

/_N_UKS_DIR/_N_UEBUNG_20_UPD/_N_UEBUNG_20_MPF

N10 UORKPIECE(,,, "BOX", 112, 0, -20, -80, 0, 0, 150, -150)

N20 ; Uebung_20

N30 ; 041109 Christiani Team

N40 G17 G54 G64 G90 G94

N50 G0 Z200

N60 UJP

N70 ; Herstellen Rechtecktaschen I, II, IV mit Langlfr_10

N80 T="LANGLFR_10"

N90 M6

N100 G97 S4138 F827 M3

N110 G0 X115 Y-22.5 Z2

N120 POCKET3(2, 0, 1, -5, 50, 25, 8, 115, -22.5, 0, 2, 0.5, 0.5, 827, 827, 0, 11, 6.6, , , , 0, , 0, , , 1100, 11, 0)

N130 G97 S4615 F923

N140 POCKET3(2, 0, 1, -5, 50, 25, 8, 115, -22.5, 0, 2, 0.5, 0.5, 923, 923, 0, 12, 6.6, , , , 0, , 0, , , 1100, 11, 0)

N150 G97 S4138 F827

N160 POCKET3(2, -5, 1, -10, 40, 15, 6, 115, -22.5, 0, 2, 0.5, 0.5, 827, 827, 0, 11, 6.6, , , , 0, , 0, , , 1100, 11, 0)

N170 G97 S4615 F923

N180 POCKET3(2, -5, 1, -10, 40, 15, 6, 115, -22.5, 0, 2, 0.5, 0.5, 923, 923, 0, 12, 6.6, , , , 0, , 0, , , 1100, 11, 0)

N190 G97 S4138 F827

N200 POCKET3(2, 0, 1, -5, 40, 24, 6, 75, -125, 20, 2, 0.5, 0.5, 827, 827, 0, 11, 6.6, , , , 0, , 0, , , 1100, 11, 0)

N210 G97 S4615 F923

N220 POCKET3(2, 0, 1, -5, 40, 24, 6, 75, -125, 20, 2, 0.5, 0.5, 923, 923, 0, 12, 6.6, , , , 0, , 0, , , 1100, 11, 0)

N230 UJP

N240 ; ANFERTIGEN KREISTASCHE III MIT LANGLFR_20

N250 T="LANGLFR_20"

N260 M6

N270 G97 S2069 F827 M3

N280 G0 X75 Y-75 Z2

N290 POCKET4(2, 0, 1, -4, 40, 75, -75, 2, 0.5, 0.5, 827, 827, 0, 11, 13.2, 9, 15, 0, 2, 0, 1, 2, 10100, 111, 100)

N300 G97 S2307 F923 M3

N310 POCKET4(2, 0, 1, -4, 40, 75, -75, 2, 0.5, 0.5, 923, 923, 0, 12, 13.2, 9, 15, 0, 2, 0, 1, 2, 10100, 111, 100)

N320 UJP

N330 ; ZENTRIEREN ALLER BOHRUNGEN MIT NC-ANBOHRER 12MM

/_N_UKS_DIR/_N_UEBUNG_20_UPD/_N_UEBUNG_20_MPF

N340 T="ANBOHRER_12"

N350 M6

N360 G97 S5092 F582 M3

N370 G0 X0 Y0

N380 MCALL CYCLE81(2, 0, 1, 6, , 0, 10, 1, 21)

N390 BOHRBILD_1

N400 BOHRBILD_2

N410 MCALL

N420 MCALL CYCLE81(2, -5, 1, 6, , 0, 10, 1, 21)

N430 BOHRBILD_3

N440 MCALL

N450 UJP

N460 ; BOHREN ALLER BOHRUNGEN MIT SPIRALBOHRER 5MM

N470 T="SPIBO_5"

N480 M6

N490 G97 S1273 F152 M3

N500 G0 X0 Y0

N510 MCALL CYCLE83(2, 0, 1, -22, , -5, , 100, 0, 1, 100, 1, 0, 5, 0.1, 0, 1.6, 10, 1, 12222222)

N520 BOHRBILD_1

N530 BOHRBILD_2

N540 MCALL

N550 MCALL CYCLE83(2, -5, 1, -22, , -10, , 100, 0, 1, 100, 1, 0, 5, 0.1, 0, 1.6, 10, 1, 12222222)

N560 BOHRBILD_3

N570 UJP

N580 M30