lathe Rough R.0.4 (Ge)
    - Parameters
    - Toolpath (61)
  - Lathe Finish R.0.4 (Ge)
    - Parameters
    - Toolpath (1)

Change Post Run Post

Show/Hide toolpaths

Modifica della lavorazione:  
Doppio Click su Parametri per aprire i dialoghi di Finitura



### Lathe Finish

Tools

Profiles

Parameters

Finish parameters:

Face toolpath

Lead in... (0 @ 0°)

Lead out... (0 @ 0°)

Stock to leave: 0

N. 1

Finish cut size: 0

Home position: X40, Z5

Calculate

Cancel

Aggiungere l'Entrata al profilo

Change Post

Run Post

Show/Hide toolpaths

X: -20.979 Y: 14.895

Set the cutting parameters and press the 'Calculate' button

SNAP OFF

90°

Grid

Y

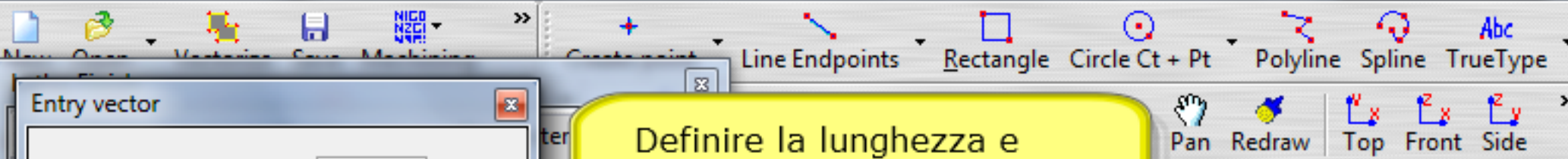
X

STOP

Check

Current layer: 0

Layer indicator



Entry vector

Entry length:

Direction(degrees):

Ok

Calculate Cancel

Home position: X=0, Z5

Change Post Run Post

Show/Hide toolpaths

X: -20.979 Y: 14.895

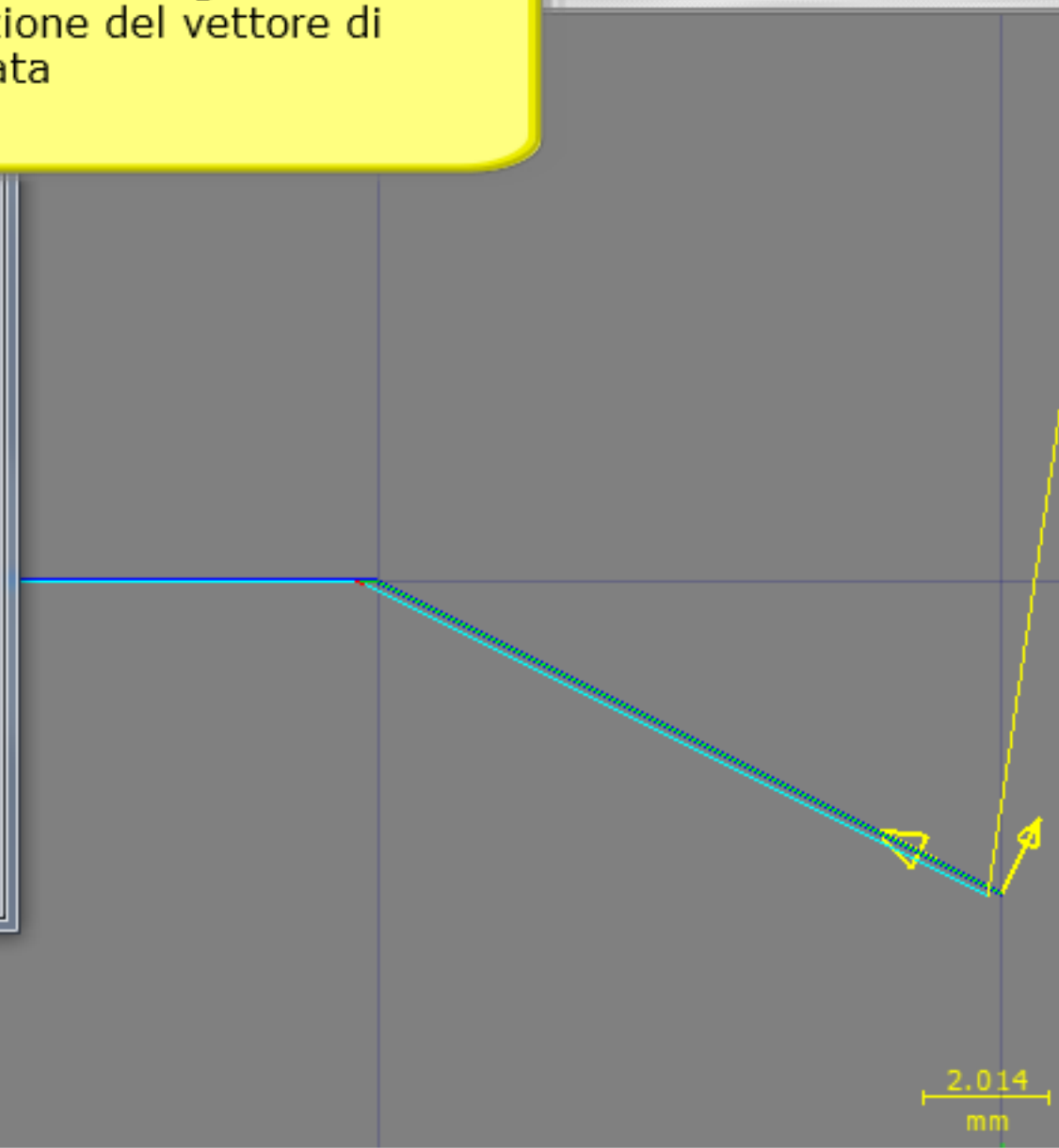
Set the cutting parameters and press the 'Calculate' button

SNAP OFF 90°

Current layer: 0

The 'Entry vector' dialog box is the central focus. It contains two input fields: 'Entry length' with the value '1' and 'Direction(degrees)' with the value '180'. Below these fields is a diagram with a central point and an arrow pointing to the left, representing a vector. There are several other points around the central point, some with small circles around them. At the bottom of the dialog are 'Calculate' and 'Cancel' buttons. Below the dialog, there are buttons for 'Change Post', 'Run Post', and 'Show/Hide toolpaths'. The status bar at the bottom shows coordinates 'X: -20.979 Y: 14.895', a message 'Set the cutting parameters and press the 'Calculate' button', and various icons including 'SNAP OFF', '90°', and 'Current layer: 0'.

Definire la lunghezza e direzione del vettore di Entrata



2.014 mm

### Lathe Finish

Tools | Profiles | Parameters

Finish parameters:

- Face toolpath
- Lead in... ( 1 @ 180°)
- Lead out... ( 0 @ 0°)

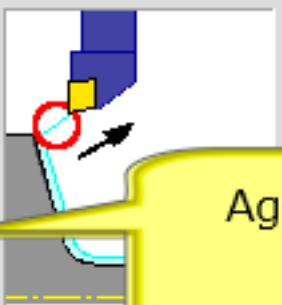
Stock to leave: 0

N. 1

Finish cut size: 0

Home position: X40, Z5

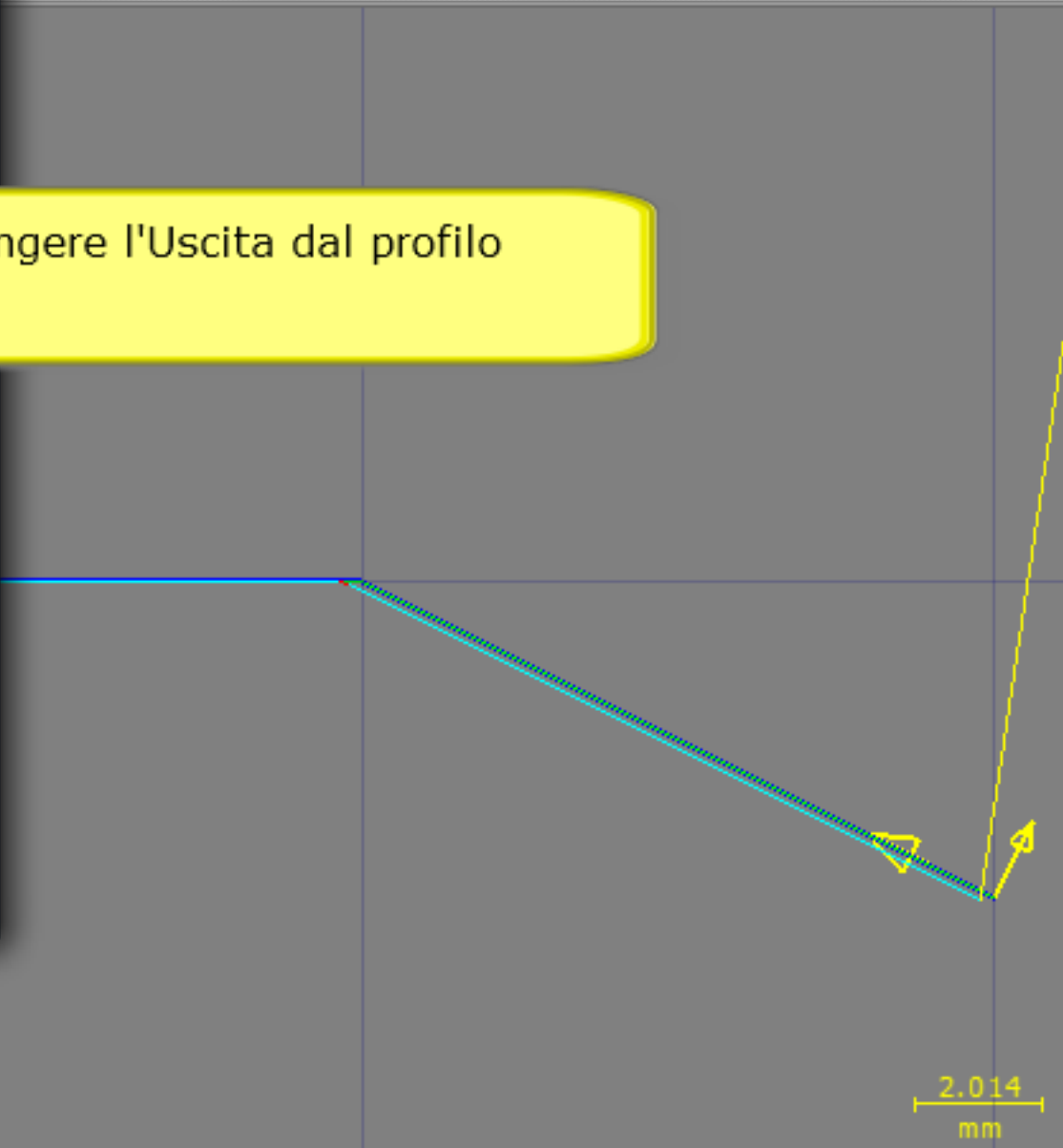
Calculate | Cancel



Aggiungere l'Uscita dal profilo

Line Endpoints | Rectangle | Circle Ct + Pt | Polyline | Spline | TrueType

Zoom In | Zoom back | Zoom window | Pan | Redraw | Top | Front | Side



Change Post | Run Post

Show/Hide toolpaths

X: -20.979 Y: 14.895

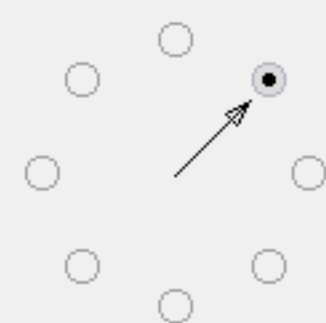
Set the cutting parameters and press the 'Calculate' button

SNAP OFF | 90° | Grid | Stop | Current layer: 0

Exit vector

Exit length: 1

Direction(degrees): 45



Ok

Calculate

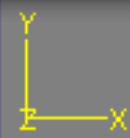
Cancel

Definire la lunghezza e direzione del vettore di Uscita

Change Post

Run Post

Show/Hide toolpaths



X: -20.979 Y: 14.895

Set the cutting parameters and press the 'Calculate' button

2.014 mm

### Lathe Finish

Tools

Profiles

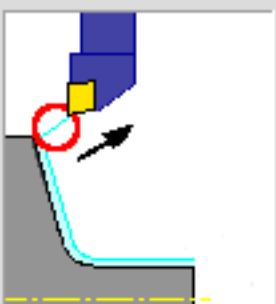
Parameters

Finish parameters:

Face toolpath

Lead in... ( 1 @ 180°)

Lead out... ( 1 @ 45°)



Stock to leave: 0

N. 1

Finish cut size: 0

Home position: X40, Z5

Calculate

Cancel

Eseguire il Ricalcolo della lavorazione con i nuovi parametri

Change Post

Run Post

Show/Hide toolpaths

X: -20.616 Y: 5.83

Set the cutting parameters and press the 'Calculate' button

SNAP OFF

90°

Grid

Isometric

Grid

STOP

Checkmark

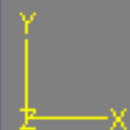
Current layer: 0

Green square

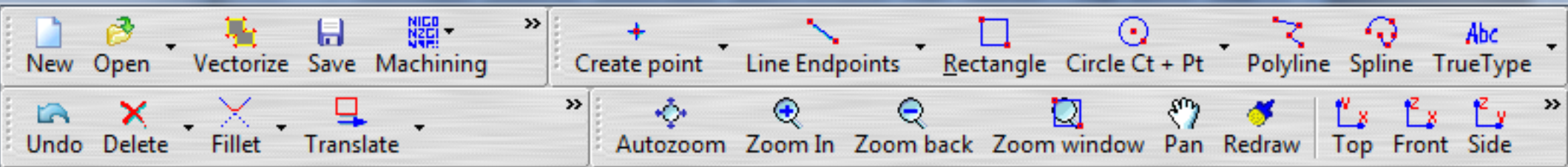
2.014 mm

Line Endpoints    Rectangle    Circle Ct + Pt    Polyline    Spline    TrueType

Zoom In    Zoom back    Zoom window    Pan    Redraw    Top    Front    Side





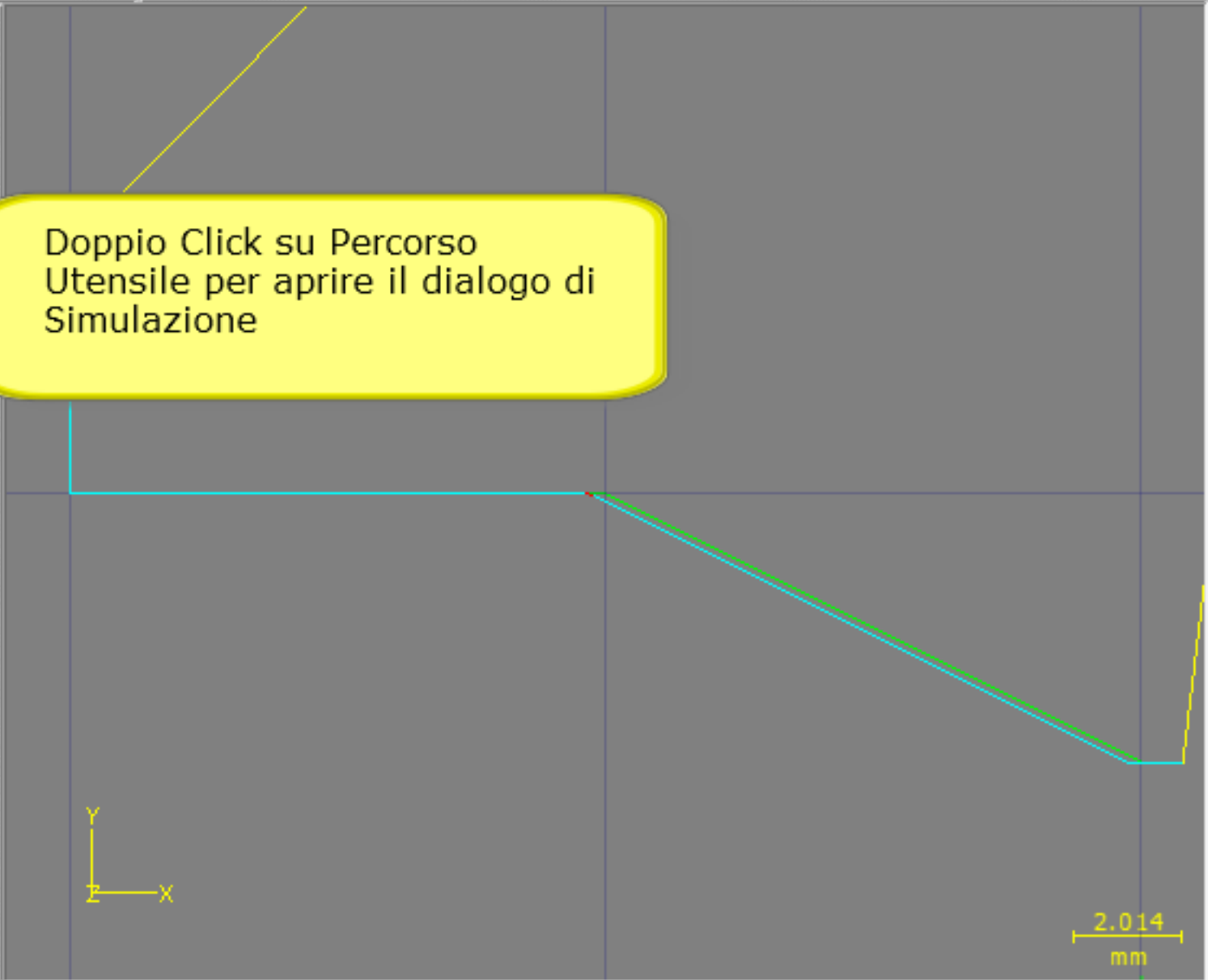


Geometry Toolpath

- Machine: TurnMach2-3
  - Lathe Rough R.0.4 (Generic OD 0...)
    - Parameters
    - Toolpath (61)
  - Lathe Finish R.0.4 (Generic OD 0...)
    - Parameters
    - Toolpath (8)

Change Post Run Post Show/Hide toolpaths

Doppio Click su Percorso Utensile per aprire il dialogo di Simulazione



File menu: New, Open, Vectorize, Save, Machining

Tools menu: Create point, Line Endpoints, Rectangle, Circle Ct + Pt, Polyline, Spline, TrueType

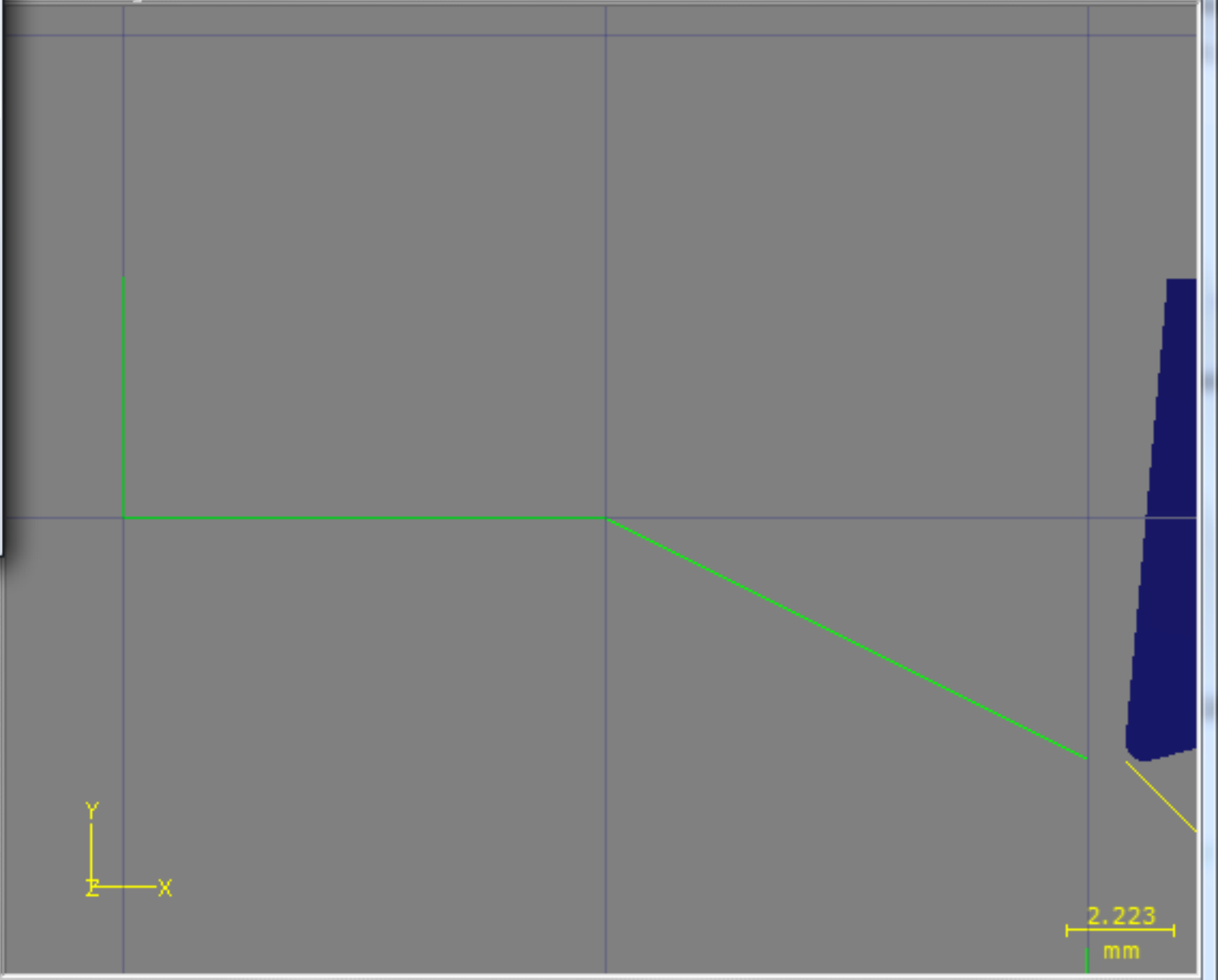
Navigation menu: Autozoom, Zoom In, Zoom back, Zoom window, Pan, Redraw, Top, Front, Side

Line: 1/7

Navigation buttons: <<<, <<, >>, >>>

Step (F5)

Simulation options:  
 Show Tool  
 Solid simulation  
 GCode simulation



Change Post

Run Post

Show/Hide toolpaths

File menu: New, Open, Vectorize, Save, Machining

Tools menu: Create point, Line Endpoints, Rectangle, Circle Ct + Pt, Polyline, Spline, TrueType

Navigation menu: Autozoom, Zoom In, Zoom back, Zoom window, Pan, Redraw, Top, Front, Side

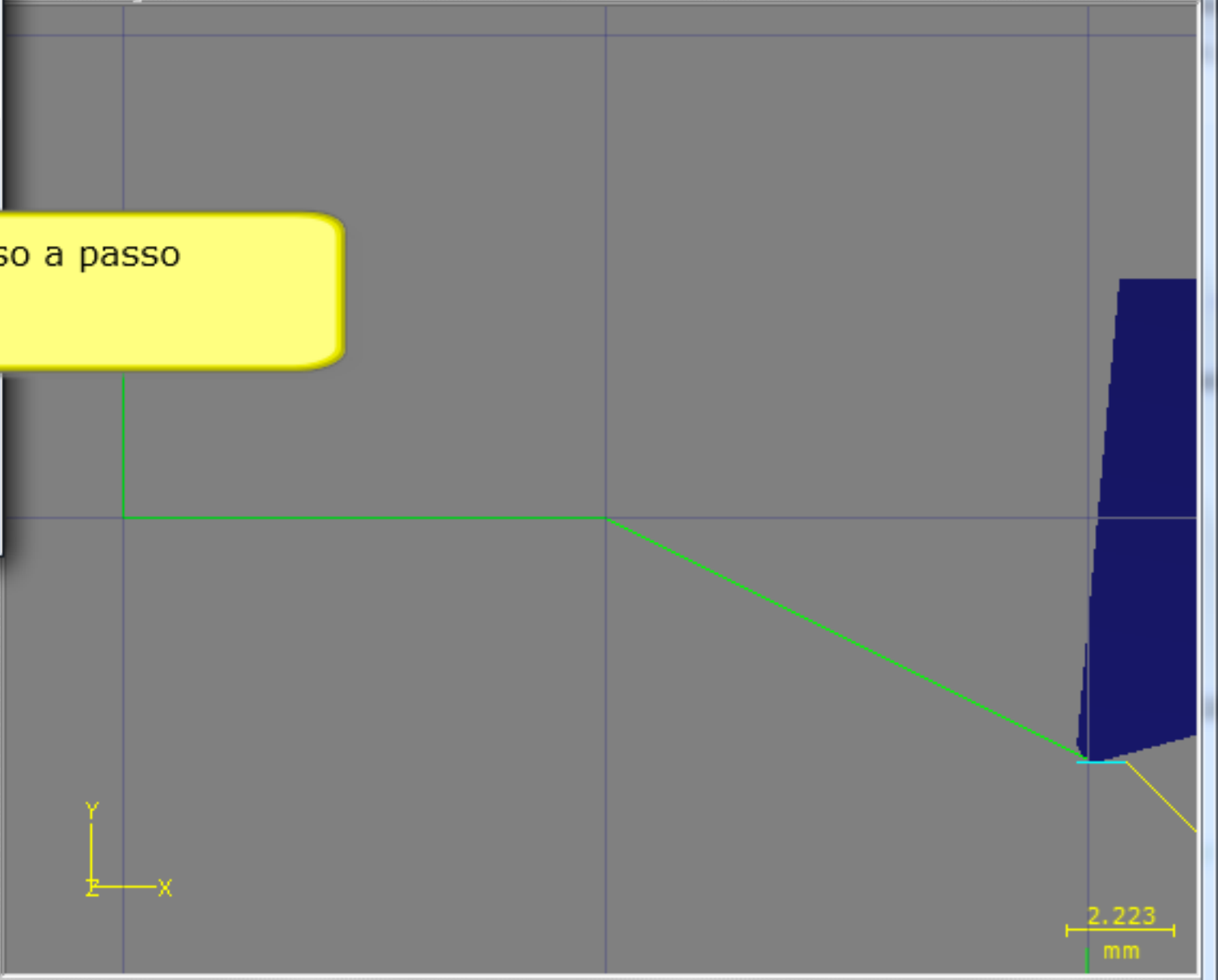
Line: 2/7

Navigation buttons: Previous, Play, Next, Stop

Simulation options:  
 Show Tool  
 Solid simulation  
 GCode simulation

Passo a passo

Change Post, Run Post, Show/Hide toolpaths



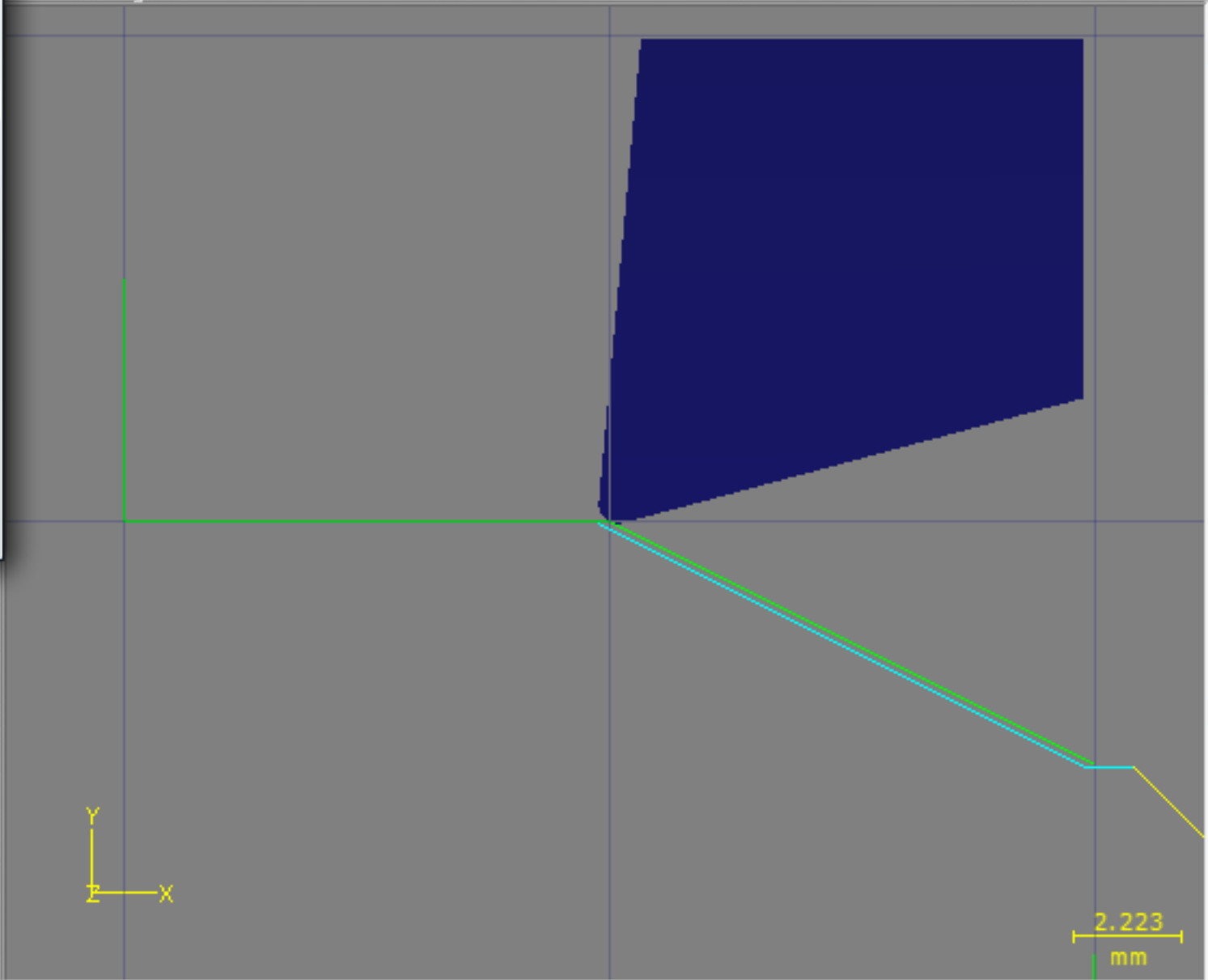
New
 Open
 Vectorize
 Save
 Machining

Create point
 Line Endpoints
 Rectangle
 Circle Ct + Pt
 Polyline
 Spline
 TrueType

Autozoom
 Zoom In
 Zoom back
 Zoom window
 Pan
 Redraw
 Top
 Front
 Side

.....  
 .....  
 .....  
 .....  
 .....  
 .....  
 |.....  
 Line:3/7

Show Tool  
 Solid simulation  
 GCode simulation



Change Post
 Run Post

Show/Hide toolpaths

X: -22.419 Y: 10.563

SNAP OFF
 90°
 
 STOP
 
 Livello corrente: 0

File menu: New, Open, Vectorize, Save, Machining

Tools menu: Create point, Line Endpoints, Rectangle, Circle Ct + Pt, Polyline, Spline, TrueType

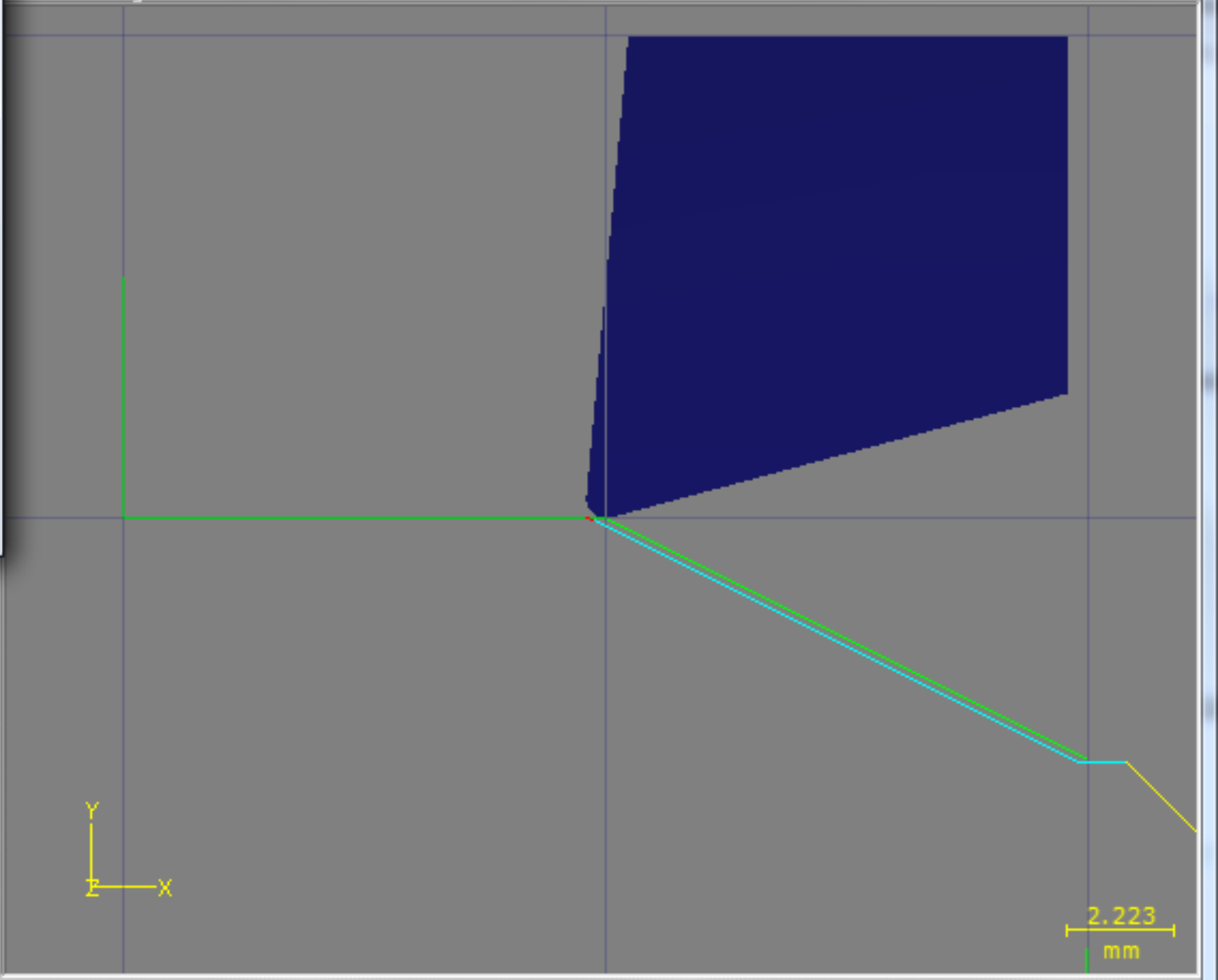
Navigation menu: Autozoom, Zoom In, Zoom back, Zoom window, Pan, Redraw, Top, Front, Side

Line: 4/7

Navigation buttons: <<, <, >, >>

Step (F5)

Options:  
 Show Tool  
 Solid simulation  
 GCode simulation



Change Post

Run Post

Show/Hide toolpaths

New
 Open
 Vectorize
 Save
 Machining

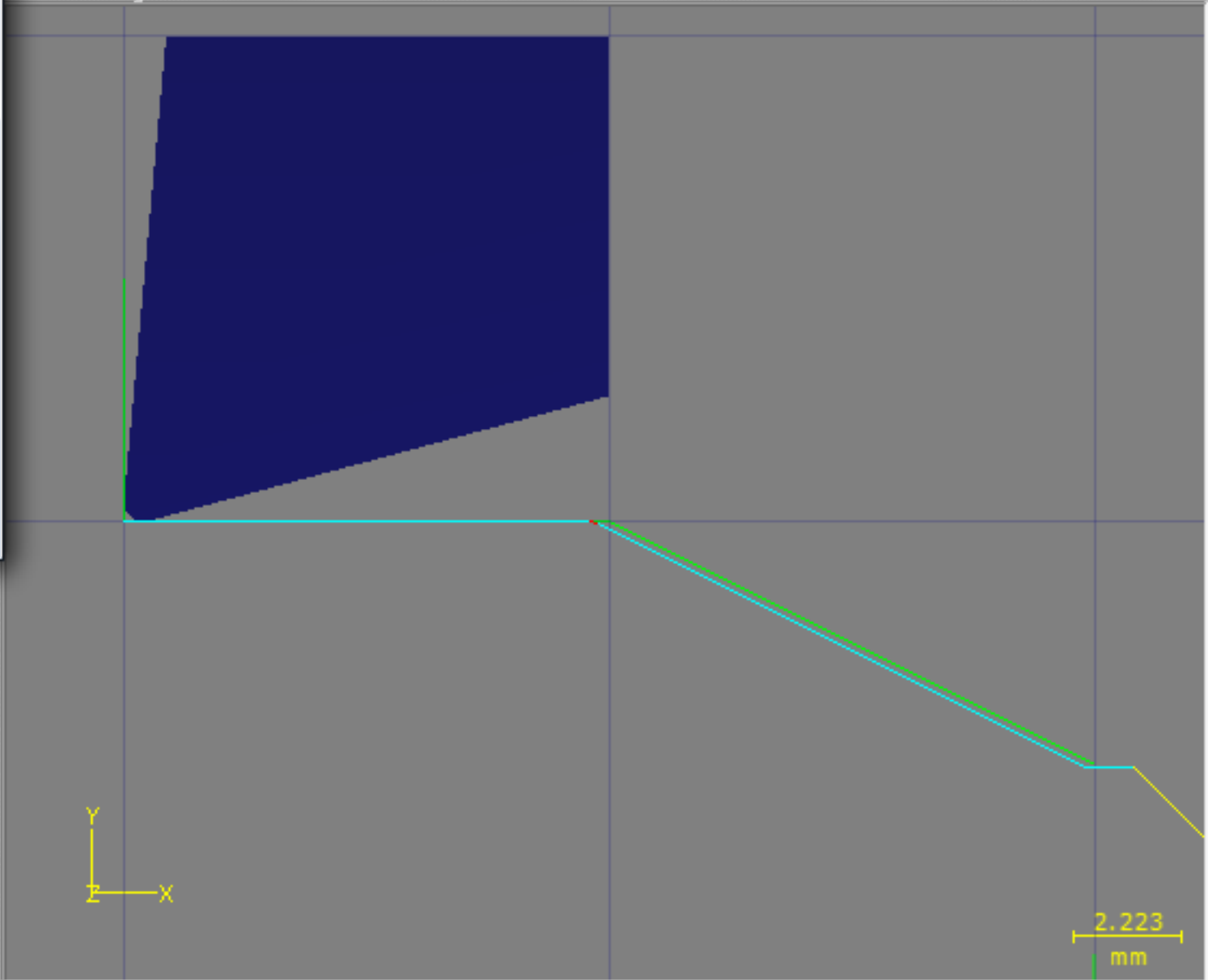
Create point
 Line Endpoints
 Rectangle
 Circle Ct + Pt
 Polyline
 Spline
 TrueType

Autozoom
 Zoom In
 Zoom back
 Zoom window
 Pan
 Redraw
 Top
 Front
 Side

\*\*\*\*\*  
 \*\*\*\*\*  
 \*\*\*\*\*  
 \*\*\*\*\*  
 \*\*\*\*\*  
 \*\*\*\*\*

Line:5/7

Show Tool  
 Solid simulation  
 GCode simulation



Change Post
 Run Post

Show/Hide toolpaths

X: -22.419 Y: 10.563

SNAP OFF
 90°
 Grid
 Snap
 STOP
 ✓
 Livello corrente: 0

New
 Open
 Vectorize
 Save
 Machining

Create point
 Line Endpoints
 Rectangle
 Circle Ct + Pt
 Polyline
 Spline
 TrueType

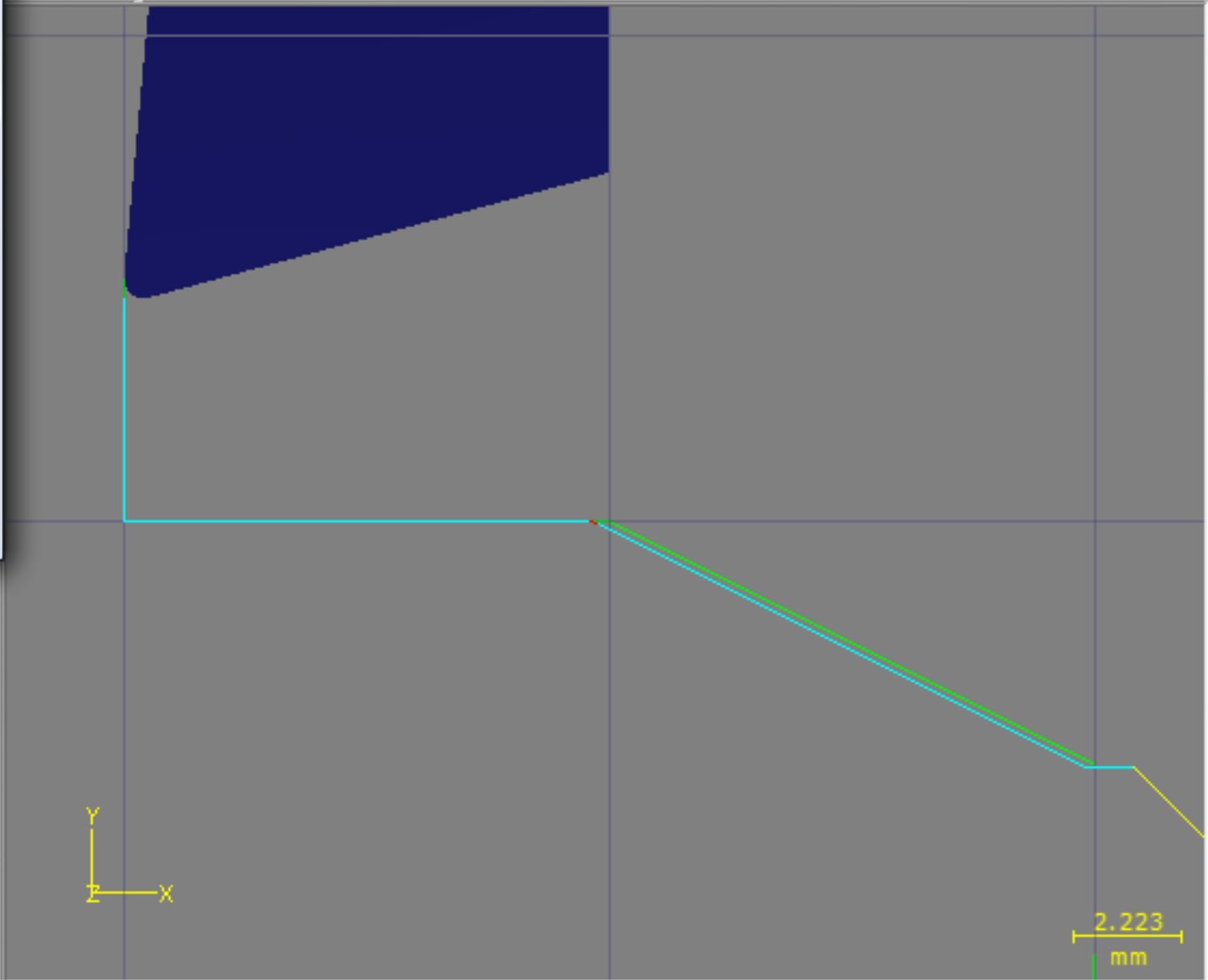
Autozoom
 Zoom In
 Zoom back
 Zoom window
 Pan
 Redraw
 Top
 Front
 Side

.....  
.....  
.....  
.....  
.....

Line:6/7

Step (F5)

Show Tool  
 Solid simulation  
 GCode simulation



Change Post
 Run Post

Show/Hide toolpaths

X: -22.419 Y: 10.563

SNAP OFF
 90°
 

 STOP
 
 Livello corrente: 0

New Open Vectorize Save Machining

Create point Line Endpoints Rectangle Circle Ct + Pt Polyline Spline TrueType

Autozoom Zoom In Zoom back Zoom window Pan Redraw Top Front Side

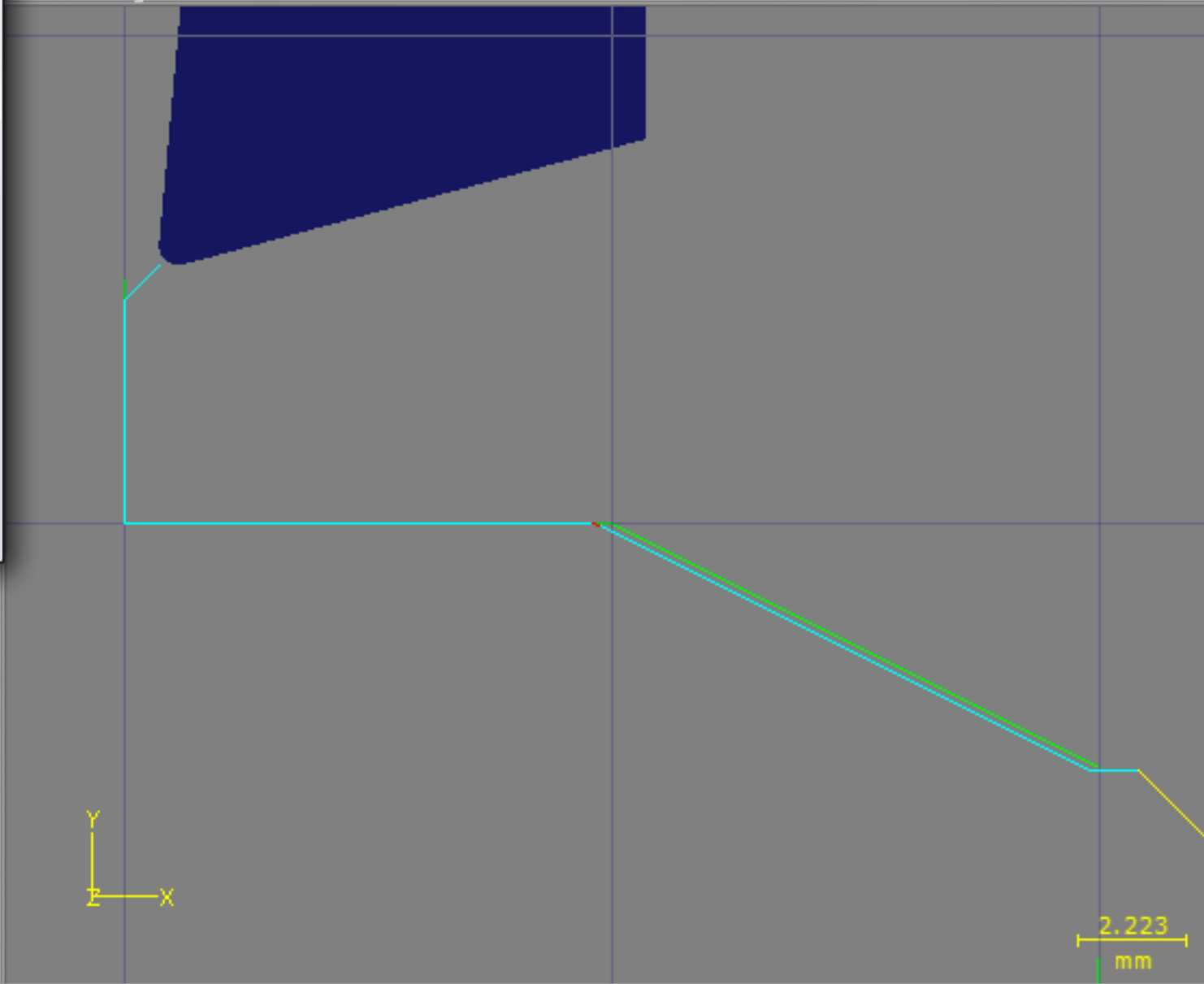
.....

Line: 7/7

⏪ ⏩ ⏴ ⏵ ⏶ ⏷

Step (F5)

Show Tool  
 Solid simulation  
 GCode simulation

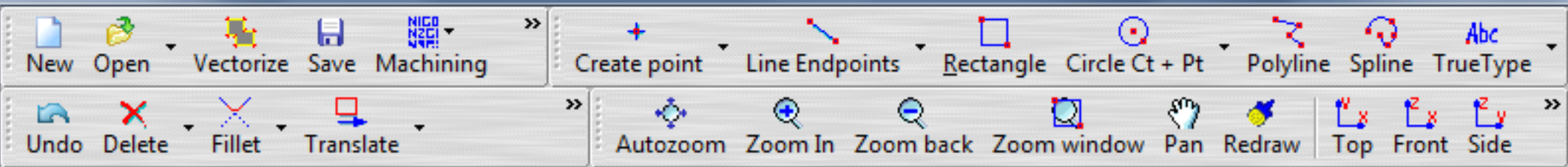


Change Post Run Post

Show/Hide toolpaths

X: -22.419 Y: 10.563

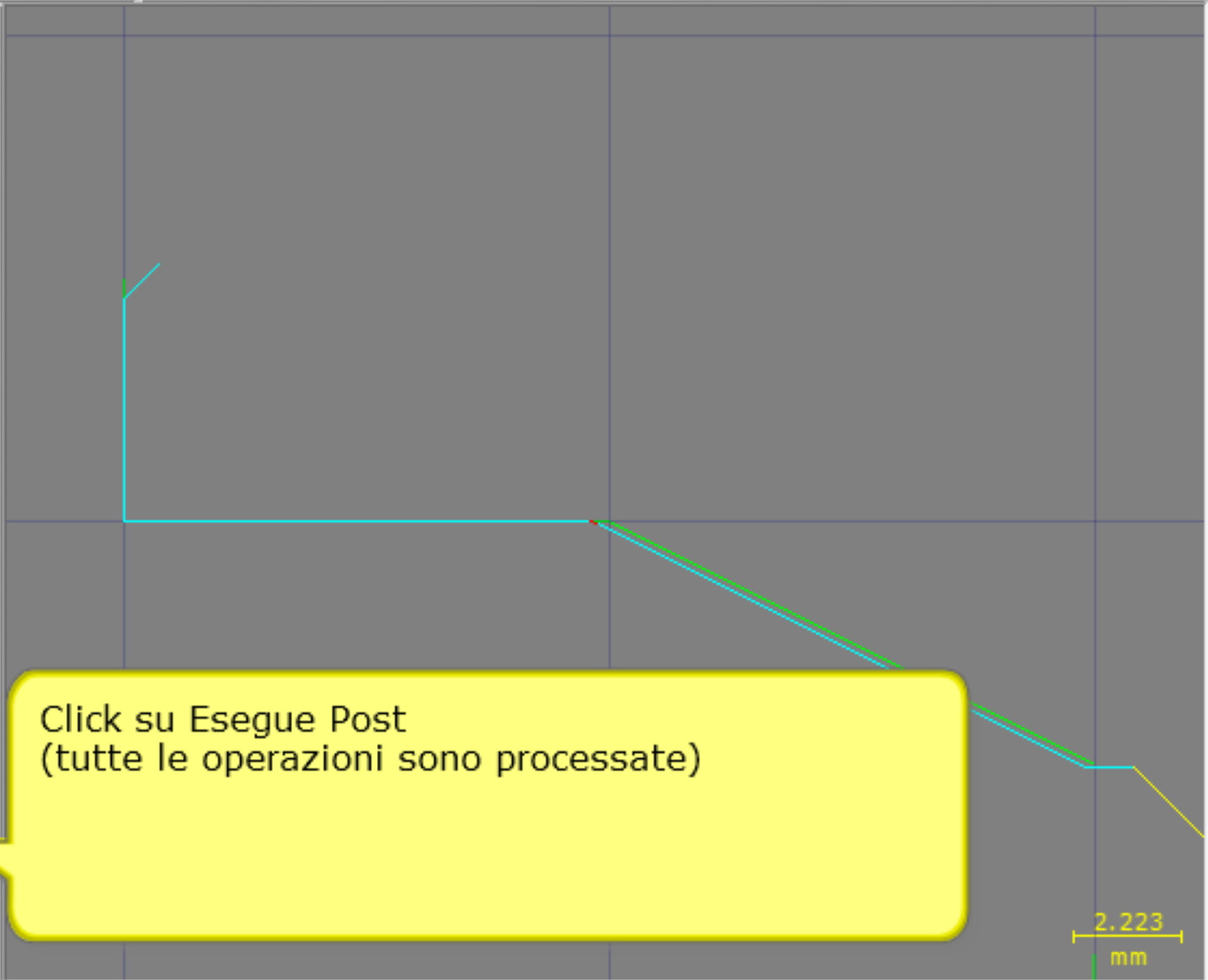




Geometry Toolpath

- Macchina: TurnMach2-3
  - Lathe Rough R.0.4 (Generic OD 0...
    - Parameters
    - Toolpath (61)
  - Lathe Finish R.0.4 (Generic OD 04...
    - Parameters
    - Toolpath (7)

Change Post Run Post Show/Hide toolpaths



New Open Vectorize Save Machini

Undo Delete Fillet Translate

Geometry Toolpath

- Macchina: TurnMach2-3
  - Lathe Rough R.0.4 (Generic OD 0...
    - Parameters
    - Toolpath (61)
  - Lathe Finish R.0.4 (Generic OD 04...
    - Parameters
    - Toolpath (7)

Change Post Run Post

Show/Hide toolpaths

X: -19.708 Y: 17.765

gcEditor v 0.9.9.2

File Edit Text Tools Help

C:\ProgramData\SimplyCam 3\gcode\test.nc

```
N22 X24.2
N23 G01 Z0.1
N24 Z-19.9
N25 X26.2
N26 X26.907 Z-19.546
N27 G00 Z1.1
N28 X22.2
N29 G01 Z0.1
N30 Z-19.9
N31 X24.2
N32 X24.907 Z-19.546
N33 G00 Z1.1
N34 X20.2
N35 G01 Z0.1
N36 Z-19.9
N37 X22.2
N38 X22.907 Z-19.546
N39 G00 Z1.1
N40 X18.2
N41 G01 Z0.1
N42 Z-8.282
N43 X20.094 Z-10.176
N44 G03 X20.2 Z-10.4 I-0.444 K-0.223
N45 G01 X20.907 Z-10.046
N46 G00 Z1.1
N47 X16.2
```

In 0 col 0

Current Z: 0

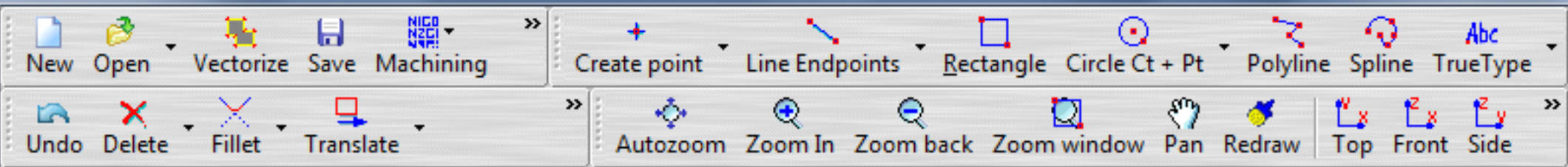
Polyline Spline TrueType

Pan Redraw Top Front Side

2.223 mm

Livello corrente: 0

Il file G-Code con le due operazioni è creato



Geometry Toolpath

- Macchina: TurnMach2-3
  - Lathe Rough R.0.4 (Generic OD 0...)
    - Parameters
    - Toolpath (61)
  - Lathe Finish R.0.4 (Generic OD 0...)
    - Parameters
    - Toolpath (7)

Change Post    Run Post

Show/Hide toolpaths

- Delete operation
- Change parameters
- Show toolpath
- Simulate
- Enable/Disable
- Post only this Op.

Click destro sull'operazione,  
da menu selezionare la voce:  
Post solo questa Op.  
(solo l'operazione di Finitura è processata)



2.223 mm

X: -22.33 Y: 16.609

New Open Vectorize Save Machini

Undo Delete Fillet Translate

Geometry Toolpath

- Macchina: TurnMach2-3
  - Lathe Rough R.0.4 (Generic OD 0)
    - Parameters
    - Toolpath (61)
  - Lathe Finish R.0.4 (Generic OD 04)
    - Parameters
    - Toolpath (7)

Change Post Run Post

Show/Hide toolpaths

X: -6.994 Y: 9.674

gcEditor v 0.9.9.2

File Edit Text Tools Help

C:\ProgramData\SimplyCam 3\gcode\finish.nc

```
%  
N1 (POST PROCESSOR: TURNMACH2-3)  
N2 (FINISH.NC)  
N3 G21 (UNITS: MM)  
N4 G18 G40 G49 G80 G90  
N5 (TOOL/STANDARD, 15, 70, 0.4, 10,3)  
N6 T1 M6 (TLDIA=0.4)  
N7 S300 M3  
N8 G43 H1 S0  
N9 G00 Z0.779  
N10 X9.916  
N11 G00 Z0.  
N12 X0.779 Y4.958  
N13 G01 X-0.221 Y4.958 Z0. F0.1  
N14 X-10.221 Y9.958  
N15 G03 X-10.4 Y10. I-0.358 K-  
N16 G01 X-20.  
N17 Y14.6  
N18 X-19.293 Y15.307  
N19 G00 Z0.  
N20 M05  
N21 M30  
%
```

In 0 col 0

Il file G-Code con la sola operazione di finitura è creato

Polyline Spline TrueType

Pan Redraw Top Front Side

2.223 mm

SHARP OFF 90 Livello corrente: 0