

HAAS ADVANCED MILL PROGRAMMING COURSE OUTLINE

◆ SUBROUTINES vs SUB PROGRAMS

- A. M97
- B. M98
- C. SUBPROGRAM LOGIC
- D. DEPTH OF SUBPROGRAMS

◆ STEP and REPEAT

- A. Use of Subprogram
- B. Use of "L" for Repeating

◆ ROTATION

- A. Use of G68
- B. Use of G69
- C. Work Coordinate Shift

◆ MIRROR IMAGE

- A. Use of G101
- B. Use of G100
- C. Work Coordinate Shift

◆ POCKET MILLING with ISLANDS

- A. G150
- B. Use of G41 and G42
- C. Use of G150 in a Subprogram

◆ **PLANE SELECTION**

- A. G18 - XZ
- B. G19 - YZ

◆ **THREAD MILLING**

- A. Hole preparation
- B. Thread Calculations
- C. Tool placement calculations
- D. Helical Interpolation
- E. Helical interpolation and looping for deep holes

▶ **PROGRAMMABLE OFFSETS**

- A. G10 L2 – WORK OFFSETS
- B. G10 L10 – TOOL OFFSETS
- C. G10 L12 – TOOL DIAM.