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 048103
 (BUSE + CAPUCHON 3D)
 (Ø2 12 ZØ14, 12H)
 (BRUT DIA 30) (G59)
 (BUSE)
 (T2 DRESSAGE)
 (T7 PERCAGE COURT)
 (T5 PERCAGE 1MM)
 (T4 CONTOURNAGE)
 (T8 FILETAGE)
 (T6 TRONCONAGE)
 (BOUCHON)
 (T2 DRESSAGE)
 (T7 POINTAGE)
 (T11 PERCAGE 4.6)
 (T1 PERCAGE 9)
 (T3 FILETAGE)
 (T2 PROFIL EXTERIEUR)
 G59
 (Dressage)
 (Outil = 2)
 (Smax = 2500)
 (S trmn = 500)
 (Vcc = 175)
 (Sens Rot = 4)
 (Avance = 0.1)
 (DIA1 = 35.)
 (ZBrut = 1.)
 (ZØ = 0.)
 (Passe Z = 0.5)
G00 T2
 G50 S2500
 G97 S500 M04
 G00 X37. Z1. M08
 G96 S175
 G72 P10 Q20 D0.5 U0 W0 F0.1
 N10 G01 Z0.
 G01 X-1.
 N20 G00 Z2.
 G00 G40 G28
 M01
 (Perçage Court G81)
 (Outil = 7)
 (S trmn = 2000)
 (ZØ = 0.)
 (Z1 = -0.75)
 (Plan R = 5.)
 (Avance = 0.1)
 G28
T7
 G97 S2000 M03
 G00 Z5.
 G00 X0. M08
 G81 Z-0.75 R5. F0.1
 G00 G80 Z5. M09
 G28 X0
 G28
 M01
 (Perçage Deburrage G83)
 (Outil = 5)
 (S trmn = 2500)
 (ZØ = 0.)
 (Z1 = -5.5)
 (Plan R = 10.)
 (Pas = 0.5)
 (Avance = 0.05)
 G28
T5
 G97 S2500 M03
 G00 Z3.
 G00 X0. M08
 G83 Z-5.5 Q0.5 R10. F0.05
 G00 G80 Z3. M09
 G28 X0
 G28
 M01
 (Cylindrage 5)
 (Outil Eb = 4)
 (Avance Eb = 0.25)
 (Outil Fin = 4)
 (Avance Fin = 0.1)
 (Smax = 2500)
 (S trmn = 500)
 (Vcc = 100)
 (Sens Rot = 4)
 (DiaBrut = 35.)
 (ZØ = 0.)
 (DIA1 = 4.)
 (Z1 = -14.)
 (DIA2 = 10.)
 (Z2 = -18.)
 (DIA3 = 12.)

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(Z3 = -21.)
(K1 = 1.7)
(K2 = 0.)
(K3 = 0.)
(Passe X = 1.)
(Sur Ep X = 0.15)
(Sur Ep Z = 0.1)
T4
G50 S2500
G97 S500 M04
G00 X35. Z1. M08
G96 S100
G71 P150 Q160 D1. U0.15 W0.1 F0.25
N150 G00 G42 X-1.4
G01 X4. Z-1.7
G01 Z-14.
G01 X10.
G01 X10. Z-14.
G01 Z-18.
G01 X12.
G01 X12. Z-18.
G01 Z-25.
N160 G01 X37.
G97 S500 M09
G00 G40 G28
T4
G00 X37. Z1. M08
G96 S100
G70 P150 Q160 F0.1
G97 S500 M09
G00 G40 G28
M01
(Gorge simple ext)
(Outil = 6)
(Smax = 1000)
(S trmn = 1000)
(Sens Rot = 4)
(Vcc = 100)
(Avance = 0.05)
(DIA1 = 10.)
(Z0 = 0.)
(DIA2 = 9.)
(Z1 = -18.)
T6
G50 S1000
G97 S1000 M04
G00 Z-18. M08
G00 X13.
G96 S100
G01 X9. F0.05
G00 X15.
G00 G28
M01
(Filetage Ext)
(Outil = 8)
(Smax = 2500)
(S trmn = 500)
(Sens Rot = 4)
(DIA1 = 10.)
(Z0 = 0.)
(Z1 = -17.5)
(Pas = 1.)
(Prof Passe = 0.1)
T8
G50 S2500
G97 S500 M04
G00 X12. Z-17.51 M08
G76 X8.774 Z3. K0.613 D0.1 F1.
G00 G28
M01
(Gorge simple ext)
(Outil = 6)
(Smax = 2500)
(S trmn = 500)
(Sens Rot = 4)
(Vcc = 80)
(Avance = 0.1)
(DIA1 = 30.2)
(Z0 = 0.)
(DIA2 = 0.)
(Z1 = -24.15)
T6
G50 S2500
G97 S500 M04
G00 Z-24.15 M08
G00 X35.
G96 S80
G01 X0. F0.05
G00 X35.
G00 G28
M01
(FIN BUSE)
(DEBUT BOUCHON)

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(Dressage )
(Outil = 2)
(Smax = 2000)
(S trmn = 500)
(Vcc = 175)
(Sens Rot = 4)
(Avance = 0.1)
(DIA1 = 28.)
(ZBrut = -24.15)
(Z0 = -25.15)
(Passe Z = 0.5)
G00 T2
G50 S2000
G97 S500 M04
G00 X28. Z-24.15 M08
G96 S175
G72 P10 Q20 D0.5 U0 W0 F0.1
N10 G01 Z-25.15
G01 X-1.
N20 G00 Z-23.15
G00 G40 G28
M01
(Percage Court G81)
(Outil = 7)
(S trmn = 2000)
(Z0 = -25.15)
(Z1 = -26.0)
(Plan R = -20.)
(Avance = 0.1)
G28
T7
G97 S2000 M03
G00 Z-20.15
G00 X0. M08
G81 Z-26. R-20 F0.1
G00 G80 Z5. M09
G28 X0
G28
M01
(Percage Debourrage G83)
(Outil = 11)
(S trmn = 2500)
(Z0 = -25.15)
(Z1 = -45)
(Plan R = -20.)
(Pas = 2.)
(Avance = 0.05)
G28
T11
G97 S2500 M03
G00 Z-20.15
G00 X0. M08
G83 Z-45. Q2. R-20 F0.05
G00 G80 Z5. M09
G28 X0
G28
M01
(Percage Debourrage G83)
(Outil = 1)
(S trmn = 2500)
(Z0 = -25.15)
(Z1 = -36.85)
(Plan R = -20.)
(Pas = 2.)
(Avance = 0.05)
G28
T1
G97 S2500 M03
G00 Z-20.15
G00 X0. M08
G83 Z-36.85 Q2. R-20 F0.05
G00 G80 Z5. M09
G28 X0
G28
M01
(Cylindrage 1)
(Outil = 2)
(Avance Eb = 0.15)
(Avance Fin = 0.1)
(Smax = 2500)
(S trmn = 500)
(Vcc = 200)
(Sens Rot = 4)
(DiaBrut = 30.)
(Z0 = -25.15)
(DIA1 = 12.)
(Z1 = -39.15)
(K = 0.)
(Passe X = 0.5)
(Sur Ep X = 0.15)
(Sur Ep Z = 0.1)
T2
G50 S2500

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G97 S500 M04
G96 S200 M08
G00 X30. Z-24.15 M08
G96 S200
G71 P70 Q80 D0.5 U0.15 W0.1 F0.15
N70 G00 G42 X10.
G01 X12. Z-25.15
G01 Z-39.15
N80 G01 X32.
G00 G40 X32. Z-24.15
G70 P70 Q80 F0.1
G97 S500 M09
G00 G40 G28
M01
(Filetage Int)
(Outil = 3)
(Smax = 2000)
(S trmn = 500)
(Sens Rot = 3)
(DIA1 = 9.)
(Z0 = -25.15)
(Z1 = -30.65)
(Pas = 1.)
(Prof Passe = 0.15)
T3
G50 S2000
G97 S500 M03
G00 X7. Z-22.15 M08
G76 X10.154 Z-30.66 K0.577 D0.15 F1.
G00 G28
M01
(Gorge simple ext)
(AVEC CHANFREIN) (Outil = 6)
(Smax = 2000)
(S trmn = 500)
(Sens Rot = 4)
(Vcc = 80)
(Avance = 0.1)
(DIA1 = 28.)
(Z0 = -25.15)
(DIA2 = 0.)
(Z1 = -38.0)
T6
G50 S2000
G97 S500 M04
G00 Z-35.5 M08
G00 X16.
G96 S80
G01 X6.8 Z-38. F0.05
G01 X0.
G00 X30.
G00 G28
M01
%
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