

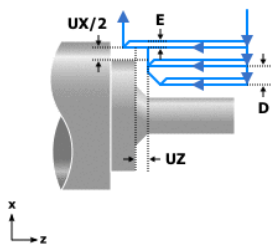
Stock Removal - Turning (G71)

DynaPath WinDelta CNC Lathe · Conversational Programming Quick Guide

G71 roughs and / or finishes an outside (OD) or inside (ID) diameter shape, cutting along Z down to a profile. [15.5.2]

Needs	A profile event (LC2), referenced with REF
Rules	No grooves, and X must only increase or only decrease along the profile. Grooves go in an Irregular Groove event (LC11)
Cuts	Along Z (longitudinal), OD or ID

G71 Stock Removal in Turning



Stock removal in turning G71 [Fig. 15.5-2]

Basic settings

Code	Meaning	Code	Meaning
Machining	Rough, finish or rough + finish	REF	Profile to cut to

Roughing parameters

Code	Meaning	Code	Meaning
T	Tool	V	Constant surface speed
SL	Max spindle RPM (with V)	S	Spindle RPM
F	Feed (per min or per rev)	D	Depth of cut
UX / UZ	Finish allowance in X / Z	E	Retract distance
CL	Coolant on / off	DS	Spindle direction CW / CCW
SP	Start point in X	RP	Start from stock or profile

Finishing parameters

Code	Meaning	Code	Meaning
T	Tool	V	Constant surface speed
SL	Max spindle RPM (with V)	S	Spindle RPM
F	Feed (per min or per rev)	COM	Nose radius comp off / left / right
CL	Coolant on / off	DS	Spindle direction CW / CCW
SP	Start point in X	RP	Start from stock or profile

NOTE When you use constant surface speed V, set SL: the spindle speeds up as the diameter gets smaller.