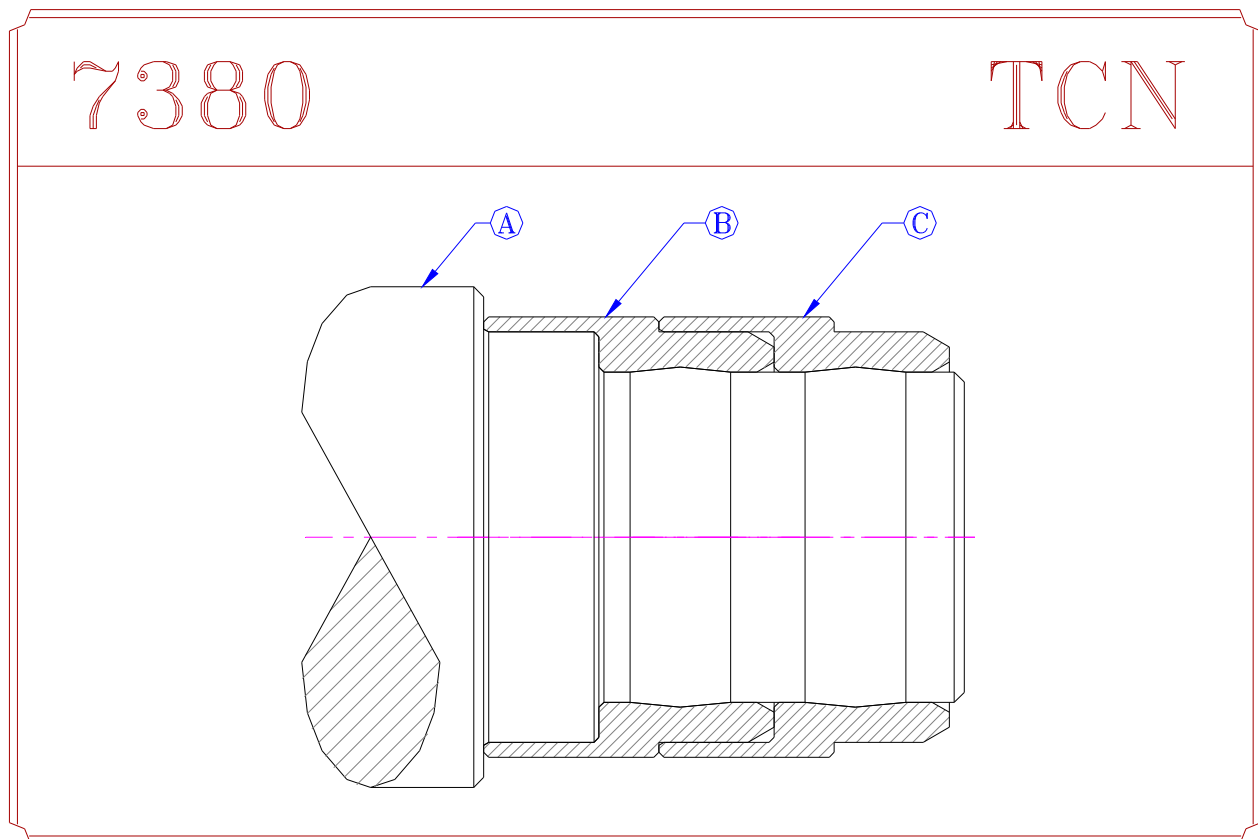


MCN02_R09_Ejemplo2Conjunto_Doble_Atadas



F0499 PTD-04 7830 Icono

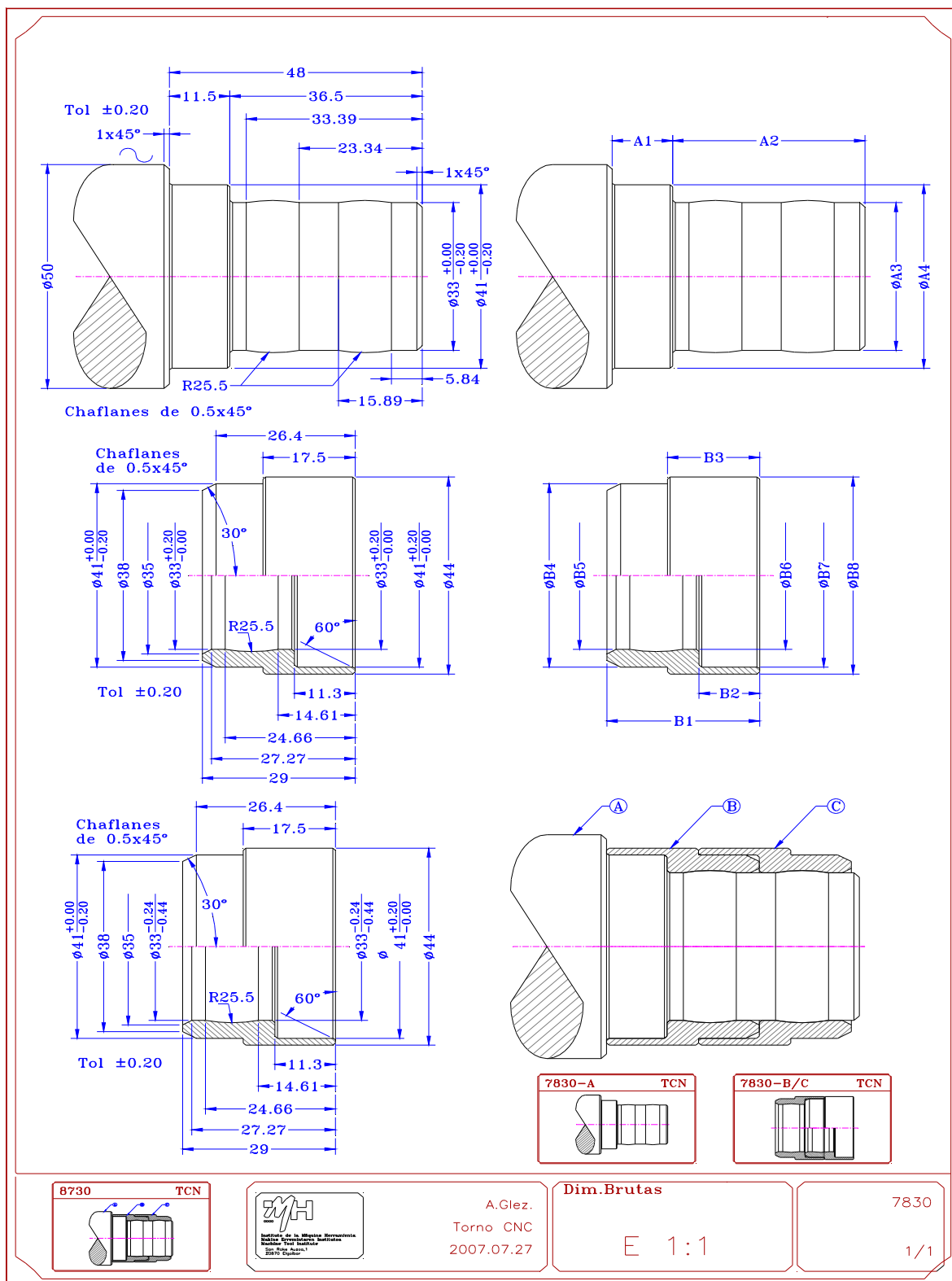
2008 Julio

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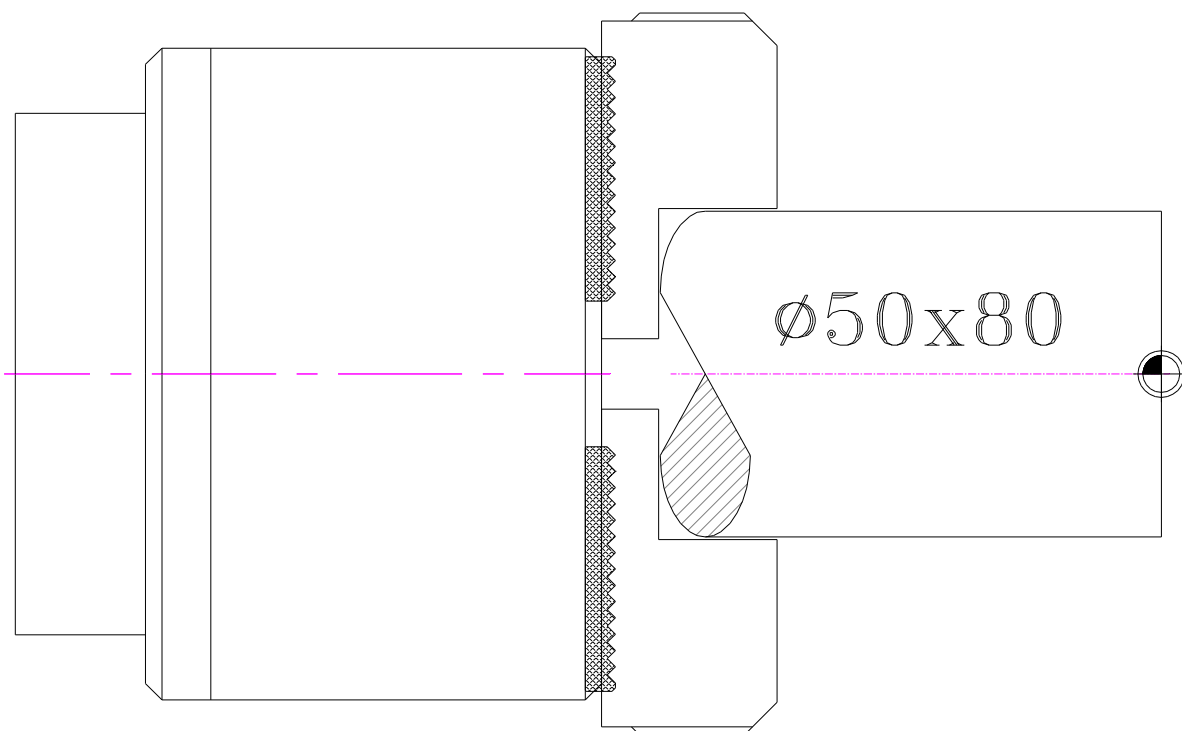
6. Pieza C - Programa CNC.....8

1. PLANO



F0498 PTD-04 7830 Plano

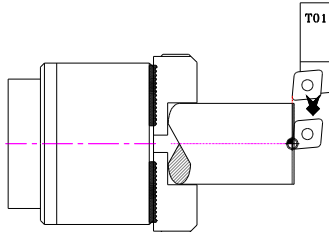
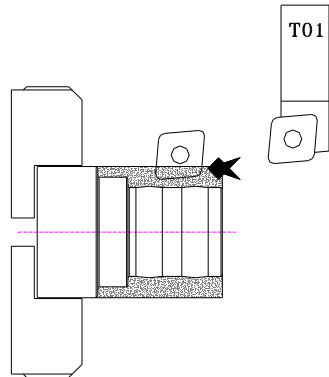
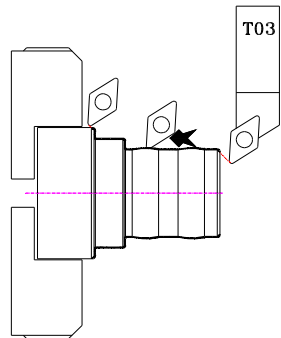
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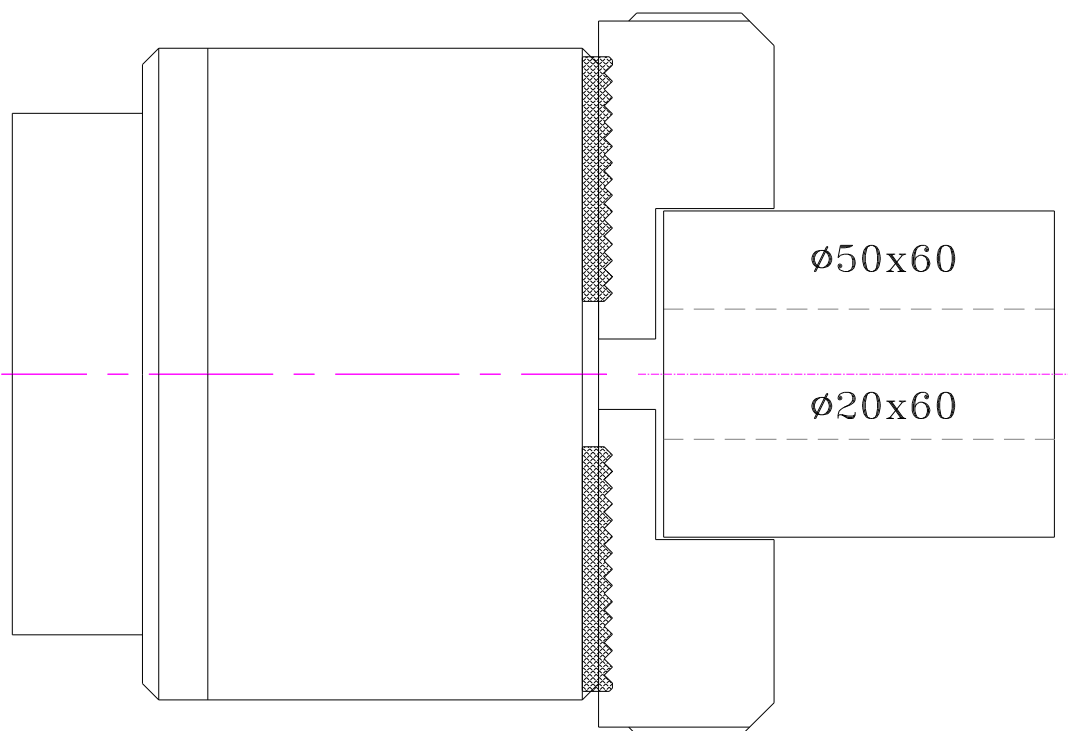
F0297 PTD-02 7840-A-AMARRE

Descripción del amarre:

3. PIEZA A - PROGRAMA CNC

Programa CNC Fanuc OT	Programa CNC Fagor 8055	Operaciones
:8730 (PTD-3 7830-A TCN H27) (AGH 2008.06.26) (PLASTICO DELRIN) (ALECOPI ECLIPSE FANUC OT) () (OP-1 REFRENTADO) N100 G00 G40 G28 W0 N110 G92 S2000 N120 T0101 N130 G96 F0.30 S330 M04 N140 G40 G00 X52 Z0 N150 G01 X-1.5 N160 G00 Z2 N170 X52 () (OP-2 DESBASTE EXTERIOR) N200 G71 U1.5 R0.5 N210 G71 P220 Q320 U1 W0.2 N220 G00 X[27-0.1] Z2 N230 X[33-0.1] Z-1 N240 Z-5.1 N250 G03 Z-15.15 R25.5 N260 G01 Z-22.6 N270 G03 Z-32.65 R25.5 N280 G01 Z-35.76 C0.5 N290 X[41-0.1] C0.5 N300 W-11.5 C0.5 N310 X48 N320 A135 X51 N330 G00 G28 W0 () (OP-3 ACABADO EXTERIOR) N300 T0303 N310 G92 S2000 N320 G96 F0.15 S480 M04 N330 G42 G00 X53 Z3 N340 G70 P220 Q320 N350 G40 G00 G28 W0 () M30	%PTD-3 7830-A TCN,MX, ; GGV 2007.09.26 ; PLASTICO ; ALECOPI ECLIPSE FAGOR 8055 ; ; ; OP-1 REFRENTADO N100 G00 G40 Z111 N110 G92 S2000 N120 T01 D01 N130 G96 F0.30 S330 M04 N140 G90 G40 G00 X52 Z0 N150 G01 X-1.5 N160 G00 Z2 N170 X52 ; ; OP-2 DESBASTE EXTERIOR N200 G68 X33 Z0 C1 L1 M0.2 S340 E430 N210 G00 X55 Z111 ; ; OP-3 ACABADO EXTERIOR N300 T03 D03 N310 G92 S2000 N320 G96 F0.15 S480 M04 N330 G90 G42 G05 G00 X26.9 Z2 N340 G01 X32.9 Z-1 N350 Z-5.1 N360 G03 Z-15.15 R25.5 N370 G01 Z-22.6 N380 G03 Z-32.65 R25.5 N390 G39 R0.5 G01 Z-35.76 N400 G39 R0.5 X40.9 N410 G91 G39 R0.5 Z-11.5 N420 G90 X48 N430 Q135 X51 N440 G40 G00 X55 Z111 ; M30	Operación 1 Refrentado  F0496 PTD-04 7830-A-OP1-REFRENTADO Operación 2 Desbaste  F0495 PTD-04 7830-A-OP2-DESBASTE Operación 3 Acabado  F0494 PTD-04 7830-A-OP3-ACABADO

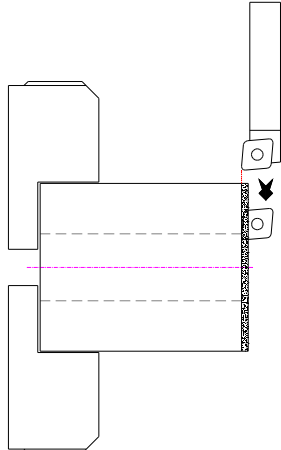
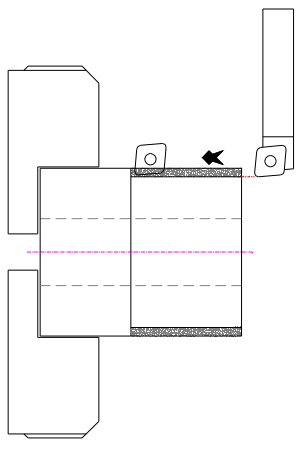
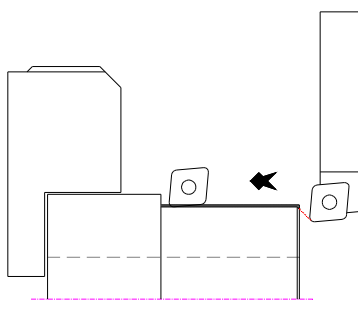
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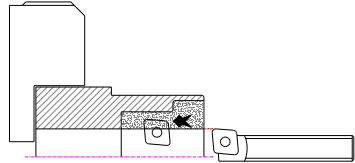
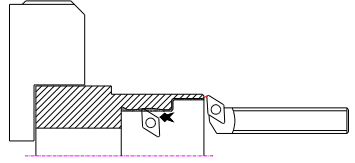
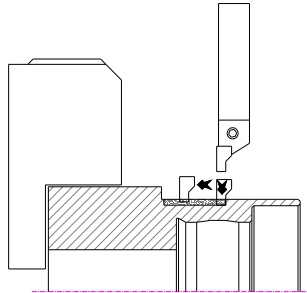
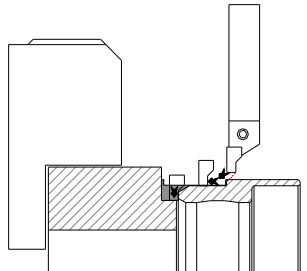


F0493 PTD-04 7830-B-AMARRE

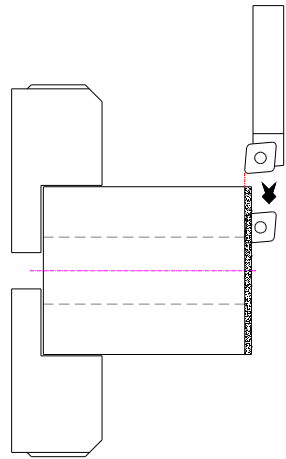
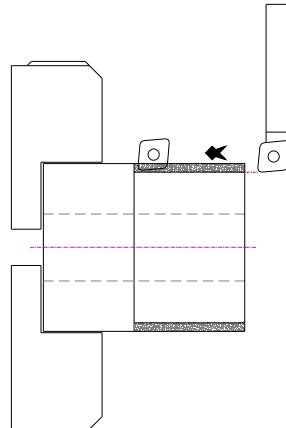
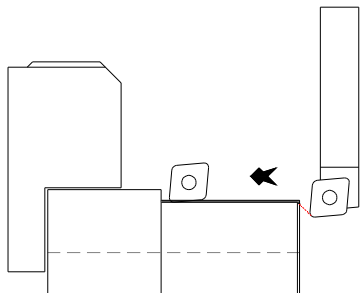
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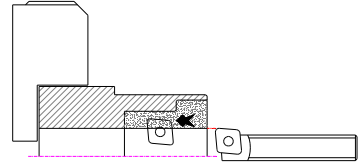
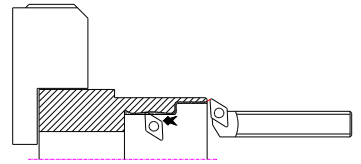
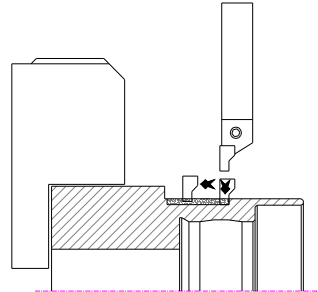
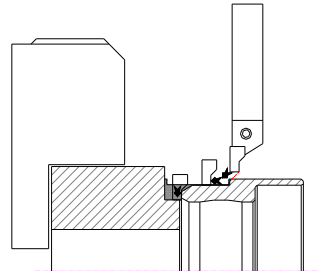
5. PIEZA B - PROGRAMA CNC

Programa CNC Fanuc OT	Programa CNC Fagor 8055	Operaciones
:7831 (PTD-3 7831-B) (AGH 2007.07.24) (PLASTICO DENRIL) (ALECOPI ECLIPSE FAGOR 8055) () G92 S2800 (OP-1 REFRENTADO) N100 T0101 N110 G96 F0.33 S280 M04 N120 G40 G00 X52 Z0 N130 G01 X18 N140 G00 Z2 () (OP-2 DESBASTE EXTERIOR) N200 X52 N210 G71 U1 R0.5 N220 G71 P230 Q260 U1 W0 N230 G00 X41 Z1 N240 G01 X44 Z-0.5 N250 Z-33.5 N260 X51 () (OP-3 ACABADO EXTERIOR) N300 G96 F0.15 S450 M04 N310 G42 G00 X52 Z2 N320 G71 P230 Q260 U1 W0 N330 G40 G00 G28 W0 () (OP-4 DESBASTE INTERIOR) N400 T0202 N410 G92 S2800 N420 G96 F0.22 S220 M04 N430 G40 G00 X18 Z3 N440 G71 U1 R0.25 N450 G71 P460 Q470 U-0.5 W0.1 N460 G00 X43.987 Z2 G01 X[41+0.1] Z-0.5 G01 Z-11.3 C0.5 X33.1 C0.5 Z-14.61 G03 Z-24.66 R25.5 G01 Z-27.27 X35 Z-29 Z-29.5 N470 X20 N480 G00 G28 W0 () (OP-5 ACABADO INTERIOR)	%PTD-3 7831-B,MX, ; AGH 2007.07.24 ; PLASTICO DENRIL ; ALECOPI ECLIPSE FAGOR 8055 ; G92 S2800 ; OP-1 REFRENTADO N100 T01 D01 N110 G96 F0.33 S280 M04 N120 G90 G40 G05 G00 X52 Z0 N130 G01 X18 N140 G00 Z2 ; ; OP-2 DESBASTE EXTERIOR N200 X52 N210 G81 X44 Z-33 Q44 R-33 C1 D1 L1 M0 ; ; OP-3 ACABADO EXTERIOR N300 G96 F0.15 S450 M04 N310 G42 G00 X39 Z2 N320 G01 X44 Z-0.5 N330 Z-33.5 N340 X51 N350 G40 G00 Z111 ; ; OP-4 DESBASTE INTERIOR N400 T02 D02 N410 G92 S2800 N420 G96 F0.22 S220 M04 N430 G90 G40 G00 X18 Z3 N440 G68 X41 Z0 C1 L0.5 M0.1 S540 E550 N450 G00 Z111 ; ; OP-5 ACABADO INTERIOR N500 T04 D04 N510 G92 S2800 N520 G96 F0.15 S320 M04 N530 G90 G41 G00 X43.987 Z2 N540 G01 X41.1 Z-0.5 G39 R0.5 G01 Z-11.3 G39 R0.5 X33.1 Z-14.61 G03 Z-24.66 R25.5 G01 Z-27.27 X35 Z-29 Z-29.5 N550 X20 N560 G40 G00 X30	<p>Operación 1 Refrentado</p>  <p>F0492 PTD-04 7830-B-OP1-REFRENTADO</p> <p>Operación 2 Desbaste exterior</p>  <p>F0491 PTD-04 7830-B-OP2-DESASBTE-EXT</p> <p>Operación 3 Acabado exterior</p> 

Programa CNC Fanuc OT	Programa CNC Fagor 8055	Operaciones
N500 T0404 N510 G92 S2800 N520 G96 F0.15 S320 M04 N530 G41 G00 X18 Z2 N540 G70 P460 Q470 N550 G40 G00 G28 W0 N560 X55 () (OP-6 RANURADO EXTERIOR) N600 T0505 (W 2 MM) N610 G92 S2800 N620 G96 F0.18 S180 M04 N630 G40 G00 X50 Z2 N640 X44 Z-[17.75+2] N650 G75 R0 N660 G75 X41.3 Z-33 P9999 Q1000 R0 () (OP-7 ACABADO RANURA Y TRONZADO) N700 G96 F0.11 S330 M04 N710 G00 X47 Z-17.5 N720 G01 X43 Z-19.7 N730 X[41-0.1] N740 Z-28.4 N750 A210 X38 F0.08 N760 Z-31 N770 X34 N780 G40 G00 G28 X55 W0 () M30	N560 Z111 ; ; OP-6 RANURADO EXTERIOR N600 T05 D05 N610 G92 S2800 N620 G96 F0.18 S180 M04 N630 G90 G05 G40 G00 X50 Z2 N640 G88 X44 Z-33 Q41.25 R-17.75 C1 D1 ; ; OP-7 ACABADO RANURA Y TRONZADO N700 G96 F0.11 S330 M04 N710 G00 X47 Z-17.5 N720 G01 X43 Z-19.7 N730 X40.9 N740 Z-28.4 N750 Q210 X38 F0.08 N760 Z-31 N770 X34 N780 G00 X55 N790 Z111 ; M30	<p><i>F0490 PTD-04 7830-B-OP3-ACABADO-EXT</i></p> <p>Operación 4 Desbaste interior</p>  <p><i>F0489 PTD-04 7830-B-OP4-DESBASTE-INT</i></p> <p>Operación 5 Acabado interior</p>  <p><i>F0488 PTD-04 7830-B-OP5-ACABADO-INT</i></p> <p>Operación 6 Ranurado exterior</p>  <p><i>F0487 PTD-04 7830-B-OP6-RANURADO-EXT</i></p> <p>Operación 7 Acabado y Tronzado</p>  <p><i>F0486 PTD-04 7830-B-OP7-ACABADO-TRON</i></p>

6. PIEZA C - PROGRAMA CNC

Operaciones	Programa CNC Fagor 8055	Programa CNC Fanuc OT
:7832 (PTD-3 7832-C) (AGH 2007.07.24) (PLASTICO DENRIL) (ALECOPI ECLIPSE FAGOR 8055) () G92 S2800 (OP-1 REFRENTADO) N100 T0101 N110 G96 F0.33 S280 M04 N120 G40 G00 X52 Z0 N130 G01 X18 N140 G00 Z2 () (OP-2 DESBASTE EXTERIOR) N200 X52 N210 G71 U1 R0.5 N220 G71 P230 Q260 U1 W0 N230 G00 X41 Z1 N240 G01 X44 Z-0.5 N250 Z-33.5 N260 X51 () (OP-3 ACABADO EXTERIOR) N300 G96 F0.15 S450 M04 N310 G42 G00 X52 Z2 N320 G71 P230 Q260 U1 W0 N330 G40 G00 G28 W0 () (OP-4 DESBASTE INTERIOR) N400 T0404 N410 G92 S2800 N420 G96 F0.22 S220 M04 N430 G40 G00 X18 Z3 N440 G71 U1 R0.25 N450 G71 P460 Q470 U-0.5 W0.1 N460 G00 X43.987 Z2 G01 X[41+0.1] Z-0.5 G01 Z-11.3 C0.5 X32.66 C0.5 Z-14.61 G03 Z-24.66 R25.5 G01 Z-27.27 X35 Z-29 Z-29.5 N470 X20 N480 G00 G28 W0 () (OP-5 ACABADO INTERIOR)	%PTD-3 7832-C,MX, ; AGH 2007.07.24 ; PLASTICO DENRIL ; ALECOPI ECLIPSE FAGOR 8055 ; G92 S2800 ; OP-1 REFRENTADO N100 T01 D01 N110 G96 F0.33 S280 M04 N120 G90 G40 G05 G00 X52 Z0 N130 G01 X18 N140 G00 Z2 ; ; OP-2 DESBASTE EXTERIOR N200 X52 N210 G81 X44 Z-33 Q44 R-33 C1 D1 L1 M0 ; ; OP-3 ACABADO EXTERIOR N300 G96 F0.15 S450 M04 N310 G42 G00 X39 Z2 N320 G01 X44 Z-0.5 N330 Z-33.5 N340 X51 N350 G40 G00 Z111 ; ; OP-4 DESBASTE INTERIOR N400 T02 D02 N410 G92 S2800 N420 G96 F0.22 S220 M03 N430 G90 G40 G00 X18 Z3 N440 G68 X41 Z0 C1 L0.5 M0.1 S540 E550 N450 G00 Z111 ; ; OP-5 ACABADO INTERIOR N500 T04 D04 N510 G92 S2800 N520 G96 F0.15 S320 M04 N530 G90 G41 G01 X43.987 Z2 N540 G01 X41.1 Z-0.5 G39 R0.5 G01 Z-11.3 G39 R0.5 X32.66 Z-14.61 G03 Z-24.66 R25.5 G01 Z-27.27 X35 Z-29 Z-29.5 N550 X20 N560 G40 G00 X30	<p>Operación 1 Refrentado</p>  <p>F0492 PTD-04 7830-B-OP1-REFRENTADO</p> <p>Operación 2 Desbaste exterior</p>  <p>F0491 PTD-04 7830-B-OP2-DESASBTE-EXT</p> <p>Operación 3 Acabado exterior</p>  <p>F0490 PTD-04 7830-B-OP3-ACABADO-EXT</p>

Operaciones	Programa CNC Fagor 8055	Programa CNC Fanuc OT
N500 T0404 N510 G92 S2800 N520 G96 F0.15 S320 M04 N530 G41 G00 X18 Z2 N540 G70 P460 Q470 N550 G40 G00 G28 W0 N560 X55 () (OP-6 RANURADO EXTERIOR) N600 T0505 (W 2 MM) N610 G92 S2800 N620 G96 F0.18 S180 M04 N630 G40 G00 X50 Z2 N640 X44 Z-[17.75+2] N650 G75 R0 N660 G75 X41.3 Z-33 P9999 Q1000 R0 () (OP-7 ACABADO RANURA Y TRONZADO) N700 G96 F0.11 S330 M04 N710 G00 X47 Z-17.5 N720 G01 X43 Z-19.7 N730 X[41-0.1] N740 Z-28.4 N750 A210 X38 F0.08 N760 Z-31 N770 X34 N780 G00 X55 N790 G28 W0 () M30	N560 Z111 ; ; OP-6 RANURADO EXTERIOR N600 T05 D05 N610 G92 S2800 N620 G96 F0.18 S180 M04 N630 G90 G05 G40 G00 X50 Z2 N640 G88 X44 Z-33 Q41.25 R-17.75 C1 D1 ; ; OP-7 ACABADO RANURA Y TRONZADO N700 G96 F0.11 S330 M04 N710 G00 X47 Z-17.5 N720 G01 X43 Z-19.7 N730 X40.9 N740 Z-28.4 N750 Q210 X38 F0.08 N760 Z-31 N770 X34 N780 G00 X55 N790 Z111 ; M30	<p>Operación 4 Desbaste interior</p>  <p>F0489 PTD-04 7830-B-OP4-DESBASTE-INT</p> <p>Operación 5 Acabado interior</p>  <p>F0488 PTD-04 7830-B-OP5-ACABADO-INT</p> <p>Operación 6 Ranurado exterior</p>  <p>F0487 PTD-04 7830-B-OP6-RANURADO-EXT</p> <p>Operación 7 Acabado y Tronzado</p>  <p>F0486 PTD-04 7830-B-OP7-ACABADO-TRON</p>