

/\_N\_UKS\_DIR/\_N\_UEBUNG\_17\_UPD/\_N\_UEBUNG\_17\_MPF

---

N10 UORKPIECE(,,, "BOX", 112, 0, -20, -80, 0, 0, 150, -150)  
N20 ; Uebung\_17  
N30 ; 041109 Christiani Team  
N40 G17 G54 G64 G90 G94  
N50 G0 Z200  
N60 UJP  
N70; Anfertigen Außenkontur Tiefe 10 mm mit Schaftfräser Ø 25 mm  
N80 T="SCHAFTFR\_25"  
N90 M6  
N100 G97 S2546 F916 M3 M8  
N110 G0 X60 Y37  
N120 G0 Z-10  
N130 G247 G41 DISR=20 X60 Y-8  
N140 G1 X115  
N150 G2 X115 Y-58 CR=25  
N160 G3 X115 Y-98 CR=20  
N170 G1 X142 RND=12  
N180 G1 Y-142 RND=10  
N190 G1 X85  
N200 G1 Y-127  
N210 G3 X55 Y-127 CR=15  
N220 G1 Y-142  
N230 G1 X16.556  
N240 G2 X16.556 Y-8 CR=200  
N250 G1 X60  
N260 G248 G40 DISR=20 X60 Y37  
N270 UJP  
N280 ; Anfertigen Innenkontur Tiefe 10 mm mit Schaftfräser Ø 16 mm  
N290 T="LANGLFR\_16"  
N300 M6  
N310 G97 S3979 F716 M3 M8  
N320 G0 X60 Y-50  
N330 G0 Z-7  
N340 G1 Z-10  
N350 G247 G41 DISR=5 X60 Y-20  
N360 G3 I0 J-20  
N370 G248 G40 DISR=5 X60 Y-50  
N380 G0 Z2  
N390 UJP  
N400 M30