

EziLathe USER MANUAL

Tools for the CNC Lathe

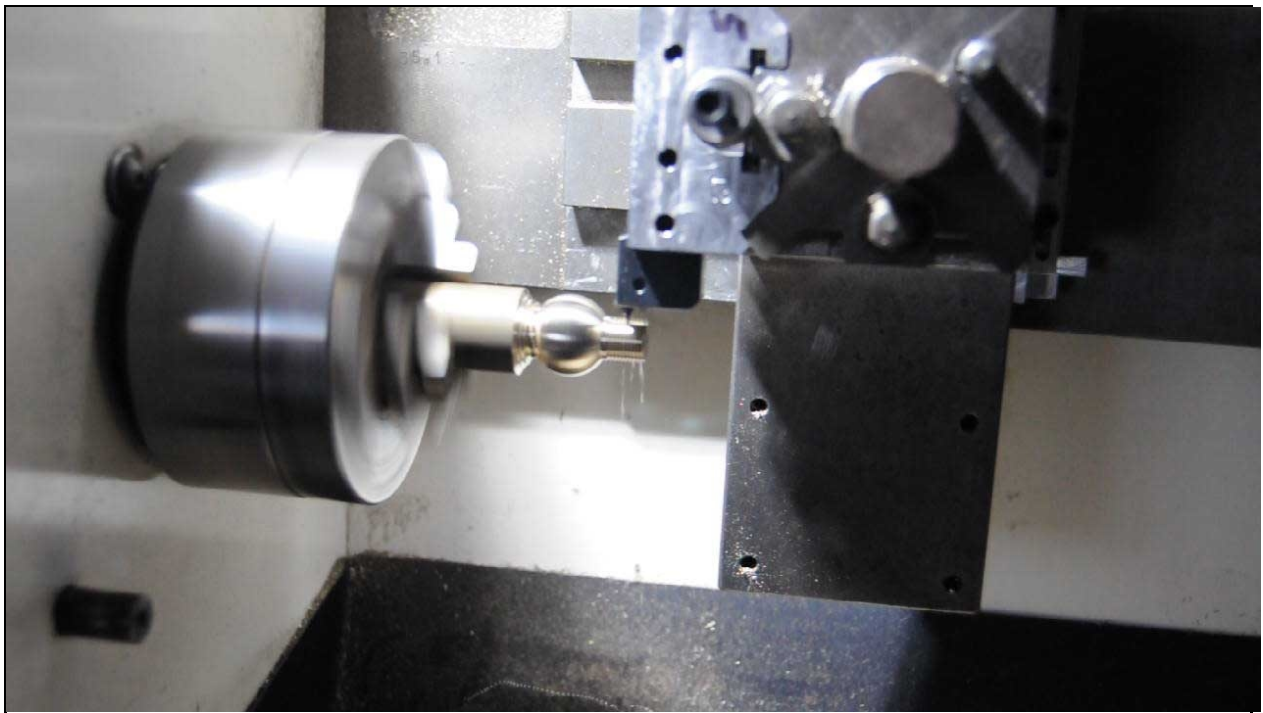


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Introduction

Ezilathe (Tools for the CNC Lathe) is a program, designed to ease the production and debugging of G-code programs for the CNC lathe. It is written by a user of a CNC Lathe running Mach3 (Copyright Artsoft) for users who are similarly set-up, who have found good support for lathe work to be a bit "Thin on the ground". Code is produced that is both compact and "Commented", and as such can be easily fine tuned by hand if required.

Safety Emphasized

The Ezilathe program is used to produce and/or optimize G-code programs for use on CNC lathes. Potential dangers exist for both personnel and machine tools, if the work is not carried out in a safe manner. **No guarantee is given that G-code generated is safe to run on any CNC machine, It must be checked carefully before use, and then initially by "Dry Run – without tooling" before any metal is cut.** Speeds and Feeds, Excessive Gouging, and collisions especially in rapid feed are all potential dangers in the use of CNC machinery.

This Version of Help / Manual is Correct for Ezilathe Version 1.1.0.0

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Welcome

As a user of CNC equipment in the pursuit of my hobby (Model Engineering), I am obviously into "Shortcuts" to eliminate the mundane work, and concentrate on the more interesting jobs. Even in programming a CNC Lathe, the mundane tasks creep in, it quickly becomes apparent that a higher level of "Automation" would be welcome in the production of programs.

Fully featured "CAM" systems are easily obtainable for the mill etc, but few exist for the lathe. Low cost packages like the "Vetric" programs are easily justified to support a mill, however for the hobby lathe, even that level of expense is difficult to justify. For the lathe, the use of "Wizards" can get you most of the way (especially with a bit of cutting / pasting), but still leaves many places where hand coding / calculation is required.

With the availability of no or low cost cad systems as "Graphical Calculators", it seems only logical to use this data to assist in the production of CNC programs as efficiently as possible. It can sometimes be difficult to get access to the data required, often just picking the lines etc and handwriting the data on paper drawings ! The first use for "**EziLathe**", was to automate the listing of all the useful data to paper copy for transfer to CNC. It has grown a bit since then, as other repetitive tasks come to hand.

I fully intend to continue to develop / debug this program for at least my own use. Other users are welcome, and are invited to provide feedback on bugs , suggestions, etc.

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Overview

The "**Ezilathe**" program has a number of tools built in to assist in producing / modifying G-code for Mach3 Lathe and simulating the result :-

- **G-code Editor.** This is a simple text editor where programs can be loaded or produced with the tools supplied and "put together". It has a number of arithmetic functions to make global or local changes in the G-code, as is often needed. The functions can be used to convert (metric/imperial, diameter/radius) or modify (Change lengths/diameters keeping rough cuts in step, to produce a new, but

similar component).

- **Favorites List.** A place where your favorite routines may be held, so they can be copied/pasted into the program editor and re-used as required.
- **Simulator.** Displays a high resolution graphical representation of the G-code program. This simulator is linked into the editor, avoiding searching for the code that produces the feature in question. An inbuilt Tool Library is linked to the simulator to enable visualization of the finished part as produced with the tool profiles and see the effects of "Gouging" of the workpiece. The simulator allows an overlay of DXF data over the simulated finished part to confirm accuracy of the G-code program.
- **DXF Processor.** This enables retrieval of entity coordinate data from Cad via DXF files. A graphical representation as well as a complete printout of Co-ordinate data is available. DXF data may also be used to produce the G-code program or fragment directly with little or no additional work required via the in-built DXF - G code processor.
- **Speeds and Feeds Calculator.** Is included to assist in the correct use of tooling. An estimate of power requirements is available to further assist in optimizing the operation of the CNC lathe.
- **Thread Calculator.** used to calculate the cutting parameters (with radius or sharp tools) and G76 Threading Calculator, producing code fragments, that can quickly and easily be integrated into the program currently in the editor.
- **Cad 4 Lathe.** A Simple Cad window designed to produce simple drawings that can then be processed as DXF files with the DXF Processor. It is intended for simple components only, such as those that are usually programmed via the "Wizards". Use this when opening your cad program accounts for more than 50% of the drawing time.

This Function is the latest addition to Ezilathe, and is still being developed to a full working state, and some features are currently under review.

Getting Started

"EziLathe" is a stand alone program, that does not require any unusual prerequisites or an installation program, simply extract the zip file to the working directory, and away you go.

Working Directory = C:\Ezilathe (There are internal pointers to this directory, for the placement of data-files etc).

The zip file (Ezilathe.zip) contains the following main files :-

Main Executable	= Ezilathe.exe
Help File	= Ezilathe.chm
Material Properties File	= Materialm.txt

Two sample directories are included that include sample data files as listed below for a Metric or Imperial setup.

The Material Properties file (basic version) is included in both sample directories if required.

For Initial installation, it is recommended that the total contents of the appropriate sample directory be copied to the working directory.

(This avoids overwriting your working data files on future updates).

A PDF Manual is also available if required (Ezilathe.pdf)

The program will run using default values, that should be verified, before serious usage. The program options may be changed via the [main menu](#) (Main Menu > Options).

The two current options (Metric & Radius Mode) are discussed in [Program Modes](#).

With use, the program updates a number of data-files that are created automatically if missing :-

Favorites.rtf	= Default File for Favorites. (Saved on Operator Request)
Lathes.txt	= Data on up to 4 lathes in Speeds / Feeds (Updates on Program Exit)
Lathetdat.txt	= Data on up to 60 Lathe Tools (This data is saved on operator request)
Ezilathe.cfg	= Options and Editor settings (Updates on program exit)
Speeds.txt	= Editor settings for Speeds / Feeds (Updates on Program Exit)
Threads.cfg	= Editor settings for Threading (Updates on Program Exit)

Most of the data files (the ones that update on program exit) are just saving your last inputs in the various controls around the place. However, to get full value out of the Simulator and CAM processor, details of your lathe and lathe tools will need to be entered early on.

It is recommended that archive copies of at least the important files are kept, just in case. Recreating the lathe tool data or the favorites can be time consuming as these will get quite large with use. Note that all data files are simple text files, so can be viewed with Notepad (or by EziLathe) or any text editor.

"EziLathe" can if required, be the G code editor used under MACH3. Simply bring up the menu item **Config > General Config** in Mach3 and change the editor listed by browsing to C:\Ezilathe\Ezilathe.exe

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System requirements

"EziLathe's" minimum system configuration includes :-

- Windows XP, Windows 7 or Windows 8
- Ram 512Mb for XP, 1Gb for 7,8

- 40Mb of free disk space
- 1024 x 768 screen resolution or higher.

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Getting help

Off-line help is available via windows std help interface Press "F1" or any help buttons.

A manual in PDF format is also available (Ezilathe.pdf), that can be printed if required.

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Conventions

The Lathe has a "Z" Axis (Bed) and a "X" Axis (Cross slide).

The Graphic Screen (and Cad systems) have a "X" Axis (Left to Right) and a "Y" Axis (Up / Down).

To avoid confusion, I have labeled things this way.

So the Screen "X" is the Lathe "Z" and the Screen "Y" is the Lathe "X"

At least it's a different state of confusion.

"Value to Process" - Labels on program features are shown In this text format.

Terminology Used in this Help File or User Manual.

Full Program - A complete G-code program including initialization of active G codes and Program exit code. When generated, the program will replace the contents of the editor. It is expected that this program can be run (as is) with or without additional code added.

Program Fragment - A section of code to produce a feature. Usually generated from Tool Change to return to Tool Change Position. When generated, the fragment is **Added** to the editor contents at the end of the file, from where it can be re-located, if required, forming one part of the program.

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Material Properties

The materials data file is basically just the Mach3 Mill data file "Metricated and Extended" to suit "EziLathe".

Material Name,Hss,HSStin,Carbide,CarbideTin,Kp
Aluminum,152,198,259,305,0.9
Soft Steel,29,40,76,76,1.2
Medium Steel,23,35,66,84,2.1
Hard Steel,8,20,38,66,3
Brass,70,99,168,212,0.82
Bronze,61,84,137,168,1.5
Soft Cast Iron,28,34,69,82,0.96
Hard Cast Iron,8,20,40,60,1.94
Other,30,30,30,30,2

All surface speed data is in Meters / Min. Data is all checked as reasonable from the "Machinery Handbook".

Kp Field is a factor from the "Machinery Handbook" for cutting power calculations.

This file can be edited / extended using any text editor, but note the format must remain intact (not a comma out of place).

Only the One version of the data file is used for both metric and Imperial Modes.

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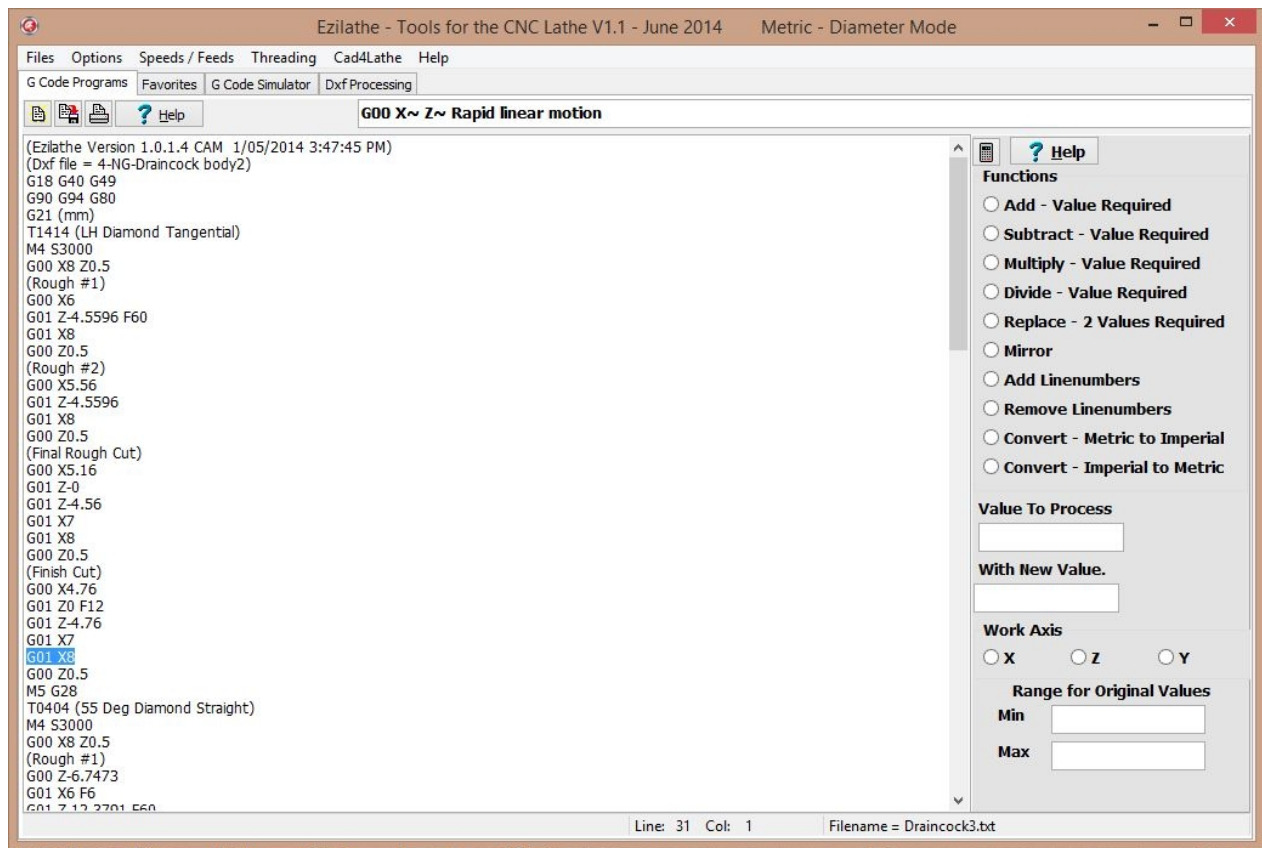
Description

EziLathe - Tools for the CNC Lathe is a collection of useful routines brought together, so they can share data and resources.

These routines have developed over time in use by me for my own work. This development has predominantly been in Metric and Diameter mode. As a result, the program thinks and acts in Metric. The Imperial mode is purely cosmetic, and as such may contain as yet unnoticed issues (I hope not). Please be aware that 99% of the program is unaffected by this mode, seeing only units of length. Speeds/Feeds and Threading are really the only areas effected.

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User Interface



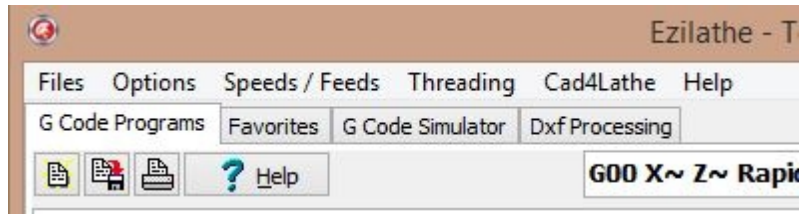
G-Code Editor and Functions Bar

"EziLathe" is a typical Windows program using the Following Elements (From Top to Bottom)

1. Title bar showing Version number and current operating modes.
2. [Main Menu](#) - A number of Global options are available here, as the headings for sub-menus or stand alone menu Items.
3. [Page Control](#) - 4 Selectable page tabs that lead to the main program functions.
4. Working Area - The Main part of the screen, may be a text editor or a graphical display, with or without an additional Tool-bar, Page control or Side bar.
5. Status bar - A Collection of information panels. Always dedicated to the current Page.

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Main Menu



The Main Menu consists of 5 Items :-

- **Files** Menu Header - **Exit** = Close Program.
- **Options** Header - Two Check-boxes.
 1. **Radius Mode** - Checked = Radius Mode. Un-checked = Diameter Mode.
 2. **Metric** - Checked = Metric. Un-checked = Imperial.
- **Speeds / Feeds** - Opens the Speeds / Feeds Dialog Box.
- **Threading** - Opens the Threading Dialog Box.
- **Cad4Lathe** - Opens the Drawing Editor
- **Help** Menu Header.
 1. **Help** - Open Windows Help (This File)
 2. **About** - Opens About Dialog Box.

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Program Modes

Operating modes may be changed via the [Main Menu](#). - **Options**.

Radius Mode

All "X" axis co-ordinates are specified as a Radius. E.G. X6.00 refers to a point at 6 Radius (12 Diameter). This should Match the mode set in Mach3.

Diameter Mode

All "X" axis co-ordinates are specified as a Diameter. E.G. X6.00 refers to a point at 3 Radius (6 Diameter). This should Match the mode set in Mach3.

Note :-

- DXF Data is **ALWAYS** in effect Radius mode (As displayed in graphic), and will convert as required for code generation. A Line at X(Y) 6.00 in the DXF graphic will produce the G-code X6 in Radius mode and X12 in Diameter Mode.
- A drill entered as 12 Diameter in the Tool editor is still that in both modes i.e. 12 diameter / 6 radius.
- A Workpiece entered as 12 Diameter in the Speeds/Feeds or a workpiece entered as 12 Diameter is also that in both modes.

Metric or Imperial Modes

For the most part, Metric or Imperial does not matter, as the program works essentially in Units. However ! It

is Strongly recommended you stick with one only.

Note :-

- Tool editor works in units. A 4mm drill is very different to a 4 inch drill (Would look strange in the simulator). All sizes would need to change if this mode is changed.
- Feeds/Speeds inputs work in the ruling units and are taken as M.M. or Inches as appropriate. A 12mm workpiece will produce very different results to a 12 inch workpiece.
- Default settings under the DXF system will also need changing manually (60 feed looks good in mm / min, but a bit fast in inches / min).
- Dxf system works in Units. If required Scale up/down in CAD system first.

G code Editor

The G code editor is a typical basic text editor under Windows, with the required editing functions controlled via Speedbuttons or a Pop-up Menu.

G code can be loaded from disk or generated via the Dxf system, or typed in from scratch. Once G-code is here, it can be simulated and adjusted as required.

It is best to save often as the program grows, to avoid having to rework it, if things go wrong.

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File Open Button



Opens a G code Program in the Editor. The file is opened via a standard file open dialog box. By default file selection is filtered to Text Files (.txt).

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File Save Button



Saves the G code Program in the Editor. The file is saved via a standard file save dialog box, to give the option to change the file name.

By default file selection is filtered to Text Files (.txt).

The default extension = .txt. for file names. (where none entered)

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Print Button



Prints the G code Program in the Editor. The file is printed via a standard printer dialog box, that gives the capability to select a printer and modify it's printing options.

By default, the file is printed to the default system printer.

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G-code Prompt Box

A Pull-down list of G-code commands is also located on the tool-bar, for quick reference.

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Pop-up Menu

Select Items in Editor then Right-Click in Editor to Activate the Pop-up Menu. Left-click on menu to select action.

Menu Items are :-

- **"Cut"** - Cut Selected Item.
- **"Copy"** - Copy Selected Item.
- **"Paste"** - Paste to cursor position.
- **"Select All"** - Selects All text in the Editor.
- **"Delete"** - Delete Selected Text

Warning ! If nothing is selected in the editor, then all is assumed to be selected.

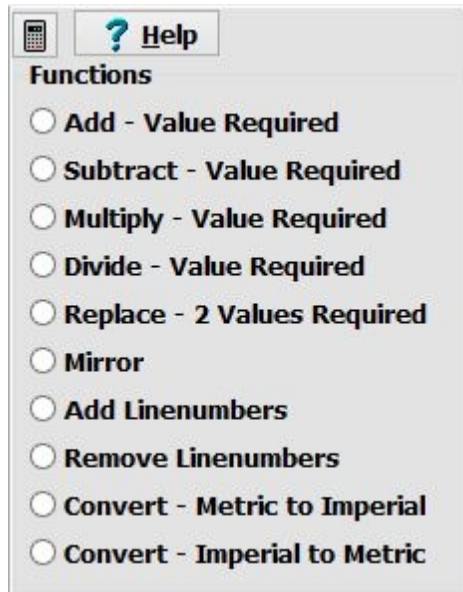
For **"Delete"** this is a quick way to clear the editor.

Functions

The Functions Box Consists of a number of Available Options, with an Execute button above. Simply Select the required function, Fill in the values required in the boxes below, Select the section of code in the editor (if required) and press the Execute button.

Note ! If No code selected, then function is applied to all code in the editor.

Input boxes below the functions are available as appropriate for the function selected.



Functions

- ☐ Add - Value Required
- ☐ Subtract - Value Required
- ☐ Multiply - Value Required
- ☐ Divide - Value Required
- ☐ Replace - 2 Values Required
- ☐ Mirror
- ☐ Add Linenumbers
- ☐ Remove Linenumbers
- ☐ Convert - Metric to Imperial
- ☐ Convert - Imperial to Metric



Work Axis

- ☐ X
- ☐ Z
- ☐ Y

For many functions, an Axis will be required. This box will only be visible when an Axis is required. A "Y" axis is also included, as this area of the program is also useful for Milling Machine operations.

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Add, Subtract Value

These functions typically are used to extend or reduce a feature keeping values in step (Finish and rough cuts)

Requirements

Must have numeric value in "**Value to Process**"

Must have an Axis selected in "**Work Axis**"

Optional

Specify a range of values in "**Range for Original Values**"

Selection

Restricted to selected text range only, unless no text selected (in which case, whole file is scanned).

Multiply, Divide Value

These functions typically are used to scale up or scale down a feature. Often used on "X" axis to convert between diameter and radius modes.

Requirements

Must have numeric value in "**Value to Process**"

Must have an Axis selected in "**Work Axis**"

Optional

Specify a range of values in "**Range for Original Values**"

Selection

Restricted to selected text range only, unless no text selected (in which case, whole file is scanned).

Replace

This function typically is used to change a specific value, such as distance from final rough cut to finished size

Requirements

Must have numeric value in "**Replace Old Value**"

Must have numeric value in "**With New Value**"

Must have an Axis selected in "**Work Axis**"

Optional

None

Selection

Restricted to selected text range only, unless no text selected (in which case, whole file is scanned).

Mirror

This function typically is used to turn the 'Job' around in "Z", often in conjunction with a shift (Add or Subtract).

The Mirror line is always through zero.

Requirements

Must have an Axis selected in "**Work Axis**"

Optional

None

Selection

Restricted to selected text range only, unless no text selected (in which case, whole file is scanned).

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Add, Remove Line numbers

These functions add or Remove Line-numbers.

Requirements

None

Optional

None

Selection

Restricted to selected text range only, unless no text selected (in which case, whole file is scanned).

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Convert Metric or Imperial

These functions Convert a G code Program Metric to Imperial or Imperial to Metric.

Note that these functions are sensitive to the G codes in play, and should not effect integer values. Where G20 or G21 are included in the file, they are also changed as required.

Requirements

None

Optional

None

Selection

Whole file is converted, whether or not anything is selected.

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Execute

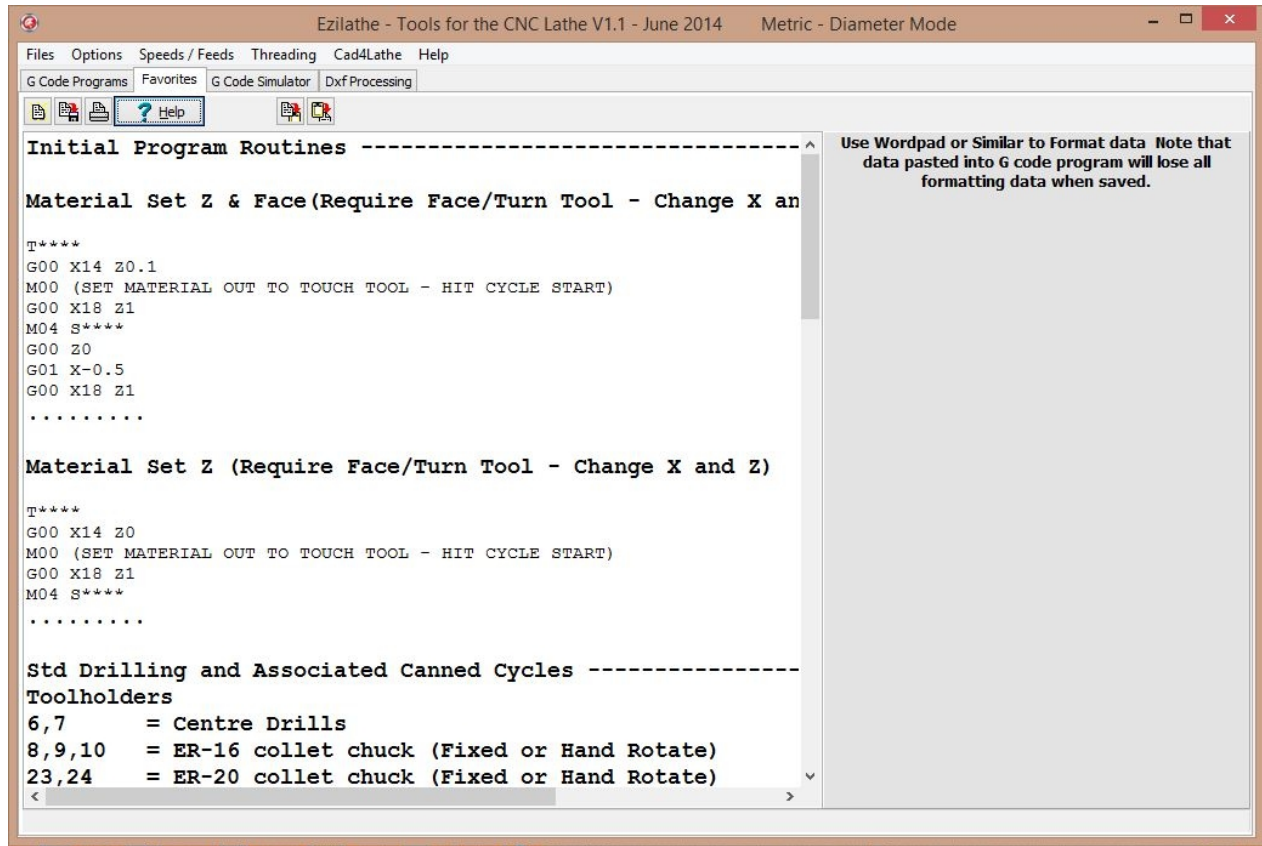


Execute the selected function on the editor contents.

Note ! If no Text is selected, then the function is applied to all the editor contents.

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Favorites page



This is essentially a Rich-Text editor, of the simplest kind. Start your file in Wordpad or similar, to make it look the way you want, and then just Copy/Paste away. How you use this is entirely up to you. For my part, I just store Code fragments (Blocks from tool change to tool change), some need virtually no changes to be reused.

Simply copy from here and paste to the editor. As new useful fragments are produced, copy/paste to Favorites and add a title. Please note that all text formatting is lost in data that is pasted into the editor (Simple-Text only, as is MACH3).

The File Favorites.rtf is the default, loading automatically on program start. You can have as many favorites as you like.

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File Open Button



Opens a favorites file in the Editor. The file is opened via a standard file open dialog box. By default file selection is filtered to Rich-Text Files (.rtf).

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File Save Button



Saves the Favorites file in the Editor. The file is saved via a standard file save dialog box, to give the option to change the file name.

By default file selection is filtered to Rich-Text Files (.rtf).

The default extension = .rtf for file names. (where none entered)

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Print Button



Prints the Favorites file in the Editor. The file is printed via a standard printer dialog box, that gives the capability to select a printer and modify it's printing options.

By default, the file is printed to the default system printer.

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Copy Button



Copies the selected text to the clipboard (Duplicated by **"Copy"** in Pop-up Menu)

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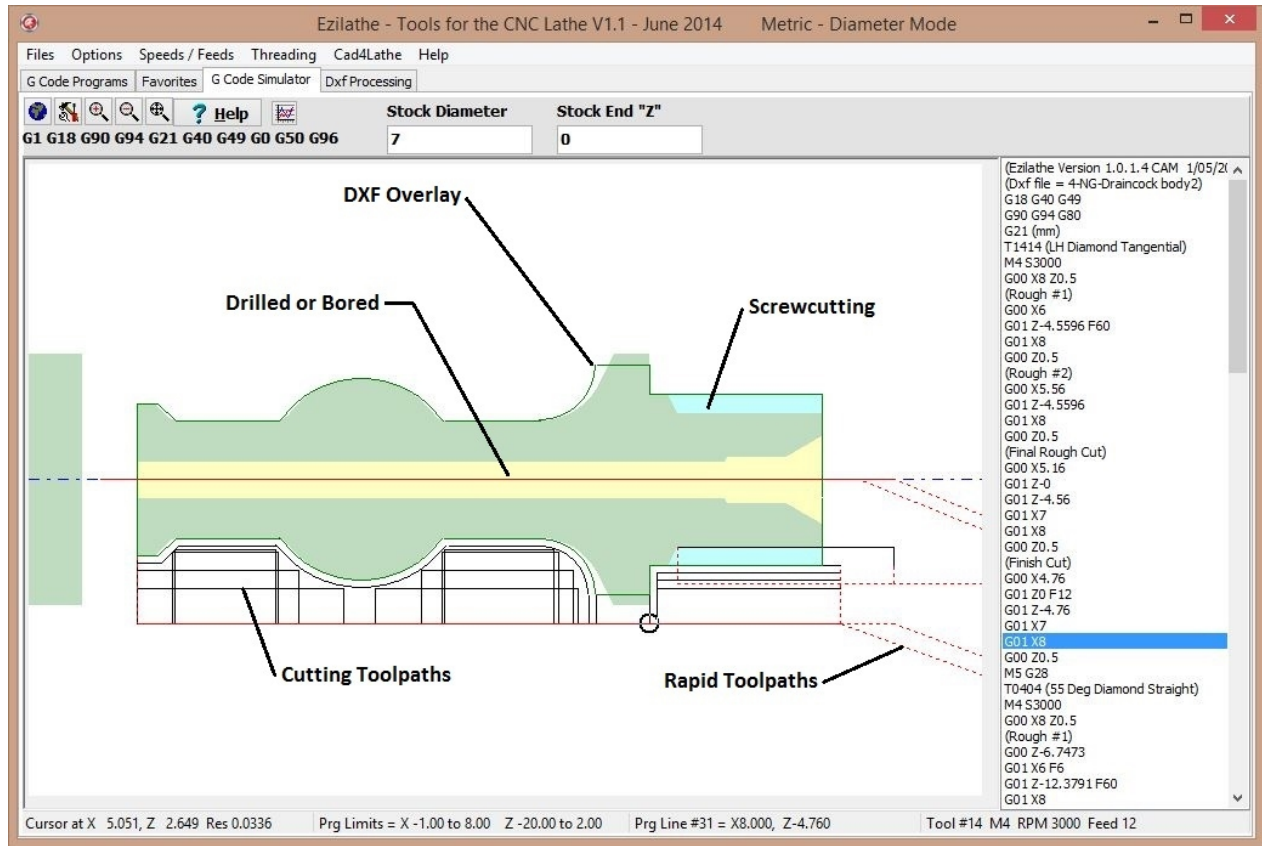
Paste Button



Pastes the contents of the clipboard to the Favorites editor (Duplicated by **"Paste"** in Pop-up Menu)

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G code Simulator



The Simulator is available to quickly check the results of edits in the G-code editor and compare DXF data (Where available) to resulting part program. The code may be stepped through line by line in the Program List-box (Right hand side of screen). A Circle highlights the current point in the graphic, and status of program is displayed at top of screen and within the Status-bar. The Highlighted line in the List-box is also highlighted in the program editor, to assist in changing the code. You can move within the program list-box, using mouse or arrow keys (list-box must be the currently active control).

Where available, the dxf profile may be overlaid on graphic, as a further check of accuracy (as shown above).

Tool Display

The Tool may not be Displayed, but you can see where they have been !

One of the features of the simulator is portray the effect of tool shape on the workpiece. The graphic above shows clearly the deviation from programmed tool-path and the finished size of the workpiece. The white area between the tool-path (in black) and the finished workpiece (in green) represents "Gouging". Caused in this example by using a 55 deg Diamond shaped carbide tip with 0.8mm (0.032") radius, in a straight tool. You may wish to compensate in your dxf, Fiddle the program, change tool or put-up with it (in this case, I quite like it).

To prove the point, simply disable the tool in the Tool editor, and regenerate graphic (a Zoom will do) to see it cut with a zero width sharp tool (wish i had one).

This is the same tool used, if you do not have the tool defined in the Tool Editor.

Load Button



Loads and Processes the data in the G code editor. If any changes have been made in the editor, the data must be reloaded.

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Open Toolform Button



Opens the Lathe Tool Editor Dialog box.

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Zoom In Button



Zooms In to the graphic image. As the image size is increased, Horizontal and Vertical Scroll-bars enable any part of the image to be viewed.

The Graphic may be Zoomed In by up to a factor of 2.5 : 1

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Zoom Out Button



Zooms out of the graphic image. As the image size is decreased, Horizontal and Vertical Scroll-bars enable any part of the image to be viewed, until no longer required.

The Graphic may be Zoomed out to the original factor of 1 : 1 (Zoomed to view the Extents)

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Zoom Extents Button



Zooms back to the original graphic image size i.e. Zoomed to the Extents. Horizontal and Vertical Scroll-bars are no longer required.

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View DXF Button



Overlay the Simulator graphic with the DXF graphic if Available. This button is not enabled if no DXF data loaded.

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Stock Diameter Input

When a program is initially loaded in the editor, this value is assumed from the "X" Axis limit found. The Stock diameter under DXF processing is used if available.

This can be overwritten manually if required, and will remain until a new program loaded.

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Stock End "Z" Input

When a program is initially loaded in the editor, this value is assumed to be 0.

This can be overwritten manually if required, and will remain until a new program loaded.

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Graphic Area

Workpiece is displayed from the perspective of the operator of a conventional lathe and displayed to fit the display window. The Workpiece (in green) is shown finished (Yellow areas are drilled or bored, and Blue area is a screwcut thread). Toolpaths in Red are Rapid (G00) otherwise shown in black. A DXF overlay is shown as dark green lines, if applicable).

The current mouse position is shown in the status-bar panel #1 (together with the resolution per pixel in units).

Various other data items are shown in other Status-bar panels, when lines in the list box are selected.

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Program List-Box

To the right of the graphic area is the program list box. This is a read only listing of the loaded program. When Active (has focus, a line highlighted) enables navigation through the program in both directions. A Highlight follows in the editor to assist in finding the line there. The active G codes are shown in the box above the graphics, and other modes are shown in the status bar including the co-ordinates. The point referred to in the program is also highlighted in the graphic with a black circle.

You can move up or down in this list-box using mouse or arrow keys (when list-box) has focus).

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Status Bar Panels

Panel #1 = Current cursor location from a Lathe point of view (X,Z axis). Res refers to the current resolution of 1 pixel in the graphics area (Changes only when display is zoomed or program is reloaded).

Panel #2 = Limit of travel for current program (Excluding tool change location).

Panel #3 * = List-box Line Number + Axis location after execution.

Panel #4 * = Status at List-box Line - Tool No, Spindle Rotation, Spindle Speed, Current Feed.

Panel #5 = Current Zoom Status.

Top panel (Under buttons) * = Current active G codes.

* Display is current only when List-box line is highlighted.

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Tool Editor

The Lathe tool editor supplies tool data to the Simulator, where the effect of tool shape may be viewed, and to populate the selection box of Tools used in DXF processing.

No radius compensation or gouging avoidance is programmed, so the entry of tool data is optional in the use of the program. (you will be missing out however on the graphic supplied by the simulator)

(You will need something entered as a boring tool, as the CAM system will not use anything else to bore with.)

To set-up a tool library is very simple, with instant feedback of edits in the graphic window.

Changes to tools can be permanent (Edit the press **"Save /Exit"** button - this will save changes to disk) use when setting up or adding / editing tools.

The **"Exit without Saving"** button can be used to try "what if" changes or Disable / Enable tools on a temporary basis. (Changes are in force for session only, and are lost when "EziLathe" is closed).

Note That Changes made here and saved to disk, will not be reflected in the selection boxes until the program is closed and Re-opened.

Tool Number Input

This Integer number may be entered directly into the box, or use the Up / Down Control.

Limits - 1 to 60 only.

Usage - Reference number for library only.

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Tool Description Input

Description of tool, sometimes useful to describe a chuck rather than the tool itself.

Limits - Limited to 40 length max.

Use - Just local in editor.

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Tool Selection Input

Format = Integer , Description

Limits - Limited to 40 length Total.

Use -

Integer - Must compile to a number used by the system as the tool number between 1 and 60. the format used may be nn (i.e. 04) as tool number only or nnnn (i.e. 0404) as tool number and offset number (Generally the same). If the Tool number entered does not compile to an integer, only the simulator view will be effected (No display of actual tools). The compiled value may be confirmed in the status-bar under the simulator.

The Comma is required to separate the two values.

Description - This is the bracketed description inserted as a comment in G-code when a tool change is generated via the DXF Processor.

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Tool Type Check-group

The type of tool is selected from here. The tool type effects where a tool may be used, and the data used to define it.

Currently there are 5 types :-

- **Turn** - Normal external turning tools like the LH face / turn tool shown above. (My lathe is back to front, that's why RH face / turn labeled as LH !)
- **Groove** - Grooving or Parting tools. (This type to be extended in future release to include Radius corners, Max Radius = button tool)
- **Drill** - Std drills, Center drills, Countersinks etc.
- **Bore** - Boring tools - only type allowed in CAM system for boring.

- **Trepan** - As Groove, except turned 90 deg towards chuck.

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Tool Dimensions Inputs

This group inputs used to describe lathe tools are all real numbers, and may be Positive or Negative (Positive assumed, if no sign entered).

Input availability will vary depending on tool type selected. Inputs may be replaced, or dis-enabled dependent on tool type.

The inputs are :-

- **"Lead Angle deg."** - The angle in degrees of the Leading face of the tool. Positive value gives clearance. The same 55 deg diamond insert in a straight holder would have a value of -27.5 here.
- **"Included Angle deg."** - The included angle of the Tip. A square insert would have a value of 90 degrees here.
- **"Tip Radius"** - Entered in units. This is the radius at the cutting tip.
- **"Z Offset"** - The controlled point is at the Tip of a sharp tool (Zero offset required) or at the center of radius otherwise (This will require an offset = to the radius in most cases to place the controlled point at the normal location).
- **"X Offset"** - As for Z offset, except X Axis.
- **"Width"** - The Width of the cutting edge, usually Groove or Trepan tools.
- **"Max Cutting Depth"** - Arbitrary number, just effects the size of the tool when displayed in editor, and the sweep of the tool in the Simulator. Set too small as a turning tool, could leave bits of green material on the screen. Set to large as a boring tool, could take out the other side of the hole. This input should be manipulated so tools like screwcutting tools will have an accurate projected width (Helps with collision detection in the Simulator).
- **"Diameter - Body"** - Diameter in Units of a Drill, O.D. of a center drill etc.
- **"Included Angle - Tip"** - Included angle of tip in degrees. Used for Drills , Countersinks etc. On two diameter tools this stays with the body (60 deg for center drill). The end angle is assumed at 118 deg.
- **"Diameter - Tip"** - The smaller of the two diameters on a two diameter tool such as a center drill.
- **"Length - Tip"** - The extension of tip beyond the body on two diameter tools e.g. center drill.
- **"Min Bore Diameter"** - Used exclusively with Boring tools, This is the minimum diameter of the initial hole that a boring tool may fit This size is enforced in CAM system, too large may not fit the finished size, too small, and the tool will "Crash" on the lathe.

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Tool Cutting Side Check-group

Controls the side of the tool where the "Controlled Point" is situated.

Typically most turning tools are Right Hand (for a conventional lathe). Parting tools are generally entered as left hand to avoid consideration of tool width in parting off operations.

Not enabled for drills.

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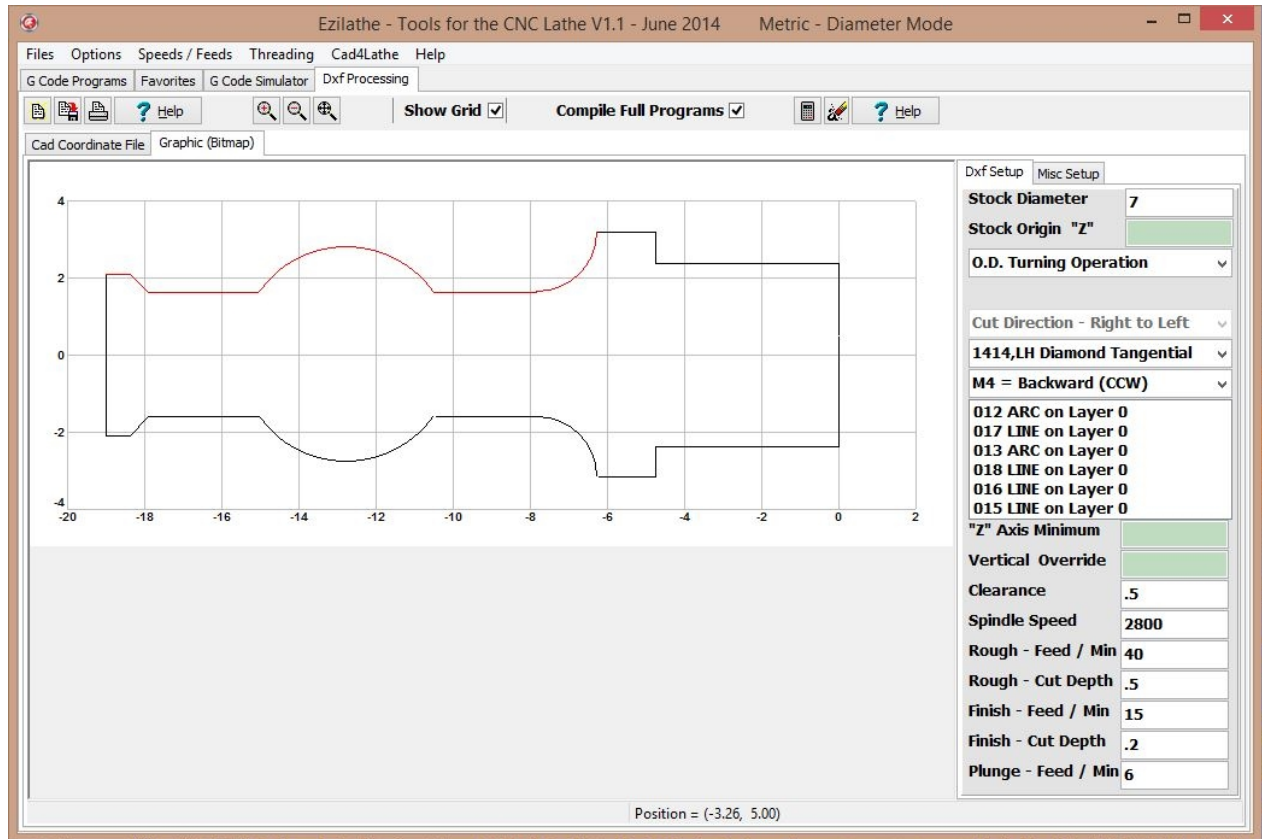
Lathe Tool Disabled Check-box

If Checked then a tool is disabled. This is a quick way to compare the cut to a Zero width tool. Incomplete inputs should be left disabled.

The state of this does not effect code generation in any way.

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Dxf Viewer



The DXF viewer is one of the most useful functions within "EziLathe". Adding the DXF processor extends the value even further. Between the graphic screen (above) and the Cad Co-ordinate page (Text screen next) all entities within a drawing can be identified. Entities can be selected in the graphics screen (red when selected, otherwise black) and their id number read from the **"Selections List-box"** The same ID number as on the text page.

To ease the burden of finding what you want on the graphic screen, the display may be filtered to display only entities on the selected layers refer to [Layers Check-box](#) under Cam processor section.

As with the Simulator, the mouse position is continually updated in panel #1 of the status-bar.

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DXF files

DXF files are produced by many CAD systems, the format was after all developed for inter-application transmission of data. Over time, the format has continued to develop, and branch out into binary and text formats. "EziLathe" does not need anything sophisticated.

File Type. - Text based .DXF files

Supported Entity Types

- **Lines**
- **Arcs**
- **Polylines** - Line and Arc segments.
- **LWPolylines** - (Light weight Polylines) Lines and Arc segments.

Not Supported Entity Types

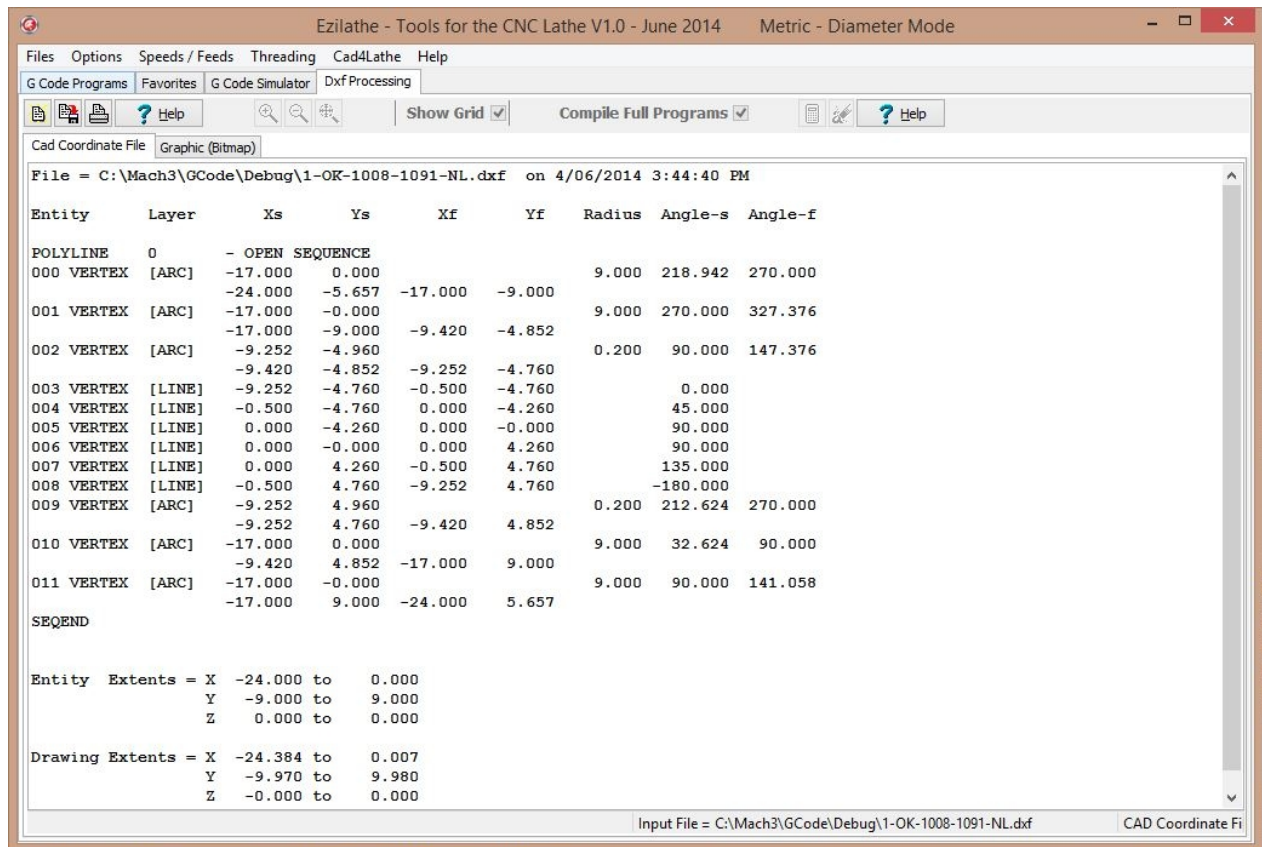
- **Splines** - Unlikely to be supported or needed.

Notes

- I tend to prefer Polylines / Lwpolylines, that are joined. This gives the ability to offset / move whole profiles for radius compensation etc.
- It is recommended that you keep your stock end at Z = 0 and Work towards Z minus (Chuck end). Your DXF should reflect this (X axis to CAD) . Only Positive X values may be selected for CAM, so keep to Positive 'Y' axis in CAD.
- Use layers so you can control visibility if required, but "Ezilathe" only uses up to 6 characters in length.
- Additional entities are fine, "EziLathe" will only use what you select. You can often find that an original profile as well as an adjusted profile are useful in the cad data to confirm the accuracy of any variations you have set up (radius compensation etc).

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Cad Co-ordinate Page



This page contains a listing of all entities within the DXF file, The Axis listed are named as is conventional for the CAD system, so in effect Listed X axis = Lathe Z axis, and Listed Y axis = Lathe X axis.

The listing may refer to polylines, containing a group of vertex (of type Arc or Line). Polylines may be open or closed, and the sequence is terminated by "SEQEND".

The Columns list data as follows :-

1. Entity - Polyline or Entity ID + Entity Type
2. Layer - Layer name or Vertex type
3. Xs - X Start co-ordinate - for 1st line of Vertex Arc or Arc this is the X center of arc.
4. Ys - Y Start co-ordinate - for 1st line of Vertex Arc or Arc this is the Y center of arc.

5. Xf - X Finish co-ordinate.
6. Yf - Y Finish co-ordinate.
7. Radius - Radius of Vertex Arc or Arc.
8. Angle-s - Start Angle of Vertex Arc or Arc. Angle of a Vertex Line or Line.
9. Angle-f - Finish Angle of Vertex Arc or Arc.

Note Angles are degrees running Counter Clockwise from Horizontal (0 deg) to the Right (East). 90 deg is Up (North).

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File Open Button



Opens a Dxf file in the Viewer. The file is opened via a standard file open dialog box.
By default file selection is filtered to Dxf Files (.dxf).

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File Save Button



Saves the Dxf processed data. The file is saved via a standard file save dialog box, to give the option to change the file name.
If the graphics page is active, then it's contents are saved as type Bitmap (.bmp)
Otherwise the text data is saved as a text file with the extension .ccf (Cad co-ordinate File)

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Print Button



Prints the Dxf processed data. The file is printed via a standard printer dialog box, that gives the capability to select a printer and modify it's printing options.
If the graphics page is active, then it's contents are printed, otherwise the text data is printed.

By default, the file is printed to the default system printer.

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Zoom In Button



Zooms In to the graphic image. As the image size is increased, Horizontal and Vertical Scroll-bars enable any part of the image to be viewed.
The Graphic may be Zoomed In by up to a factor of 2.5 : 1

Zoom Out Button



Zooms out of the graphic image. As the image size is decreased, Horizontal and Vertical Scroll-bars enable any part of the image to be viewed, until no longer required.

The Graphic may be Zoomed out to the original factor of 1 : 1 (Zoomed to view the Extents)

Zoom Extents Button



Zooms back to the original graphic image size i.e. Zoomed to the Extents. Horizontal and Vertical Scroll-bars are no longer required.

Show Grid Check-box

If Checked, a grid is shown on the graphics page.

Full Programs Check-Box

In the DXF processor, if this box is checked, then a full G-code program is produced, that will clear all existing content of the G-code editor (after confirmation if data already exists).

If this box is not checked then a code fragment is produced, that is simply added to the end of the editor, leaving existing content intact.

Compile Code Button



Compiles the G code Program from the inputs presented, if no errors are present. For a full description of the processes involved, Go to Dxf Processor.

Clear Selections Button



Clears all selected entities in DXF processor.

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Status-bar Panels

Graphics Page

Panel #1 = Current mouse position.

Text Page

Panel #1 = Input File Name (*.DXF)

Panel #2 = Output File Name (*.CCF)

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DXF Processor

The in-built DXF processor takes the DXF data loaded in the viewer, and with a minimum of set-up can produce a complete G-code program, or a code fragment for insertion into a G-code program.

Entity Selection

Entities must be selected in order in the cut direction, If out of correct sequence, the results will be interesting, but not very useful. Entities are selected using the mouse on the graphic screen, simply place the cursor on the entity to be selected, and select using the left mouse button.

As entities are selected, a note appears in the selection list-box, and the entity is displayed in red in the graphics screen.

If there is a gap between selected entities, the program will simply cut a straight line across the gap. (That's one reason to select entities in order)

Re-ordering or Removing from Selections

Entities may be selected in the **"Selections List-box"**. If Right-clicked, a Pop-up menu appears with the options [**"Move Up"**, **"Move Down"**, **"Remove from List"**, **"Delete Entity from Graphic"**]. Left-click on the required option to complete the action. This may need multiple moves if some distance involved. Entities may be removed from selection by re-selecting in the graphics screen.

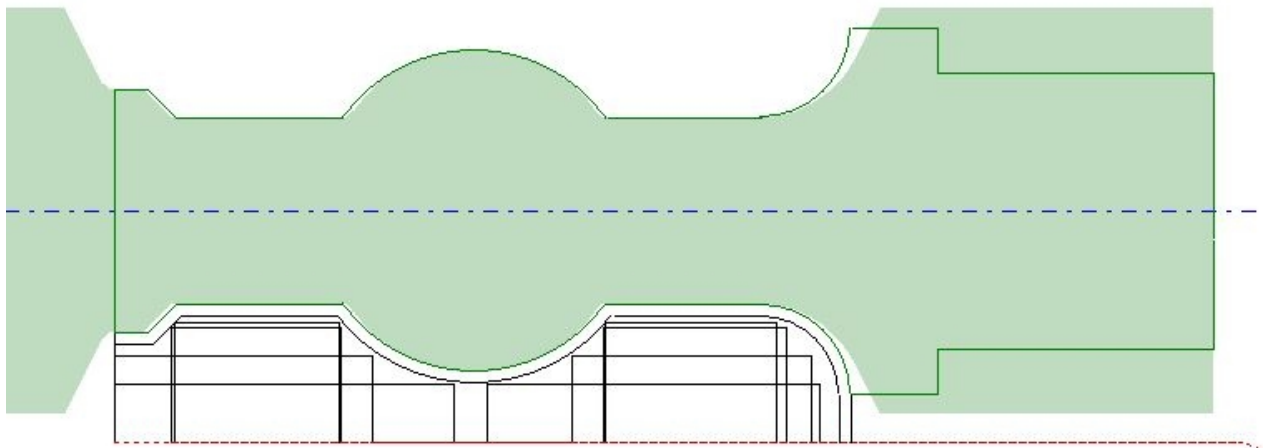
A Typical Job.

The steps can be done in any order, and assembled in a more appropriate order later (I tend to do the best bits first).

Step #1

After data entry into the Cam Setup control, Set **"Compile Full Programs"** Check-box to Checked, to Clear the editor (If Req'd) and add all the Program header data.

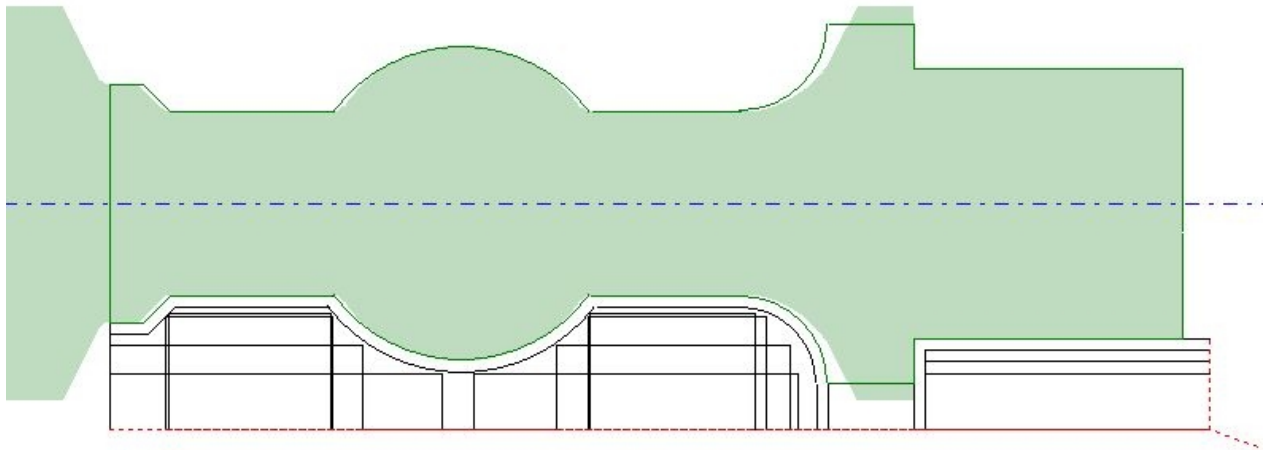
For the first step, I used a straight 55 deg Diamond tip tool, best for plunging in to take cuts. The Stock Origin is at Z 0.0, the computer automatically plunged in at a reduced feed to start the cuts, as the cutting started at Z -6.350, well away from the stock end.



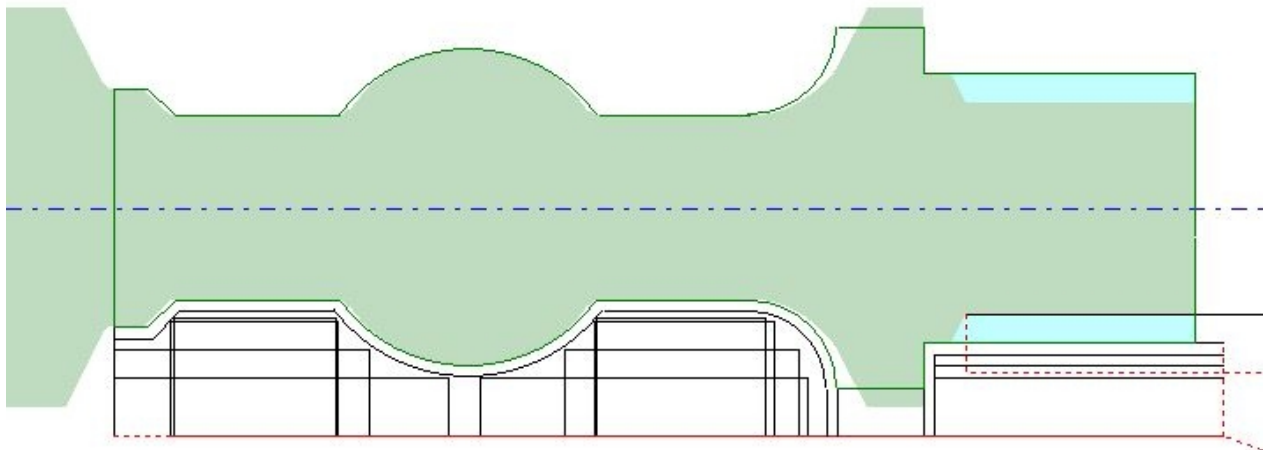
Step #2

Compile Full Programs Check-box Un-checked, so that this step is added to the end of Step #1.

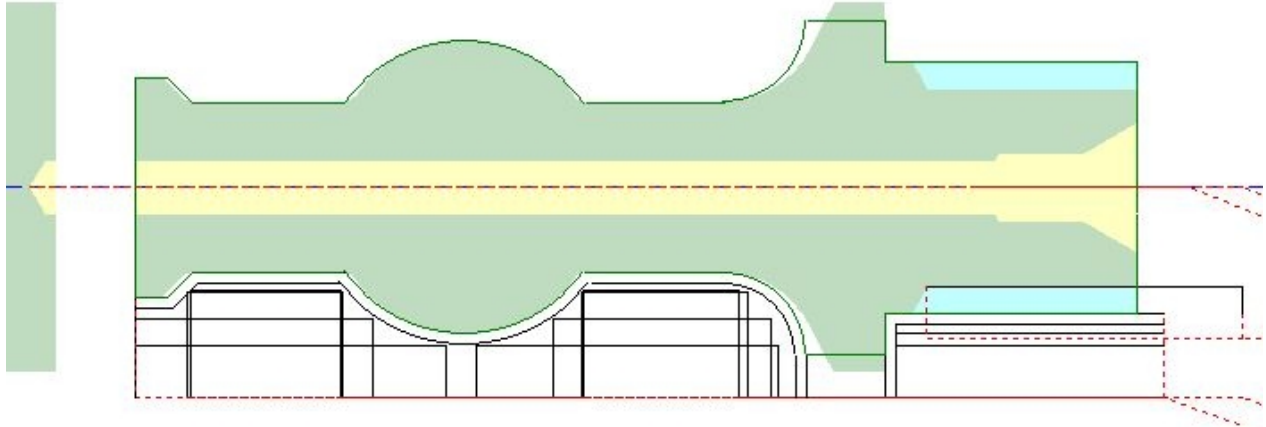
For This second step, I used a Sharp Face/Turn Tool. This is cut from the end, so no plunging cuts. All entities from Step #1 are cleared from selection, and the new entities selected.

**Step #3**

Using the Threading and G76 calculator, a program fragment was produced to cut the 3/16" x 40 M.E. thread to the end of the workpiece. When the tooling is correctly set-up in the Tools Editor, clearance from screwcutting tool to shoulder can be confirmed visually.

**Step #4**

Cut and Paste from "Favorites" - Center Drill - Drill through - Part off. Manually add speeds into favorites fragments, adjust drill depth, and part off co-ordinates. Re-order initial steps to a more suitable order, i.e. Start with Step #2, then Steps #3 and #1 (Looked a bit fragile to cut in previous order). Job Done ?

**Step #5**

Not Quite Finished. I see the end of the drill "Peeping". I need a flat face here, as i will not be facing off, so pull the drill back 1mm (Parting tool is 1.5mm wide). Final result can be seen under "G code Simulator". Copy from the favorites a couple of lines that position the facing tool as a material stop before the spindle start-up. Includes a M0, for opening the chuck / sliding the material out to touch the tool at Z 0.0. Now the job is done. In case you are wondering, the part of the job left not machined, is a hexagon.

This job was run on a CNC lathe (running Mach3) exactly as depicted here, without any further edits.

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DXF Setup Page

The DXF setup page can be seen under [Dxf Viewer](#).

Note ! Green inputs are optional, may be left clear.

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Stock Diameter Input

Enter the Stock Diameter. Note that the tool will return at clearance value above this Diameter, and Roughing cuts are calculated from Stock Diameter.

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Stock Origin "Z" Input

The End of the Bar. It is recommended that this is always Z = 0.0
If left clear, 0.0 is assumed.

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Operation Combo-box

Two options here :-

1. O.D. Turning Operation - the usual for most turning operations.
2. I.D. Boring Operation - Used for boring only. Assumes the initial hole exists. (Copy / Paste from "Favorites" as required)

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Initial Hole Diameter Input

Visible and applicable only when I.D. Boring Operation is selected.

The Initial Hole Diameter must be small enough to fit within the required bore (from selected entities from DXF), and be big enough to allow the boring tool to enter (and have the entered Clearance value).

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Cut Direction Combo-box

Two Options Here :-

1. Cut Direction - Right to Left
2. Cut Direction - Left to Right

Cut direction into chuck or away from chuck. Usually Right to Left.

This Box is currently locked to Right to Left. Reason = Not worth the Trouble.

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Tool Combo-box

This Box allows selection of the tool to use for the current job.

It is populated from the Tool Editor, and will reflect latest additions only after Re-opening the program.

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Rotation Combo-box

Two Options Here :-

1. M3 = Backward (CCW)
2. M4 = Forward (CW)

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Selections List-box

As mentioned previously, this List-box shows the currently selected entities (I.D., Type, and layer name)

If Right-clicked, a Pop-up menu appears with the options [**"Move Up", "Move Down", "Remove from List", "Delete Entity from Graphic"**]. Left-click on the required option to complete the action. This may need multiple moves if some distance involved. Entities may be removed from selection by re-selecting in the graphics screen.

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"Z" Axis Minimum Input

If entered this value must be Less than the Minimum Z co-ordinate from the DXF data.

If correctly entered, the cut will continue on from the end of the DXF data to the specified point, at X = to DXF End X

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Vertical Override Input

If Entered, this value must be less than **"Finish - Cut Depth"**

This value is the effectively the finish cut depth for vertical shoulders. This reduced cut can often be required when the tool is "Plunged" into a shoulder, prior to facing outwards during the finish cut.

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Clearance Input

This value is the distance above stock diameter used for all rapid traverses of the tool.

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Spindle Speed Input

This value is spindle speed used after the toolchange.

Value can be exported from **"Speeds / Feeds"** if required.

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Rough - Feed/Min Input

This Value is the Roughing feed used for all rough cuts, except when plunging.

Value can be exported from **"Speeds / Feeds"**.

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Rough - Cut Depth Input

This value is the Maximum depth of cut for Roughing. The program will generate code to produce cuts to this depth as far as possible, only the last cut is adjusted to maintain the finishing cut depth. If you prefer, due to minimal depth of the last numbered rough cut (Not the final rough cut), it can be deleted. The code is commented to simplify fine tuning of the code.

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Finish - Feed/Min Input

This Value is the Finishing feed used for the Finishing cuts, except when plunging.

Value can be exported from **"Speeds / Feeds"**.

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Finish - Cut Depth Input

This Value is the Standard finish cut depth, This can be reduced at vertical shoulders by **"Vertical Override Input"**

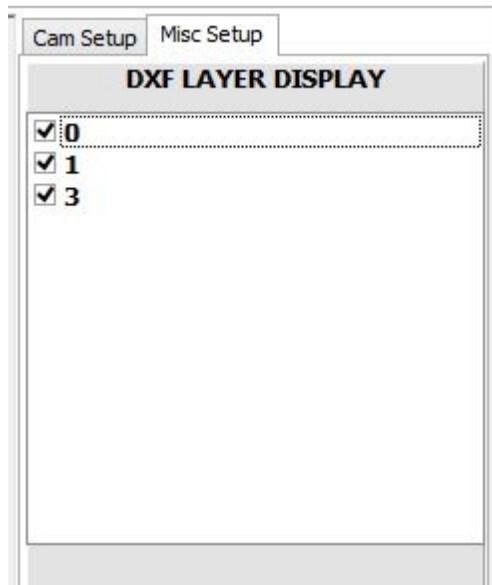
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Plunge - Feed/Min Input

This is a slow feed used when Plunge cuts are used.

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Misc Setup Page



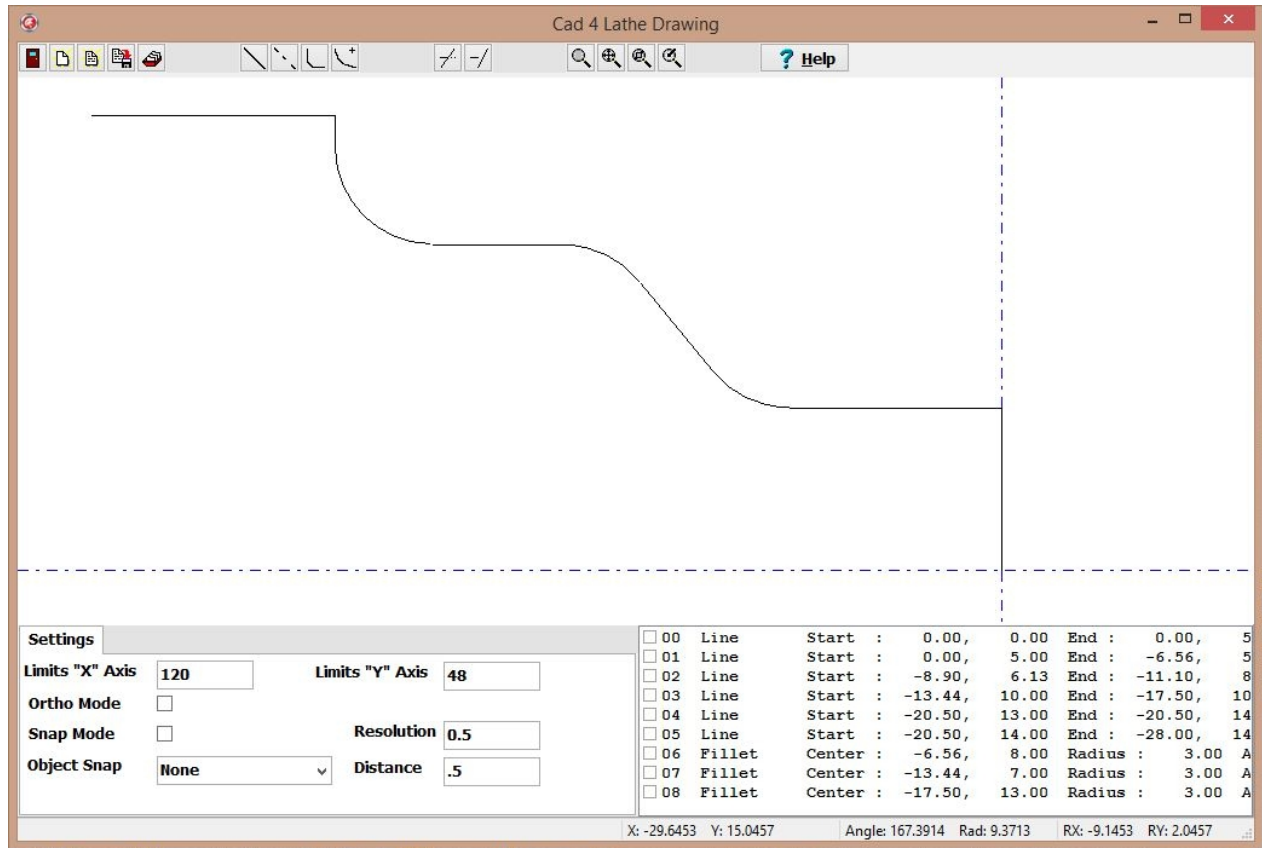
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Layers Check-box

Layers in the DXF file are listed here. By Default, all are checked i.e. will display. Un-check to not display the selected Layer.

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Cad 4 Lathe



This Function is currently under development and is subject to change. Functions may not be implemented completely yet, but there are sufficient features operational to allow for simple turned parts to be drawn for DXF processing.

Cad4Lathe is designed as a quick and simple way to draw a few lines / arcs, that can then be exported into the DXF processor to produce the G-code. It is not intended to replace even the simplest Cad system, but can replace the more usual "Wizards" often used for simple programs. Cad4Lathe is designed to operate only within the bounds of recommended practice for Lathe work, and as such does not consider entities in the X plus or Y minus areas when calculating the drawing extents.

There is no provision for adding presentation entities (such as text, dimensions), and it is not planned. If it is required to check or document the program offline, use the DXF graphic and text printouts. The drawing file format is not standard, and cannot be accessed with other Cad systems, and DXF export or Import is also not planned.

Entities can be produced by selecting the co-ordinates on screen (Ortho, Snap and Object Snap modes help) or entering co-ordinates via input boxes.

Entity Draw or Modify commands when entered bring up the "Command" tab that supplies useful data and prompts for the command in question. A text edit box will be available if required. The Command tab replaces the "Settings" tab (visible above).

If while a command is active, the settings page is accessible, by clicking on the "Settings" tab (Access to drawing modes etc). The command tab will return, when the mouse pointer clears the Settings tab.

Settings editor

The Settings editor allows the entry of a variety of modes and settings.

Note Axis are as per CAD / DXF i.e. X = Horizontal and Y = Vertical.

"Limits "X" Axis" - Enter a value to define the initial "X" size of the drawing, to allow for the maximum size likely to be drawn.

"Limits "Y" Axis" - Enter a value to define the initial "Y" size of the drawing, to allow for the maximum size likely to be drawn.

"Ortho Mode" - Ortho Mode allows only horizontal or vertical lines to be drawn by selecting co-ordinates on screen. Checked = Ortho Mode.

"Snap Mode" - Snap mode allows only co-ordinates that are rounded to **"Resolution"** by selecting on screen. Checked = Snap Mode.

"Object Snap Mode" - Object Snaps allow the selection of features on previously drawn entities. Object snap mode is selected from a series of options in a Pull-down list. The current modes are :- None, Endpoint, Center. To snap to a feature, you must move the mouse to within the set distance of the feature and have a relevant command active (Where more than one feature is possible, the closest one to the picked point will be selected). A colored marker will show the currently selected feature, if applicable.

Note that these modes apply only to on screen selection. Data entered in edit boxes is not effected by these modes.

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Keyboard / Popup

Pop-up Menu.

"Enter" Terminates a text entry, or if no text entered (Null input) terminates a multi entity command such as Lines or Trim etc.

"Undo" Undo Last Edit.

"Delete" Deletes a selected entity. (same as placing a check mark in the entity list box).

"Cancel" Cancels the current command.

Keyboard.

Return or Enter key = as **"Enter"** from Pop-up menu.

Space bar = as **"Enter"** from Pop-up menu.

Escape (Esc) key = as **"Cancel"** from Pop-up menu.

Arrow keys = Move up / down the control list (Usually edit boxes).

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Basic Controls



Closes Cad4Lathe window (Data remains intact, and available when the window is re-opened)



Starts a new Drawing.



Opens an Existing Drawing via Std File Open Dialog box.



Saves the Current Drawing via Std File Save Dialog box.



Exports the Current drawing to the DXF Processor and closes the Cad window. (Data remains intact, and available when the window is re-opened)

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Entity Draw Controls

Co-ordinates may, when required be entered by picking on screen (Using Ortho, Snap or Object Snap modes as required) or as text in the command line.

For text entry, Co-ordinate data may be entered as Absolute data or Relative data (to the last point entered as listed in the location box). Prefix the co-ordinates with "@" for relative data.

Cartesian Co-ordinates = Z, X e.g. -12.7, 9.52 or @-10, 0 for relative co-ordinates.

Polar Co-ordinates = Radius < Angle e.g. 12.7 < 150 or @10 < 180



Line Button - Lines will continue to be drawn until Finish button (on Line Panel) is pressed (or Enter selected from Pop-up menu).



Construction Line Button - Construction Lines will continue to be drawn until Finish button (on CLine Panel) is pressed (or Enter selected from Pop-up menu).

Construction Lines are not exported via the Export Function.



Fillet Button - Constructs a fillet of input radius between 2 entities. Current Fillet Radius is displayed in the Location box. To accept the current radius without change, simple pick the 2 lines without entering a radius. Note that entry of a 0 radius, will effectively trim or extend the entities to an intersection.

Currently only pairs of Lines may be Filleted.



Arc Button - Constructs an arc at input radius and center between 2 points. The order of input (on screen or text) is Arc Center, Radius, Start Angle (from center), End Angle (from center).

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Entity Modify Controls

The first step in these commands is to select a boundary line, followed by any number of lines to trim or extend.



Trim Button - Trims entities that intersect the boundary line.



Extend Button - Extends entities to boundary line if an intersection is possible.

Currently Under Review, Not all combinations of entities operational.

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Zoom Controls



Zoom All (To Limits as set in Data Editor)



Zoom Extents (of drawing entities)



Zoom Window.

1. Pick first point on screen to define first corner of rectangular window.
2. Move the mouse to the diagonally opposite corner of the rectangular window, a rectangular box will stretch out with mouse movement.
3. Pick second point on screen to define the second corner of the rectangular window.

4. Move the mouse to move the rectangular window if required.
5. Pick on screen again to execute the zoom.

Note ! To back-up 1 step, right-click on screen.



Zoom Previous (Zoom to last view)

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Edit Window

Selecting a drawing entity on screen or in the entity list box, while not in a command, will bring up the Edit tab.

The edit tab will contain the controls and prompts relevant to the entity to be edited.

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Deleting Entities

Entities may be deleted by "Checking" within the Entity List box, or selecting on screen and selecting **"Delete"** from the Pop.up menu.

Entities may be un-deleted by removing the check mark against it's listing in the entity list box.

Deleted entities are removed from the list when the program is opened next time.

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Speeds/Feeds

Speeds / Feeds and Lathe Details - Metric Mode							
Material Type		Lathe Tool Specification		Lathe Details			
Medium Steel		High Speed Steel - Plain		Boxford 125 TCL Lathe			
Operation <input checked="" type="radio"/> Rough Turning <input type="radio"/> Finish Turning <input type="radio"/> Parting Off <input type="radio"/> Drilling		Work Diameter mm		25		Description	
		Depth of Cut mm		1		Boxford 125 TCL Lathe	
						Max Spindle Speed	
						3200	
Overrides - Percentage or Absolute <input checked="" type="checkbox"/> Percentage <input checked="" type="checkbox"/> Percentage <div> <div></div> <div>50</div> </div>						Max Feed Units/Min	
						300	
Speed RPM		Feed mm/Rev		Feed mm/min		X Axis Travel Units	
293		0.2000		58.6		125	
C/S Metres/Min				Power kW		Z Axis Travel Units	
23.00				0.17		125	
		? Help		Transfer Data to CAM Panel		Swing Over Bed	
				Close		160	
						Swing Over X Slide	
						70	
						Init String #1	
						G18 G40 G49	
						Init String #2	
						G90 G94 G80	
						Init String #3	
						G21 (mm)	
						Exit String #1	
						M5 G28	
						Exit String #2	
						M30	

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Speed & Feeds calculator

This is a stand alone calculator for Speeds / Feeds (Some data may, however be exported to the Dxf processor)

The basic data is taken from the Materialm.txt data file, that can be user modified to more closely match your requirements.

The combination of Material Type, Lathe tool specification and work diameter are used to calculate the spindle speed required.

This speed is adjusted (slightly) by the operation involved.

Using the same data as above, feeds can be approximated for most applications, but feeds are much effected by other considerations.

The calculated feeds take into account the flexibility of the workpiece, reducing the feed as the workpiece diameter reduces.

However without "seeing" the length of the job (effect on Rigidity), these feeds can only be a rough guideline only.

A pair of overrides are available to tailor the output to your needs (Speed and Feed both can be overridden as a percentage, or an absolute value)

Power calculations are again guidelines only. Power is that used for cutting only, and takes no account of transmission losses in the spindle drive. A mental derate should be applied to your motor power to account for these losses. Taking that into account, the figures seem realistic.

The last of the Output boxes **"C/S Meters / Min"** or **"C/S Feet / Min"** just shows the actual cutting speed achieved at the **"Speed RPM"**

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Lathe Details

There is an allowance for data on up to 4 lathes to be entered here, and the active lathe will be showing in

the edit boxes. Not all this data is currently used, but may be in the future.

Data that is currently used :-

"Max Spindle Speed" - The limit of Spindle Speed used in the Speeds / Feeds Dialog box.

"Init String" - These 3 Strings are used in Full Program Mode as Initialization values for the Program's Active G-codes.

"Exit String #1" - This string terminate all program fragments. Usually "M5 G28" (Stop spindle, Go to tool change location) works for me anyway.

"Exit String #2" - This string terminate the Full Program. Usually "M30" (Program End and Rewind).

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Threading

G76 Threading Calculator						Metric	Basic Thread Systems	Imperial
Details of Thread for Cutting						Unified Thread Form - 60 Deg		
Thread Depth *	0.6874	Cut	Inc. Cut	Depth	Area of Cut	1.27	Pitch of Thread **	0.05
Infeed Angle	29	1	0.3437	0.3437	0.0171		Threads per Inch **	20
Thread Cut Area (Ref)	0.2728	2	0.1424	0.4861	0.0171	12.7	Outside Diameter **	0.5
Number of Cuts	16	3	0.1092	0.5953	0.0171			
First Cut Depth	0.3437	4	0.0921	0.6874	0.0171			
Last Cut Depth	0.04366	5	0.0811	0.7685	0.0171			
Core Diameter (Ref)	11.33	6	0.0734	0.8419	0.0171			
"Z" Axis Start (Inc Run Up)	2	7	0.0675	0.9093	0.0171			
"Z" Axis End	-30	8	0.0628	0.9721	0.0171			
Tool Retract in Rotation	45	9	0.0590	1.0311	0.0171			
Number of Spring Passes	2	10	0.0558	1.0869	0.0171			
Taper of Thread	0	11	0.0530	1.1399	0.0171			
"X" Axis Clearance	1	12	0.0507	1.1906	0.0171			
Spindle Speed	400	13	0.0486	1.2392	0.0171			
		14	0.0468	1.2860	0.0171			
		15	0.0451	1.3311	0.0171			
		16	0.0437	1.3748	0.0171			
1111, Screwcut External 60 Deg						0.1375	Tip Shortening	0.005413
M3 - Forward (CW)						0.6874	Depth of Thread *	0.02706
						11.3252	Core Diameter	0.4459
						11.43	Bore Diameter	0.450
						12.7	O.D. of Cut (Groove)	0.5
						11.8751	Basic Pitch Diameter	0.4675
Generate G-code (Add to Editor)								
Exit						Help		

This Dialog box is designed to assist in the production of threaded parts on the CNC lathe. Firstly enter your thread details, then the parameters required to actually cut the thread. The cuts are calculated to maintain a constant area of cut for maximum efficiency and consistency in threading.

Edit boxes with red text are read only. Thread depth, Infeed angle are entered from the Thread details, but may be changed manually in the G76 Calculator if required.

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Thread Calculator

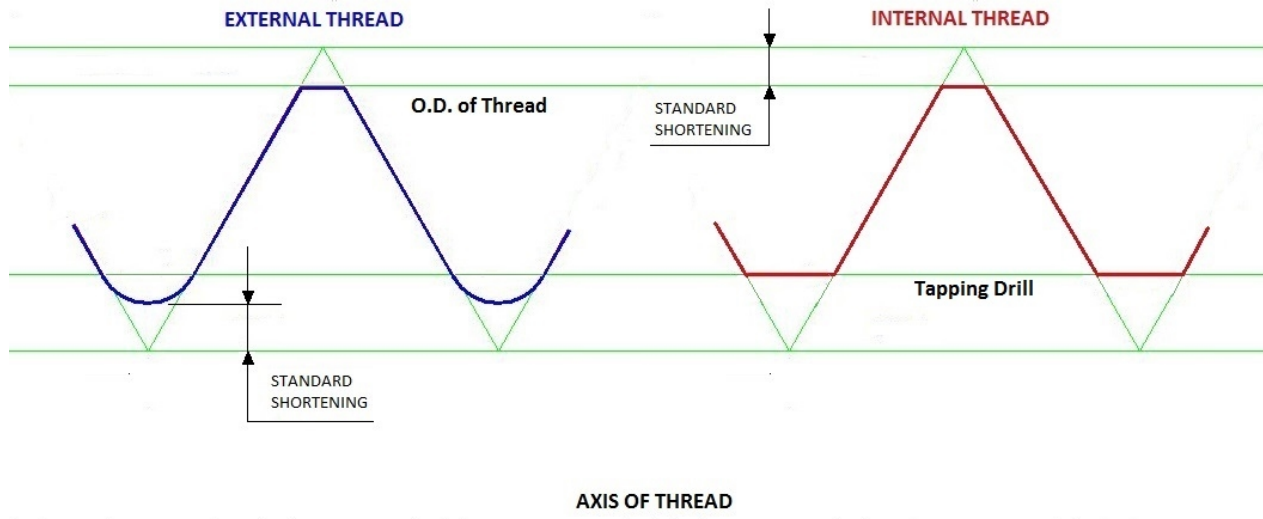
The inbuilt thread calculator is designed to quickly calculate the cutting parameters that can be used in the G76 Thread calculator to actually cut the thread.

Even in the metric world we still cut Imperial threads, so both metric (Blue boxes) and Imperial (Yellow boxes) are available, and are kept in sync.

Data here is taken from the applicable basic thread forms as listed in the Machinery Handbook.

Knowing what Thread form to use and an Outside Diameter and Threads per Inch (or Pitch) is all that is required.

Metric or Imperial Mode only effects where the G76 Thread Calculator gets it's data (Blue box or Yellow box).



The calculator can adjust for Non-Standard Tip Radius or Flat on your screw-cutting tool. Tip Shortening controls the Distance from the standard maximum depth of cut to the apex of the sharp "V" of the thread form. Pick Non-Standard Shortening, and enter value in the edit box below.

e.g. when using a sharp "V" screwcutting tool, pick Non-Standard Shortening, and enter "0" in the edit box below.

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G76 Threading Calculator

The G76 Threading Calculator allows the generation of a code fragment for screw-cutting in the lathe. This code is added to the end of the program in the editor, where it can be Cut / Pasted to where you require it.

Inputs Required (For the Basic Thread) :-

- **"Thread Depth"** - This is the depth supplied from the Basic Thread Systems side, However it can be manually adjusted here.
- **"Infeed Angle"** - This is generally slightly less than 1/2 the thread angle for the recommended modified flank cutting (or 1/2 the angle for flank cutting). This is fully discussed in other documents.
- **"Thread Cut Area (Ref)"** - Read Only. This is the Area of the Vee form cut.
- **"Number of Cuts"** - See Note 1. This can be entered directly, or the up / down arrows used.
- **"First Cut Depth"** - See Note 1. The Number of cuts may be based on this.
- **"Last Cut Depth"** - See Note 1. The Number of cuts may be based on this.
- **"Core Diameter Ref"** - Read Only. Actual Core diameter as produced with the tool used. Knowing this can avoid unexpected appearances of thread on thin wall workpieces.

Note 1 - These 3 inputs interact together to maintain a constant volume removal of material per pass (important to avoid power fluctuations and the effects). Changing any one of these will recalculate all.

Inputs Required (For the Job)

- **"Z" Axis Start (Inc Run Up)"** - The cut should start a couple of pitches clear of the job to allow the axis movement to stabilize. A thread starting at Z = 0.0 might see an input of 4mm (0.160") here.
- **"Z" Axis End"** - This is the end co-ordinate of the thread. This is not the Length of thread, it is the co-ordinate of the Z axis.
- **"Tool Retract in Rotation"** - Called Chamfer in some places, but is the spindle rotation angle used for

the tool to dis-engage from the workpiece. (45 or 1/8 turn is often used)

- **"Number of Spring Passes"** - The number of additional passes (with no "X" axis change) to clean-up the effect of any spring in the workpiece. Use Sparingly especially on some materials.
- **"Taper of Thread"** - Entered in degrees for taper threads, like Pipe Threads.
- **"X" Axis Clearance "** - The Distance above the Thread Outside Diameter (or Below the Thread Code diameter for Internal threads) used for the "X" axis when tool is retracting.
- **"Spindle Speed"** - Enter the Spindle Speed here (Not imported from other areas).

Note on Taper Threads - BSP / NPT Threads may have a taper of whatever. This is entered as the included angle. Outside Diameter is entered at the small end (including run-up), so may be smaller than you think.

Final Thoughts

Safety Emphasized

The "EziLathe" program is used to produce and/or optimize G-code programs for use on CNC lathes. Potential dangers exist for both personnel and machine tools, if the work is not carried out in a safe manner. **No guarantee is given that G-code generated is safe to run on any CNC machine, It must be checked carefully before use, and then initially by "Dry Run – without tooling" before any metal is cut.** Speeds and Feeds, Excessive Gouging, and collisions especially in rapid feed are all potential dangers in the use of CNC machinery.

I just thought i would catch those who always check out the last page First.

Happy CNC'ing.

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