



## PROGRAMMING COURSE

**Course title : T6 Turning Course Training Module for Fanuc Controls.  
OTT/16TT/18TT/21TT /30T.**

**Twin Spindle, Twin Turret with Upper Rotating B Axis.**

**Course length : 3 days Course cost : £450.00 (+ VAT)**

### Day 1: Wednesday

#### Start Time

#### Finish Time

Tool Offset & Cutter Compensation on Main & Sub Spindle using Lower Turret.  
Using Wait Codes M900~M999.  
Spindle Control & M codes.  
Passover Program OR Tailstock Use.  
Synchronise Spindles for Support or Steady.  
G131 Soft Push & G300 Soft Pull.  
G54~G59 Use of Work Co-ordinates.  
Orientation of Spindles for C Axis Work.  
C Axis Drilling on Main & Sub Spindle using Lower Turret.  
C Axis Milling on Main & Sub Spindle using Lower Turret.  
Program Examples using the above information.

9:30 AM

5:00 PM

### Day 2: Thursday

#### Start Time

#### Finish Time

G400 Tool Offset Comp on Main & Sub Spindle using Upper B Axis Turret.  
Using a Multi Turret on Upper B Axis Turret.  
G41 & G42 Tool Cutter Radius Comp on Main & Sub Spindle using Upper B Axis Turret.  
G490 Orientation of Spindle on Upper B axis Turret.  
C Axis Drilling on Main & Sub Spindle using Upper B Axis Turret.  
C Axis Milling on Main & Sub Spindle using Upper B Axis Turret.  
Y Axis Drilling on Main & Sub Spindle using Upper B Axis Turret.  
Y Axis Thread Milling on Main & Sub Spindle using Upper B Axis Turret.  
Program Examples using the above information.

9:00 AM

5:00 PM

### Day 3: Friday

#### Start Time

#### Finish Time

3 Dimensional Co-Ord Rotation G368 on Main & Sub Spindle using Upper Baxis Turret.  
G490 Orientation of Spindle on Upper Turret.  
B Axis Drilling Co-Ord Rotation G368 on Main & Sub Spindle using Upper B Axis Turret.  
B Axis Milling Co-Ord Rotation G368 on Main & Sub Spindle using Upper B Axis Turret.  
Y Axis Thread Milling on Main & Sub Spindle using Upper Turrets.  
Program Examples using the above information.

9:00 AM

3:00 PM

NB 1: Machine availability for use on examples will vary and will be advised upon on the day.

NB 2: T6 course follows on from the T1, T2, T3 & T4 Turning Courses and all four courses may be required.