

HAUBEX NC sub-program sample

 Control: **Siemens**

Loading:	N10 FA[S1]=50000	Vise loaded in hood. Tool positioning with reduced speed
	N20 Tool Call	Call hood and vise from tool magazine
	N30 SPOS=0 (0 / 90 / 180 / 270)	Define angular spindle position [Marking on hood in line with symbol (unclamped) on zero-point device]
	N40 G0 X0 Y0	Spindle position concentrically above zero-point device
	N50 G0 Z0	Position the 5-Axis Vise with clamping studs approx. 8 mm above the zero-point device
	N60 G1 Z-20 F500	Insert the clamping studs of the 5-Axis Vise slowly into the zero-point device
	N70 G1 Z-29.9 F100	Place the 5-Axis Vise smoothly in the zero-point device
	N80 SPOS=92 FA[S1]=5400	Turn the spindle clockwise by 92°
	N90 SPOS=90 FA[S1]=5400	Turn the spindle counter clockwise by 2°
	N100 G1 Z-25 F100	Slow retraction in Z-axis
	N110 G1 Z30 F500	Slow retraction in Z-axis
	N120 G0 Z150	Retraction in Z-Axis
	N130 FA[S1]=0	Reset positioning speed
	N140 Werkzeugaufruf	Hood back to tool magazine

These sub-programs are only samples that are intended to serve as programming aids. Please note that the actual programs may differ depending on the version of the control. LANG Technik is not liable for any damage that may result from incorrect programming.

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Unloading:	N10 Tool Call	Call hood from tool magazine
	N20 SPOS=90 (0 / 90 / 180 / 270)	Define angular spindle position [marking on hood in line with symbol on the 5-Axis Vise]
	N30 G0 X0 Y0	Spindle position concentrically above zero-point device
	N40 G0 Z135	Position the hood with a safety distance above the workpiece
	N50 G1 Z-10 F500	Slow pre-positioning of the hood in the Z-axis
	N60 G1 Z-29.9 F100	Smooth approach to the unloading position
	N70 SPOS=358 FA[S1]=5400	Turn spindle counterclockwise to -2°.
	N80 SPOS=0 FA[S1]=5400	Turn the spindle clockwise to 0°
	N90 G1 Z-20 F100	Lift the 5-Axis Vise smoothly
	N100 G0 Z150	Retraction in Z-Axis
	N110 FA[S1]=50000	Vise loaded in hood. Tool positioning with reduced speed.
	N120 Tool Call	Unload hood and 5-Axis Vise
	N130 FA[S1]=0	Reset positioning speed

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