

CNC Programming Circles (360°)

G02 = Circular Interpolation (Clockwise)

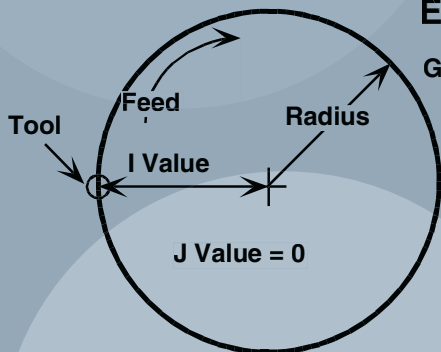
G03 = Circular Interpolation (Counterclockwise)

Information required:

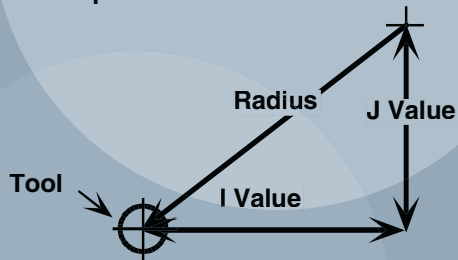
1. Select G02 or G03
2. Center point of Circle: I and J (or K) values
Determine Radius of Circle; Sign (+ or -)
Indicates Direction of Center from Tool Position.
3. Feed Rate: F address

Example A

G02 I(R) F100;

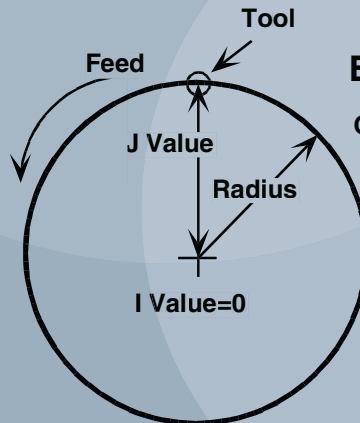


The Radius of the Circle is The Hypotenuse of the I-J-R Right Triangle. If the Center is Exactly On The X or Y Axis, Then I or J Is Equal to the Radius.



Example B

G03 J(-R) F100;



Example C

G02 I___ J___ F100;

