

Torneado de cono y rosca

<https://www.programacioncnc.es/torneado-cono-rosca/>

\$G54

N10 G40 G00

N20 G99

N30 M5

N40 M9

N50 T0101

N60 G97 S1000

N70 (set new zero point 'G54': X0. Z251.)

N80 T0505

N90 G50 S3500

N100 G96 S0240 M4

N110 G00 X92. Z0.

N120 G01 X-2. F0.15 M7

N130 G00 X90. Z2.

N140 G00 Z2.5

N150 G00 X84.

N160 G01 Z-101.8

N170 G01 X90.

N180 G00 X92. Z-101.22

N190 G00 Z2.5

N200 G00 X78.

N210 G01 Z-101.153

N220 G02 X83.7 Z-101.8 I2.85 K5.953

N230 G01 X84.

N240 G00 X86. Z-101.22

N250 G00 Z2.5

N260 G00 X72.



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N270 G01 Z-98.256

N280 G02 X78. Z-101.153 I5.85 K3.056

N290 G00 X80. Z-100.573

N300 G00 Z2.5

N310 G00 X66.

N320 G01 Z-78.031

N330 G01 X70.481 Z-88.113

N340 G03 X70.5 Z-88.2 I-0.39 K-0.087

N350 G01 Z-95.2

N360 G02 X72. Z-98.256 I6.6 K0.

N370 G00 X74. Z-97.676

N380 G00 Z2.5

N390 G00 X60.

N400 G01 Z-64.531

N410 G01 X66. Z-78.031

N420 G00 X68. Z-77.451

N430 G00 Z2.5

N440 G00 X54.

N450 G01 Z-51.031

N460 G01 X60. Z-64.531

N470 G00 X62. Z-63.951

N480 G00 Z2.5

N490 G00 X48.

N500 G01 Z-42.8

N510 G01 X49.7

N520 G03 X50.481 Z-43.113 I0. K-0.4

N530 G01 X54. Z-51.031

N540 G00 X56. Z-50.451

N550 G00 Z2.5

N560 G00 X42.



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N570 G01 Z-1.784

N580 G01 X42.266 Z-1.917

N590 G03 X42.5 Z-2.2 I-0.283 K-0.283

N600 G01 Z-32.7

N610 G01 Z-42.8

N620 G01 X48.

N630 G00 X50. Z-42.22

N640 G00 Z2.5

N650 G00 X38.431

N660 G01 Z-0.

N670 G01 X42. Z-1.784

N680 G00 X44. Z-1.205

N690 G00 Z-32.7

N700 G01 X42.5

N710 G03 X42.393 Z-32.9 I-0.4 K0.

N720 G01 X38.1 Z-36.618

N730 G01 Z-41.88

N740 G02 X39.94 Z-42.8 I0.92 K0.

N750 G01 X42.5

N760 G00 X44.5 Z-42.22

N770 G00 X95.

N780 G00 X90.

N790 G00 Z2.

N800 G00 X120. Z100.

N810 M9

N820 T0707

N830 G97 S1200 M3

N840 G00 Z3.

N850 G00 X0.

N860 G74 R1.0



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N870 G74 Z-134.0 Q20000 F0.22

N880 G00 X200.

N890 G00 Z100.

N900 T0202 M7

N910 G50 S4000

N920 G96 S0380 M4

N930 G42 G00 X34. Z2.

N940 G01 X42. Z-2. F0.08

N950 G01 Z-31.

N960 G01 Z-32.5

N970 G01 X37.6 Z-36.311

N980 G01 Z-41.68

N990 G02 X40.24 Z-43. I1.32 K0.

N1000 G01 X42.

N1010 G01 X50.

N1020 G01 X70. Z-88.

N1030 G01 Z-95.

N1040 G02 X84. Z-102. I7. K0.

N1050 G01 X92.

N1060 G40

N1070 G00 X200. Z100.

N1080 M9

N1090 T0303

N1100 G97 S1000 M3

N1110 G00 X48. Z6.

N1120 G76 P020058 Q29 R50

N1130 G76 X38.32 Z-39. R0. P1840 Q184 F3.0

N1140 G00 X120. Z120.

N1150 M5

N1160 G28 U0. W0.



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N1170 M30

