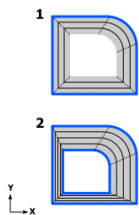


Tapered Face and Tapered Pocket

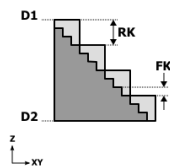
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Tapered face machines a sloped surface; **tapered pocket** clears a pocket with sloped walls. Both use either one path plus a taper angle, or two paths at two depths. [15.7.2, 15.7.3]

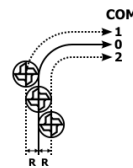
Geometry	One open or closed path (MODE = one path, with TA), or two paths (both open, or two closed with one inside the other) running the same direction
How it runs	Starts with a tool change and tool length compensation, moves to the safe height, starts the spindle and coolant, rapids to the plunge height, then plunges at plunge feed. It then steps over and down across the sloped surface until it is fully machined.



MODE one or two paths



Depths D1, D2, RK, FK



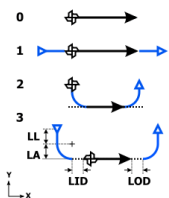
COM cutter comp



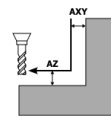
MR forward and back

Parameters (same for both events) Manual 15.7.2, 15.7.3

Code	Meaning	Code	Meaning
T	Tool	RF	Rough, finish or both
MODE	One path or two paths	COM	Cutter comp off / left / right
TA	Taper angle (one-path mode)	RP	Plunge safe height
D1 / D2	Depth of path 1 / path 2 (absolute)	RK / FK	Rough / finish step-down
STEP	Rough step-over (% tool Ø if > 1)	RMI	Rough mill the inner pocket first
LS	Lead: extend, recede, custom	LID / LOD	Lead in / out tangent extension
LL / LA	Lead line length / arc radius	MR	Mill forward and back (open paths)
KTD	Keep tool down (open paths)	AXY / AZ	Stock left on walls / floor
S	Spindle RPM (– for CCW)	P / F	Plunge feed / cutting feed
CL	Coolant: off, air, flood		



Lead in / out



Allowances AXY, AZ