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O42191 (Reprise motoReducteur Axe Z V2)

(CN HAAS)

(T01 FRAISE DIA=50 CRO=0)

(T02 FRAISE DIA=14 CRO=0)

(T03 FRAISE DIA=32 CRO=0)

(T12 FORET DIA=14 A 180 DEGRES)

(T04 FORET A POINTER DIA=3 A 90 DEGRES)

(T05 FORET DIA=4.2 A 120 DEGRES)

(T06 FORET DIA=8.2 A 120 DEGRES)

N1 G90 G99 G80 G40

N2 G54 (DECALAGE ORIGINE)

N3 G0 G53 Z0

N4 T01 M6 (EBAUCHE SURFACAGE)

N5 S2000 M3

N6 G0 X-31. Y-7.5 M8

N7 G43 H01 Z3.

N8 Z0.2

N9 G1 X148. F500

N10 Y-45.

N11 X-6.

N12 Y-52.

N13 X173.

N14 G0 Z3.

N15 M9

N16 G0 G53 Z0 M5

N17 T02 M6 (EBAUCHE PROFIL)

N18 S1000 M3

N19 G0 X5. Y27.2 M8

N20 G43 H02 Z2.

N21 G1 Z-5.9 F100

N22 G42 D02 X15. Y9.879 F150

N23 G2 X5. Y7.2 R20. F111

N24 G3 X-0.091 Y5.091 R7.2 F150

N25 G1 X-5.091 Y0.091

N26 G3 X-7.2 Y-5. R7.2

N27 G1 Y-65.

N28 G3 X-5.091 Y-70.091 R7.2

N29 G1 X-0.091 Y-75.091

N30 G3 X5. Y-77.2 R7.2

N31 G1 X76.42

N32 G3 X77.047 Y-77.173 R7.2

N33 G1 X113.406 Y-73.993

N34 G3 X113.406 Y3.993 R39.14

N35 G1 X77.047 Y7.173

N36 G3 X76.42 Y7.2 R7.2

N37 G1 X5.

N38 G2 X-5. Y9.879 R20. F111

N39 G1 G40 X5. Y27.2 F150

N40 Z-11.8 F100

N41 G42 D02 X15. Y9.879 F150

N42 G2 X5. Y7.2 R20. F111

N43 G3 X-0.091 Y5.091 R7.2 F150

N44 G1 X-5.091 Y0.091

N45 G3 X-7.2 Y-5. R7.2

N46 G1 Y-65.

N47 G3 X-5.091 Y-70.091 R7.2

N48 G1 X-0.091 Y-75.091

N49 G3 X5. Y-77.2 R7.2

N50 G1 X76.42

N51 G3 X77.047 Y-77.173 R7.2

N52 G1 X113.406 Y-73.993

N53 G3 X113.406 Y3.993 R39.14

N54 G1 X77.047 Y7.173

N55 G3 X76.42 Y7.2 R7.2

N56 G1 X5.

N57 G2 X-5. Y9.879 R20. F111

N58 G1 G40 X5. Y27.2 F150

N59 G0 Z2.

N60 Z2.

(FINITION PROFIL)

N61 G0 X5. Y27.

N62 G1 Z-12. F100

N63 G42 D02 X15. Y9.679 F150

N64 G2 X5. Y7. R20. F111

N65 G3 X0.05 Y4.95 R7. F150

N66 G1 X-4.95 Y-0.05

N67 G3 X-7. Y-5. R7.

N68 G1 Y-65.

N69 G3 X-4.95 Y-69.95 R7.

N70 G1 X0.05 Y-74.95

N71 G3 X5. Y-77. R7.

N72 G1 X76.42

N73 G3 X77.03 Y-76.973 R7.

N74 G1 X113.388 Y-73.794

N75 G3 X113.388 Y3.794 R38.94

N76 G1 X77.03 Y6.973

N77 G3 X76.42 Y7. R7.

N78 G1 X5.

N79 G2 X-5. Y9.679 R20. F111

N80 G1 G40 X5. Y27. F150

N81 G0 Z2.

N82 Z2.

(EBAUCHE POCHE CIRCULAIRE)

N83 G0 X110. Y-35.

N84 G1 Z-1.4 F40

N85 X120.5 F80

N86 G3 X99.5 Y-35. R10.5

N87 G3 X120.5 Y-35. R10.5

N88 G1 X124.9

N89 G3 X95.1 Y-35. R14.9

N90 G3 X124.9 Y-35. R14.9

N91 G1 X124.8

N92 G0 Z0.6

N93 X110.

N94 G1 Z-2.8 F40

N95 X120.5 F80

N96 G3 X99.5 Y-35. R10.5

N97 G3 X120.5 Y-35. R10.5

N98 G1 X124.9

N99 G3 X95.1 Y-35. R14.9

N100 G3 X124.9 Y-35. R14.9

N101 G1 X124.8

N102 G0 Z-0.8

N103 Z2.

N104 Z2.

(FINITION POCHE CIRCULAIRE)

N105 G0 X110. Y-35.

N106 Z-0.8

N107 G1 Z-3. F40

N108 X120.5 F80

N109 G3 X99.5 Y-35. R10.5

N110 G3 X120.5 Y-35. R10.5

N111 G1 X124.9

N112 G3 X95.1 Y-35. R14.9

N113 G3 X124.9 Y-35. R14.9

N114 G1 X124.8

N115 G0 Z2.

N116 X123.1

N117 Z-1.

N118 G1 Z-3. F40

N119 G41 D02 X124.832 Y-36. F80

N120 G3 X125.1 Y-35. R2. F17

N121 G3 X110. Y-19.9 R15.1 F54

N122 G3 X110. Y-50.1 R15.1

N123 G3 X125.1 Y-35. R15.1

N124 G3 X124.832 Y-34. R2. F17

N125 G1 G40 X123.1 Y-35. F80

N126 G0 Z2.

N127 M9

N128 G0 G53 Z0 M5

N129 T03 M6 (EBAUCHE RAINURAGE)

N130 S500 M3

N131 G0 X53.8 Y-98. M8

N132 G43 H03 Z5.

N133 Z-0.8

N134 G1 Z-1.933 F100

N135 Y18.

N136 X37.8

N137 Y-98.

N138 X21.8

N139 Y18.

N140 X11.2

N141 Y-98.

N142 G0 Z5.

N143 X53.8

N144 Z-0.8

N145 G1 Z-3.867

N146 Y18.

N147 X37.8

N148 Y-98.

N149 X21.8

N150 Y18.

N151 X11.2

N152 Y-98.

N153 G0 Z5.

N154 X53.8

N155 Z-0.8

N156 G1 Z-5.8

N157 Y18.

N158 X37.8

N159 Y-98.

N160 X21.8

N161 Y18.

N162 X11.2

N163 Y-98.

N164 G0 Z5.

N165 Z5.

(FINITION RAINURAGE)

N166 G0 X53.8 Y-98.

N167 Z-1.

N168 G1 Z-6.

N169 Y18.

N170 X37.8

N171 Y-98.

N172 X21.8

N173 Y18.

N174 X11.2

N175 Y-98.

N176 G0 Z5.

N177 X13. Y18.

N178 Z-1.

N179 G1 Z-6.

N180 G41 D03 X11.

N181 Y-98.

N182 G40 X13.

N183 G0 Z5.

N184 X52.

N185 Z-1.

N186 G1 Z-6.

N187 G41 D03 X54.

N188 Y18.

N189 G40 X52.

N190 G0 Z5.

N191 M9

N192 G0 G53 Z0 M5

N193 T12 M6 (PERCAGE)

N194 S800 M3

N195 G0 X50. Y-35. M8

N196 G43 H12 Z5.

N197 Z2.

N198 G83 X50. Y-35. Z-15. Q3. R2. F80.

N199 G0 G80 Z5.

N200 M9

N201 G0 G53 Z0 M5

N202 T04 M6 (CENTRAGE)

N203 S2000 M3

N204 G0 X8.25 Y-7. M8

N205 G43 H04 Z5.

N206 Z-4.

N207 G81 X8.25 Y-7. Z-7.5 R-4. F0.02

N208 G0 G80 Z5.

N209 G81 X64.25 Y-7. Z-7.5 R-4. F0.02

N210 G0 G80 Z5.

N211 G81 X64.25 Y-63. Z-7.5 R-4. F0.02

N212 G0 G80 Z5.

N213 G81 X8.25 Y-63. Z-7.5 R-4. F0.02

N214 G0 G80 Z5.

N215 Z5.

(CENTRAGE)

N216 G0 X110. Y-35.

N217 Z-1.

N218 G81 X110. Y-35. Z-4.5 R-1. F0.02

N219 G0 G80 Z5.

N220 M9

N221 G0 G53 Z0 M5

N222 T05 M6 (PERCAGE)

N223 S2000 M3

N224 G0 X8.25 Y-7. M8

N225 G43 H05 Z5.

N226 Z-1.

N227 G83 X8.25 Y-7. Z-16. I5. J1.333 K1. R-1. F0.02

N228 G0 G80 Z5.

N229 G83 X64.25 Y-7. Z-16. I5. J1.333 K1. R-1. F0.02

N230 G0 G80 Z5.

N231 G83 X64.25 Y-63. Z-16. I5. J1.333 K1. R-1. F0.02

N232 G0 G80 Z5.

N233 G83 X8.25 Y-63. Z-16. I5. J1.333 K1. R-1. F0.02

N234 G0 G80 Z5.

N235 M9

N236 G0 G53 Z0 M5

N237 T06 M6 (PERCAGE)

N238 S1500 M3

N239 G0 X110. Y-35. M8

N240 G43 H06 Z5.

N241 Z2.

N242 G81 X110. Y-35. Z-17. R2. F0.02

N243 G0 G80 Z5.

N244 M9

N245 G0 G53 Z0 M5

N246 M30

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