

## HOW TO USE FANUC “AICC” & “AI APC” FUCNTION

AICC – AI Contour Control or Simple HPCC

AI APC – Advance Preview

Fadal machine with Fanuc 18i-5MB or 0i-MC CNC comes with AICC function standard. AICC is an advanced processing feature that provides higher cutting feedrate while maintaining contouring accuracy. When this function is in effect, you will see “AICC” blinking in the lower right corner of the screen.

Hyundai VX400 and VX500 come with AI APC function, it is similar to AICC function, intended to increase the contouring smoothness and accuracy. When this function is in effect, you will see “AI APC” blinking in the lower right corner of the screen.

Application Case 1: *In 2D contouring, it addresses the typical corner rounding or overshoot problems when feed rate is high or feature is small.*

Applications Case 2: *When 3D surfacing this function will keep the contouring profile more accurate.*

Example:

G00G90G17G40G49 Safety block

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M6T1

Call Tool #1

M3S5000

Spindle on

M7

Coolant on

**G05.1 Q1 R5**

Turn on AICC (R5 is optional, Can be R1~R10, From smooth to accurate)

G54G0X10.Y10.

Positioning

G43H1Z0.1

Rapid down

G1 Z-.0375 F25.

Feed in

G1X9.Y9.F50.

Start cutting

G2...

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G0Z0.1

Retract

**G05.1Q0**

Turn off AICC

M5

Spindle off

M9

Coolant off

G49

Cancel tool height

G91G28Z0

Return to machine home

G90

Recover to absolute mode

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Repeat the format for different tools

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Note:

1. Make sure G49 is called before the execution of G05.1 Q1
2. AICC and AI APC need to be turned on and off for each tool.