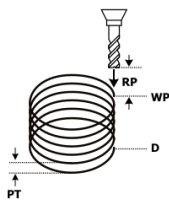


Helix Event

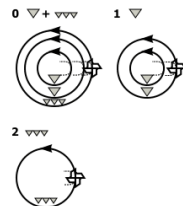
DynaPath WinDelta CNC Mill · Conversational Programming Quick Guide

The **Helix** event mills circular holes or bosses with a helical toolpath, ideal for holes bigger than the drills you have, or for tapered bores. [15.6.2]

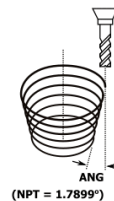
Geometry	Closed circles of any diameter; several circles in one event
How it runs	Starts with a tool change and tool length compensation, moves to the safe height, starts the spindle and coolant, rapids to the plunge height, then plunges at plunge feed. It then interpolates a helix down to the target depth and retracts.
Pick geometry with	SELECT → CIRCLES on the drawing (MC13)



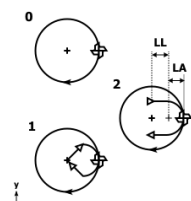
Depths RP, WP, D, L



RF rough / finish



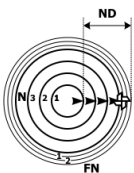
ANG taper angle



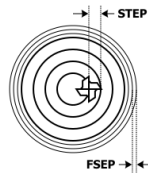
Lead in / out

Parameters Manual 15.6.2

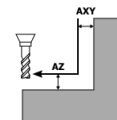
Code	Meaning	Code	Meaning
T	Tool number	RF	Rough, finish or both
MODE	Thread, or contour with a finish pass at depth	DIR	CW / CCW, going down or up
COM	Machine inside or outside the circle	RP	Plunge safe height (above WP)
WP	Start depth (absolute)	D	End depth (absolute)
L	Depth per turn (helix pitch)	ANG	Taper angle from vertical
LS	Lead: none, automatic, centre, custom	LL / LA	Lead line length / arc radius
NT	Side passes: none, count or distance	N / ND	Number / total distance of side passes
STEP	Rough step-over (% tool Ø if > 1)	FSEP	Finish step-over
FN	Number of finish passes	AXY / AZ	Stock left on walls / floor
S	Spindle RPM (– for CCW)	P / F	Plunge feed / cutting feed
CL	Coolant: off, air, flood, CTS, CTS + flood		



Side passes N, ND, FN



Step-over STEP, FSEP



Allowances AXY, AZ