

## Mecanizado de cajeados y taladrados en matriz circular

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<https://www.programacioncnc.es/mecanizado-de-cajeados-y-taladrados-en-matriz-circular/>

&G54  
&G55  
&G56  
&G57  
N0010 G94  
N0015 M5  
N0020 M9  
N0025 G54  
N0030 T1 D1  
N0035 M6  
N0040 S950 M3  
N0045 G0 Z50  
N0050 G0 X125 Y125  
N0055 G0 Z2  
N0060 G0 Z-10 M7  
N0065 G42 G1 Y96 F200  
N0070 G1 X-25  
N0075 G40  
N0080 G0 Z2  
N0085 G0 Y-25  
N0090 G0 Z-10  
N0095 G42 G1 Y4  
N0100 G1 X125  
N0105 G40  
N0110 G0 Z2  
N0115 G0 Y100  
N0120 G0 Z-5  
N0125 G41 G1 X115  
N0130 G3 X95 Y75 I4.995 J-24.496  
N0135 G1 Y19  
N0140 G1 X85 Y9  
N0145 G1 X15  
N0150 G1 X5 Y19  
N0155 G1 Y61.388  
N0160 G2 X12.541 Y77.005 I20 J-0.028  
N0165 G1 X27.321 Y88.809  
N0170 G2 X33.551 Y91 I6.247 J-7.809  
N0175 G1 X66.492  
N0180 G2 X72.739 Y88.809 I0 J-10  
N0185 G1 X87.494 Y77.005  
N0190 G2 X95 Y61.388 I-12.494 J-15.617  
N0195 G1 Y48  
N0200 G3 X125 Y18 I30 J0  
N0205 G40



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N0210 G0 Z100
N0215 M5
N0220 M9
N0225 T6 D1
N0230 M6
N0235 S2800 M3
N0240 F40
N0245 G0 Z20
N0250 MCALL CYCLE82(20,-5,2,,3,0)
N0255 L1000
N0260 G0 Z100
N0265 M5
N0270 T3 D1
N0275 M6
N0280 S2200 M3
N0285 G0 Z20
N0290 MCALL CYCLE83(20,-5,2,,24,,15,3,1,1,1,1)
N0295 L1000
N0300 G0 Z100
N0305 M5
N0310 T4 D1
N0315 M6
N0320 S500 M3
N0325 G0 Z20
N0330 MCALL CYCLE84(20,-5,4,,26,0,3,,1,0,500,500)
N0335 L1000
N0340 G0 Z100
N0345 M5
N0350 G55
N0355 T2 D1
N0360 M6
N0365 S2200 M3
N0370 G0 Z50
N0375 G0 X0 Y0
N0380 AROT RPL=30
N0385 G0 Z20
N0390 POCKET3(20,0,2,-12,10,30,3,0,0,0,8,0,0,100,30,2,11,4.8)
N0395 TRANS
N0400 G54
N0405 G0 X50 Y19
N0410 POCKET3(20,0,2,-12,30,10,3,50,19,0,8,0,0,100,30,2,11,4.8)
N0415 G0 Y81
N0420 POCKET3(20,0,2,-12,30,10,3,50,81,0,8,0,0,100,30,2,11,4.8)
N0425 G0 Z100
N0430 M5
N0435 G56
N0440 T8 D1
N0445 M6
N0450 S1800 M3
N0455 G0 X0 Y0
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N0460 M7  
N0465 G0 Z20  
N0470 POCKET3(20,0,2,-17,20,30,5,0,0,150,8,0,0,100,30,2,11,6.4)  
N0475 G0 Z100  
N0480 M5  
N0485 M9  
N0490 G57  
N0495 T6 D1  
N0500 M6  
N0505 S2800 M3  
N0510 G0 X0  
N0515 M7  
N0520 F40  
N0525 G0 X7.071 Y7.071  
N0530 G0 Z20  
N0535 MCALL CYCLE82(20,0,2,-3,0)  
N0540 HOLES2(0,0,10,45,45,3)  
N0545 HOLES2(0,0,10,225,45,3)  
N0550 MCALL  
N0555 G0 Z100  
N0560 M5  
N0565 M9  
N0570 T7 D1  
N0575 M6  
N0580 S2200 M3  
N0585 G0 X0 Y0  
N0590 G0 Z186.1  
N0595 M7  
N0600 F80  
N0605 G0 X7.071 Y7.071  
N0610 G0 Z20  
N0615 MCALL CYCLE83(20,0,2,,28,,15,3,1,1,1,1)  
N0620 HOLES2(0,0,10,45,45,3)  
N0625 HOLES2(0,0,10,225,45,3)  
N0630 MCALL  
N0635 G0 Z100  
N0640 M5  
N0645 M9  
N0650 M30  
N0655

