

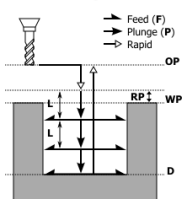
Pocket Event

DynaPath WinDelta CNC Mill · Conversational Programming Quick Guide

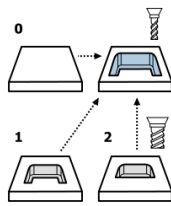
The **Pocket** event clears all material inside a shape, layer by layer, with optional islands, rest machining and separate wall and floor finishing. [15.7.1]

Geometry	Closed (or open) paths; several in one event. Islands allowed
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 clears the shape at feed, one step-down at a time, to the final depth.
Islands	Select the outer boundary clockwise and each island anticlockwise , so the tool always travels on the left

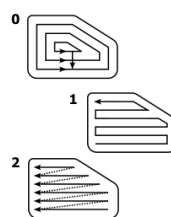
Pocket Peck Milling



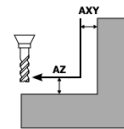
Depths RP, WP, D, L



RES rest machining



MM milling methods



Allowances AXY, AZ

Parameters Manual 15.7.1

Code	Meaning	Code	Meaning
T	Tool	RF	Rough, finish or both
RP	Plunge safe height (above WP)	WP	Start depth (absolute)
D	End depth (absolute)	L	Rough step-down
STEP	Rough step-over (% tool Ø if > 1)	RES	Rest machining: none, XY and Z, tool Ø
FM	Finish: both, wall, bottom, custom	FSEP	Finish step-over
FZ	Finish step-down	FNX / FNZ	Finish passes on walls / floor
PM	Plunge: straight, ramp, helical	PR / PA	Helical plunge Ø / plunge angle
MM	Milling method	MO	Milling order
AXY / AZ	Stock left on walls / floor	S	Spindle RPM (– for CCW)
P / F	Plunge feed / cutting feed	CL	Coolant: off, air, flood

NOTE Use a ramp or helical plunge (PM) with tools that can't plunge straight down, and keep PR smaller than the narrowest part of the pocket.