

/\_N\_UKS\_DIR/\_N\_UEBUNG\_12\_UPD/\_N\_UEBUNG\_12\_MPF

---

N10 WORKPIECE(,,, "CYLINDER", 192, 1, -180, -130, 100)  
N20 ; Übung12  
N30 ; 041112 Christiani Team  
N40 WUP  
N50 G54 G90 G26 S3000  
N60 ; Plandrehen auf Länge 160mm  
N70 T="A\_SCHRUPP\_35\_0.8"  
N80 M6  
N90 G96 S250 F0.2 M4 M8  
N100 G0 X102 Z0  
N110 G1 X-1.6  
N120 G1 Z1  
N130 G0 X102  
N140; Vordrehen der Kontur  
N150 G96 S230 F0.4  
N160 CYCLE62("FKA\_UE12", 0, , )  
N170 CYCLE952("FKA\_UE12\_1", , "" , 1101311, 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 WUP  
N190; Schlichten der Kontur  
N200 T="A\_SCHLICHT\_35\_0.3"  
N210 M6  
N220 G96 S260 F0.1 M4 M8  
N230 G42  
N240 FKA\_UE12  
N250 G40  
N260 WUP  
N270 M30