

# MECANIZADO EN CAD/CAM

<https://www.programacioncnc.es/mecanizado-de-una-pieza-simple/>

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Este documento descargado se vincula al enlace:

<https://www.programacioncnc.es/mecanizado-de-una-pieza-simple/>

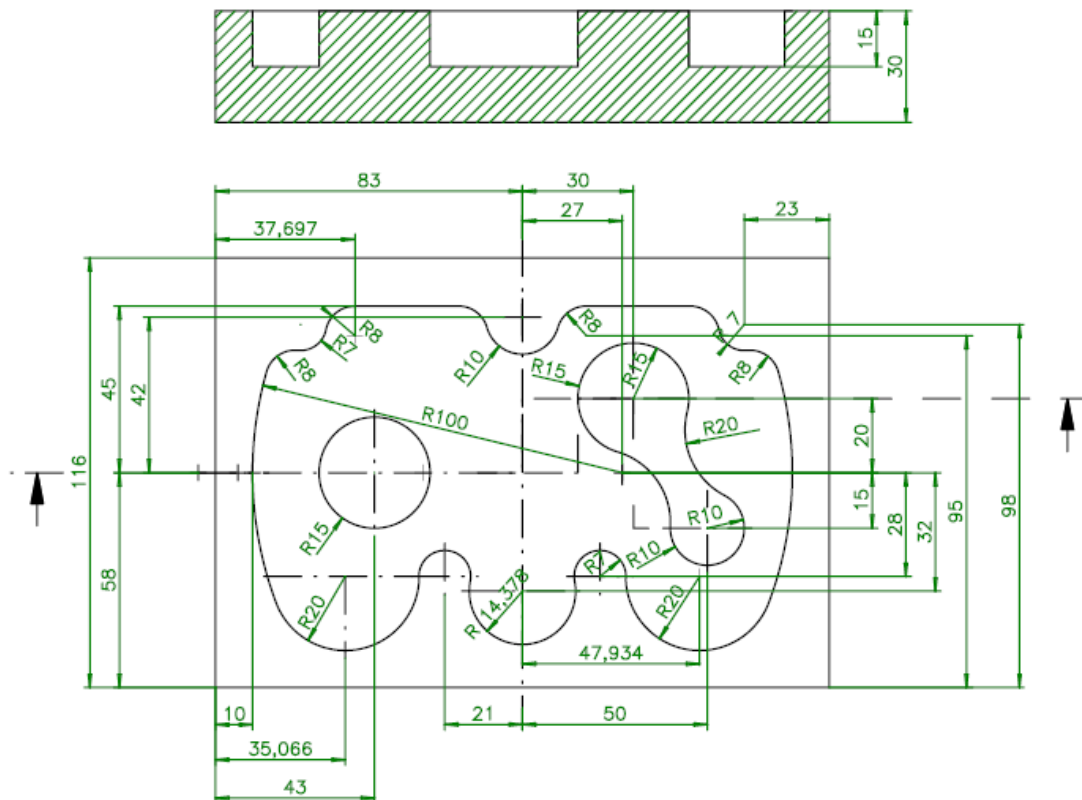
En él se puede ver la simulación del mecanizado de la pieza según plano. El programa se adjunta a continuación del plano de pieza.

Como puedes comprobar, los programas realizados con software CAD/CAM se componen de grandes cantidades de puntos calculados por el software. Se hace bastante difícil hacer un seguimiento de lo que hace el programa cnc.

Normalmente, con el buscador de palabras del editor, se buscan zonas específicas del programa, como por ejemplo los cambios de herramienta, los avances, velocidades ...

Siempre es interesante editar el programa indicando que tipo de mecanizado va a realizar la herramienta.

Aquí os dejo el **plano de la pieza**



Seguidamente las líneas de código del programa de mecanizado.

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O0001

N1 G91 G28 Z0.

N2 G91 G28 X0. Y0.

N3 G98 G40 G80 G49

N4 G90

N5 G94

N6 G97

N8 G54

N9 T6 M6

N10 S800 M3

N11 G0 X-25. Y13.667

N12 G0 G43 Z4. H6

N13 G1 Z0. F300.

N14 G1 X193.

N15 G0 Z4.

N16 G0 X-25. Y52.333

N17 G1 Z0.

N18 G1 X193.

N19 G0 Z4.

N20 G0 X-25. Y96.667

N21 G1 Z0.

N22 G1 X193.

N23 G0 Z4.

N24 G0 X84. Y58.

N25 (G37 T2 D8 DB55 RH4 O2 Q1 H7 VA10 E200 F250 S1250 FM400 M3)

N26 ( SOLLTE EIGENTLICH H6 SEIN)

N27 ( Startpunkt)  
N28 (Insel2)  
N29 (Konturtaschenaufruf)  
N30 T4 M6  
N31 S1000 M3  
N32 G0 X95.579 Y62.406  
N33 G0 G43 Z1. H4  
N34 G2 X87.94 Y58.159 Z-2. I-5. J0. F200.  
N35 G2 X88.364 Y66.889 Z-5. I2.639 J4.247  
N36 G2 X90.579 Y62.406 I1.107 J-2.241  
N37 G3 X92.348 Y56.119 I11.755 J-0.086 F225.  
N38 G2 X96.103 Y57.303 I12.496 J-33.068 F246.  
N39 G1 X98.595 Y59.31 F243.  
N40 G1 X102.334 Y62.321 F225.  
N41 G3 X113.53 Y70.65 I-19.334 J37.679  
N42 G1 X116.218 F228.  
N43 G3 X118.794 Y68.535 I26.234 J29.328 F231.  
N44 G3 X122.971 Y65.79 I23.658 J31.443 F225.  
N45 G2 X123.289 Y62.566 I-67.146 J-8.245 F228.  
N46 G2 X123.475 Y57.711 I-67.464 J-5.022 F225.  
N47 G1 X123.962 Y56.737 F228.  
N48 G3 X123.974 Y56.743 I-0.487 J0.974 F504.  
N49 G1 X123.475 Y57.711 F600.  
N50 G3 X120.554 Y59.129 I-18.631 J-34.66 F519.  
N51 G3 X102.334 Y62.321 I-15.711 J-36.078 F600.  
N52 G1 X94.405 Y63.385  
N53 G2 X90.579 Y62.406 I-11.405 J36.615

N54 G2 X88.248 Y70.019 I-0.791 J3.921 F228.  
N55 G2 X88.998 Y70.249 I1.54 J-3.692 F387.  
N56 G3 X92.85 Y71.293 I-5.998 J29.751 F330.  
N57 G3 X100.636 Y75.3 I-9.851 J28.707 F321.  
N58 G3 X103.725 Y77.828 I-17.637 J24.699 F282.  
N59 G3 X107.901 Y82.65 I-20.725 J22.171 F228.  
N60 G1 X111.84 F294.  
N61 G1 X115.779 F264.  
N62 G1 X121.293 F231.  
N63 G3 X124.07 Y79.728 I21.16 J17.328 F324.  
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N65 G3 X129.316 Y75.99 I15.87 J22.274 F258.  
N66 G3 X133.746 Y74.052 I13.137 J23.988 F225.  
N67 G2 X135.238 Y63.683 I-77.921 J-16.507 F294.  
N68 G2 X135.296 Y62.879 I-79.413 J-6.139 F306.  
N69 G2 X135.447 Y59.658 I-79.471 J-5.335 F291.  
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N71 G2 X135.357 Y53.209 I-79.642 J1.112 F243.  
N72 G2 X135.036 Y49.191 I-79.532 J4.335 F228.  
N73 G2 X130.971 Y31.139 I-79.211 J8.354 F225.  
N74 G3 X129.529 Y34.828 I-26.127 J-8.088 F504.  
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N77 G3 X124.036 Y42.537 I-19.748 J-18.921 F345.  
N78 G3 X106.295 Y50.363 I-19.192 J-19.486 F324.  
N79 G3 X105.503 Y50.393 I-1.451 J-27.311 F528.  
N80 G3 X101.547 Y50.202 I-0.659 J-27.342 F522.

N81 G3 X97.648 Y49.437 I3.297 J-27.151 F405.  
N82 G3 X93.901 Y48.117 I7.196 J-26.387 F276.  
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N87 G3 X78.265 Y55.552 I-33.322 J11.801 F246.  
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N89 G3 X78.272 Y60.339 I-35.311 J1.651 F450.  
N90 G3 X77.784 Y64.299 I-35.272 J-2.339 F342.  
N91 G3 X76.086 Y70.448 I-34.784 J-6.299 F234.  
N92 G1 X70.939 Y76.573 F225.  
N93 G2 X62.363 Y83.616 I12.062 J23.427  
N94 G3 X61.845 Y83.054 I13.722 J-13.168 F384.  
N95 G2 X69.421 Y74.874 I-18.845 J-25.054 F600.  
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N97 G3 X82.999 Y69.65 I6.915 J29.552  
N98 G3 X88.998 Y70.249 I0. J30.35  
N99 G2 X83.311 Y72.163 I-1.186 J5.882  
N100 G2 X81.826 Y75.722 I4.501 J3.968 F312.  
N101 G2 X85.145 Y81.505 I5.986 J0.408 F240.  
N102 G2 X86.626 Y82.012 I2.668 J-5.374 F291.  
N103 G3 X93.801 Y85.166 I-3.627 J17.988 F339.  
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N109 G1 X122.395 F252.  
N110 G1 X128.058 F225.  
N111 G3 X132.747 Y88.086 I14.395 J5.328 F345.  
N112 G3 X135.477 Y86.305 I9.705 J11.892 F303.  
N113 G3 X138.521 Y85.141 I6.976 J13.673 F249.  
N114 G3 X143.373 Y84.656 I3.932 J14.837 F225.  
N115 G2 X144.074 Y32.809 I-87.548 J-27.112 F294.  
N116 G2 X141.872 Y25.989 I-88.249 J24.736 F252.  
N117 G2 X130.934 Y18.35 I-10.938 J4.011 F249.  
N118 G2 X126.249 Y19.334 I0. J11.65 F252.  
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N123 G3 X94.373 Y34.275 I7.902 J-13.16 F306.  
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N125 G3 X90.706 Y29.031 I12.581 J-8.795 F228.  
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N127 G2 X87.2 Y21.1 I-5.971 J0.826  
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N130 G2 X81.45 Y20.175 I-0. J6.028  
N131 G2 X77.031 Y25.156 I1.55 J5.825 F234.  
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N133 G3 X73.945 Y32.432 I-14.131 J-5.994 F345.  
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N135 G3 X67.646 Y37.209 I-9.275 J-12.231 F234.

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N137 G3 X54.56 Y36.519 I-0.366 J-15.345

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N141 G3 X61.93 Y44.33 I-16.854 J16.161 F306.

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N144 G3 X62.076 Y71.465 I-22.862 J-4.751 F543.

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N151 G1 X33.22 Y28.215 F225.

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N162 G3 X47.006 Y26.973 I13.347 J-7.58 F351.  
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N165 G2 X24.943 Y25.644 I10.122 J5.767 F408.  
N166 G2 X22.539 Y32.373 I85.04 J34.173 F411.  
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N171 G2 X20.169 Y78.065 I90.398 J-15.096 F306.  
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N179 G1 X46.059 F255.  
N180 G1 X53.33 F240.  
N181 G1 X56.561 F324.  
N182 G1 X59.793 F300.  
N183 G1 X65.448 F243.  
N184 G3 X68.866 Y88.298 I17.553 J5.35 F576.

N185 G3 X83. Y81.65 I14.135 J11.702 F600.

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N188 G0 Z125.

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N190 G0 Z1.

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N193 G2 X34.575 Y75.458 I-1.396 J-6.246 F342.

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N200 G2 Y60.475 I-2.828 J-2.828 F525.

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N203 G0 Z-4.

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N206 G2 X37.549 Y27.871 Z-13. I2.215 J-4.483

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N208 G3 X37.743 Y27.018 I10.428 J29.644 F225.

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N238 G3 X80.7 Y42.906 I-21.486 J-17.044 F288.

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N242 G2 X62.513 Y83.31 I11.972 J23.557

N243 G2 X68.701 Y88.381 I3.094 J2.535

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N245 G3 X74.818 Y83.491 I11.504 J14.392 F348.

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N266 G3 X109.797 Y37.659 I-9.181 J-12.395 F336.

N267 G3 X105.893 Y38.44 I-4.953 J-14.608 F462.

N268 G3 X96.741 Y36.176 I-1.05 J-15.389 F345.

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N273 G2 X83.391 Y20.038 I-3.489 J4.824 F228.

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N275 G2 X77.518 Y23.679 I-0. J5.953

N276 G2 X77.106 Y25.166 I5.482 J2.322 F243.

N277 G3 X76.328 Y28.278 I-15.273 J-2.164 F285.

N278 G3 X74.004 Y32.478 I-14.495 J-5.276 F345.

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N281 G3 X62.201 Y38.423 I-7.294 J-13.591 F225.

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N307 G2 X32.572 Y28.356 I3.559 J1.827

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N309 G0 X144.462 Y79.878

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N327 G3 X145.028 Y56.957 I-14.351 J-11.555 F462.  
N328 G3 X141.577 Y59.306 I-12.028 J-13.957 F279.  
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N330 G2 X135.732 Y72.345 I11.001 J3.601 F600.  
N331 G3 X136.374 Y79.541 I-22.732 J5.655  
N332 G2 X141.483 Y79.878 I2.554 J0.168  
N333 G0 Z125.  
N334 G0 X37.732 Y28.221

N335 G0 Z-12.  
N336 G2 X28.304 Y25.898 Z-15.75 I-5. J0. F200.  
N337 G2 X35.573 Y32.335 Z-19.5 I4.428 J2.323  
N338 G2 X32.732 Y28.221 I-1.421 J-2.057  
N339 G3 X37.538 Y26.977 I10.268 J29.779 F225.  
N340 G2 X35.633 Y26.49 I-1.785 J3.011 F600.  
N341 G2 X32.732 Y28.221 I0.12 J3.498  
N342 G2 X32.877 Y24.452 I-3.452 J-2.02 F246.  
N343 G2 X26.863 Y23.013 I-3.598 J1.748 F231.  
N344 G2 X25.827 Y24.181 I2.417 J3.187 F279.  
N345 G2 X25.082 Y25.7 I9.926 J5.808 F294.  
N346 G2 X23.684 Y29.409 I84.901 J34.117 F243.  
N347 G2 X18.499 Y58.154 I86.299 J30.408 F225.  
N348 G2 X21.362 Y82.587 I91.484 J1.662  
N349 G3 X24.565 Y82.579 I1.638 J15.414 F237.  
N350 G3 X38.1 Y94.5 I-1.564 J15.421 F225.  
N351 G1 X41.304 F234.  
N352 G1 X65.337 F225.  
N353 G3 X66.626 Y91.389 I17.663 J5.5 F231.  
N354 G3 X68.995 Y87.913 I16.374 J8.611 F225.  
N355 G1 X66.572 Y85.823 F267.  
N356 G1 X62.938 Y82.687 F234.  
N357 G2 X62.661 Y83.013 I20.062 J17.313 F600.  
N358 G3 X62.447 Y82.781 I13.662 J-12.773 F372.  
N359 G2 X65.351 Y80.196 I-19.447 J-24.781 F261.



N360 G2 X69.696 Y74.721 I-22.351 J-22.196 F225.

N361 G1 X76.323 Y70.24

N362 G3 X78.45 Y69.841 I6.677 J29.76

N363 G3 X93.712 Y48.197 I34.549 J8.158

N364 G1 X98.815 Y46.958

N365 G3 X98.957 Y48.459 I-5.104 J1.239 F351.

N366 G1 X93.712 Y48.197 F600.

N367 G3 X90.269 Y46.371 I11.132 J-25.146 F291.

N368 G3 X87.118 Y44.076 I14.575 J-23.32 F231.

N369 G3 X83.319 Y40.166 I17.725 J-21.025 F225.

N370 G3 X81.081 Y42.643 I-21.486 J-17.164 F297.

N371 G3 X76.503 Y46.262 I-19.247 J-19.642 F246.

N372 G3 X76.323 Y70.24 I-33.503 J11.738 F600.

N373 G1 X71.117 Y76.314

N374 G2 X62.938 Y82.687 I11.883 J23.686

N375 G2 X68.995 Y87.913 I3.028 J2.613

N376 G3 X71.897 Y85.202 I14.005 J12.087 F459.

N377 G3 X75.312 Y83.174 I11.103 J14.797 F339.

N378 G3 X79.08 Y81.92 I7.689 J16.826 F282.

N379 G3 X83.03 Y81.5 I3.92 J18.08 F234.

N380 G3 X90.013 Y82.881 I-0.03 J18.5 F225.

N381 G3 X89.519 Y78.934 I22.987 J-4.881 F321.

N382 G3 X96.19 Y61.579 I23.481 J-0.934 F330.

N383 G3 X96.756 Y61.019 I16.81 J16.421 F456.

N384 G3 X99.852 Y58.522 I16.244 J16.981 F393.

N385 G3 X106.309 Y55.473 I13.147 J19.478 F237.

N386 G2 X109.892 Y53.681 I-3.274 J-11.024 F231.

N387 G2 X113.431 Y49.366 I-6.857 J-9.233 F228.

N388 G2 X114.522 Y43.893 I-10.396 J-4.918 F225.

N389 G3 X142.023 Y26.85 I18.478 J-0.894

N390 G2 X141.731 Y26.041 I-86.198 J30.695 F600.

N391 G2 X139.802 Y22.678 I-10.797 J3.959 F456.

N392 G2 X131.712 Y18.526 I-8.868 J7.322 F411.

N393 G2 X130.934 Y18.5 I-0.779 J11.474 F447.

N394 G2 X126.309 Y19.471 I0. J11.5 F459.

N395 G2 X119.822 Y27.041 I4.625 J10.529 F600.

N396 G3 X114.069 Y35.507 I-14.978 J-3.99

N397 G3 X108.278 Y38.166 I-9.226 J-12.456 F327.

N398 G3 X107.491 Y38.323 I-3.434 J-15.115 F501.

N399 G3 X104.295 Y38.541 I-2.647 J-15.272 F411.

N400 G3 X96.702 Y36.24 I0.549 J-15.49 F345.

N401 G3 X94.164 Y34.285 I8.142 J-13.189 F300.

N402 G3 X92.083 Y31.849 I10.68 J-11.234 F249.

N403 G3 X89.49 Y25.179 I12.761 J-8.798 F225.

N404 G2 X87.72 Y21.727 I-5.823 J0.806

N405 G2 X83.395 Y20.113 I-4.053 J4.258 F228.

N406 G3 X83. Y20.122 I-0.395 J-8.491

N407 G2 X77.587 Y23.708 I-0. J5.878

N408 G2 X77.18 Y25.177 I5.413 J2.292 F243.

N409 G3 X76.398 Y28.304 I-15.347 J-2.175 F279.

N410 G3 X74.063 Y32.525 I-14.565 J-5.302 F345.

N411 G3 X71.829 Y34.848 I-12.23 J-9.523 F300.

N412 G3 X69.163 Y36.659 I-9.996 J-11.846 F249.

N413 G3 X62.203 Y38.498 I-7.33 J-13.657 F225.

N414 G3 X54.489 Y36.651 I-0.369 J-15.495

N415 G2 X54.136 Y37.306 I-0.176 J0.327 F363.

N416 G3 X58.061 Y39.961 I-11.136 J20.694 F600.

N417 G3 X62.756 Y45.275 I-15.061 J18.039 F309.

N418 G3 X66.5 Y58. I-19.756 J12.725 F330.

N419 G3 X66.158 Y61.993 I-23.5 J0. F378.

N420 G3 X66.008 Y62.781 I-23.158 J-3.993 F540.

N421 G3 X62.65 Y70.889 I-23.008 J-4.781 F543.

N422 G3 X60.712 Y73.444 I-19.65 J-12.889 F480.

N423 G3 X58.444 Y75.712 I-17.712 J-15.444 F360.

N424 G3 X55.889 Y77.65 I-15.444 J-17.712 F276.

N425 G3 X45.403 Y81.377 I-12.889 J-19.65 F249.

N426 G3 X19.5 Y58. I-2.403 J-23.377 F600.

N427 G3 X23.283 Y45.213 I23.5 J0.

N428 G3 X28.026 Y39.889 I19.717 J12.787 F414.

N429 G3 X31.986 Y37.241 I14.974 J18.111 F543.

N430 G3 X38.719 Y34.893 I11.014 J20.759 F348.

N431 G3 X39.503 Y34.762 I4.281 J23.107 F528.

N432 G3 X54.136 Y37.306 I3.497 J23.238 F600.

N433 G1 X54.488 Y36.651

N434 G3 X50.72 Y33.807 I7.345 J-13.649

N435 G3 X48.356 Y30.657 I11.113 J-10.805 F483.

N436 G3 X46.861 Y27.012 I13.478 J-7.654 F348.

N437 G2 X39.361 Y19.069 I-11.108 J2.976 F336.

N438 G2 X35.358 Y18.495 I-3.608 J10.919 F600.

N439 G2 X25.827 Y24.181 I0.395 J11.493

N440 G2 X32.732 Y28.221 I3.452 J2.02

N441 G0 Z125.

N442 G0 X144.495 Y79.755

N443 G0 Z-12.

N444 G2 X138.972 Y78.394 Z-15.75 I-2.929 J0. F200.

N445 G2 X143.23 Y82.166 Z-19.5 I2.594 J1.361

N446 G2 X141.566 Y79.755 I-0.832 J-1.205

N447 G1 X141.569 Y79.675 F225.

N448 G2 X136.626 Y78.667 I-2.559 J-0.077

N449 G2 X136.455 Y79.441 I2.385 J0.931 F324.

N450 G3 X134.938 Y86.422 I-23.455 J-1.441 F225.

N451 G3 X139.351 Y84.792 I7.514 J13.556 F600.

N452 G3 X143.265 Y84.5 I3.102 J15.186 F288.

N453 G2 X144.351 Y80.685 I-87.44 J-26.955 F576.

N454 G2 X145.27 Y76.826 I-88.526 J-23.14 F297.

N455 G2 X146.022 Y72.931 I-89.445 J-19.282 F234.

N456 G2 X147.283 Y54.757 I-90.197 J-15.387 F225.

N457 G3 X144.992 Y57.087 I-14.283 J-11.758 F462.

N458 G3 X141.612 Y59.373 I-11.992 J-14.087 F279.

N459 G2 X136.035 Y65.973 I5.353 J10.178 F270.

N460 G2 X135.805 Y72.327 I10.93 J3.578 F600.

N461 G3 X136.455 Y79.441 I-22.805 J5.673

N462 G2 X141.566 Y79.755 I2.555 J0.157

N463 G0 Z125.

N464 T1 M6

N465 S1100 M3

N466 G0 X16.711 Y83.974

N467 G0 G43 Z1. H1

N468 G1 Z-5. F200.

N469 G2 X16.422 Y84.055 I-0.144 J0.042 F398.75

N470 G2 X16.427 Y84.074 I4.827 J-1.305

N471 G3 X16.454 Y84.177 I-2.893 J0.794

N472 G2 X16.49 Y84.314 I93.529 J-24.36

N473 G2 X21.605 Y87.744 I4.498 J-1.179

N474 G3 X21.764 Y87.723 I0.467 J2.963

N475 G2 X21.783 Y87.721 I-0.514 J-4.974

N476 G2 X21.754 Y87.423 I-0.016 J-0.149

N477 G0 Z125.

N478 G0 X143.123 Y89.35

N479 G0 Z1.

N480 G1 Z-5. F200.

N481 G2 X143.11 Y89.649 I-0.005 J0.15 F398.75

N482 G2 X143.13 I0.263 J-4.993

N483 G3 X143.285 Y89.662 I-0.146 J2.996

N484 G2 X148.063 Y86.413 I0.34 J-4.638

N485 G2 X148.138 Y86.174 I-92.238 J-28.869

N486 G3 X148.142 Y86.16 I2.865 J0.889

N487 G2 X148.155 Y86.117 I-4.769 J-1.504

N488 G2 X147.869 Y86.026 I-0.143 J-0.044

N489 G0 Z125.

N490 G0 X33.401 Y95.707

N491 G0 Z1.

N492 G1 Z-5. F200.

N493 G2 X33.109 Y95.777 I-0.145 J0.037 F398.75

N494 G2 X33.113 Y95.796 I4.871 J-1.127

N495 G3 X33.145 Y95.95 I-2.92 J0.688

N496 G2 X37.697 Y99.65 I4.552 J-0.95

N497 G1 X37.791

N498 G1 X38.091

N499 G0 Z125.

N500 G0 X65.497 Y99.35

N501 G0 Z1.

N502 G1 Z-5. F200.

N503 G2 X65.503 Y99.65 I0.005 J0.15 F398.75

N504 G2 X65.523 I-0.056 J-5.

N505 G3 X65.637 I0.045 J3.

N506 G1 X65.709

N507 G2 X70.175 Y96.294 I-0. J-4.65

N508 G3 X70.214 Y96.161 I2.898 J0.774

N509 G2 X70.22 Y96.143 I-4.766 J-1.511

N510 G2 X69.934 Y96.05 I-0.143 J-0.045

N511 G0 Z125.

N512 G0 X96.066

N513 G0 Z1.

N514 G1 Z-5. F200.

N515 G2 X95.78 Y96.143 I-0.142 J0.048 F398.75

N516 G2 X95.786 Y96.161 I4.772 J-1.493

N517 G3 X95.825 Y96.294 I-2.86 J0.907

N518 G2 X100.292 Y99.65 I4.466 J-1.294

N519 G1 X100.592

N520 G0 Z125.

N521 G0 X143.087 Y89.272

N522 G0 Z-4.

N523 G1 Z-9.75 F200.

N524 G2 X143.075 Y89.572 I-0.004 J0.15 F398.75

N525 G2 X143.094 I0.244 J-4.994

N526 G3 X143.254 Y89.584 I-0.135 J2.997

N527 G3 X143.268 Y89.585 I-0.801 J10.394

N528 G2 X147.991 Y86.391 I0.357 J-4.561

N529 G2 X148.042 Y86.227 I-92.166 J-28.847

N530 G3 X148.074 Y86.125 I2.884 J0.827

N531 G2 X148.08 Y86.107 I-4.755 J-1.548

N532 G2 X147.795 Y86.012 I-0.143 J-0.046

N533 G0 Z125.

N534 G0 X131.754 Y90.176

N535 G0 Z-4.

N536 G1 Z-9.75 F200.

N537 G2 X131.561 Y90.405 I0.906 J0.964 F398.75

N538 G3 X130.863 Y91.39 I-18.561 J-12.405 F209.

N539 G3 X126.637 Y95.675 I-17.863 J-13.39 F178.75

N540 G1 X126.261 Y95.479 F214.5

N541 G2 X126.441 Y96.051 I-0.196 J0.376 F187.

N542 G1 X126.637 Y95.675 F398.75

N543 G1 X128.303 F354.75

N544 G2 X128.94 Y95.224 I0. J-0.675 F398.75

N545 G3 X130.093 Y92.738 I13.513 J4.754

N546 G1 X130.244 Y92.479

N547 G0 Z125.

N548 G0 X130.402 Y84.911

N549 G0 Z-4.

N550 G1 Z-9.75 F200.

N551 G2 X130.122 Y84.806 I-0.141 J-0.052 F398.75

N552 G2 X130.118 Y84.815 I4.671 J1.785

N553 G3 X130.069 Y84.936 I-2.805 J-1.065

N554 G3 X129.029 Y87.085 I-17.069 J-6.936

N555 G3 X126.37 Y90.677 I-16.029 J-9.085 F291.5

N556 G3 X125.299 Y91.718 I-13.37 J-12.677 F335.5

N557 G3 X124.148 Y92.669 I-12.3 J-13.718 F264.

N558 G3 X122.924 Y93.523 I-11.148 J-14.669 F203.5

N559 G3 X121.635 Y94.276 I-9.924 J-15.523 F181.5



N560 G3 X116. Y96.179 I-8.635 J-16.276 F178.75

N561 G1 Y97.414 F189.75

N562 G1 Y99.575 F178.75

N563 G1 X117.2 F253.

N564 G1 X118.4 F233.75

N565 G1 X119.601 F214.5

N566 G1 X122.902 F200.75

N567 G1 X123.202 F327.25

N568 G1 X124.402 F308.

N569 G1 X125.902 F275.

N570 G1 X127.103 F258.5

N571 G1 X128.303 F228.25

N572 G2 X132.512 Y96.795 I0. J-4.575 F225.5

N573 G2 X132.619 Y96.518 I-4.208 J-1.795 F398.75

N574 G3 X137.276 Y90.93 I9.834 J3.46

N575 G0 Z125.

N576 G0 X88.33 Y87.352

N577 G0 Z-4.

N578 G1 Z-9.75 F200.

N579 G2 X88.219 Y87.631 I-0.054 J0.14 F398.75

N580 G2 X88.237 Y87.638 I1.897 J-4.626

N581 G3 X88.364 Y87.693 I-1.127 J2.78

N582 G3 X90.229 Y88.688 I-5.364 J12.307

N583 G3 X91.218 Y89.384 I-7.23 J11.312 F255.75

N584 G3 X92.139 Y90.166 I-8.218 J10.616 F198.

N585 G3 X95.896 Y96.271 I-9.139 J9.833 F178.75  
N586 G1 X97.337 Y95.854 F192.5  
N587 G1 X98.778 Y95.437 F178.75  
N588 G1 X99.108 Y94.311 F200.75  
N589 G2 X100.053 Y95.07 I13.891 J-16.311 F214.5  
N590 G1 X95.896 Y96.271 F398.75  
N591 G2 X96.525 Y97.598 I4.395 J-1.27 F220.  
N592 G2 X97.784 Y98.827 I3.766 J-2.598 F206.25  
N593 G2 X100.292 Y99.575 I2.508 J-3.826 F200.75  
N594 G1 X101.505 F187.  
N595 G1 X110. F178.75  
N596 G1 X111.5 F239.25  
N597 G1 X113. F398.75  
N598 G1 X116.  
N599 G2 Y98.075 I0. J-0.75  
N600 G1 X116.244 Y97.659  
N601 G2 X116. Y96.179 I-0.122 J-0.74  
N602 G3 X114.805 Y96.336 I-3. J-18.179 F365.75  
N603 G3 X113. Y96.425 I-1.805 J-18.336 F343.75  
N604 G3 X111.795 Y96.385 I0. J-18.425 F321.75  
N605 G3 X110. Y96.179 I1.205 J-18.385 F280.5  
N606 G3 X108.539 Y95.876 I3. J-18.179 F247.5  
N607 G3 X104.37 Y94.278 I4.461 J-17.877 F206.25  
N608 G3 X104.107 Y94.137 I8.63 J-16.279 F390.5  
N609 G3 X102.831 Y93.364 I8.893 J-16.137 F379.5

N610 G3 X101.622 Y92.491 I10.169 J-15.364 F294.25

N611 G3 X100.487 Y91.523 I11.378 J-14.491 F211.75

N612 G3 X98.288 Y89.092 I12.513 J-13.524 F198.

N613 G3 X95.039 Y82.109 I14.712 J-11.092 F398.75

N614 G3 X95.012 Y81.991 I2.911 J-0.726

N615 G2 X95.008 Y81.973 I-4.896 J1.014

N616 G2 X94.714 Y82.032 I-0.147 J0.031

N617 G0 Z125.

N618 G0 X152.047 Y54.352

N619 G0 Z-4.

N620 G1 Z-9.75 F200.

N621 G2 X152.347 Y54.335 I0.15 J-0.01 F398.75

N622 G2 Y54.316 I-4.995 J0.219

N623 G3 X152.343 Y54.21 I2.997 J-0.143

N624 G2 X152.193 Y51.225 I-96.518 J3.335

N625 G2 X152.084 Y49.735 I-96.368 J6.319 F253.

N626 G2 X151.952 Y48.247 I-96.259 J7.809 F200.75

N627 G2 X151.796 Y46.761 I-96.127 J9.297 F181.5

N628 G2 X151.239 Y42.615 I-95.971 J10.783 F178.75

N629 G1 X150.033 Y42.842 F206.25

N630 G1 X148.827 Y43.07 F184.25

N631 G1 X146.414 Y43.524 F178.75

N632 G3 X146.273 Y45.014 I-13.414 J-0.525 F305.25

N633 G3 X143.578 Y51.266 I-13.273 J-2.014 F398.75

N634 G3 X143.492 Y51.375 I-2.401 J-1.799

N635 G2 X143.48 Y51.39 I3.859 J3.179

N636 G0 Z125.

N637 G0 X139.852 Y31.108

N638 G0 Z-4.

N639 G1 Z-9.75 F200.

N640 G2 X139.707 Y31.371 I-0.071 J0.132 F398.75

N641 G2 X139.724 Y31.38 I2.454 J-4.356

N642 G3 X139.843 Y31.45 I-1.462 J2.62

N643 G3 X141.555 Y32.654 I-6.843 J11.55

N644 G3 X142.653 Y33.67 I-8.555 J10.346 F236.5

N645 G3 X143.631 Y34.802 I-9.653 J9.33 F187.

N646 G3 X145.303 Y37.628 I-10.631 J8.198 F178.75

N647 G3 X145.737 Y38.758 I-12.303 J5.372 F239.25

N648 G3 X146.192 Y40.514 I-12.737 J4.242 F398.75

N649 G3 X146.414 Y43.524 I-13.192 J2.486

N650 G2 X147.913 Y43.583 I0.749 J0.029

N651 G2 X147.666 Y40.236 I-14.913 J-0.583

N652 G2 X147.18 Y38.343 I-14.666 J2.764

N653 G1 X148.875 Y38.024 F214.5

N654 G3 X149.255 Y39.936 I-93.05 J19.521 F398.75

N655 G3 X149.757 Y42.847 I-93.43 J17.608

N656 G2 X151.239 Y42.615 I0.741 J-0.116

N657 G2 X150.729 Y39.658 I-95.414 J14.929

N658 G2 X150.44 Y38.186 I-94.904 J17.886

N659 G2 X150.128 Y36.719 I-94.615 J19.358 F211.75

N660 G2 X149.512 Y34.101 I-94.303 J20.825 F192.5

N661 G2 X146.935 Y25.518 I-93.687 J23.443 F398.75

N662 G3 X146.899 Y25.417 I2.807 J-1.058

N663 G2 X146.893 Y25.4 I-4.738 J1.597

N664 G2 X146.608 Y25.494 I-0.142 J0.048

N665 G0 Z125.

N666 G0 X16.767 Y83.889

N667 G0 Z-4.

N668 G1 Z-9.75 F200.

N669 G2 X16.478 Y83.97 I-0.144 J0.042 F398.75

N670 G2 X16.483 Y83.988 I4.828 J-1.302

N671 G3 X16.509 Y84.091 I-2.894 J0.792

N672 G2 X16.562 Y84.295 I93.474 J-24.275

N673 G2 X21.602 Y87.669 I4.426 J-1.16

N674 G3 X21.64 Y87.664 I1.398 J10.331

N675 G3 X21.799 Y87.644 I0.454 J2.965

N676 G2 X21.818 Y87.642 I-0.493 J-4.976

N677 G2 X21.874 Y87.361 I-0.015 J-0.149

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N679 G0 X33.465 Y95.649

N680 G0 Z-4.

N681 G1 Z-9.75 F200.

N682 G2 X33.173 Y95.721 I-0.145 J0.037 F398.75

N683 G2 X33.178 Y95.74 I4.867 J-1.146

N684 G3 X33.211 Y95.896 I-2.917 J0.699

N685 G3 X33.215 Y95.915 I-10.211 J2.104  
N686 G2 X37.697 Y99.575 I4.482 J-0.915  
N687 G1 X37.851  
N688 G3 X37.965 I0.069 J2.999  
N689 G2 X37.985 I0.075 J-5.  
N690 G2 X37.991 Y99.275 I0.002 J-0.15  
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N692 G0 X65.441  
N693 G0 Z-4.  
N694 G1 Z-9.75 F200.  
N695 G2 X65.448 Y99.575 I0.005 J0.15 F398.75  
N696 G2 X65.467 I-0.056 J-5.  
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N698 G1 X65.709  
N699 G2 X70.104 Y96.271 I-0. J-4.575  
N700 G3 X70.115 Y96.233 I12.896 J3.729  
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N702 G2 X70.16 Y96.082 I-4.762 J-1.526  
N703 G2 X69.908 Y95.934 I-0.143 J-0.045  
N704 G0 Z125.  
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N710 G3 X143.217 Y89.506 I-0.123 J2.997  
N711 G3 X143.273 Y89.511 I-0.765 J10.472  
N712 G2 X147.92 Y86.368 I0.351 J-4.487  
N713 G2 X147.989 Y86.146 I-92.095 J-28.824  
N714 G3 X148.02 Y86.044 I2.884 J0.825  
N715 G2 X148.026 Y86.026 I-4.756 J-1.545  
N716 G2 X147.741 Y85.931 I-0.143 J-0.046  
N717 G0 Z125.  
N718 G0 X131.934 Y90.036  
N719 G0 Z-8.75  
N720 G1 Z-14.625 F200.  
N721 G2 X131.742 Y90.267 I0.911 J0.953 F398.75  
N722 G3 X131.495 Y90.636 I-18.742 J-12.267  
N723 G1 X130.378 Y92.133 F181.5  
N724 G3 X126.856 Y95.6 I-17.378 J-14.133 F178.75  
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N726 G2 X126.657 Y95.975 I-0.199 J0.375 F187.  
N727 G1 X126.856 Y95.6 F398.75  
N728 G1 X128.303 F379.5  
N729 G2 X128.869 Y95.199 I0. J-0.6 F398.75  
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N731 G1 X130.478 Y92.404  
N732 G0 Z125.  
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N734 G0 Z-8.75

N735 G1 Z-14.625 F200.  
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N738 G3 X130.2 Y84.81 I-2.814 J-1.04  
N739 G3 X129.183 Y86.964 I-17.201 J-6.81  
N740 G3 X126.568 Y90.576 I-16.183 J-8.964 F291.5  
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N747 G1 Y99.5 F178.75  
N748 G1 X117.2 F261.25  
N749 G1 X118.4 F239.25  
N750 G1 X119.601 F220.  
N751 G1 X123.202 F203.5  
N752 G1 X123.502 F324.5  
N753 G1 X124.702 F305.25  
N754 G1 X125.902 F275.  
N755 G1 X127.103 F255.75  
N756 G1 X128.303 F228.25  
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N758 G2 X132.548 Y96.493 I-4.133 J-1.781 F398.75  
N759 G3 X137.363 Y90.795 I9.904 J3.485



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N761 G0 X88.26 Y87.242

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N763 G1 Z-14.625 F200.

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N767 G3 X90.151 Y88.55 I-5.297 J12.417

N768 G3 X91.373 Y89.41 I-7.151 J11.45 F236.5

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N774 G2 X99.571 Y94.79 I13.894 J-16.407 F305.25

N775 G1 X95.968 Y96.25 F398.75

N776 G2 X96.462 Y97.363 I4.323 J-1.25 F225.5

N777 G2 X97.236 Y98.304 I3.829 J-2.363 F209.

N778 G2 X98.51 Y99.132 I3.055 J-3.304 F198.

N779 G2 X100.292 Y99.5 I1.782 J-4.132 F192.5

N780 G1 X101.809 F181.5

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N782 G1 X111.2 F239.25

N783 G1 X113. F398.75

N784 G1 X116.

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N792 G3 X108.818 Y96.021 I3. J-18.255 F264.  
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N794 G3 X104.05 Y94.191 I5.347 J-17.71 F200.75  
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N1082 G3 X98.033 Y89.146 I3.073 J-0.893 F544.5

N1083 G3 X98.756 Y87.728 I3.123 J0.698 F264.

N1084 G3 X102.785 Y87.089 I2.4 J2.116 F214.5

N1085 G3 X103.419 Y87.581 I-1.629 J2.754 F264.

N1086 G2 X126.52 Y77.099 I9.581 J-9.581 F297.

N1087 G2 X126.149 Y74.729 I-13.52 J0.901 F266.75

N1088 G3 X136.98 Y50.567 I20.816 J-5.178 F264.

N1089 G2 X133. Y34.45 I-3.98 J-7.567 F313.5

N1090 G2 X124.889 Y40.296 I0. J8.55

N1091 G2 X124.46 Y43.413 I8.111 J2.704 F266.75

N1092 G3 X123.632 Y50.439 I-21.425 J1.036 F264.

N1093 G2 X124.851 Y52. I1.97 J-0.282 F211.75

N1094 G2 X127.114 Y51.452 I0.752 J-1.843 F511.5

N1095 G1 X128.171 Y50.217 F379.5

N1096 G1 X129.229 Y48.983 F302.5

N1097 G1 X130.286 Y47.749 F255.75

N1098 G3 X134.187 Y45.256 I16.679 J21.802 F266.75

N1099 G2 X133.784 Y40.574 I-1.187 J-2.257 F453.75

N1100 G2 X133. Y40.45 I-0.784 J2.426 F618.75

N1101 G2 X131.154 Y41.241 I0. J2.55 F783.75

N1102 G1 X123.632 Y50.439 F1375.

N1103 G3 X122.99 Y52.316 I-20.597 J-5.991 F352.

N1104 G3 X121.807 Y54.827 I-19.955 J-7.867 F277.75

N1105 G3 X120.768 Y56.517 I-18.772 J-10.379 F266.75

N1106 G3 X109.898 Y64.771 I-17.733 J-12.068 F264.

N1107 G3 X109.142 Y65.011 I-6.863 J-20.322 F286.

N1108 G2 X99.634 Y80.228 I3.858 J12.989 F297.

N1109 G2 X99.706 Y80.621 I13.365 J-2.228 F1267.75

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N1112 G3 X102.942 Y83.96 I2.974 J-0.392 F338.25  
N1113 G3 X107.661 Y83.338 I2.598 J1.5 F217.25  
N1114 G2 X120.427 Y79.357 I5.338 J-5.338 F319.  
N1115 G2 X120.546 Y77.762 I-7.427 J-1.357 F305.25  
N1116 G2 X120.326 Y76.177 I-7.546 J0.238 F272.25  
N1117 G3 X119.714 Y66.251 I26.639 J-6.626 F266.75  
N1118 G1 X120.24 Y64.713 F1210.  
N1119 G1 X121.03 Y62.406 F1375.  
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N1122 G3 X117.064 Y68.043 I-15.38 J-22.737 F368.5  
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N1129 G3 X109.006 Y78.319 I2.38 J1.826 F272.25  
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N1131 G3 X111.904 Y79.096 I-1.5 J2.598 F390.5  
N1132 G2 X113.39 Y79.5 I1.096 J-1.096 F778.25  
N1133 G2 X114.549 Y78.025 I-0.39 J-1.5 F500.5  
N1134 G2 X114.504 Y77.626 I-1.55 J-0.025 F838.75

N1135 G3 X114.313 Y76.815 I32.461 J-8.074 F1375.

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N1137 G0 X28.083 Y70.737

N1138 G0 Z-1.5

N1139 G1 Z-3. F275.

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N1145 G2 X43. Y44.45 I-13.55 J0.

N1146 G2 X29.638 Y60.251 I0. J13.55

N1147 G2 X29.71 Y60.643 I13.362 J-2.251 F1278.75

N1148 G2 X33.419 Y67.581 I13.29 J-2.643 F1375.

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N1155 G2 X37.661 Y63.339 I7.244 J2.127 F1375.

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N1163 G2 X44.445 Y57.44 I-1.432 J-0.593 F1375.

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N1165 S1250

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N1167 G0 Z0.45

N1168 G1 Z-5.5 F200.

N1169 G1 X82.937 F250.

N1170 G3 X83. Y15.622 I0.063 J-1.999

N1171 G2 X83.186 Y15.618 I0. J-4.

N1172 G3 X93.948 Y24.561 I0.482 J10.367

N1173 G2 X103.518 Y33.971 I10.896 J-1.51

N1174 G2 X115.473 Y25.883 I1.326 J-10.92

N1175 G3 X130.934 Y14. I15.461 J4.117

N1176 G3 X145.956 Y24.491 I-0. J16.

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N1179 G2 X132.077 Y96.327 I-0.86 J10.966

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N1181 G1 X100.292

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N1192 G3 X35.203 Y13.998 I14.846 J5.966  
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N1202 G1 Z-5.5 F200.  
N1203 G1 Y58.063 F250.  
N1204 G3 X62. Y58. I-1.999 J-0.063  
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N1206 G2 X62. I19. J0.  
N1207 G3 X65.999 Y57.937 I2. J0.  
N1208 G1 Y58.  
N1209 G0 Z125.

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N1309 G1 Y58.

N1310 G0 Z125.

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N1315 G3 X133. Y29. I-0.063 J1.999

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N1323 G0 Z125.

N1324 S1100

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N1326 G0 Z-18.5

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N1332 G2 X82.008 Y51.158 I29.913 J28.039 F651.75

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N1334 G2 X79.995 Y53.676 I32.023 J25.603 F330.

N1335 G2 X79.065 Y54.992 I33.005 J24.324 F236.5  
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N1344 G2 X80.424 Y45.259 I-17.331 J-23.252 F305.25  
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N1359 G2 X75.301 Y68.94 I5.766 J31.476 F209.



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N1427 G1 X43.199 F206.25

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N1429 G2 X40.31 Y82.855 I-19.197 J12.669 F206.25

N1430 G1 X37.256 Y80.271

N1431 G3 X26.943 Y74.467 I5.744 J-22.271

N1432 G2 X25.697 Y76.897 I13.367 J8.388 F233.75

N1433 G2 X25.755 Y77.181 I84.286 J-17.081 F302.5

N1434 G3 X33.533 Y79.832 I-2.755 J20.819 F1375.

N1435 G3 X36.436 Y81.86 I-10.533 J18.168 F979.

N1436 G1 X40.31 Y82.855 F1375.

N1437 G2 X42.298 Y82.99 I2.69 J-24.855 F426.25

N1438 G2 X44.29 Y82.967 I0.702 J-24.99 F393.25

N1439 G2 X46.274 Y82.785 I-1.29 J-24.967 F352.

N1440 G2 X50.548 Y81.833 I-3.274 J-24.785 F283.25

N1441 G2 X54.236 Y80.333 I-7.548 J-23.833 F448.25

N1442 G2 X54.591 Y80.151 I-11.236 J-22.333 F442.75

N1443 G2 X56.318 Y79.157 I-11.591 J-22.151 F360.25

N1444 G2 X57.96 Y78.03 I-13.318 J-21.157 F269.5

N1445 G2 X59.508 Y76.775 I-14.96 J-20.03 F239.25

N1446 G2 X62.023 Y74.221 I-16.508 J-18.775 F228.25

N1447 G2 X63.254 Y72.655 I-19.023 J-16.221 F426.25

N1448 G2 X64.357 Y70.995 I-20.254 J-14.655 F338.25

N1449 G2 X67.782 Y61.293 I-21.357 J-12.995 F286.

N1450 G2 X67.636 Y53.751 I-24.782 J-3.293 F1375.

N1451 G3 X67.336 Y55.656 I-2.956 J0.51 F973.5

N1452 G3 X65.937 Y56.984 I-2.656 J-1.395 F286.

N1453 G3 X61.815 Y55.152 I-1.258 J-2.724 F214.5

N1454 G3 X61.723 Y54.771 I2.864 J-0.891 F277.75

N1455 G2 X60.779 Y51.298 I-18.723 J3.229 F291.5

N1456 G2 X60.633 Y50.925 I-17.779 J6.702 F324.5

N1457 G2 X59.975 Y49.465 I-17.633 J7.075 F294.25

N1458 G2 X59.196 Y48.066 I-16.975 J8.535 F247.5

N1459 G2 X58.302 Y46.737 I-16.196 J9.934 F217.25

N1460 G2 X52.004 Y41.269 I-15.302 J11.263 F206.25

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N1462 G2 X55.59 Y38.814 I8.056 J-14.97 F332.75

N1463 G2 X59.447 Y39.834 I6.243 J-15.812 F247.5

N1464 G2 X59.844 Y39.885 I2.386 J-16.831 F327.25

N1465 G2 X62.239 Y39.997 I1.99 J-16.883 F294.25

N1466 G2 X76.421 Y31.731 I-0.405 J-16.995

N1467 G2 X77.174 Y30.327 I-14.588 J-8.729 F387.75

N1468 G2 X77.342 Y29.965 I-15.341 J-7.325 F379.5

N1469 G2 X78.049 Y28.104 I-15.509 J-6.963 F297.

N1470 G2 X78.665 Y25.387 I-16.216 J-5.102 F214.5

N1471 G3 X79.587 Y23.258 I4.335 J0.613 F211.75

N1472 G3 X83. Y21.622 I3.413 J2.742 F214.5

N1473 G2 X83.464 Y21.611 I0. J-10. F225.5

N1474 G3 X87.821 Y24.598 I0.203 J4.374 F222.75

N1475 G3 X88.005 Y25.386 I-4.153 J1.387 F330.

N1476 G2 X102.794 Y39.927 I16.839 J-2.335 F294.25

N1477 G2 X104.763 Y40.051 I2.049 J-16.876 F272.25

N1478 G2 X106.733 Y39.946 I0.081 J-17. F231.

N1479 G2 X108.677 Y39.613 I-1.889 J-16.895 F209.

N1480 G2 X113.765 Y37.522 I-3.833 J-16.562 F206.25

N1481 G2 X113.383 Y39.105 I19.235 J5.478 F374.

N1482 G2 X113.055 Y41.525 I19.617 J3.895 F242.

N1483 G2 X113.024 Y43.966 I19.945 J1.475 F253.

N1484 G3 X105.882 Y54.035 I-9.988 J0.483 F250.25

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N1486 G2 X88.337 Y73.91 I24.258 J6.044 F258.5

N1487 G2 X88.089 Y75.89 I24.663 J4.09 F222.75

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N1490 G1 X88.143 Y80.673 F1375.

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N1492 G2 X85.792 Y80.196 I-3.188 J19.744 F288.75

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N1495 G2 X66.231 Y89.101 I15.604 J12.51 F261.25

N1496 G2 X65.232 Y90.819 I16.769 J10.899 F222.75

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N1499 G1 X44.014 F253.

N1500 G1 X42.028 F222.75

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N1504 G2 X27.292 Y81.55 I-5.826 J15.971 F415.25

N1505 G2 X25.719 Y81.218 I-4.292 J16.45 F313.5

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N1507 G2 X22.514 Y81.007 I-1.121 J16.963 F209.

N1508 G3 X22.068 Y79.073 I87.469 J-21.19 F343.75

N1509 G3 X21.664 Y77.129 I87.915 J-19.256 F280.5

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N1511 G3 X20.987 Y73.218 I88.679 J-15.36 F214.5  
N1512 G3 X19.998 Y58.182 I88.996 J-13.401 F206.25  
N1513 G3 X22.467 Y38.821 I89.985 J1.636  
N1514 G1 X24.328 Y39.267 F228.25  
N1515 G1 X26.561 Y39.803 F206.25  
N1516 G2 X27.724 Y40.566 I2.515 J-2.566  
N1517 G1 X29.075 Y37.237 F209.  
N1518 G3 X32.041 Y28.497 I80.908 J22.581 F206.25  
N1519 G3 X35.615 Y25.991 I3.712 J1.491  
N1520 G3 X39.617 Y28.953 I0.138 J3.998  
N1521 G2 X41.154 Y33.068 I22.217 J-5.951  
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N1523 G1 X41.154 Y33.068 F1375.  
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N1538 G2 X50.536 Y40.558 I-9.004 J16.731 F420.75  
N1539 G2 X49.012 Y39.976 I-7.536 J17.442 F288.75  
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N1545 G2 X31.789 Y42.66 I9.538 J16.432 F371.25  
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N1550 G2 X24.012 Y57.334 I18.813 J2.656 F429.  
N1551 G2 X24.047 Y59.331 I18.988 J0.666 F390.5  
N1552 G2 X24.291 Y61.314 I18.953 J-1.331 F346.5  
N1553 G2 X24.743 Y63.26 I18.709 J-3.314 F302.5  
N1554 G2 X27.277 Y68.666 I18.257 J-5.26 F247.5  
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N1557 G2 X36.232 Y75.753 I8.238 J-17.121 F412.5  
N1558 G2 X37.749 Y76.26 I6.768 J-17.753 F335.5  
N1559 G2 X61.589 Y61.928 I5.251 J-18.26 F291.5



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N1566 G3 X56.621 Y32.689 I-1.065 J2.805 F288.75

N1567 G2 X62.095 Y33.999 I5.212 J-9.686 F302.5

N1568 G2 X71.994 Y27.216 I-0.262 J-10.997

N1569 G2 X72.724 Y24.546 I-10.161 J-4.214 F255.75

N1570 G3 X81.007 Y15.815 I10.276 J1.455 F253.

N1571 G3 X83. Y15.622 I1.993 J10.185 F258.5

N1572 G2 X83.186 Y15.618 I0. J-4. F255.75

N1573 G3 X93.948 Y24.562 I0.482 J10.367 F253.

N1574 G2 X103.518 Y33.971 I10.896 J-1.511 F302.5

N1575 G2 X108.241 Y33.513 I1.326 J-10.92

N1576 G2 X110.071 Y32.73 I-3.397 J-10.462 F258.5

N1577 G2 X111.729 Y31.63 I-5.227 J-9.679 F214.5

N1578 G2 X113.894 Y29.304 I-6.885 J-8.579 F206.25

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N1580 G1 X117.185 Y31.577 F231.

N1581 G2 X118.427 Y32.435 I4.337 J-4.956 F214.5

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N1588 G2 X141.246 Y25.359 I-1.742 J-2.235 F305.25  
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N1590 G2 X136.922 Y23.388 I-5.835 J19.13 F753.5  
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N1593 G2 X127.171 Y23.869 I0. J20. F605.  
N1594 G2 X121.522 Y26.622 I5.83 J19.131 F1375.  
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N1598 G2 X114.741 Y27.852 I-9.05 J-6.253 F332.75  
N1599 G2 X115.473 Y25.883 I-9.897 J-4.8 F264.  
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N1601 G3 X143.173 Y19.694 I-0. J16.  
N1602 G3 X143.425 Y20.002 I-12.239 J10.306 F319.  
N1603 G3 X144.57 Y21.629 I-12.491 J9.998 F305.25  
N1604 G3 X145.956 Y24.491 I-13.636 J8.371 F244.75  
N1605 G3 X146.624 Y26.375 I-90.131 J33.053 F214.5  
N1606 G3 X151.096 Y69.356 I-90.799 J31.169 F206.25  
N1607 G1 X149.508 Y69.159 F236.5  
N1608 G1 X147.92 Y68.962 F211.75  
N1609 G1 X141.172 Y68.125 F206.25

N1610 G3 X140.966 Y69.672 I-85.347 J-10.581 F233.75

N1611 G3 X141.202 Y67.881 I5.999 J-0.121 F500.5

N1612 G3 X141.172 Y68.125 I-85.377 J-10.336 F1375.

N1613 G3 X143.785 Y66.473 I1.985 J0.246 F332.75

N1614 G3 X145.141 Y68.617 I-0.629 J1.899 F1375.

N1615 G3 X144.876 Y70.584 I-89.316 J-11.073 F299.75

N1616 G3 X144.566 Y72.545 I-89.051 J-13.04 F220.

N1617 G3 X142.156 Y82.981 I-88.741 J-15. F206.25

N1618 G2 X140.522 Y83.089 I0.297 J16.997 F214.5

N1619 G2 X137.324 Y83.771 I1.93 J16.89 F206.25

N1620 G1 X135.687 Y85.276

N1621 G2 X136.004 Y85.56 I1.637 J-1.505 F349.25

N1622 G1 X137.324 Y83.771 F1375.

N1623 G2 X137.706 Y81.822 I-24.325 J-5.771 F332.75

N1624 G2 X137.931 Y79.849 I-24.706 J-3.822 F299.75

N1625 G2 X137.78 Y74.696 I-24.931 J-1.849 F261.25

N1626 G2 X137.725 Y74.302 I-24.78 J3.304 F426.25

N1627 G2 X137.26 Y71.965 I-24.725 J3.698 F352.

N1628 G3 X136.973 Y69.973 I9.705 J-2.414 F343.75

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N1630 G3 X137.355 Y66.785 I9.93 J1.188 F316.25

N1631 G3 X137.924 Y65.278 I9.61 J2.767 F291.5

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N1633 G3 X139.744 Y62.632 I8.238 J5.67 F247.5

N1634 G3 X140.949 Y61.563 I7.22 J6.919 F233.75

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N1637 G2 X145.822 Y58.349 I-12.221 J-15.831 F550.  
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N1639 G2 X146.432 Y56.075 I-1.156 J2.051 F343.75  
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N1641 G3 X145.754 Y61.12 I-89.997 J-0.804 F1265.  
N1642 G1 X151.053 Y68.361 F1375.  
N1643 G3 X151.096 Y69.356 I-2.934 J0.625  
N1644 G3 X148.665 Y81.972 I-95.271 J-11.811 F272.25  
N1645 G3 X148.243 Y83.523 I-92.84 J-24.428 F255.75  
N1646 G3 X147.443 Y86.219 I-92.418 J-25.978 F220.  
N1647 G3 X144.139 Y88.991 I-3.818 J-1.195 F217.25  
N1648 G3 X143.312 Y89.012 I-0.514 J-3.967 F269.5  
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N1657 G3 X112.293 Y97.293 I0. J-1. F209.  
N1658 G3 X113. Y97. I0.707 J0.707 F407.  
N1659 G2 X114.602 Y96.932 I-0. J-19. F712.25

N1660 G2 X116.192 Y96.73 I-1.602 J-18.932 F585.75  
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N1663 G2 X120.782 Y95.333 I-6.293 J-17.927 F316.25  
N1664 G2 X122.215 Y94.615 I-7.782 J-17.333 F269.5  
N1665 G2 X123.583 Y93.779 I-9.216 J-16.615 F236.5  
N1666 G2 X126.084 Y91.777 I-10.583 J-15.779 F214.5  
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N1669 G2 X129.326 Y87.718 I-14.462 J-12.322 F236.5  
N1670 G2 X129.528 Y87.371 I-16.326 J-9.718 F374.  
N1671 G2 X130.259 Y85.944 I-16.528 J-9.371 F352.  
N1672 G2 X130.867 Y84.461 I-17.259 J-7.944 F294.25  
N1673 G2 X131.912 Y76.177 I-17.867 J-6.461 F291.5  
N1674 G2 X131.438 Y73.413 I-18.912 J1.823 F261.25  
N1675 G3 X139.517 Y55.39 I15.527 J-3.862 F258.5  
N1676 G2 X140.887 Y54.566 I-6.517 J-12.39 F382.25  
N1677 G2 X142.155 Y53.591 I-7.887 J-11.566 F321.75  
N1678 G2 X146.793 Y45.399 I-9.155 J-10.591 F239.25  
N1679 G2 X146.976 Y43.81 I-13.793 J-2.399 F566.5  
N1680 G2 X146.977 Y42.211 I-13.976 J-0.81 F547.25  
N1681 G2 X146.796 Y40.622 I-13.977 J0.789 F503.25  
N1682 G2 X146.435 Y39.064 I-13.796 J2.378 F445.5  
N1683 G2 X145.899 Y37.558 I-13.435 J3.936 F385.  
N1684 G2 X145.194 Y36.122 I-12.899 J5.442 F330.

N1685 G2 X144.33 Y34.776 I-12.194 J6.878 F283.25

N1686 G2 X142.172 Y32.423 I-11.33 J8.224 F253.

N1687 G2 X141.866 Y32.165 I-9.172 J10.577 F418.

N1688 G2 X140.572 Y31.225 I-8.866 J10.835 F376.75

N1689 G2 X139.18 Y30.438 I-7.572 J11.775 F305.25

N1690 G2 X133. Y29. I-6.18 J12.562 F297.

N1691 G2 X126.499 Y30.601 I0. J14.

N1692 G2 X124.178 Y32.129 I6.501 J12.399 F481.25

N1693 G2 X122.728 Y33.488 I8.822 J10.87 F396.

N1694 G2 X120.657 Y36.394 I10.272 J9.512 F266.75

N1695 G2 X119.159 Y40.901 I12.343 J6.606 F297.

N1696 G2 X119.017 Y43.676 I13.841 J2.099 F264.

N1697 G3 X107.59 Y59.787 I-15.981 J0.772 F258.5

N1698 G2 X94.019 Y77.156 I5.409 J18.213 F291.5

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N1702 G2 X94.8 Y83.455 I18.671 J-3.519 F209.

N1703 G2 X107.883 Y96.297 I18.2 J-5.455 F206.25

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N1707 G1 X109.029 F495.

N1708 G1 X107.043 F396.

N1709 G1 X105.058 F321.75

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N1711 G1 X100.292 F225.5  
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N1716 G2 X94.351 Y91.805 I-12.213 J6.843 F374.  
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N1718 G2 X90.59 Y88.236 I-10.339 J9.439 F247.5  
N1719 G2 X90.25 Y88.024 I-7.59 J11.764 F335.5  
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N1723 G2 X70.415 Y93.867 I11.801 J7.531 F272.25  
N1724 G2 X69.551 Y96.111 I12.585 J6.132 F220.  
N1725 G3 X66.105 Y98.98 I-3.843 J-1.111 F217.25  
N1726 G3 X65.709 Y99. I-0.396 J-3.98 F269.5  
N1727 G1 X42.099 F275.  
N1728 G1 X40.498 F258.5  
N1729 G1 X37.697 F220.  
N1730 G3 X34.008 Y96.546 I0. J-4. F217.25  
N1731 G3 X33.778 Y95.8 I3.689 J-1.546 F272.25  
N1732 G2 X25.532 Y87.295 I-10.778 J2.2 F302.5  
N1733 G2 X23.94 Y87.04 I-2.532 J10.705 F275.  
N1734 G2 X21.525 Y87.099 I-0.94 J10.96 F217.25

N1735 G3 X17.118 Y84.149 I-0.537 J-3.964 F214.5  
N1736 G3 X13.999 Y58.073 I92.864 J-24.332 F272.25  
N1737 G3 X20.177 Y25.893 I95.984 J1.745  
N1738 G3 X20.907 Y24.022 I89.806 J33.924 F261.25  
N1739 G3 X35.203 Y13.998 I14.846 J5.966 F258.5  
N1740 G3 X51.208 Y25.848 I0.55 J15.991  
N1741 G2 X51.745 Y27.386 I10.625 J-2.846 F1086.25  
N1742 G2 X56.621 Y32.689 I10.088 J-4.384 F1375.  
N1743 G3 X54.725 Y36.211 I-0.948 J1.761  
N1744 G0 Z125.  
N1745 ( 3 Kreistaschen)  
N1746 T3 M6  
N1747 S1100 M3  
N1748 G0 X43. Y58.  
N1749 G0 G43 Z125. H3  
N1750 G0 Z-2.  
N1751 G0 X46.  
N1752 G3 Z-3. I-3. J0. F200.  
N1753 G1 X43. F250.  
N1754 G0 X46.  
N1755 G3 Z-4.5 I-3. J0. F200.  
N1756 G1 X43. F250.  
N1757 G1 X45.75  
N1758 G3 X40.25 I-2.75 J0.  
N1759 G3 X45.75 I2.75 J0.



N1760 G3 X48.5 I1.375 J0.

N1761 G3 X37.5 I-5.5 J0.

N1762 G3 X48.5 I5.5 J0.

N1763 G3 X43. I-2.75 J0. F750.

N1764 G0 Z-2.

N1765 G0 X48.25

N1766 G1 Z-3.

N1767 G1 Z-4.5 F200.

N1768 G3 X49. I0.375 J0. F250.

N1769 G3 X37. I-6. J0.

N1770 G3 X49. I6. J0.

N1771 G3 X48.25 I-0.375 J0.

N1772 G0 X43.

N1773 G0 X46.

N1774 G3 Z-5. I-3. J0. F200.

N1775 G1 X43. F250.

N1776 G1 X46.

N1777 G3 X40. I-3. J0.

N1778 G3 X46. I3. J0.

N1779 G3 X49. I1.5 J0.

N1780 G3 X37. I-6. J0.

N1781 G3 X49. I6. J0.

N1782 G3 X43. I-3. J0. F750.

N1783 G0 Z125.

N1784 S1100

N1785 G0 X113. Y78.

N1786 G0 Z-4.5

N1787 G0 X116.

N1788 G3 Z-5.5 I-3. J0. F200.

N1789 G1 X113. F250.

N1790 G0 X116.

N1791 G3 Z-8.5 I-3. J0. F200.

N1792 G1 X113. F250.

N1793 G1 X116.

N1794 G3 X110. I-3. J0.

N1795 G3 X116. I3. J0.

N1796 G3 X119. I1.5 J0.

N1797 G3 X107. I-6. J0.

N1798 G3 X119. I6. J0.

N1799 G3 X113. I-3. J0. F750.

N1800 G0 Z-4.5

N1801 G0 X119.

N1802 G1 Z-5.5

N1803 G1 Z-8.5 F200.

N1804 G3 X107. I-6. J0. F250.

N1805 G3 X119. I6. J0.

N1806 G0 Z125.

N1807 G0 X113.

N1808 S1100

N1809 G0 X133. Y43.

N1810 G0 Z-4.5

N1811 G0 X136.

N1812 G3 Z-5.5 I-3. J0. F200.

N1813 G1 X133. F250.

N1814 G0 X136.

N1815 G3 Z-8.5 I-3. J0. F200.

N1816 G1 X133. F250.

N1817 G3 X136. I1.5 J0.

N1818 G3 X130. I-3. J0.

N1819 G3 X136. I3. J0.

N1820 G3 X133. I-1.5 J0. F750.

N1821 G0 Z-4.5

N1822 G0 X136.

N1823 G1 Z-5.5

N1824 G1 Z-8.5 F200.

N1825 G3 X130. I-3. J0. F250.

N1826 G3 X136. I3. J0.

N1827 G0 Z125.

N1828 G0 X133.

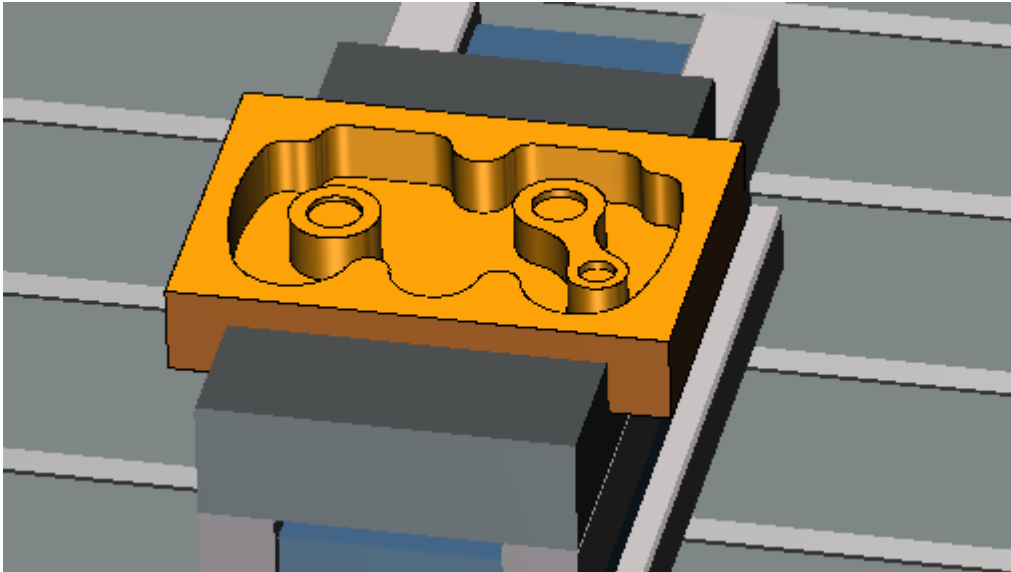
N1829 M5

N1830 M5

N1831 M30

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El resultado del mecanizado se puede apreciar a continuación.



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