

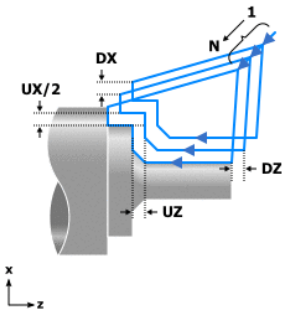
Stock Removal - Pattern Repeat (G73)

DynaPath WinDelta CNC Lathe · Conversational Programming Quick Guide

G73 repeats the profile shape in a set number of passes, each one stepping in by equal amounts in X and Z. [15.5.4]

Needs	A profile event (LC2), referenced with REF
How it cuts	Each pass follows the full profile, offset by DX / N and DZ / N from the last

G73 Pattern Repeating



Pattern repeating G73 [Fig. 15.5-4]

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)	UX / UZ	Finish allowance in X / Z
DX / DZ	Total depth of cut in X / Z	N	Number of cuts
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.