

Torneado esférico

<https://www.programacioncnc.es/torneado-esferico/>

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N10 G54
N20 G92 S2000
; (OP 1 DIAMETER ROUGH TOOL 01 EBLC 08 16 95 5 80 CT525 P)
; (TOOL TIP RAD 0.8, DEPTH OF CUT 1)
N30 T1 D1 ; SELECT TOOL 1
N40 G97 G95 G40 S500 M03 ; CONSTANT SPINDLE SPEED
N50 G0 X38. Z49.869 M09
N60 X38. Z3.
N70 G1 Z-18.3 F0.4
N80 X40.
N90 X40.354 Z-18.123
N100 G0 X40.354 Z3.
N110 X36. Z3.
N120 G1 Z-18.3
N130 X38.
N140 X38.354 Z-18.123
N150 G0 X38.354 Z3.
N160 X34. Z3.
N170 G1 Z-12.25
N180 G3 X36. Z-18.3 I-17.8 K-6.05
N190 G1 X36.354 Z-18.123
N200 G0 X36.354 Z3.
N210 X32. Z3.
N220 G1 Z-9.862
N230 G3 X34. Z-12.25 I-16.8 K-8.438
N240 G1 X34.354 Z-12.073
N250 G0 X34.354 Z3.
N260 X30. Z3.
N270 G1 Z-8.112
N280 G3 X32. Z-9.862 I-15.8 K-10.188
N290 G1 X32.354 Z-9.685
N300 G0 X32.354 Z3.
N310 X28. Z3.
N320 G1 Z-6.707
N330 G3 X30. Z-8.112 I-14.8 K-11.593
N340 G1 X30.354 Z-7.935
N350 G0 X30.354 Z3.
N360 X26. Z3.
N370 G1 Z-5.533
N380 G3 X28. Z-6.707 I-13.8 K-12.767
N390 G1 X28.354 Z-6.53
N400 G0 X28.354 Z3.
N410 X24. Z3.
N420 G1 Z-4.53
N430 G3 X26. Z-5.533 I-12.8 K-13.77
N440 G1 X26.354 Z-5.356
N450 G0 X26.354 Z3.
N460 X22. Z3.
N470 G1 Z-3.664
N480 G3 X24. Z-4.53 I-11.8 K-14.636
N490 G1 X24.354 Z-4.354
N500 G0 X24.354 Z3.
N510 X20. Z3.
N520 G1 Z-2.912
N530 G3 X22. Z-3.664 I-10.8 K-15.388
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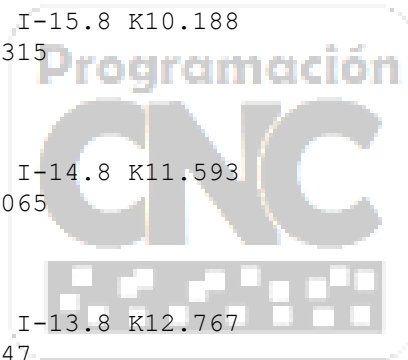


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N540 G1 X22.354 Z-3.488
N550 G0 X22.354 Z3.
N560 X18. Z3.
N570 G1 Z-2.256
N580 G3 X20. Z-2.912 I-9.8 K-16.044
N590 G1 X20.354 Z-2.735
N600 G0 X20.354 Z3.
N610 X16. Z3.
N620 G1 Z-1.687
N630 G3 X18. Z-2.256 I-8.8 K-16.613
N640 G1 X18.354 Z-2.08
N650 G0 X18.354 Z3.
N660 X14. Z3.
N670 G1 Z-1.194
N680 G3 X16. Z-1.687 I-7.8 K-17.106
N690 G1 X16.354 Z-1.51
N700 G0 X16.354 Z3.
N710 X12. Z3.
N720 G1 Z-0.773
N730 G3 X14. Z-1.194 I-6.8 K-17.527
N740 G1 X14.354 Z-1.018
N750 G0 X14.354 Z3.
N760 X10. Z3.
N770 G1 Z-0.417
N780 G3 X12. Z-0.773 I-5.8 K-17.883
N790 G1 X12.354 Z-0.596
N800 G0 X12.354 Z3.
N810 X8. Z3.
N820 G1 Z-0.123
N830 G3 X10. Z-0.417 I-4.8 K-18.177
N840 G1 X10.354 Z-0.24
N850 G0 X10.354 Z3.
N860 X6. Z3.
N870 G1 Z0.112
N880 G3 X8. Z-0.123 I-3.8 K-18.412
N890 G1 X8.354 Z0.054
N900 G0 X8.354 Z3.
N910 X4. Z3.
N920 G1 Z0.29
N930 G3 X6. Z0.112 I-2.8 K-18.59
N940 G1 X6.354 Z0.289
N950 G0 X6.354 Z3.
N960 X2. Z3.
N970 G1 Z0.414
N980 G3 X4. Z0.29 I-1.8 K-18.714
N990 G1 X4.354 Z0.467
N1000 G0 X4.354 Z3.
N1010 X0. Z3.
N1020 G1 Z0.483
N1030 G3 X2. Z0.414 I-0.8 K-18.783
N1040 G1 X2.354 Z0.59
N1050 G0 X2.354 Z3.
N1060 X-1.6 Z3.
N1070 G1 Z0.5
N1080 G3 X0. Z0.483 K-18.8
N1090 G1 X0.354 Z0.66
N1100 G0 X79.988 Z0.66
N1110 X79.988 Z49.869
; (OP 2 DIAMETER ROUGH TOOL 09 EBRC 08 16 95 5 80 CT525 P)
; (TOOL TIP RAD 0.8, DEPTH OF CUT 1)
N1120 T9 D9 ; SELECT TOOL 9
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N1130 G97 G95 G40 S400 M03 ; CONSTANT SPINDLE SPEED
N1140 G0 X79.988 Z-39. M09
N1150 X38. Z-39.
N1160 G1 Z-15.7 F2
N1170 X40.
N1180 X40.354 Z-15.877
N1190 G0 X40.354 Z-39.
N1200 X36. Z-39.
N1210 G1 Z-16.7
N1220 Z-15.7
N1230 X38.
N1240 X38.354 Z-15.877
N1250 G0 X38.354 Z-39.
N1260 X34. Z-39.
N1270 G1 Z-22.75
N1280 G2 X36. Z-16.7 I-17.8 K6.05
N1290 G1 X36.354 Z-16.877
N1300 G0 X36.354 Z-39.
N1310 X32. Z-39.
N1320 G1 Z-25.138
N1330 G2 X34. Z-22.75 I-16.8 K8.438
N1340 G1 X34.354 Z-22.927
N1350 G0 X34.354 Z-39.
N1360 X30. Z-39.
N1370 G1 Z-26.888
N1380 G2 X32. Z-25.138 I-15.8 K10.188
N1390 G1 X32.354 Z-25.315
N1400 G0 X32.354 Z-39.
N1410 X28. Z-39.
N1420 G1 Z-28.293
N1430 G2 X30. Z-26.888 I-14.8 K11.593
N1440 G1 X30.354 Z-27.065
N1450 G0 X30.354 Z-39.
N1460 X26. Z-39.
N1470 G1 Z-29.467
N1480 G2 X28. Z-28.293 I-13.8 K12.767
N1490 G1 X28.354 Z-28.47
N1500 G0 X28.354 Z-39.
N1510 X24. Z-39.
N1520 G1 Z-30.47
N1530 G2 X26. Z-29.467 I-12.8 K13.77
N1540 G1 X26.354 Z-29.644
N1550 G0 X26.354 Z-39.
N1560 X22. Z-39.
N1570 G1 Z-31.336
N1580 G2 X24. Z-30.47 I-11.8 K14.636
N1590 G1 X24.354 Z-30.646
N1600 G0 X24.354 Z-39.
N1610 X20. Z-39.
N1620 G1 Z-32.088
N1630 G2 X22. Z-31.336 I-10.8 K15.388
N1640 G1 X22.354 Z-31.512
N1650 G0 X22.354 Z-39.
N1660 X18. Z-39.
N1670 G1 Z-32.744
N1680 G2 X20. Z-32.088 I-9.8 K16.044
N1690 G1 X20.354 Z-32.265
N1700 G0 X20.354 Z-39.
N1710 X16. Z-39.
N1720 G1 Z-33.313
N1730 G2 X18. Z-32.744 I-8.8 K16.613
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N1740 G1 X18.354 Z-32.92
N1750 G0 X18.354 Z-39.
N1760 X14. Z-39.
N1770 G1 Z-33.806
N1780 G2 X16. Z-33.313 I-7.8 K17.106
N1790 G1 X16.354 Z-33.49
N1800 G0 X108.444 Z-33.372
N1810 X79.8 Z50.042
N1820 X16.354 Z49.869
N1830 X79.988 Z49.869
; (OP 3 FINISHING TOOL 03 EBLD 04 15 93 32 55 CT525 P)
; (TOOL TIP RAD 0.4)
N1840 T3 D3 ; SELECT TOOL 3
N1850 G97 G95 G40 S550 M03 ; CONSTANT SPINDLE SPEED
N1860 G0 X-4.8 Z49.869 M09
N1870 X-4.8 Z1.
N1875 G1 X-4.8 Z0.
N1880 G1 G42 X0. F0.064
N1890 G3 X35. Z-17.5 I0. K-17.5
N1900 G1 Z-19.9
N1910 G0 G40 X79.988 Z-19.9
N1920 X79.988 Z49.869
; (OP 4 FINISHING TOOL 10 EBRD 04 15 93 32 55 CT525 P)
; (TOOL TIP RAD 0.4)
N1930 T10 D10 ; SELECT TOOL 10
N1940 G97 G95 G40 S550 M03 ; CONSTANT SPINDLE SPEED
N1950 G0 X79.988 Z-15.1 M09
N1960 X35. Z-15.1
N1970 G1 G42 Z-17.5 F0.07
N1980 G3 X14.359 Z-33.459 I-17.5 K0.
N1990 G2 X12. Z-35.283 I0.821 K-1.824
N2000 G1 Z-38.
N2010 G40 Z-39.6
N2020 M30
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