

CYCLE832

840D pl 软件 V6.5

Program

CHAN1

Auto

MPF.DIR
0003G.MPF

Channel active

Program running

ROV

Editor

123.MPF

1

```

11
=eof=

```

Thread milling

HighSpeed settings

Engraving cycle

<<

Inspire Actions
Develop Together
Best Team

↑

Edit

Contour

Drilling

Milling

Turning

Simulation

Re-translate

erved.
Sector

CYCLE832

840D pl 软件 V6.5

SIEMENS

CYCLE832

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SIEMENS

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SIEMENS

CYCLE832

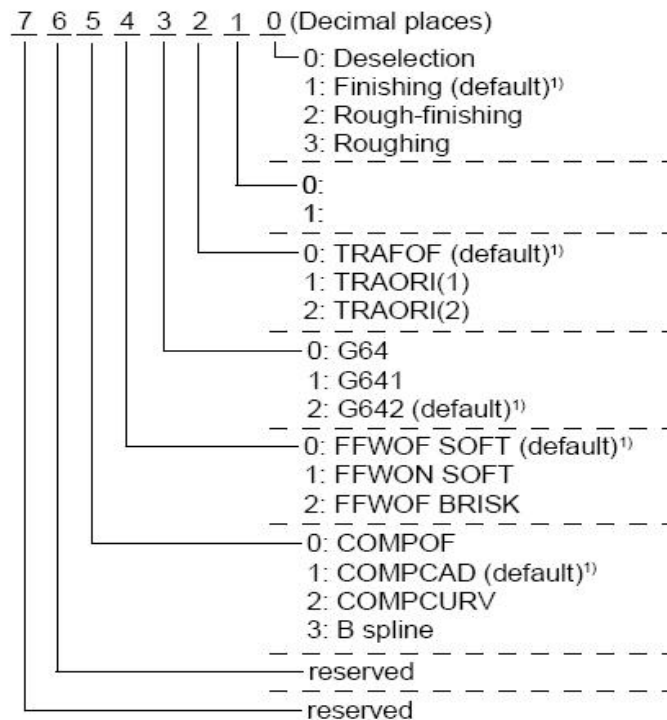
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Programming

CYCLE832(_TOL, _TOLM)

Parameters

_TOL	real	Tolerance of machining axes → unit. mm/inch; deg
_TOLM	integer	Tolerance mode



1) Machine manufacturer can change the setting, see "Customizing technology" section.

CYCLE832 参数

840D pl 软件 V6.5

CYCLE832(_TOL,_TOLM)

公差 (_TOL)

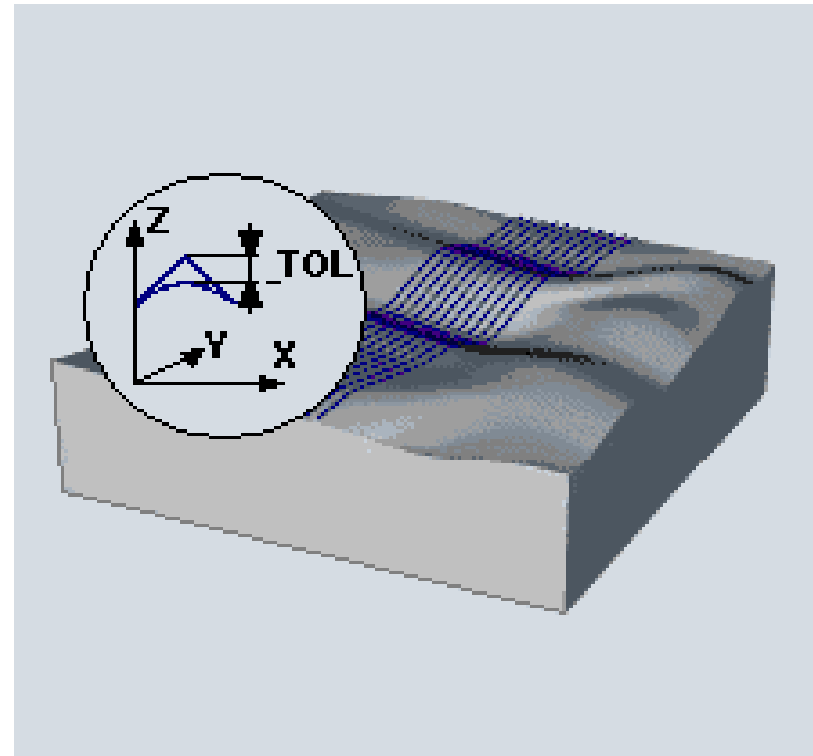
G642

COMPCAD

COMPCURV

旋转轴

默认系数 = 8

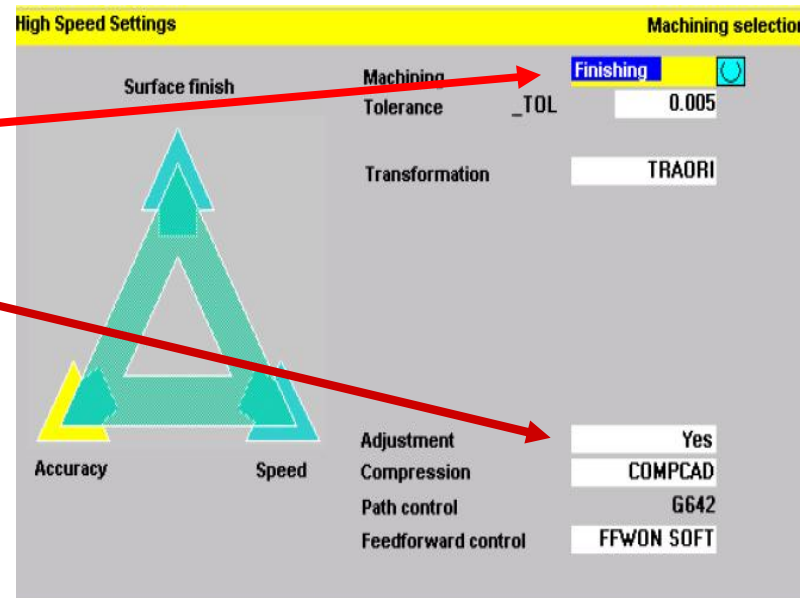


CYCLE832 _TOLM

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_TOLM Decimal					
5	4	3	2	1	0
a	b	c	d	e	f

- f** = 0: Deselection
- f** = 1: Finishing (default)
- f** = 2: Rough-finishing
- f** = 3: Roughing



Customization preset by machine tool builder

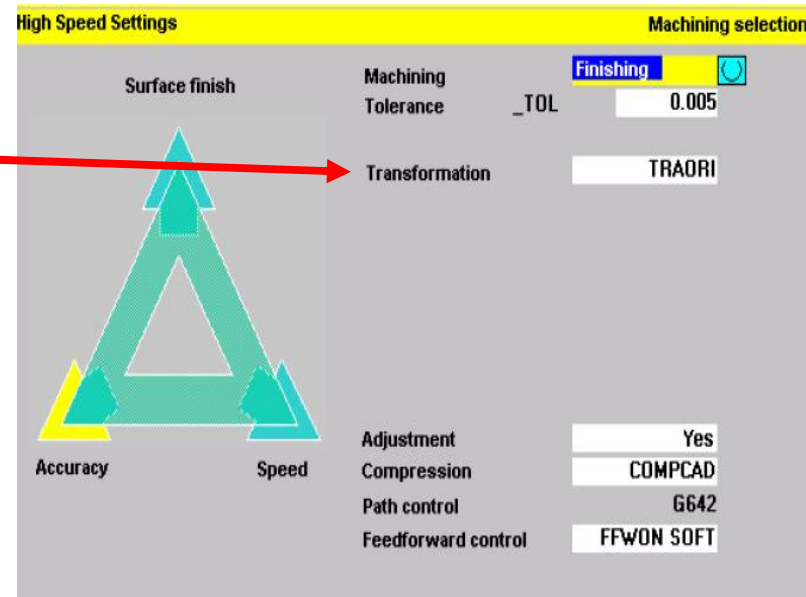
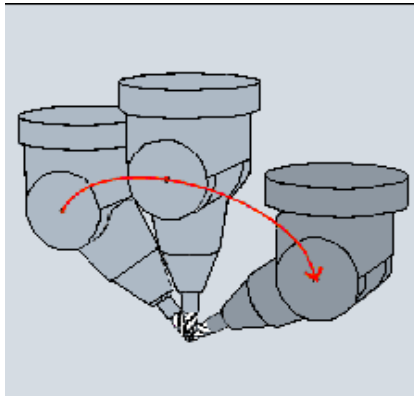
- e** = no only f valid with predefined values
- e** = yes a, b, c, d, can be activated by **_TOLM**



CYCLE832 _TOLM

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_TOLM					
Decimal					
5	4	3	2	1	0
a	b	c	d	e	f



**d = 0: No Transformation
(default)**

d = 1: TRAORI(1)

d = 2: TRAORI(2)



CYCLE832 _TOLM

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_TOLM Decimal					
5	4	3	2	1	0
a	b	c	d	e	f

G64 $v1 > v2 > v3$ 	G641
G642 	

High Speed Settings

Machining selection: **Finishing**

Surface finish:

Machining Tolerance: _TOL 0.005

Transformation: TRAORI

Accuracy:

Speed:

Adjustment: Yes

Compression: COMPCAD

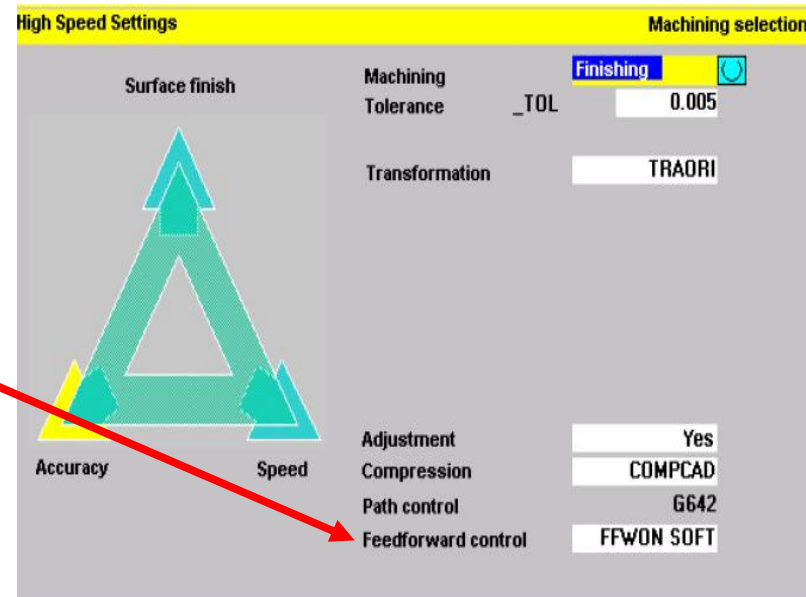
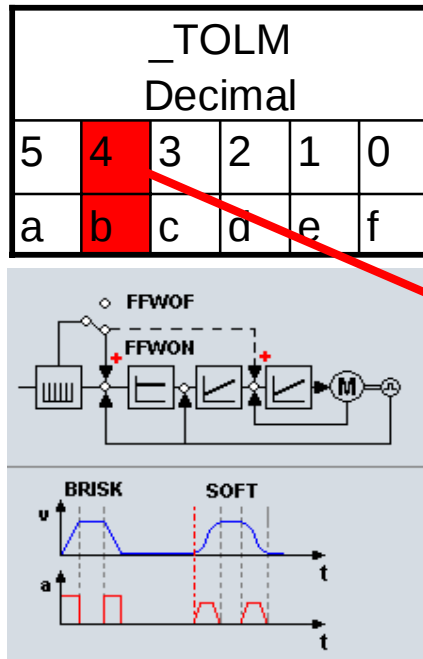
Path control: G642

Feedforward control: FFWON SOFT

- c = 0: G64**
- c = 1: G641**
- c = 2: G642 (default)**

CYCLE832 _TOLM

840D pl 软件 V6.5



b = 0: FFWOF SOFT (default)

b = 1: FFWON SOFT

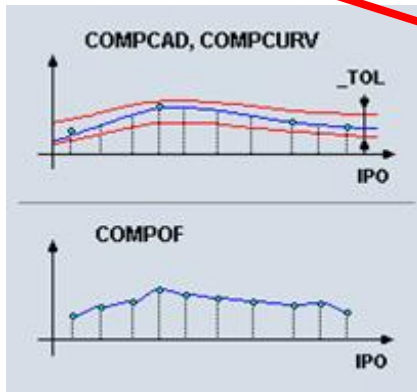
b = 2: FFWOF BRISK



CYCLE832 _TOLM

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_TOLM					
Decimal					
5	4	3	2	1	0
a	b	c	d	e	f



High Speed Settings

Machining selection

Surface finish

Machining Tolerance _TOL 0.005

Transformation TRAORI

Accuracy

Speed

Adjustment Yes

Compression COMPCAD

Path control G642

Feedforward control FFWON SOFT

a = 0: COMPOF (default)

a = 1: COMPCAD

a = 2: COMPCURV

a = 3: B SPLINE

G-Codes

List of the G commands programmed in CYCLE832:

- **TRAORI, TRAORI(2),TRAOFOF**
- **G64, G641, G642**
- **FFWON, FFWOF**
- **SOFT, BRISK**
- **COMPCAD, COMPCURV,COMPOF,B-SPLINE**
- **UPATH**

CYCLE832 举例

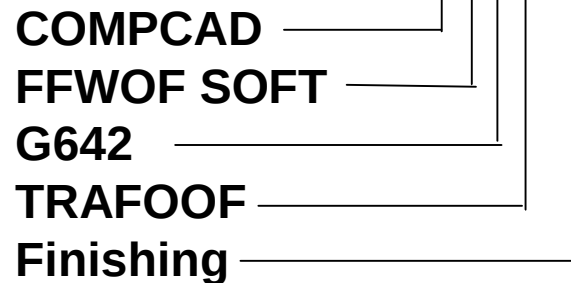
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CYCLE832(0.20, 3)

Roughing with predefined setting
Tolerance 0.2 mm

CYCLE832(0.01,102001)

Tolerance=0.01



CYCLE832 举例

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CYCLE832(0.02,212101)

Tolerance=.02

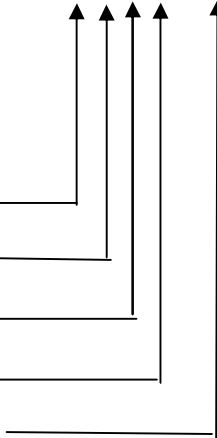
COMPCURV

FFWON SOFT

G642

TRAORI(1)

Finishing



Reduced program call

The following options to call CYCLE832 with a reduced parameter transfer are available:

- **CYCLE832()**

Deselection

The G codes are set to the value set in MD 20150: GCODE_RESET_VALUE.

- **CYCLE832(0.01)**

Entering the tolerance value.

The active G commands are not changed in the cycle.

CYCLE832

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Error messages

Explanation

Alarm source CYCLE832

Alarm number	Alarm text	Explanation, remedy
61191	"5-axis transformation not set up"	1. Machining package five axes or multi-axis interpolation option not set. 2. Check MD 24100: \$MC_TRAFO_TYPE_1 to \$MC_TRAFO_TYPE_8 for a valid 5-axis transformation type
61192	"Second 5-axis transformation not set up"	
61193	"Compressor option not set up"	Set spline interpolation option (A-, B- and C-splines/compressor function
61194	"Spline interpolation option not set up"	