

/\_N\_UKS\_DIR/\_N\_UTEDERHOL\_6\_UPD/\_N\_UTEDERHOL\_6\_MPF

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N10 WORKPIECE(, , , "CYLINDER", 192, 1, -115, -95, 60)  
N20; Wiederholaufgabe 6  
N30 ;101112 Christiani TeamN  
N40 UJP  
N50 G54 G90 G26 S3000  
N60; Plandrehen auf Länge 115mm  
N70 T="A\_SCHRUPP\_80\_0.8"  
N80 G0 X62 Z0  
N90 G1 X-1.6  
N100 G1 Z1  
N110 G0 X62  
N120; Vordrehen der Kontur  
N130 G96 S450 F0.4  
N140 CYCLE62(, 2, "AK\_ANF", "AK\_ENDE")  
  
N150 CYCLE952("FKA\_UA6\_1", , , "", 2101311, 0.4, 0.2, 0, 3, 0.1, 0.1, 0.5, 1, 0.1, 0, 1, 1, 0.5, , ,  
, , 2, 2, , , 0, 1, , 0, 12, 100010, 1, 0)  
  
N160 UJP  
N170; Schlichten der Kontur  
N180 T="A\_SCHLICHT\_55\_0.8"  
N190 M6  
N200 G42  
N210 G0 X7 Z1  
N220 AK\_ANF: G1 X15 Z-3  
N230 G1 X20 Z-33  
N240 G1 X38 Z-48  
N250 G1 Z-72 RND=2  
N260 G1 X46  
N270 G1 Z-85 CHF=1.5  
N280 G1 X54  
N290 G3 X60 Z-88 CR=3  
N300 AK\_ENDE: G1 X62  
N310 G40  
N320 UJP  
N330 M30