

/_N_UKS_DIR/_N_UEBUNG_15_UPD/_N_UEBUNG_15_MPF

N10 WORKPIECE(,,, "CYLINDER", 192, 1, -100, -85, 120)
N20 ; Übung 15
N30 ; 041109 Christiani Team
N40 WJP
N50 G54 G90 G26 S3000
N60 ; Plandrehen auf Länge 100mm
N70 T="A_SCHRUPP_35_0.3"
N80 M6
N90 G96 S220 F0.2 M4
N100 G0 X122 Z0
N110 G1 X-1.6
N120 G1 Z1
N130; Vorbereitung der Aussenkontur
N140 G0 X121

N150 CYCLE62("FKA_UE15", 0, ,)
N160 CYCLE952("FKA_UE15_1", , "", 1111311, 0.4, 0.1, 0, 3, 0.1, 0.1, 0.5, 1, 0.5, 0, 1, 1, 1, , , ,
2, 2, , , 0, 1, , 0, 12, 1100010, 1, 0)
N170 WJP
N180 ; Vorbohren der Innenkontur Durchmesser 30mm
N190 T="UP_BOHRER_30"
N200 M6
N210 G97 S850 F0.4 M4
N220 G17
N230 G0 X0 Z2
N240 CYCLE82(2, 0, 1, , -40, 1, 0, 1, 21)
N250 WJP
N260 ; Vorbereitung der Innenkontur
N270 T="I_SCHRUPP_35_0.8"
N280 M6
N290 G96 S400 F0.15 M4
N300 G0 X30 Z2
N310 CYCLE62("FKI_UE15", 0, ,)

N320 CYCLE952("FKA_UE15_1", , "", 1112311, 0.4, 0.1, -1, 2, 0.1, 0.1, 0.5, 1, 0.5, 0, 1, 1, 1, , , ,
2, 2, , , 0, 1, , 0, 12, 1100010, 1, 0)
N330 WJP
N340 ; Fertigbearbeitung der Aussenkontur
N350 T="A_SCHLICHT_35_0.3"
N360 M6
N370 G96 S230 F0.1 M4
N380 G42
N390 FKA_UE15
N400 WJP
N410 ; Fertigbearbeitung der Innenkontur
N420 T="I_SCHLICHT_35_0.3"
N430 M6
N440 G96 S450 F0.15 M4
N450 CYCLE62("FKI_UE15", 0, ,)

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N460 CYCLE952("FKI_UE15_2",, "", 1112321, 0.4, 0.1, -30, 2, 0.1, 0.1, 0.5, 1, 0.5, 0, 1, 1, 1, ,
,, , 2, 2, , , 0, 1, , 0, 12, 1100010, 1, 0)

N470 UJP

N480 ; Anfertigen Freistich Breite 4mm

N490 T="STECHE_3.0"

N500 M6

N510 G96 S180 F0.1 M4

N520 G0 X110 Z-60

N530 CYCLE930(100, -62, 4, 4, 90, , 0, 0, 0, 1, 0, 0, 1, 0.2, 0, 1, 10530, , 1, 30, 0.1, 1, 0.2, 0.2, 2,
1111100)

N540 UJP

N550 ; Anfertigen Gewinde M8x1.5 mit Vc konstant

N560 T="A_GEWINDE_METR"

N570 M6

N580 G96 S150 M3

N590 CYCLE99(0, 84, -19, , 4.5, 3, 0.92016, 0, 29.8, 0, 4, 2, 1.5, 1310103, 4, 2, 0.3, 0.5, 0, 0, 1,
0, 0.526981, 1, , , , 102, 1)

N600 UJP

N610 M30