

O04102
(CYLINDRE DE REFROIDISSEMENT)
(G81 Perçage court, 5-Trous)
(Origine = 54)
(No Outil = 2)
(S tr mn = 2000)
(Avance = 300.)
(Plan R = 5.)

T2 M06
G00 G90 G54 X6.717 Y6.717
S2000 M03
G43 H2 Z5. M08
G81 G98 Z-3. R5. F300.
X-6.717 Y6.717
X-6.717 Y-6.717
X6.717 Y-6.717
X0. Y0.
G00 G80 Z5. M09
G53 G90 Z0 M05
M01

(G83 Perçage Déburrage, 4-Trous)
(Origine = 54)
(No Outil = 3)
(S tr mn = 3200)
(Avance = 300.)

T3 M06
G00 G90 G54 X6.717 Y6.717
S3200 M03
G43 H3 Z5. M08
G83 G98 Z-12. Q2. R5. F300.
X-6.717 Y6.717
X-6.717 Y-6.717
X6.717 Y-6.717
G00 G80 Z5. M09
G53 G90 Z0 M05
M01

(G84 Taraudage pas a droite, 4-Trous)
(Origine = 54)
(No Outil = 7)
(S tr mn = 200)
(Plan R = 5.)

T7 M06
G00 G90 G54 X6.717 Y6.717
S200
G43 H7 Z5. M08
G84 G98 Z-8. R5. F100.
X-6.717 Y6.717
X-6.717 Y-6.717
X6.717 Y-6.717
G00 G80 Z5. M09
G53 G90 Z0 M05
M01

(G12 Poche: Multi passes axiales et radiales)
(Origine = 54)
(No Outil = 4)
(S tr mn = 500)
(Avance = 80.)
(Z approche = 10.)
(Z Début = 1.)
(X Centre = 0.)
(Y Centre = 0.)
(Profondeur = 18.25)
(I:R Entrée = 6.5)
(K:R poche = 6.65)
(Q:Passe = 0.5)
(L = 3)

T4 M06
G00 G90 G54 X0. Y0.
S500 M03
G43 H4 Z10. M08
Z2.
G12 G91 Z-6.417 I6.5 K6.65 Q0.5 L3 D20 F80.
G00 G90 Z10. M09
G53 Z0 M05
M01

(G81 Perçage court, 1-Trou)
(Origine = 54)
(No Outil = 2)
(S tr mn = 2000)
(Avance = 300)
(Plan R = 5.)

T2 M06
G00 G90 G54 X0. Y0.
S2000 M03
G43 H2 Z5. M08
G81 G98 Z-21.25 R5. F300.
G00 G80 Z5. M09
G53 G90 Z0 M05
M01

(G83 Perçage Déburrage, 1-Trou)
(Origine = 54)
(No Outil = 5)
(S tr mn = 2000)
(Avance = 320.)
(Plan R = 5.)
(Z Prof Perçage = -34.)
(Pas = 2.)
(X Pos No1 = 0.)
(Y Pos No1 = 0.)

T5 M06
G00 G90 G54 X0. Y0.
S2000 M03
G43 H5 Z5. M08
G83 G98 Z-34. Q2. R5. F320.
G00 G80 Z5. M09
G53 G90 Z0 M05
M01

(G81 Perçage court, 1-Trou)
(Origine = 54)
(No Outil = 6)
(S tr mn = 300)
(Avance = 0.08)
(Plan R = 5.)
(Z Prof Perçage = -34.)
(X Pos No1 = 0.)
(Y Pos No1 = 0.)

T6 M06
G00 G90 G54 X0. Y0.
S300 M03
G43 H6 Z5. M08
G81 G98 Z-34. R5. F60.
G00 G80 Z5. M09
G53 G90 Z0 M05
M01