



/_N_WKS_DIR/_N_UEBUNG_14_WPD/_N_UEBUNG_14_MPF

N10 WORKPIECE(, , , "CYLINDER", 192, 1, -65, -45, 90)
N20 ; Übung 14
N30 ; 041109 Christiani Team
N40 WWP
N50 G54 G90 G26 S3000
N60 ; Plandrehen auf Länge 65mm
N70 T="A_SCHRUPP_55_0.8"
N80 M6
N90 G96 S250 F0.2 M4 M8
N100 G0 X92 Z0
N110 G1 X-1.6
N120 G1 Z1
N130 G0 X85
N140 G42
N150 G1 X92 Z-2.5
N160 WWP
N170 ; Vorbohren Durchmesser 33mm auf Durchmesser 30mm
; NCG#CYC82#\CST.DIR\bohren.com#NC1#2#*NCG;*RO*;*HD*
; #1#1#1#2#1###"M3"###1##1#*NCG;*RO*;*HD*
; #END#*NCG;*RO*;*HD*
N180 T="WP_BOHRER_30"
N190 M6
N200 G97 S850 F0.4 M4 M8
N210 G17
N220 G0 X0 Z2
N230 CYCLE82(2,0,1, , 66,0,0,0,1,21)
N240 WWP
N250 ; Vordrehen der Innenkontur
N260 T="I_SCHRUPP_35_0.8"
N270 M6
N280 G96 S230 F0.3 M4 M8
N290 CYCLE62("FKI_UE14", 0, ,)
N300 CYCLE952("FKI_UE14_1", , , , , 1112311, 0.4, 0.1, 0, 2, 0.1, 0.1, 0.5, 1, 0.5, 0, 1, 0.1,
0.1, , , , , 2, 2, , , 8, 1, , 0, 12, 1100010, 1, 0)
N310 WWP
N320 ; Schlichten der Innenkontur
N330 T="I_SCHLICHT_35_0.3"
N340 M6
N350 G96 S260 F0.1 M4 M8
N360 G41
N370 FKI_UE14
N380 G0 Z2
N390 WWP
N400 M30