

%

041091 (Volant G et D STIRLING PH 10)
(CN HAAS)
(T02 OUTIL A DRESSER/CHARIOTER R=0.4)
(T04 OUTIL COPIEUR EXTERIEUR R=0.4)
(T01 FORET A CENTRER DIA=3)
(T09 FORET DIA=3.8)
(T03 FORET DIA=4)
(T06 OUTIL A GORGE EXTERIEUR LARGEUR=3.15 R=0.2)
N5 G90 G99 G97 G40 G80 G64
N10 G54 (DECALAGE ORIGINE)
N15 G28
N20 G50 S3000
N25 T0202 (DRESSAGE EBAUCHE)
N30 G97 S500 M4
N35 G0 X52. Z3. M8
N40 G96 S200
N45 Z0.05
N50 G1 X-0.8 F0.1
N55 G0 Z3.
N60 X52.
(T02 PROFIL EXTERIEUR EBAUCHE)
N65 G0 X53. Z3.
N70 G96 S250
N75 X47.
N80 G1 Z-16.2 F0.25
N85 X53.
N90 G0 Z3.
N95 X43.
N100 G1 Z-16.2
N105 X47.8
N110 G0 Z3.
N115 X39.
N120 G1 Z-5.31
N125 X40.19 Z-5.905
N130 G3 X40.6 Z-6.4 R0.7
N135 G1 Z-16.2
N140 X43.8
N145 G0 Z3.
N150 X35.
N155 G1 Z-4.95
N160 X37.949
N165 G3 X38.514 Z-5.067 R0.4
N170 G1 X39. Z-5.31
N175 X39.8
N180 G0 Z3.
N185 X31.
N190 G1 Z-4.95
N195 X35.8
N200 G0 Z3.

N205 X27.
N210 G1 Z-4.95
N215 X31.8
N220 G0 Z3.
N225 X23.
N230 G1 Z-4.95
N235 X27.8
N240 G0 Z3.
N245 X19.
N250 G1 Z-4.95
N255 X23.8
N260 G0 Z3.
N265 X15.
N270 G1 Z-0.7
N275 X16.449
N280 G3 X17.014 Z-0.817 R0.4
N285 G1 X17.19 Z-0.905
N290 G3 X17.6 Z-1.4 R0.7
N295 G1 Z-4.95
N300 X19.8
N305 G0 Z3.
N310 X11.
N315 G1 Z-0.7
N320 X15.8
N325 G0 Z3.
N330 X7.
N335 G1 Z0.05
N340 X7.949
N345 G3 X8.514 Z-0.067 R0.4
N350 G1 X8.69 Z-0.155
N355 G3 X9.1 Z-0.65 R0.7
N360 G1 Z-0.7
N365 X11.8
N370 G0 Z3.
N375 X3.
N380 G1 Z0.05
N385 X7.8
N390 G0 Z3.
N395 X-0.8
N400 G1 Z0.05
N405 X3.8
N410 G0 Z3.
N415 X53.
N420 M9
N425 G28 M5
N430 G50 S4000
N435 T0404 (PROFIL EXTERIEUR FINITION)
N440 G97 S500 M4
N445 G0 X53. Z3. M8
N450 G96 S250

N455 X-1.2
N460 G1 Z1. F0.15
N465 G42 X-0.4 Z0.
N470 X8.
N475 X8.5 Z-0.25
N480 Z-0.75
N485 X16.5
N490 X17. Z-1.
N495 Z-5.
N500 X38.
N505 X40. Z-6.
N510 Z-16.25
N515 X51.4
N520 G40 X50.6 Z-15.65
N525 G0 X53.
N530 Z3.
N535 M9
N540 G28 M5
N545 T0101 (CENTRAGE)
N550 G97 S3000 M3
N555 G0 Z2. M8
N560 X0.
N565 G81 X0. Z-3. R2. F0.1
N570 G0 G80 Z2.
N575 G28 U0 M9
N580 G28 M5
N585 T0909 (PERCAGE)
N590 G97 S3352 M3
N595 G0 Z2. M8
N600 X0.
N605 G83 X0. Z-15. Q5. R2. F0.08
N610 G0 G80 Z2.
N615 G28 U0 M9
N620 G28 M5
N625 T0303 (PERCAGE)
N630 G97 S1990 M3
N635 G0 Z2. M8
N640 X0.
N645 G83 X0. Z-14.5 Q8. R2. F0.05
N650 G0 G80 Z2.
N655 G28 U0 M9
N660 G28 M5
N665 T0606 (GORGE EXTERIEUR)
N670 G97 S500 M4
N675 G0 X42. Z-8.25 M8
N680 G96 S100
N685 G1 Z-10.25 F0.05
N690 X37.3
N695 G0 X42.
N700 Z-9.9

N705 G1 X37.
N710 Z-10.25
N715 X42.
N720 G0 Z-6.75
(T06 TRONCONNAGE)
N725 G0 X42. Z-15.15
N730 G1 X37.766
N735 G0 X42.
N740 Z-13.091
N745 G1 X41.883
N750 X37.766 Z-15.15
N755 X15.
N760 X16. F0.03
N765 G0 X42.
(T06 TRONCONNAGE)
N770 G0 X42. Z-16.15
N775 G1 X10. F0.05
N780 X2. F0.03
N785 G0 X42.
N790 M9
N795 G28 M5
N800 M30
%