

/_N_UKS_DIR/_N_UEBUNG_13_UPD/_N_UEBUNG_13_MPF

N10 WORKPIECE(,,, "CYLINDER", 192, 1, -76, -55, 58)
N20; Übung_13
N30; 041112 Christiani Team
N40 UJP
N50 G54 G90 G26 S3000
N60; Plandrehen auf Länge 76 mm
N70 T="A_SCHRUPP_80_0.8"
N80 M6
N90 G96 S220 F0.2 M4
N100 G0 X60 Z0
N110 G1 X-1.6
N120 G1 Z2
N130 G0 X60
N140; Vordrehen der Kontur
N150 G96 S180 F0.4

N160 CYCLE62("FKA_UE13", 0, ,)

N170 CYCLE952("FKA_UE_13_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_35_0.3"
N200 M6
N210; Schlichten der Kontur
N220 G96 S230 F0.1 M4
N230 G42
N240 FKA_UE13
N250 G40
N260; Anfertigen Gewindefreistich DIN 76 Form A
N270 G0 X40 Z-15

N280 CYCLE940(16, -25, "A", 1, 1, 0.1, 13, , , , 30, 20, 2.5, 0.1, 0.1, 0.1, 13, , , 2, 1000)
N290 UJP
N300; Anfertigen Einstich Breite 6mm
N310T="STECHE_2.0"
N320 M6
N330 G96 S180 F0.1 M4

N340 CYCLE930(35, -30, 6, 6, 25, , 0, 0, 0, 1, 0, 0, 1, 0.2, 0, 1, 10530, , 1, 30, 0.1, 1, 0.2, 0.2, 2, 1
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N350 UJP
N360 M30