

/_N_UKS_DIR/_N_UEBUNG_19_UPD/_N_UEBUNG_19_MPF

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N10 WORKPIECE(,,, "BOX", 112, 10, -20, -80, 0, 0, 90, 110)
N20 ; Uebung_19
N30 ; 041109 Christiani Team
N40 G17 G54 G64 G90 G94
N50 G0 Z200
N60 WJP
N70;Vorbearb.der Außenkontur Aufmaß in allen Achsen 2mm Eckfr 80mm
N80 T="ECKFR_80_V"
N90 M6
N100 G97 S796 F860 M3 M8
N110 G0 X-20 Y150
N120 G0 Z2
N130 OFFN=2
N140 ANF_FKA_UE19: G42
N150 G1 X30
N160 G1 Y50
N170 G1 X150
N180 ENDE_FKA_UE19: G40
N190 WJP
N200 ; Fertigbearbeitung der Außenkontur mit Eckfräser 80 mm
N210 T="ECKFR_80_F"
N220 M6
N230 G97 S1075 F645 M3 M8
N240 G0 X-20 Y150
N250 G0 Z0
N260 OFFN=0
N270 REPEAT ANF_FKA_UE19 ENDE_FKA_UE19
N280 WJP
N290 ; Anfertigen aller Zentrierbohrungen mit NC-Anbohrer
N300 T="ANBOHRER_12"
N310 M6
N320 G60 G97 S3858 F580 M3 M8

N330 MCALL CYCLE81(2, 0, 2, 6.6, , 0, 10, 1, 21)
N340 BOHRBILD_1
N350 MCALL
N360 G0 Z12

N370 MCALL CYCLE81(12, 10, 2, 6.6, , 0, 10, 1, 21)
N380 BOHRBILD_2
N390 MCALL

N400 MCALL CYCLE81(12, 0, 2, 7, , 0, 10, 1, 21)
N410 BOHRBILD_3
N420 MCALL

N430 MCALL CYCLE81(12, 10, 2, 7, , 0, 10, 1, 21)
N440 BOHRBILD_4
N450 MCALL
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N460 UJP

N470 ; Anfertigen Kernlochb.für Gewinde M6 mit Bohrb.1 und Bohrb.2

N480 T="SPIBO_5"

N490 M6

N500 G60 G97 S1910 F210 M3 M8

N510 MCALL CYCLE83(2, 0, 2, -14, , -5, , 100, 0, 0.5, 100, 0, 0, 5, 0.1, 1, 1.6, 0, 1, 12222122)

N520 BOHRBILD_1

N530 MCALL

N540 G0 Z12

N550 MCALL CYCLE83(12, 10, 2, -4, , -5, , 100, 0, 0.5, 100, 0, 0, 5, 0.1, 1, 1.6, 0, 1, 12222122)

N560 BOHRBILD_2

N570 MCALL

N580 UJP

N590 ; Anfertigen Bohrungen D 6 mm mit Bohrbild_3 und Bohrbild_4

N600 T="SPIBO_6"

N610 M6

N620 G60 G97 S1592 F191 M3 M8

N630 MCALL CYCLE83(12, 0, 2, -12, , -5, , 100, 0, 0.5, 100, 0, 0, 5, 0.1, 1, 1.6, 0, 1, 12222122)

N640 BOHRBILD_3

N650 MCALL

N660 MCALL CYCLE83(12, 10, 2, -2, , -5, , 100, 0, 0.5, 100, 0, 0, 5, 0.1, 1, 1.6, 0, 1, 12222122)

N670 BOHRBILD_4

N680 MCALL

N690 UJP

N700 ; Anfertigen Gewindebohrungen M6 mit Bohrbild_1 und Bohrbild_2

N710 T="GEUBO_M6"

N720 M6

N730 G60 G97 S796 M3 M8

N740 MCALL CYCLE84(2, 0, 2, -12, , 0, 4, , 1, 0, 798, 1000, 0, 1, 0, 0, 5, 1.4, , "ISO_METRIC", "M6", , 1001, 2001002)

N750 BOHRBILD_1

N760 MCALL

N770 G0 Z12

N780 MCALL CYCLE84(12, 10, 2, -2, , 0, 4, , 1, 0, 798, 1000, 0, 1, 0, 0, 5, 1.4, , "ISO_METRIC", "M6", , 1001, 2001002)

N790 BOHRBILD_2

N800 MCALL

N810 UJP

N820 M30