

Programa de mecanizado completo con ciclos fijos y diferentes decalajes

<https://www.programacioncnc.es/programa-de-mecanizado-ejemplo/>

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N020 G54
N030 T2
N040 M06
N050 G0 G90 G40 G43 X-42 Y5 F400 S500 D2 M3
N060 G0 Z0
N070 G0 G91 Z-1 M8
N080 G1 G90 X160
N090 G0 Y57.5
N100 G1 X-42
N110 G0 G44 Z100 M5 M9 ;---FIN PLANEADO PLATO D=80
N120 G55
N130 T3
N140 M6
N150 G0 G90 G40 G43 Z30 F56 S350 D3 M3
N160 G81 G99 X0 Y0 Z5 I-3 M8
N170 G0 X-41.995 Y15.5
N180 X-41.995 Y-15.5
N190 X41.995 Y-15.5
N200 X41.995 Y15.5
N210 G0 G80 G44 Z100 M5 M9 ;---FIN DE PUNTEADO
N220 T4
N230 M6
N240 G0 G90 G40 G43 Z30 F90 S620 D4 M3
N250 G81 G99 X0 Y0 Z5 I-11 M8
N260 (RPT N170,N200)N1
N270 G0 G80 G44 Z100 M5 M9 ;---FIN TALADRADO D=10
N280 T5
N290 M6
N300 G0 G90 G40 G43 Z30 F22 S450 D5 M3 M8
N310 G87 G98 X0 Y0 Z5 I-8 J15 K14.5 B2.5 C3 D5 H16 L1
N320 G0 G80 G44 Z100 M5 M9 ;---FIN CAJERA RECTANGULAR FRESA D=16
N330 T6
N340 M6
N350 G0 G90 G40 G43 Z30 F80 S500 D6 M3 M8
N360 G88 G98 X-41.995 Y15.5 Z5 I-8.025 J10.512 B2.5 C0.3 D5 H60 L0.2
N370 (RPT N180,N200)N1
N380 G0 G80 G44 G40 Z100 M5 M9 ;---FIN DE CAJERAS CIRCULARES CON FRESA D=20
N390 T7
N400 M6
N410 G0 G90 G40 G43 X-0.5 Y-54.5 F80 S950 D7 M3 M8
N420 G0 Z-3
N430 G1 Y-12.5
N440 G0 Y8
N450 G1 Y54.5
N460 G0 X0.5
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N470 G1 Y12.5
N480 G0 Y-8
N490 G1 Y-54.5
N500 G0 Z5
N510 G0 X-8 Y-0.5
N520 G0 Z-3
N530 G1 X-30
N540 G2 X-30 Y0.5 I0 J0.5
N550 G1 X-8
N560 G0 X8
N570 G1 X30
N580 G2 X30 Y-0.5 I0 J-0.5
N590 G1 X8
N600 G0 G90 G44 Z100 M5 M9 ;---FIN DE COLISOS FRESA D=10
N610 T3
N620 M6
N630 G0 G90 G43 X0 Y-52.5 F300 S3000 D3 M3
N640 G0 Z-2
N650 G1 G42 X-5.5
N660 G1 Y-14.5
N670 G1 X-7
N680 G2 X-15 Y-6.5 I0 J8
N690 G1 Y-5.5
N700 G1 X-30
N710 G2 X-30 Y5.5 I0 J5.5
N720 G1 X-15
N730 G1 Y6.5
N740 G2 X-7 Y14.5 I8 J0
N750 G1 X-5.5
N760 G1 Y52.5
N770 G1 X5.5
N780 G11 G12
N790 (RPT N660,N760)N1 ;---FIN DE ACHAFLANADO DE COLISOS Y CAJERA
N800 G10
N810 G0 G40 Z5
N820 G0 X-41.995 Y15.5
N830 G0 Z-2
N840 G1 G41 X-31.483
N850 G3 X-31.483 Y15.5 I-10.512 J0
N860 G0 G40 Z5
N870 G12
N880 (RPT N820,N860)N1
N890 G10
N900 G11
N910 (RPT N820,N860)N1
N920 G10
N930 G11 G12
N940 (RPT N820,N860)N1
N950 G10 ;---FIN ACHAFLANADO DE TALADROS
N990 G0 G90 G44 Z100 M5
N1000 M30

