

/\_N\_UKS\_DIR/\_N\_UEBUNG\_11\_UPD/\_N\_UEBUNG\_11\_MPF

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N10 WORKPIECE(,,, "CYLINDER", 192, 1, -80, -62, 80)  
N20 ; Übung11  
N30 ; 041112 Christiani Team  
N40 WJP  
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 F0.5  
  
N160 CYCLE62("FKA\_UE11", 0, , )  
  
N170 CYCLE952("FKA\_UE11\_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 WJP  
N190 T="A\_SCHLICHT\_55\_0.8"  
N200 M6  
N210; Schlichten der Kontur  
N220 G96 S550 F0.1 M4 M8  
N230 G42  
N240 FKA\_UE11  
N250 G40  
N260 WJP  
N270 M30