

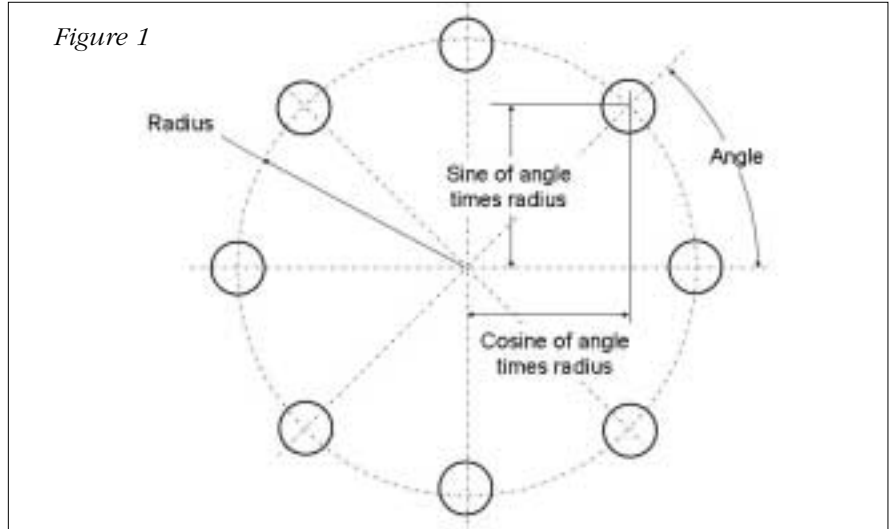
Using Polar Coordinates for Bolt Circles

When confronted with the need to machine a bolt circle, most machining center manual programmers will use trigonometry to calculate the rectangular coordinates for each hole on the circle in X and Y. And frankly speaking, its not that hard to calculate rectangular coordinates. Figure 1 shows the two needed formulae.

Again, two simple formulae are required. For X coordinates, multiply the cosine of the angle times the radius. For Y coordinates, multiply the sine of the angle times the radius. Then add or subtract the results to or from the bolt circles center position and you have the hole's coordinates.

This method of calculating rectangular coordinates is by far, the most popular way of programming bolt circles for two reasons. First, and as you have seen, its not that hard to do. But second - and more importantly - many CNC controls (especially older ones) don't allow you to do so by any other means. The CNC control must have a feature called polar coordinates in order to program bolt hole circles without having to specify rectangular coordinates. And even some of the more popular current CNC controls (Fanuc) have some pretty severe limitations when you use polar coordinates. For these reasons, you may elect to continue using the rectangular coordinate system to machine bolt circles. But after reading this article, at least you'll know how polar coordinates can be used.

Figure 1



Words involved with polar coordinates

Two G codes are used with polar coordinates. G16 is used to instate the polar coordinate mode and G15 is used to cancel, placing the machine back in rectangular coordinates mode. G15 is initialized, meaning when you turn the power on, the control automatically instates the rectangular coordinates mode. Some programmers like to include a G15 at the beginning of all programs as part of some safety commands that ensure the machine is in the appropriate modes when the program starts (some odd things will happen if the machine is in polar coordinate mode and you don't know it!)

When in polar coordinate mode, the letter address X no longer specifies a rectangular position along the X axis. Instead, it specifies the radius for the polar coordinate. Y no longer specifies a rectangular position along the Y axis. Instead, it specifies the angle for the polar coordinate. Figure 2 illustrates this.

As you can see, the radius of the bolt circle (X2.5 in our case) remains

the same for the entire circle. Only the angle (specified by Y) changes from hole to hole.

One severe limitation of Fanuc's polar coordinates G15 command is related to the origin for the polar coordinates. Notice from the previous drawing that the center of the pattern

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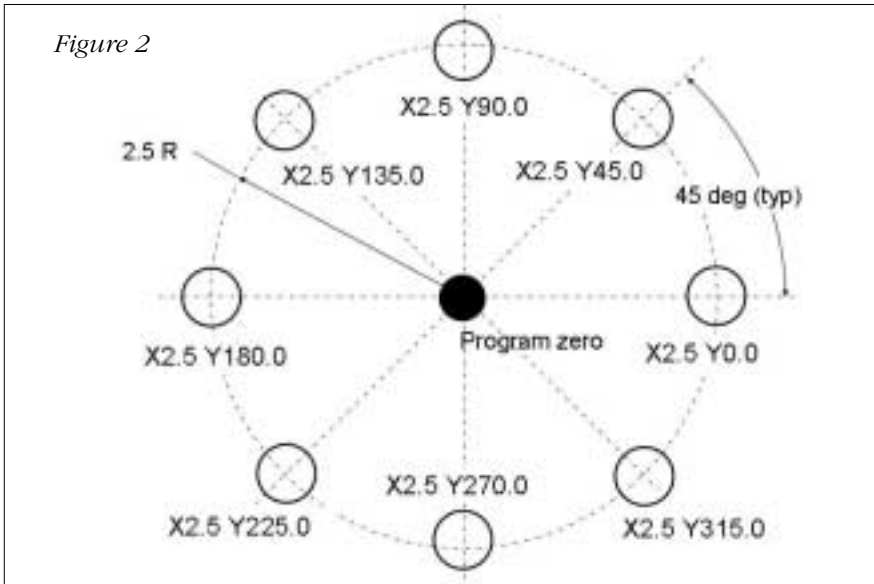
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All techniques given in this newsletter are intended to make CNC usage more efficient, easier, and/or safer. However, CNC Concepts, Inc. can accept no responsibility for the use or misuse of the techniques given.

Figure 2



happens to be the program zero point for the program. So Fanuc is simply assuming that the origin for polar coordinates is the program zero point - which is rarely the case with bolt circles (unless the bolt circle is around a ring or flange - and the center of the ring is the program zero point for the program). This is yet another reason many programmers shy away from polar coordinates - it's not very feasible for most applications since the origin for polar coordinates must be the program zero point for the program.

Using G52 to shift the program zero point

Called temporary shift of program zero, the G52 command allows you to temporarily place the program zero point at the center of your bolt circle. X and Y within the G52 command tell the control the distance from the true program zero point (probably set with fixture offsets) to the center of the bolt circle - which is of course, the origin for the polar coordinate system. For example, consider the following command.

N050 G52 X3.0 Y4.0 (Temporarily shift program zero to the center of bolt circle)

This command will shift the program zero point from its original position to a location of 3.0 in X and 4.0 in Y. The control will continue to use this location as program zero until another G52 command is given.

With every G52 command, you must specify the distances in X and Y from the original program zero point to the new one. So if you have several bolt hole patterns to machine, you'll have several G52 commands - all specifying the distance from the original program zero point to the center of each bolt circle.

When you are finished machining bolt circles, you must remember to set the program zero point back to its original position. To do so, include the following command in your program.

N105 G52 X0 Y0 (Reset program zero to original position)

Example program

Here is an example program that uses polar coordinates to machine three bolt circles and uses G52 to shift program zero to the center of each bolt circle. Figure 3 shows the workpiece to be machined.

```
O0001 (Program number)
N005 T01 M06 (Place drill in spindle)
N010 G90 G54 S1000 M03 T02 (Select abs. mode, coordinate system, start spindle, get next tool ready)
N015 G52 X4.0 Y4.0 (Shift program zero to center of first bolt circle)
N020 G00 G16 X2.0 Y0 (Move over first hole on bolt circle)
N025 G43 H01 Z0.1 (Instate tool length comp., move just above hole)
N030 G81 X2.0 Y0 R0.1 Z-0.75 F4.0 (Machine first hole of first bolt circle)
N035 Y45.0 (Second hole)
N040 Y90.0 (Third hole)
N045 Y135.0 (Fourth hole)
N050 Y180.0 (Fifth hole)
N055 Y225.0 (Sixth hole)
N060 Y270.0 (Seventh hole)
N065 Y315.0 (Eighth hole)
N070 G80 (Cancel cycle)
N075 G52 X8.0 Y8.0 (Shift program zero to center of second bolt circle)
N080 G81 X2.0 Y0 R0.1 Z-0.75 F4.0 (Machine first hole of second bolt circle)
N085 Y45.0 (Second hole)
```

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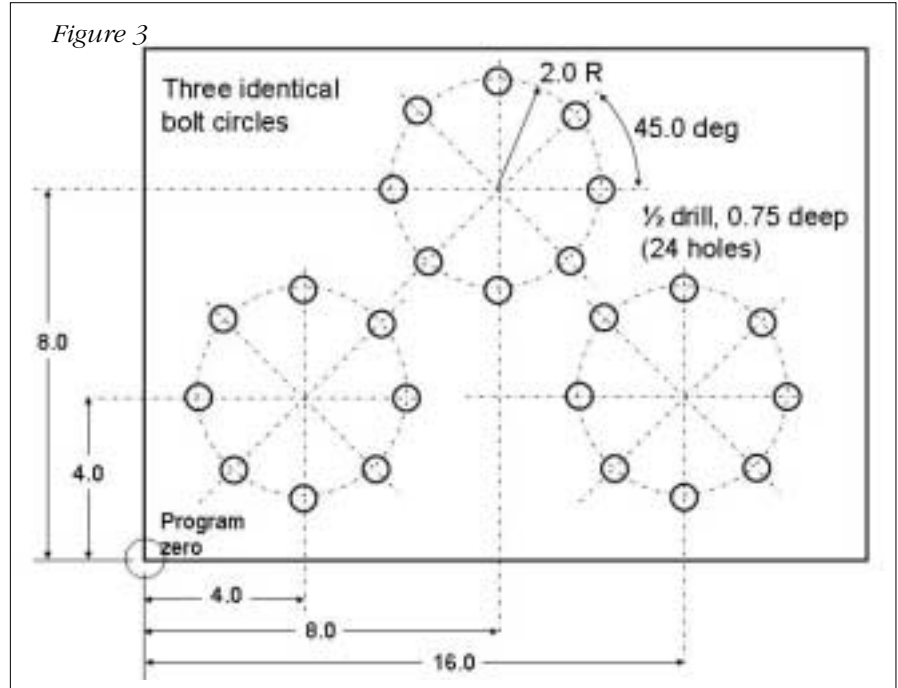
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N090 Y90.0 (Third hole)
 N095 Y135.0 (Fourth hole)
 N100 Y180.0 (Fifth hole)
 N105 Y225.0 (Sixth hole)
 N110 Y270.0 (Seventh hole)
 N115 Y315.0 (Eighth hole)
 N120 G80 (Cancel cycle)
 N125 G52 X16.0 Y4.0 (Shift program zero to center of third bolt circle)
 N130 G81 X2.0 Y0 R0.1 Z-0.75 F4.0 (Machine first hole of third bolt circle)
 N135 Y45.0 (Second hole)
 N140 Y90.0 (Third hole)
 N145 Y135.0 (Fourth hole)
 N150 Y180.0 (Fifth hole)
 N155 Y225.0 (Sixth hole)
 N160 Y270.0 (Seventh hole)
 N165 Y315.0 (Eighth hole)
 N170 G80 G15 (Cancel cycle, cancel polar coordinates)
 N175 G52 X0 Y0 (Reset program zero to original position)
 N180 G91 G28 Z0 M19 (Return to tool change position, orient spindle)
 N185 M01 (Optional stop)
 N190 _

A few notes about the program

1) Note that we had to cancel the canned cycle (G80) between bolt circles. This is because G81 is modal - and will machine a hole in every command until G80 - including the G52 command that shifts the program zero point. Without the cancellation between bolt circles, the last



hole of the first and second bolt circles will be machined twice.

2) Note that only the Y value (angle) changes from hole to hole. There is no need to repeat the redundant radius (X word) in each command.

3) Note that the actual commands to machine each bolt circle are identical. These commands could, of course, be placed in a subprogram and the subprogram can be called

three times. This will minimize the length of the program.

Does your control allow you to specify the origin?

Again, most Fanuc controls force you to use the G52 command and keep relocating the program zero point in order to use polar coordinates. However, there are control manufacturers out there that do allow you to specify the origin for the polar coordinate system right in the polar coordinate command (though it may not be a G16). Having this ability has some pretty interesting implications.

First of all, when machining bolt circles, you won't have to cancel the canned cycle between bolt circles. And of course, you won't have to reassign the program zero point for each bolt circle. But very interestingly, you'll also be able to use polar coordinates for other positioning motions that would normally require some trigonometry. Consider the drawing shown in Figure 4.

If using the rectangular coordinate system to contour mill this workpiece, of course, you will need to do some trigonometry, at least for points 4 and 5. However, with the



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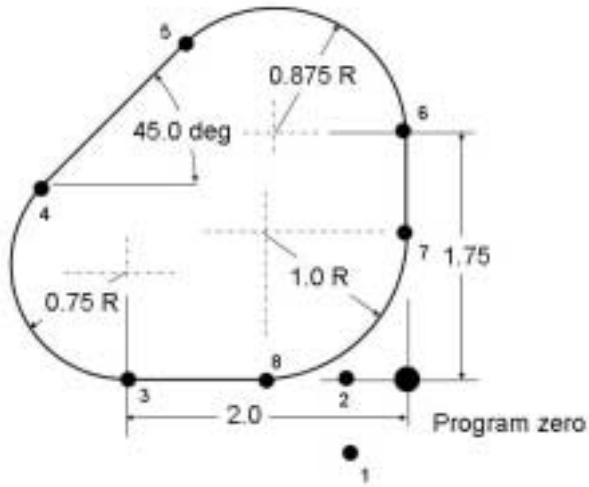
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Figure 4



polar coordinate system (and if you can specify the origin for polar coordinates within the polar coordinate command), this contour can be programmed manually without needing any trig!

Remember that polar coordinates are simply being used to specify the end point for positioning movements. While being done in a different manner than with the rectangular coordinate system, polar coordinates can be used in conjunction with any motion command, including G00, G01, G02, and G03. Again, were just using another method to

specify end points for motion commands.

For our example, well say G16 still instates and G15 still cancels the polar coordinate mode. Within the G16 command, say X and Y are now used to specify the origin of the polar coordinate system (which makes more sense) and that Q specifies the radius and A specifies the angle for the end point. Remember, if your control allows this, you'll have to reference your control manufacturer's manual to determine the related letter addresses for origin, radius, and angle, as well as the G codes for polar coordinates. Were simply giving one

possibility. Consider the following program.

```
O0001 (Program number)
N005 T01 M06 (Place 1.0 inch milling
cutter in spindle)
N010 G90 G54 S700 M03 T02 (Select
abs. mode, coordinate system, start
spindle, and get the next tool ready)
N015 G00 X-0.5 Y-0.6 (Rapid to point
1)
N020 G43 H01 Z-0.6 (Rapid to work
surface in Z)
N025 G41 G01 D31 Y0 F5.0 (Instate
cutter comp to point 2)
N030 G16 X-2.0 Y0.75 A270.0 Q0.75
(Instate polar coordinates, feed to
point 3)
N040 G02 A135.0 R0.75 (Circular
move to point 4)
N045 G01 X-0.875 Y1.75 A135.0
Q0.875 (Feed to point 5)
N050 G02 A0 R0.875 (Circular move to
point 6)
N055 G01 X-1.0 Y1.0 A0 Q1.0 (Feed to
point 7)
N060 G02 A270.0 R1.0 (Circular move
to point 8)
N065 G00 G16 Z0.1 (Rapid out in Z,
cancel polar coordinates)
N070 G40 (Cancel cutter comp.)
N075 G91 G28 Z0 M19 (Return to tool
change position, orient spindle)
N080 M01 (Optional stop)
```


With most controls that allow this, all words related to polar coordinates are modal. So in line N040, for example, only the changing value (the angle) must be included in the command. The origin in XY as well as the radius remain the same.

Notice that any kind of motion command can be specified - and that there is no need to do any trigonometry to determine the location of points four and five.

M01

How do you use a tool pre-setter?

Measuring tool length compensation values for a machining center off line is a great way to minimize the time a machining center is down between production runs (reducing setup time). Someone can be assem-



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bling and measuring tools for up-coming jobs while the machine is running production. This does, of course, assume you have enough tooling, someone available to perform the related tasks, and time during the production run to perform these tasks.

Remember that there are two ways to use tool length compensation. With one method, the distance from each tool tip down to the Z axis program zero point is placed into the tool length compensation offset (a large negative value) and the Z axis program zero assignment value (fixture offset Z) is always set to zero. This tends to be a popular method for vertical machining centers, and especially in job shops and tool rooms. But with this method, tool length compensation value measurement is almost always done at the machine, while the machine is down between production runs. And these measurements are taken by the machines setup person.

If you're going to be measuring tool lengths off line, you almost have to use the second method. While there are ways to measure tools off line with this method, the process gets pretty cumbersome.

With the second method, and again, this is the method we recommend for measuring tools off line, the distance from the spindle nose (at the Z axis zero return position) to the Z axis program zero point is stored in the program zero assignment (fixture offset Z) register. This will be a large negative value. The distance from the tool tip to the spindle nose (the tool's length) is placed in the tool length compensation offset (as a positive value).

Note that this method does not force you to measure tool length compensation values off line. It can still be done at the machine. First, touch the spindle nose to a flat block (a gauge block is recommended). Second, reset the Z axis position display to zero. Third, back the spindle off and load a tool. Fourth, bring the

tool tip to the block. The tool's length will be shown on the Z axis display.

To measure off line, of course, requires some kind of measuring tool. Parlec, Kennemetal, and other manufacturers can supply them. Purchased tool length measuring devices are great (but somewhat expensive) since they have easy-to-read digital readouts and can be quickly calibrated. However, you can easily make your own tool length measuring device using a simple height-gauge.

With whichever device you use to measure tool lengths off line, you must take into consideration the small gap that occurs between the spindle nose and the flange of the tool holder. The best way to do so is to make or buy a tool holder pot that locates the tool holder (at a tool bench) in the same way that the spindle locates the tool in the machine. This way, the gap will be the same for each device, and you'll be able to zero the height-gauge at the face of the tool pot.

M01

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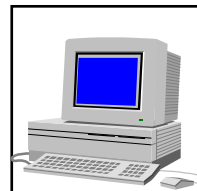
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