

## ➔ Milling Direction Project:

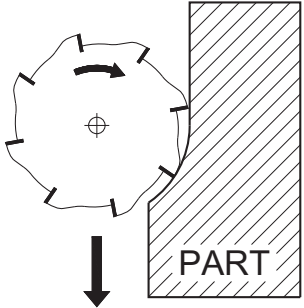
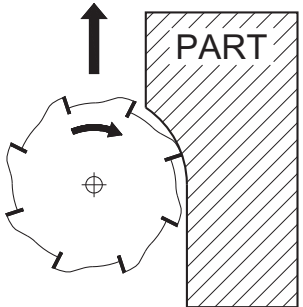
There are two types of milling directions:

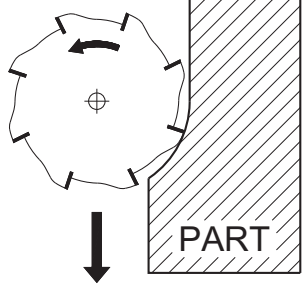
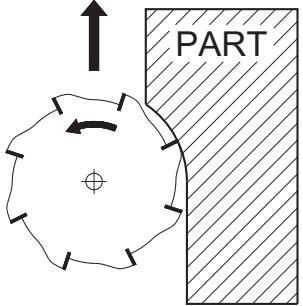
- Conventional milling - sometimes called the **up** milling
- Climb milling - sometimes called the **down** milling

Three factors influence the milling direction:

- Hand of the cutter - right hand or left hand
- Direction of spindle rotation - clockwise or counterclockwise
- Tool motion direction (**not** the machine table direction)

Since a right hand cutter cannot work with spindle rotating CCW, and a left hand cutter cannot work with spindle rotating CW, there are four options - fill-in the correct G-codes (G41 or G42), M-codes (M03 or M04) and what type of the milling direction each example illustrates (Conventional or Climb mill):

G _____ M _____		G _____ M _____	
_____ MILLING		_____ MILLING	

G _____ M _____		G _____ M _____	
_____ MILLING		_____ MILLING	

➔ TOOL MOTION DIRECTION