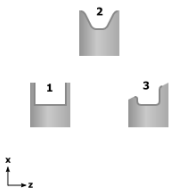


Turn Groove

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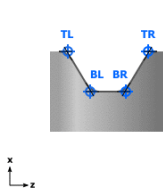
The **Turn groove** event cuts rectangular, tapered or angled grooves into the outside or inside diameter, plunging the groove tool continuously or in small pecks. [15.8.2]

Groove Type



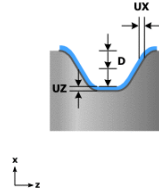
Groove type TYP

Reference Position (X0,Y0)



Reference position X0, Z0

Groove Peck and Allowance

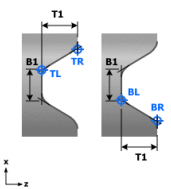


Peck D and allowance U

Parameters Manual 15.8.2

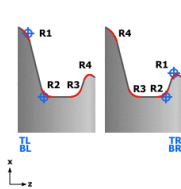
Code	Meaning	Code	Meaning
T	Tool	S	Spindle RPM
F	Feed (per rev)	TYP	1 rectangular · 2 tapered · 3 angled
MA	Rough, finish or both	RPT	Reference corner: top / bottom, right / left
POS	Machine outside (OD) or inside (ID)		
X0, Z0	Reference position (absolute)	B1	Groove width
T1	Depth (absolute or from Z0)	D	Peck depth
U	Finish allowance X and Z (radius)	N	Number of grooves
CL	Coolant on / off	DS	Spindle direction CW / CCW

Groove Dimensions



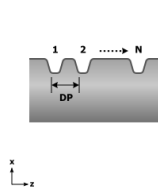
Groove dimensions

Groove Fillet



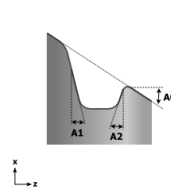
Corner fillets

Groove Count



Groove count N

Groove Angles



Groove angles