

Irregular Groove

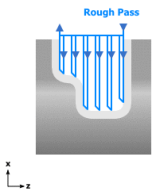
DynaPath WinDelta CNC Lathe · Conversational Programming Quick Guide

The **Irregular groove** event machines any groove shape on the OD / ID or end face, cutting to a profile. Use it for grooves that stock removal cycles can't cut. [15.8.3]

Needs A profile event (LC2) holding the groove shape, drawn or imported

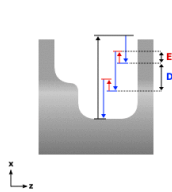
Basic settings Rough, finish or both; side (OD / ID) or end face

Groove Turning



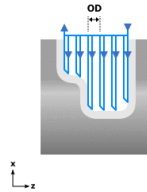
Roughing passes

Groove Peck Depth and Retract



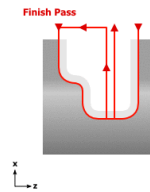
Peck depth D and retract E

Groove Overlap Distance



Pass overlap OD

Groove Turning



Finish pass

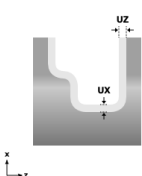
Roughing parameters Manual 15.8.3

Code	Meaning	Code	Meaning
T	Tool	V / SL	Surface speed / max RPM
S	Spindle RPM	F	Feed (per min or per rev)
DIR	Plunge order: right to left or left to right	OD	Overlap between plunges (% tool width)
UX / UZ	Finish allowance X / Z (radius)	D	Depth of cut (radius)
E	Retract each peck (radius)	CL	Coolant on / off
DS	Spindle direction CW / CCW		

Finishing parameters Manual 15.8.3

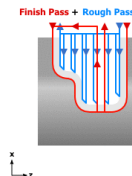
Code	Meaning	Code	Meaning
T	Tool	V / SL	Surface speed / max RPM
S	Spindle RPM	F	Feed (per min or per rev)
DIR	Pass direction	F2	Feed along the groove bottom
CL	Coolant on / off	DS	Spindle direction CW / CCW

Groove Allowance



Allowances UX, UZ

Groove Turning



Rough + finish