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O3052 (PORAUS)

N10 G1900 D70 L1185 K3

N20 G90 G40 G54 T05008

(BORR D14)

N30 G92 S1500

N40 G95 G97 F0.2 S1500 M13

N50 G0 Z20.

N60 X0. Z5.

N70 G1 Z0.

N80 G0 Z5.

N90 Z1.

N100 G1 Z-5.

N110 G0 Z5.

N120 Z-4.

N130 G1 Z-10.

N140 G0 Z5.

N150 Z-9.

N160 G1 Z-15.

N170 G0 Z5.

N180 Z-14.

N190 G1 Z-20.

N200 G0 Z5.

N210 Z-19.

N220 G1 Z-25.

N230 G0 Z5.

N240 Z-24.

N250 G1 Z-30.

N260 G0 Z5.

N270 Z-29.

N280 G1 Z-35.

N290 G0 Z5.

N300 Z-34.

N310 G1 Z-40.

N320 G0 Z5.

N330 G28 U0.

N340 G0 Z200. M15

N350 G90 G40 G54 T04040

(DUBBHALS FORSANKARE 8-40)

(KESKIO)

N360 G92 S1500

N370 G95 G97 F0.1 S795 M13

N380 G0 Z20.

N390 X0. Z5.

N400 G1 Z0.

N410 G0 Z5.

N420 Z1.

N430 G1 Z-5.

N440 G0 Z5.

N450 Z-4.

N460 G1 Z-8.

N470 G0 Z5.

N480 G28 U0.

N490 G0 Z200. M15

N500 G90 G40 G54 T10015

(OUTER ROUGHING TOOL)

(ROUHINTA)

N510 G92 S1500

N520 G95 G96 F0.35 S180 M14

N530 G0 Z20.

N540 X76. Z5.

N550 G24 X-2. Z2.

N560 G0 Z4.

N570 G24 X-2. Z1.

N580 G0 Z3.

N590 G24 X-2. Z0.

N600 G0 X76. Z5.4  
N610 G73 U3. R3.  
N620 G73 P630 Q710 U4. W1.  
N630 G0 G42 X43.6 W0.  
N640 G1 Z1.2  
N650 X50. Z-2.  
N660 Z-450.34  
N670 G2 X60. Z-459. R10.  
N680 G1 Z-511.  
N690 G2 X70. Z-522.18 R15.  
N700 G1 X73.578 Z-523.78  
N710 G40 X79.378  
N720 G28 U0.  
N730 G0 Z200. M15  
N740 G90 G40 G54 T04014  
(OUTER FINISHING TOOL)  
(VIIMEISTELY)  
N750 G92 S1500  
N760 G95 G96 F0.2 S220 M14  
N770 G0 Z20.  
N780 X90. Z3.  
N790 G42 X46.4 Z5.1  
N800 G1 Z1.3  
N810 X52. Z-1.5  
N820 Z-449.84  
N830 G2 X62. Z-458.5 R10.  
N840 G1 Z-510.5  
N850 G2 X72. Z-521.68 R15.  
N860 G1 X74.386 Z-522.747  
N870 X78.586  
N880 G0 G40 X90. Z3.  
N890 G0  
N900 G42 X44.4 Z4.6  
N910 G1 Z0.8  
N920 X50. Z-2.  
N930 Z-450.34  
N940 G2 X60. Z-459. R10.  
N950 G1 Z-511.  
N960 G2 X70. Z-522.18 R15.  
N970 G1 X72.386 Z-523.247  
N980 X76.586  
N990 G0 G40 X90. Z3.  
N1000 M15  
N1010 G28 U0.  
N1020 Z200.  
N1030 M30  
%

Ohjelman simulointi tehtiin WinCAMilla ennen tallentamista.

