

%  
O42081 (Bras G et D reprise parabole)  
(CN HAAS)  
(T01 FRAISE DIA=36 CRO=0)  
(T02 FRAISE DIA=14 CRO=0)  
(T03 FORET DIA=14 A 180 DEGRES)  
(T04 FORET A POINTER DIA=3 A 90 DEGRES)  
(T05 FORET DIA=2.5 A 120 DEGRES)  
(T06 TARA UD DIA=3 PAS=0.5)  
(T07 FORET DIA=4.2 A 120 DEGRES)  
(T08 TARA UD DIA=5 PAS=0.8)  
N1 G90 G99 G80 G40  
N2 G54 (DECALAGE ORIGINE)  
N3 G0 G53 Z0  
N4 T01 M6 (EBAUCHE SURFACAGE)  
N5 S2000 M3  
N6 G0 X-27. Y-1. M8  
N7 G43 H01 Z5.  
N8 Z-0.8  
N9 G1 X186. F200  
N10 Y-28.  
N11 X-9.  
N12 Y-55.  
N13 X186.  
N14 Y-79.  
N15 X-27.  
N16 G0 Z5.  
N17 Y-1.  
N18 Z-1.  
N19 G1 X186.  
N20 Y-28.  
N21 X-9.  
N22 Y-55.  
N23 X186.  
N24 Y-79.  
N25 X-27.  
N26 G0 Z5.

N27 M9  
N28 G0 G53 Z0 M5  
N29 T02 M6 (EBAUCHE PROFIL)  
N30 S600 M3  
N31 G0 X22. Y27.2 M8  
N32 G43 H02 Z20.  
N33 Z5.  
N34 G1 Z-2.96 F50  
N35 G42 D02 X32. Y9.879 F100  
N36 G2 X22. Y7.2 R20. F74  
N37 G3 X22. Y-51.2 R29.2 F100  
N38 G1 X172.  
N39 G3 X179.2 Y-44. R7.2  
N40 G1 Y0.  
N41 G3 X172. Y7.2 R7.2  
N42 G1 X22.  
N43 G2 X12. Y9.879 R20. F74  
N44 G1 G40 X22. Y27.2 F100  
N45 Z-5.92 F50  
N46 G42 D02 X32. Y9.879 F100  
N47 G2 X22. Y7.2 R20. F74  
N48 G3 X22. Y-51.2 R29.2 F100  
N49 G1 X172.  
N50 G3 X179.2 Y-44. R7.2  
N51 G1 Y0.  
N52 G3 X172. Y7.2 R7.2  
N53 G1 X22.  
N54 G2 X12. Y9.879 R20. F74  
N55 G1 G40 X22. Y27.2 F100  
N56 Z-8.88 F50  
N57 G42 D02 X32. Y9.879 F100  
N58 G2 X22. Y7.2 R20. F74  
N59 G3 X22. Y-51.2 R29.2 F100  
N60 G1 X172.  
N61 G3 X179.2 Y-44. R7.2  
N62 G1 Y0.  
N63 G3 X172. Y7.2 R7.2

N64 G1 X22.  
N65 G2 X12. Y9.879 R20. F74  
N66 G1 G40 X22. Y27.2 F100  
N67 Z-11.84 F50  
N68 G42 D02 X32. Y9.879 F100  
N69 G2 X22. Y7.2 R20. F74  
N70 G3 X22. Y-51.2 R29.2 F100  
N71 G1 X172.  
N72 G3 X179.2 Y-44. R7.2  
N73 G1 Y0.  
N74 G3 X172. Y7.2 R7.2  
N75 G1 X22.  
N76 G2 X12. Y9.879 R20. F74  
N77 G1 G40 X22. Y27.2 F100  
N78 Z-14.8 F50  
N79 G42 D02 X32. Y9.879 F100  
N80 G2 X22. Y7.2 R20. F74  
N81 G3 X22. Y-51.2 R29.2 F100  
N82 G1 X172.  
N83 G3 X179.2 Y-44. R7.2  
N84 G1 Y0.  
N85 G3 X172. Y7.2 R7.2  
N86 G1 X22.  
N87 G2 X12. Y9.879 R20. F74  
N88 G1 G40 X22. Y27.2 F100  
N89 G0 Z20.  
N90 Z20.  
(FINITION PROFIL)  
N91 G0 X22. Y27.  
N92 Z5.  
N93 G1 Z-15. F50  
N94 G42 D02 X32. Y9.679 F100  
N95 G2 X22. Y7. R20. F74  
N96 G3 X22. Y-51. R29. F100  
N97 G1 X172.  
N98 G3 X179. Y-44. R7.  
N99 G1 Y0.

N100 G3 X172. Y7. R7.  
N101 G1 X22.  
N102 G2 X12. Y9.679 R20. F74  
N103 G1 G40 X22. Y27. F100  
N104 G0 Z20.  
N105 M9  
N106 G0 G53 Z0 M5  
N107 T03 M6 (PERCA GE)  
N108 S600 M3  
N109 G0 X22. Y-22. M8  
N110 G43 H03 Z5.  
N111 G83 X22. Y-22. Z-18. I6. J1.1 K0.5 R5. F150.  
N112 G0 G80 Z5.  
N113 M9  
N114 G0 G53 Z0 M5  
N115 T02 M6 (EBAUCHE POCHE CIRCULAIRE N°1)  
N116 S600 M3  
N117 G0 X22. Y-22. M8  
N118 G43 H02 Z2.  
N119 G1 Z-2.7 F100  
N120 X25.8 F150  
N121 G3 X18.2 Y-22. R3.8  
N122 G3 X25.8 Y-22. R3.8  
N123 G1 X25.7  
N124 G0 Z-0.7  
N125 X22.  
N126 G1 Z-5.4 F100  
N127 X25.8 F150  
N128 G3 X18.2 Y-22. R3.8  
N129 G3 X25.8 Y-22. R3.8  
N130 G1 X25.7  
N131 G0 Z-3.4  
N132 X22.  
N133 G1 Z-8.1 F100  
N134 X25.8 F150  
N135 G3 X18.2 Y-22. R3.8  
N136 G3 X25.8 Y-22. R3.8

N137 G1 X25.7  
N138 G0 Z-6.1  
N139 X22.  
N140 G1 Z-10.8 F100  
N141 X25.8 F150  
N142 G3 X18.2 Y-22. R3.8  
N143 G3 X25.8 Y-22. R3.8  
N144 G1 X25.7  
N145 G0 Z-8.8  
N146 Z2.  
N147 Z2.  
(FINITION POCHE CIRCULAIRE N°1)  
N148 G0 X22. Y-22.  
N149 Z-8.8  
N150 G1 Z-11. F100  
N151 X25.8 F150  
N152 G3 X18.2 Y-22. R3.8  
N153 G3 X25.8 Y-22. R3.8  
N154 G1 X25.7  
N155 G0 Z2.  
N156 X24.  
N157 Z-9.  
N158 G1 Z-11. F100  
N159 G42 D02 X25.732 Y-21. F150  
N160 G2 X26. Y-22. R2. F33  
N161 G2 X22. Y-26. R4. F54  
N162 G2 X22. Y-18. R4.  
N163 G2 X26. Y-22. R4.  
N164 G2 X25.732 Y-23. R2. F33  
N165 G1 G40 X24. Y-22. F150  
N166 G0 Z2.  
N167 Z15.  
(EBAUCHE POCHE CIRCULAIRE N°2)  
N168 G0 X22. Y-22.  
N169 Z-6.  
N170 G1 Z-10.933 F100  
N171 X23.8 F150

N172 G3 X20.2 Y-22. R1.8  
N173 G3 X23.8 Y-22. R1.8  
N174 G1 X23.7  
N175 G0 Z-8.933  
N176 X22.  
N177 G1 Z-13.867 F100  
N178 X23.8 F150  
N179 G3 X20.2 Y-22. R1.8  
N180 G3 X23.8 Y-22. R1.8  
N181 G1 X23.7  
N182 G0 Z-11.867  
N183 X22.  
N184 G1 Z-16.8 F100  
N185 X23.8 F150  
N186 G3 X20.2 Y-22. R1.8  
N187 G3 X23.8 Y-22. R1.8  
N188 G1 X23.7  
N189 G0 Z-14.8  
N190 Z-6.  
N191 Z15.  
N192 Z15.  
(FINITION POCHE CIRCULAIRE N°2)  
N193 G0 X22. Y-22.  
N194 Z-6.  
N195 Z-14.8  
N196 G1 Z-17. F100  
N197 X23.8 F150  
N198 G3 X20.2 Y-22. R1.8  
N199 G3 X23.8 Y-22. R1.8  
N200 G1 X23.7  
N201 G0 Z-6.  
N202 X22.5  
N203 Z-15.  
N204 G1 Z-17. F100  
N205 G41 D02 X23.799 Y-22.75 F150  
N206 G3 X24. Y-22. R1.5 F26  
N207 G3 X22. Y-20. R2. F33

N208 G3 X22. Y-24. R2.  
N209 G3 X24. Y-22. R2.  
N210 G3 X23.799 Y-21.25 R1.5 F26  
N211 G1 G40 X22.5 Y-22. F150  
N212 G0 Z-6.  
N213 Z15.  
N214 M9  
N215 G0 G53 Z0 M5  
N216 T04 M6 (CENTRAGE)  
N217 S3000 M3  
N218 G0 X29.75 Y-8.577 M8  
N219 G43 H04 Z4.  
N220 G81 X29.75 Y-8.577 Z-3. R4. F600.  
N221 X6.5 Y-22.  
N222 X29.75 Y-35.423  
N223 G0 G80 Z4.  
N224 Z4.  
(CENTRAGE)  
N225 G0 X162. Y-22.  
N226 G81 X162. Y-22. Z-3. R4. F600.  
N227 G0 G80 Z4.  
N228 M9  
N229 G0 G53 Z0 M5  
N230 T05 M6 (PERCAGE)  
N231 S5000 M3  
N232 G0 X29.75 Y-8.577 M8  
N233 G43 H05 Z3.  
N234 G83 X29.75 Y-8.577 Z-17. I3. J0.25 K1. R3. F300.  
N235 X6.5 Y-22.  
N236 X29.75 Y-35.423  
N237 G0 G80 Z3.  
N238 M9  
N239 G0 G53 Z0 M5  
N240 T06 M6 (TARAUDAGE)  
N241 S200 M3  
N242 G0 X29.75 Y-8.577 M8  
N243 G43 H06 Z3.

N244 G84 X29.75 Y-8.577 Z-14. R3. F100.  
N245 X6.5 Y-22.  
N246 X29.75 Y-35.423  
N247 G0 G80 Z3.  
N248 M9  
N249 G0 G53 Z0 M5  
N250 T07 M6 (PERCAGE)  
N251 S3000 M3  
N252 G0 X162. Y-22. M8  
N253 G43 H07 Z3.  
N254 G83 X162. Y-22. Z-17. I4. J0.429 K1. R3. F200.  
N255 G0 G80 Z3.  
N256 M9  
N257 G0 G53 Z0 M5  
N258 T08 M6 (TARAUDAGE)  
N259 S200 M3  
N260 G0 X162. Y-22. M8  
N261 G43 H08 Z3.  
N262 G84 X162. Y-22. Z-14. R3. F160.  
N263 G0 G80 Z3.  
N264 M9  
N265 G0 G53 Z0 M5  
N266 M30  
%