

/_N_UKS_DIR/_N_UEBUNG_10_LABELS_UPD/_N_UEBUNG_10_LABELS_MPF

N10 WORKPIECE(,,, "CYLINDER", 192, 1, -80, -62, 80)
N20 ;Übung10_LABELS
N30 ;041112 Christiani Team
N40 UJP
N50 G54 G90 G26 S3000
N60; Plandrehen auf Länge 80mm
N70 T="A_SCHRUPP_80_0.8"
N80 M6
N90 G96 S500 F0.2 M4 M8
N100 G0 X82 Z0
N110 G1 X-1.6
N120 G1 Z1
N130 G0 X82
N140; Vordrehen der Kontur
N150 G96 S450 F0.4

N160 CYCLE62(, 2, "AK_ANF", "AK_ENDE")

N170 CYCLE952("FKA_UE10_1", , "", 2101311, 0.4, 0.2, 0, 3, 0.1, 0.1, 0.5, 1, 0.1, 0, 1, 1, 1, , , ,
, 2, 2, , , 0, 1, , 0, 12, 100010, 1, 0)
N180 UJP
N190 T="A_SCHLICHT_55_0.8"
N200 M6
N210; Schlichten der Kontur
N220 G96 S550 F0.1 M4 M8
N230 G42
N240 AK_ANF: G0 X16 Z1
N250 G1 X20 Z-1
N260 G1 Z-20
N270 G2 X40 Z-30 CR=10
N280 G3 X60 Z-40 CR=10
N290 G1 Z-50
N300 G2 X80 Z-60 CR=10
N310 AK_ENDE: G1 X82
N320 G40
N330 UJP
N340 M30