

In this simple project for horizontal machining, the objective is to make a circular groove on each of the four sides of a cubical stock ($600L \times 400W \times 500H$). X0Y0 is the center of pocket, Z0 is the front of each face.

➡ To develop a CNC program, follow these conditions:

1. Use $\varnothing 20$ mm end mill to full depth of each groove at 1500 r/min
2. Start each groove at 0° degrees (3 o'clock position), in the CCW direction
3. Program only one block for each full circle tool motion
4. Use functions M78 to CLAMP and M79 to UNCLAMP the indexing table

