

/\_N\_UKS\_DIR/\_N\_UEBUNG\_21\_UPD/\_N\_UEBUNG\_21\_MPF

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N10 WORKPIECE(, , , "BOX", 112, 0, -16, -80, 0, 0, 120, 90)

N20 ; Uebung\_21

N30 ; 040810 Christiani Team

N40 G17 G54 G64 G90 G94

N50 G0 Z200

N60 UJP

N70 ; Herstellen der Langlöcher I, II, III und IV mit LANGLFR\_8

N80 T="LANGLFR\_8"

N90 M6

N100 G97 S10544 F1687 M3 M8

N110 G0 X42 Y75 Z2

N120 MCALL LONGHOLE(2, 0, 1, , 16.5, 1, 18, 42, 75, 5, -90, 0, 1687, 1687, 3, 1, 0, 1100, 1011, 1)

N130 G0 X42 Y75

N140 G0 X78 Y25

N150 MCALL

N160 MCALL LONGHOLE(2, 0, 1, , 16.5, 1, 33, 42, 75, 5, 0, 0, 1687, 1687, 3, 1, 0, 1100, 1011, 1)

N170 G0 X27 Y15

N180 G0 X68 Y75

N190 MCALL

N200 UJP

N210 ; ANFERTIGEN NUTEN 1, 2 UND 3 MIT LANGLFR\_10

N220 T="LANGLFR\_10"

N230 M6

N240 G97 S7321 F1464 M3 M8

N250 G0 X15 Y45 Z2

N260 MCALL SLOT1(2, 0, 1, -2.5, , 1, 46, 16, 0, 0, 5, 90, 0, 1464, 1464, 2.5, 0, 0.5, 11, 0.1, 15, 15, 0.5, 0, 2, 0, 1, 2, 1100, 1011, 102)

N270 G0 X15 Y45

N280 G0 X105 Y15

N290 MCALL

N300 MCALL SLOT1(2, 0, 1, -2.5, , 1, 46, 16, 0, 0, 5, 90, 0, 1687, 1687, 2.5, 0, 0.5, 12, 0.1, 15, 15, 0.5, 0, 2, 0, 1, 2, 1100, 1011, 102)

N310 G0 X15 Y45

N320 G0 X105 Y15

N330 MCALL

N340 SLOT1(2, 0, 1, -1.5, , 1, 106, 16, 15, 45, 5, 0, 0, 1464, 1464, 1.5, 0, 0.5, 11, 0.1, 15, 15, 0.5, 0, 2, 0, 1, 2, 1100, 1011, 102)

N350 SLOT1(2, 0, 1, -1.5, , 1, 106, 16, 15, 45, 5, 0, 0, 1687, 1687, 1.5, 0, 0.5, 12, 0.1, 15, 15, 0.5, 0, 2, 0, 1, 2, 1100, 1011, 102)

N360 UJP

N370 M30