

Program for CNC Keyway Broaching

For OKUMA CNC 2 axis lathe

**Try using this format to reduce programming time.
Just enter your broach information in the fields shown.**

(CNC SMAPLE BROACH PROGRAM) ;

%
(YOU MUST ENTER THE VALUES BELOW FOR YOUR TOOL AND
PART) ;
G00 X20. Z20.

T_ _ _ _ (ENTER TOOL # HERE EXAMPLE IF TOOL # IS 5 THEN T0505) ;

M05;
M19;
G00 X_____ Z_____ (X & Z STARTING POSITION) ;
M08 ;
G94 ;

(ENTER VALUES IN G71 LINE BELOW) ;
(X=FINAL POSITION Z=FINAL POSITION) ;
(D=DEPTH OF CUT, H=DEPTH OF KEY WAY, U=FINISH PASS) ;
(F=FEED RATE IPM);

M22 ;

G71 M32 X_____ Z_____ D_____ H_____ U_____ F_____ ;

G00 Z1.0 M09 ;
G95;
X20. Z20.
M30 ;
%

