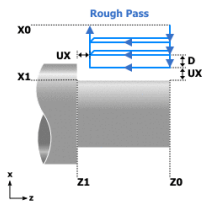


Turning (G90) and Facing (G94)

DynaPath WinDelta CNC Lathe · Conversational Programming Quick Guide

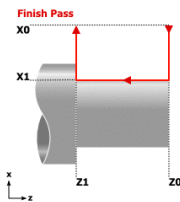
Turning G90 and Facing G94 rough or finish along a straight line between a start and end point, for example to square off a part. No profile is needed. [15.5.5]

Turning



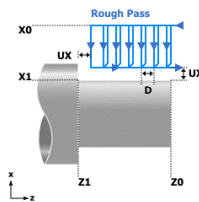
Turning, rough

Turning



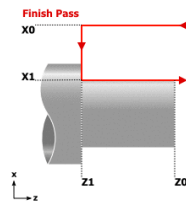
Turning, finish

Facing



Facing, rough

Facing



Facing, finish

Basic settings

Code	Meaning	Code	Meaning
Machining	Rough or finish	Direction	Along Z (OD / ID turning) or across the end face (facing)

Roughing parameters

Code	Meaning	Code	Meaning
T	Tool	V / SL	Surface speed / max RPM
S	Spindle RPM	F	Feed (per min or per rev)
X0, Z0	Start point	X1, Z1	End point
D	Depth of cut	UX / UZ	Finish allowance X / Z
CL	Coolant on / off	DS	Spindle direction CW / CCW

Finishing parameters

Code	Meaning	Code	Meaning
T	Tool	V / SL	Surface speed / max RPM
S	Spindle RPM	F	Feed (per min or per rev)
X0, Z0	Start point	X1, Z1	End point
CL	Coolant on / off	DS	Spindle direction CW / CCW

NOTE X values are diameters. A quick facing pass at the start of a program gives a true Z0 face for the operations that follow.