

/_N_UKS_DIR/_N_UEBUNG_8_UPD/_N_UEBUNG_8_MPF

N10 WORKPIECE(, , , "CYLINDER", 192, 1, -110, -70, 50)

N20; Übung 8

N30; 07112012

N40 UJP

N50 G54 G90 G26 S3000

N60; Plandrehen auf Länge 110

N70 T="A_SCHRUPP_80_0.8"

N80 M6

N90 G96 S250 F0.2 M4 M8

N100 G0 X52 Z0

N110 G1 X-1.6

N120 G1 Z1

N130 G0 X52

N140; Vordrehen der Kontur

N150 F0.4 S230

N160 CYCLE62("FKA_UE8", 0, , ,)

N170 CYCLE952("FKA_UE8_1", , "", 2101311, 0.4, 0, 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 F0.1 S260 M4 M8

N230 G42

N240 FKA_UE8

N250 G40

N260 UJP

N270 M30