3-4   Types of the Milling Unit

The milling unit is available in the following three types:

- Point machining unit ...... used for drilling of holes (Section 3-5)
- Line machining unit .... used for a contour machining (Section 3-6)
- Face machining unit ...... used for machining an area and machining form (Section 3-7)

Each milling unit includes tool sequence and shape sequence.
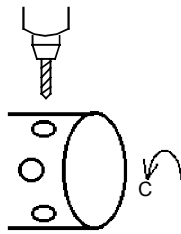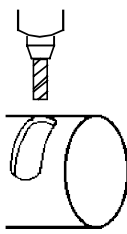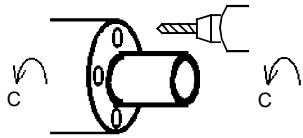
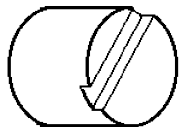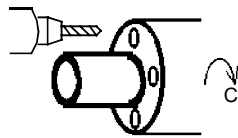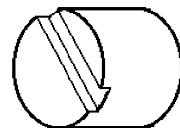### 3-4-1   Planes to be machined and machining methods

Data items for setting the plane to be machined and for setting the machining method exist in all point, linear, and face machining unit data. These data items are displayed as **MODE** and **POS-C**.
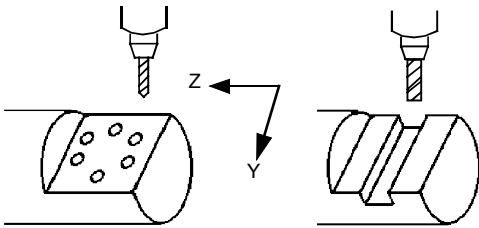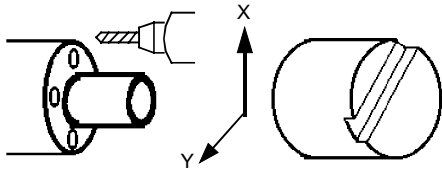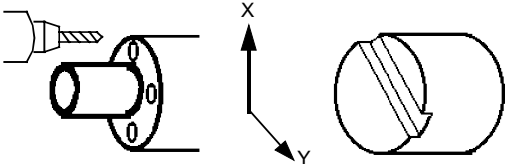
Specify the desired plane and method under the **MODE** and **POS-C** columns.

```
UNo.     UNIT       MODE         POS-C       DIA       DEPTH      CHMF
         DRILLING   [1]          [2]
```

[1] MODE

Select the machining method.

Mode	Description
ZC	Cylindrical sides can be machined into the desired shape as specified in the Z-C coordinate system. (C-axial machining) **Note:** If C-axis function for No. 2 spindle is available, the line machining can be executed on the No. 2 spindle as well.
XC	Edges can be machined into the desired shape as specified in the R-C or X-Y coordinate system. (C-axial machining)
XC	Rear plane can be machined into the desired shape as specified in the R-C or X-Y coordinate system. (C-axial machining) **Note:** The line machining is possible only if the machine has C-axis function for No. 2 spindle.

Mode	Description
ZY	Plane of cylinder can be machined into the desired shape as specified in the Z-Y coordinate system. (Y-axial machining)
XY	Edges can be machined into the desired shape as specified in the X-Y or R-C coordinate system. (Y-axial machining)
XY	Rear plane can be machined into the desired shape as specified in the X-Y or R-C coordinate system. (Y-axial machining)

The XC or XY mode can be selected for a machine model capable of back machining.

Note: The **ZC**, **XC** or XC mode cannot be selected for a face machining unit.

[2] POS-C

Specify the position of the C-axis.

This data item will become valid when the **ZY**, **XY** or XY mode is selected.