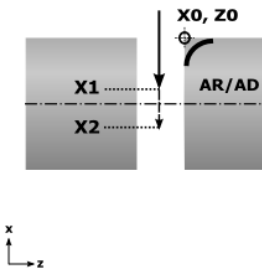


Cut-off

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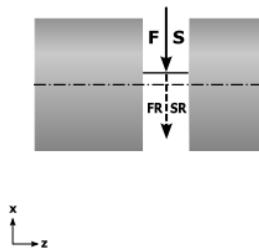
The **Cut-off** event parts the finished piece off the bar. It's usually the last event, often with a parts catcher or bar feeder, and slows down for the final part of the cut. [15.9]

Cut Off



Start, reduced-feed point X1, final depth X2, corner [Fig. 15.9-1]

Cut Off



Reduced feed FR and speed SR

Parameters Manual 15.9

Code	Meaning	Code	Meaning
T	Tool	S	Spindle RPM
F	Feed (per min or per rev)	X0, Z0	Start position (absolute)
X1	Diameter where the reduced feed / speed starts	FR	Reduced feed (per rev)
SR	Reduced spindle RPM	X2	Final diameter
ACT	Corner: none, chamfer or fillet	AR / AD	Fillet radius / chamfer size
OP	Stop after cut-off: none or stop	CL	Coolant on / off
DS	Spindle direction CW / CCW		

NOTE X1 and X2 can be absolute diameters or a diameter distance relative to X0. Set OP to stop if the part needs to be caught by hand.