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041163 (Stirling Support palier PH 30)
(CN HAAS)
(T01 FORET A POINTER DIA=4 A 90 DEGRES)
(T02 FORET DIA=3.5 A 120 DEGRES)
(T03 FORET DIA=5.8 A 120 DEGRES)
(T04 FORET DIA=9 A 120 DEGRES)
(T05 ALESOIR DIA=6)
(T06 FRAISE DIA=6 CRO=0)
N1 G90 G99 G80 G40
N2 G54 (DECALAGE ORIGINE)
N3 G0 G53 Z0
N4 T01 M6
N5 S2000 M3
N6 G0 X9.5 Y-9. M8
N7 G43 H01 Z5.
N8 G81 X9.5 Y-9. Z-1.5 R5. F200.
N9 X17. Y-9.
N10 X72.5 Y-9.
N11 G0 G80 Z5.
N12 M9
N13 G0 G53 Z0 M5
N14 T02 M6
N15 S1637 M3
N16 G0 X9.5 Y-9. M8
N17 G43 H02 Z5.
N18 G83 X9.5 Y-9. Z-17. I4. J0.25 K3. R5. F131.
N19 G0 G80 Z5.
N20 M9
N21 G0 G53 Z0 M5
N22 T03 M6
N23 S1207 M3
N24 G0 X17. Y-9. M8
N25 G43 H03 Z5.
N26 G83 X17. Y-9. Z-17. I5. J0.5 K3. R5. F121.
N27 G0 G80 Z5.
N28 M9
N29 G0 G53 Z0 M5
N30 T04 M6
N31 S1000 M3
N32 G0 X72.5 Y-9. M8
N33 G43 H04 Z5.
N34 G83 X72.5 Y-9. Z-18. I3. J0.143 K2. R5. F100.
N35 G0 G80 Z5.
N36 M9
N37 G0 G53 Z0 M5
N38 T05 M6
N39 S637 M3
N40 G0 X17. Y-9. M8
N41 G43 H05 Z5.
N42 G85 X17. Y-9. Z-17. R5. F127.
N43 G0 G80 Z5.
N44 M9
N45 G0 G53 Z0 M5
N46 T06 M6
N47 S1061 M3
N48 G0 X72.5 Y-9. M8
N49 G43 H06 Z2.
N50 G1 Z-0.96 F50
N51 X73.9 F100
N52 G3 X71.1 Y-9. R1.4
N53 G3 X73.9 Y-9. R1.4
N54 G1 X74.8
N55 G3 X70.2 Y-9. R2.3
N56 G3 X74.8 Y-9. R2.3
N57 G1 X75.7
N58 G3 X69.3 Y-9. R3.2
N59 G3 X75.7 Y-9. R3.2
N60 G1 X75.9
N61 G3 X69.1 Y-9. R3.4
N62 G3 X75.9 Y-9. R3.4
N63 G1 X75.8
N64 G0 Z1.04
N65 X72.5
N66 G1 Z-1.92 F50

N67 X73.9 F100
N68 G3 X71.1 Y-9. R1.4
N69 G3 X73.9 Y-9. R1.4
N70 G1 X74.8
N71 G3 X70.2 Y-9. R2.3
N72 G3 X74.8 Y-9. R2.3
N73 G1 X75.7
N74 G3 X69.3 Y-9. R3.2
N75 G3 X75.7 Y-9. R3.2
N76 G1 X75.9
N77 G3 X69.1 Y-9. R3.4
N78 G3 X75.9 Y-9. R3.4
N79 G1 X75.8
N80 G0 Z0.08
N81 X72.5
N82 G1 Z-2.88 F50
N83 X73.9 F100
N84 G3 X71.1 Y-9. R1.4
N85 G3 X73.9 Y-9. R1.4
N86 G1 X74.8
N87 G3 X70.2 Y-9. R2.3
N88 G3 X74.8 Y-9. R2.3
N89 G1 X75.7
N90 G3 X69.3 Y-9. R3.2
N91 G3 X75.7 Y-9. R3.2
N92 G1 X75.9
N93 G3 X69.1 Y-9. R3.4
N94 G3 X75.9 Y-9. R3.4
N95 G1 X75.8
N96 G0 Z-0.88
N97 X72.5
N98 G1 Z-3.84 F50
N99 X73.9 F100
N100 G3 X71.1 Y-9. R1.4
N101 G3 X73.9 Y-9. R1.4
N102 G1 X74.8
N103 G3 X70.2 Y-9. R2.3
N104 G3 X74.8 Y-9. R2.3
N105 G1 X75.7
N106 G3 X69.3 Y-9. R3.2
N107 G3 X75.7 Y-9. R3.2
N108 G1 X75.9
N109 G3 X69.1 Y-9. R3.4
N110 G3 X75.9 Y-9. R3.4
N111 G1 X75.8
N112 G0 Z-1.84
N113 X72.5
N114 G1 Z-4.8 F50
N115 X73.9 F100
N116 G3 X71.1 Y-9. R1.4
N117 G3 X73.9 Y-9. R1.4
N118 G1 X74.8
N119 G3 X70.2 Y-9. R2.3
N120 G3 X74.8 Y-9. R2.3
N121 G1 X75.7
N122 G3 X69.3 Y-9. R3.2
N123 G3 X75.7 Y-9. R3.2
N124 G1 X75.9
N125 G3 X69.1 Y-9. R3.4
N126 G3 X75.9 Y-9. R3.4
N127 G1 X75.8
N128 G0 Z-2.8
N129 Z2.
N130 M9
N131 G0 G53 Z0 M5
N132 M30
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