**(CICLO DE PLANEADO)**

G90 G54 G17 G21 G80 G49 G40 G94;

G91 G28 Z0;

G91 G28 X0 Y0;

T04 (Planeadora de 40 mm);

M06;

G90 G54 G00 X0 Y0;

G43 H4 Z10;

M01;

M03 S 1909;

M58;

X 240 Y 10;

Z-2;

G01 X-40 F764;

G00 Y40;

G01 X 240 Y 40;

G00 Y 70;

G01 X -40 Y 70;

G00 Y 100;

G01 X 240 Y 100;

G00 Y 130;

G01 X -240 Y 130;

G00 Y 160;

G01 X 240 Y 160;

G00 Y 190;

G01 X -40 Y 190;

G00 Z50;

M05;

M09;

G91 G28 Z0;

G91 G28 X0 Y0;

**(CONTORNEADO)**

T03 (Fresa 16 mm);

M06;

G90 G54 G00 X0 Y0;

G43 H3 Z50;

M01;

M03 S 4777;

M58;

X-20 Y190;

Z-1;

G41 D3 G00 X-20;

G01 X165 F954;

G02 X162 Y173 R10;

G01 X102 Y112;

G02 X88 R10;

G01 X27 Y173;

G02 X34 Y190 R10;

G00 Z50;

G40;

M05;

M09;

G91 G28 Z0;

G91 G28 X0 Y0;

**(CICLO DE TALADRADO)**

T06 (Broca de centros 3.18 mm);

M06;

G90 G54 G00 X0 Y0;

G43 H6 Z50;

M01;

M03 S 3804;

X44 Y183 M08;

G98 G82 Z-7 R5 P4 F76;

X64;

X89;

X104;

X129;

G80;

M09;

M05;

G91 G28 Z0;

G91 G28 X0 Y0;

T01 (Broca 11 mm);

M06;

G90 G54 G00 X0 Y0;

G43 H01 Z50;

M01;

M03 S1736;

X44 Y183 M08;

G98 G82 Z-28 R5 Q5 F86;

X64;

X89;

X104;

X129;

G80;

M09;

M05;

**(ROSCADO)**

G91 G28 Z0;

G91 G28 X0 Y0;

T02(macho ½-13 UNC);

M06;

G90 G54 G00 X0 Y0;

G43 H02 Z50;

M01;

G95;

M03 S375;

X64 Y183 M08;

G98 G82 Z-15 R5 Q3 F1.95;

X89;

X104;

G80;

M09;

M05;

G91 G28 Z0;

G91 G28 X0 Y0;

M30;