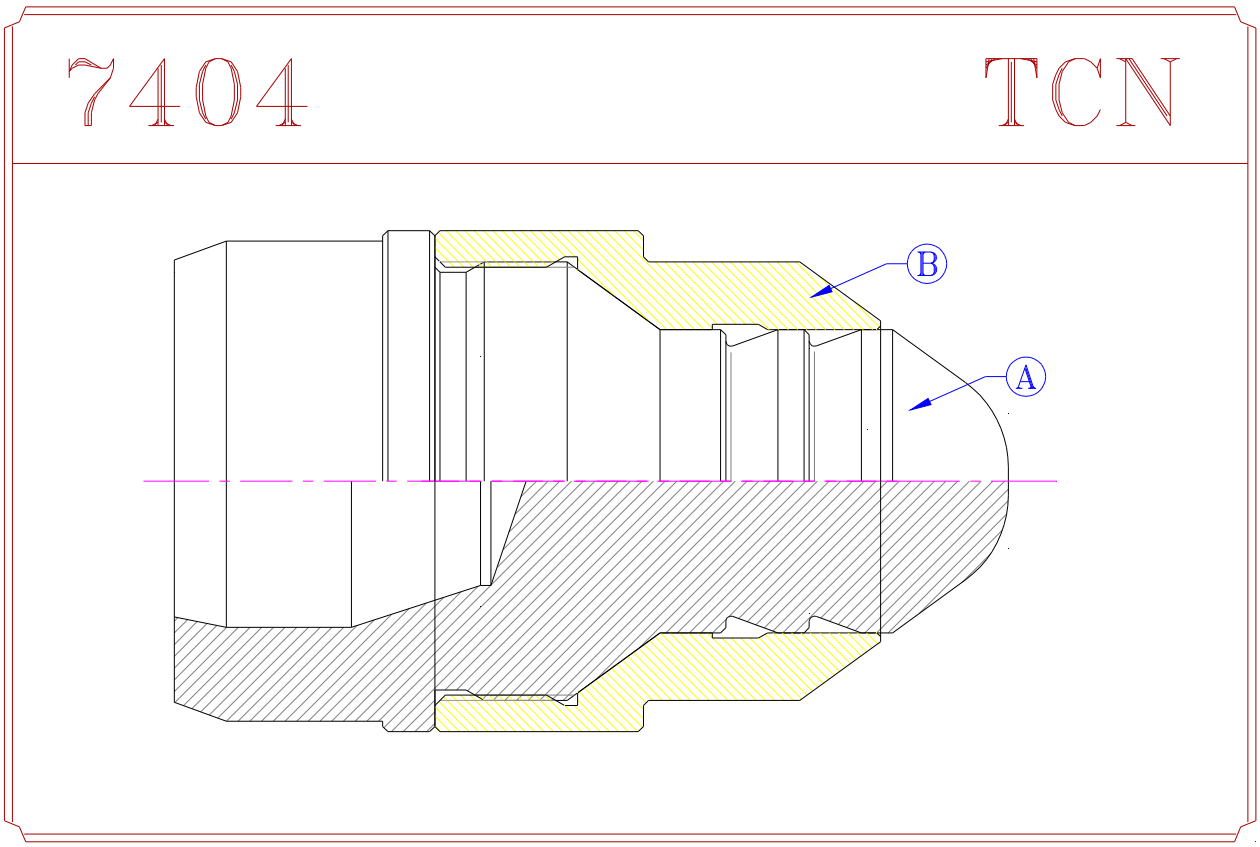
MCN02_R08_Conjunto_Doble_Atadas



F0599 PTD-05 7404 Icono

2008 Julio

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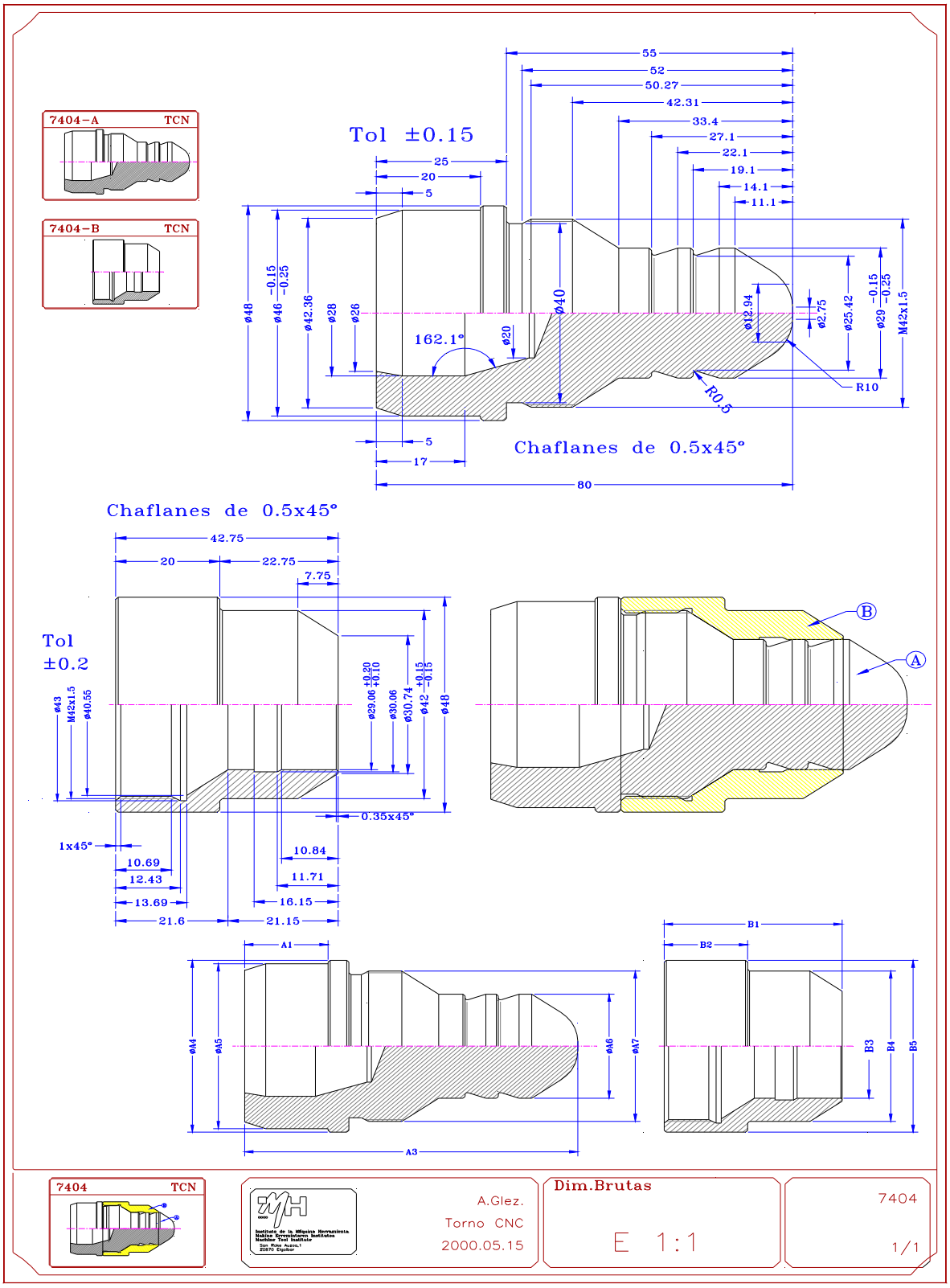
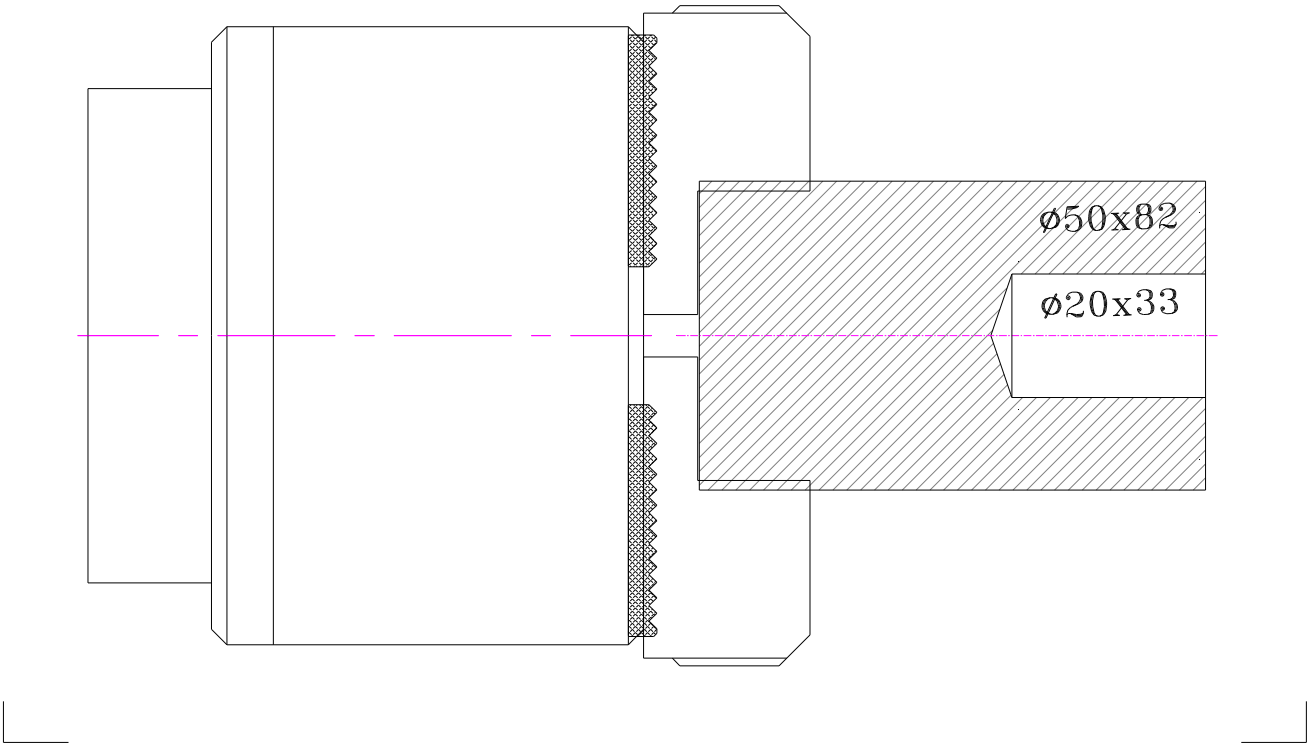
1. PLANO

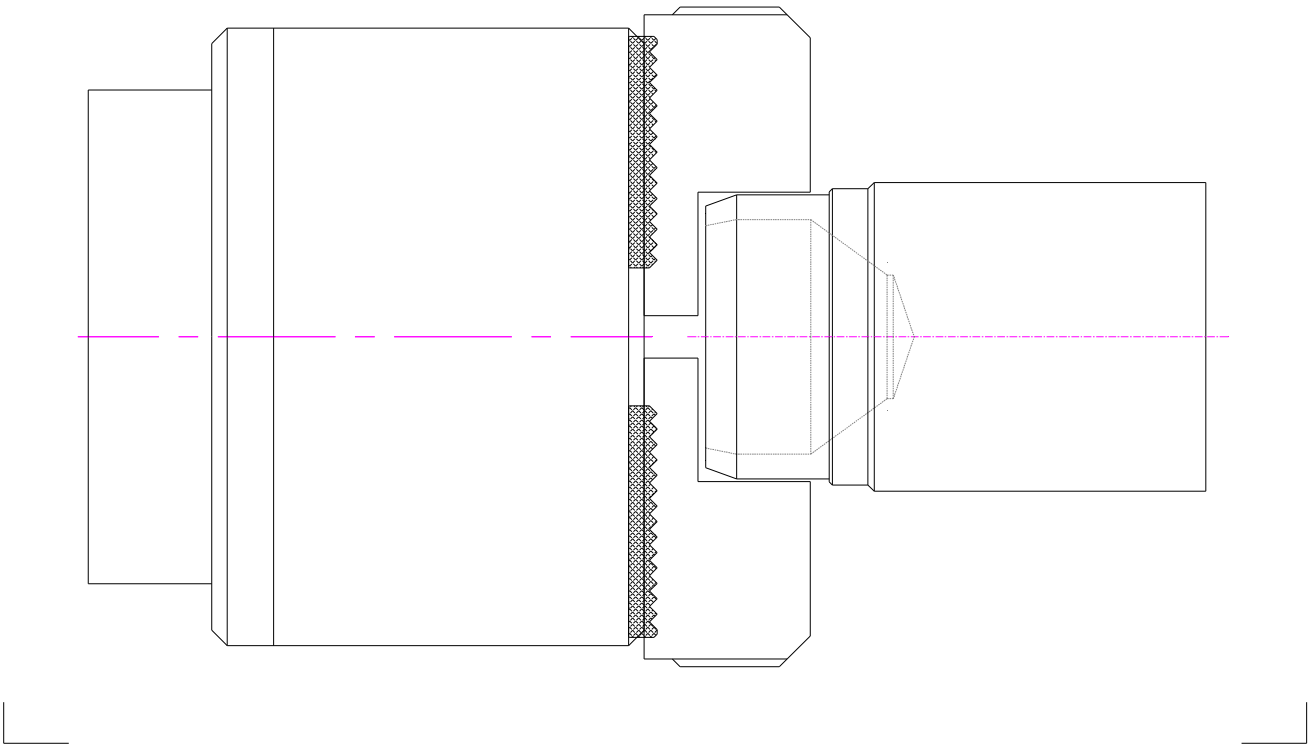


F0598 PTD-05 7404 Plano

2. PIEZA A - AMARRE



F0597 PTD-05 7404-A-AMARRE



F0596 PTD-05 7404-B-AMARRE

3. PIEZA A - PROGRAMA CNC

Programa CNC Fanuc OT

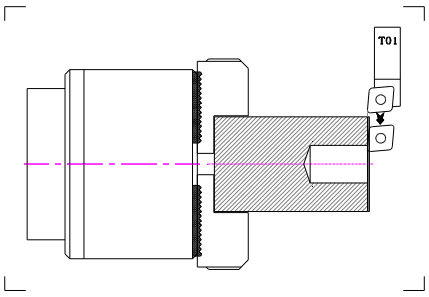
```
:7401 (PTD-4 7404-A AMARRE 1)
( ALECOP ECLIPSE FANUC OT )
( AGH 2008.06.18 )
( DELRIN )
( AMARRE 1 )
G40 G00 G28 W0
( OP-11 REFRENTADO )
N100 G92 S2800
N110 T0101
N120 G96 F0.3 S330 M04
N130 G40 G00 X52 Z0
N140 G01 X18
N150 G00 G28 W0
N160 X55
; OP-12 DESBASTE INTERIOR
N200 T0404
N210 G92 S2800
N220 G96 F0.3 S400 M04
N230 G40 G00 X18 Z3
N240 G71 U2 R0.25
N250 G71 P260 Q290 U-1 W0.2
N260 G00 X27 Z1
N265 G01 X26 Z0
N270 G01 X28 Z-5
N280 Z-17
N290 A-162.1 X19
G00 G28 W0
( OP-13 ACABADO INTERIOR )
N310 T0404
N300 G92 S2800
N320 G96 F0.2 S400 M04
N330 G41 G00 X18 Z3
N340 G70 P260 Q290
N350 G40 G00 G28 W0
N360 X55
( OP-14 ACABADO EXTERIOR )
N400 T01 D01
N410 G92 S2800
N420 G96 F0.3 S330 M04
N430 G42 G00 X38 Z2
N440 G01 X42.36 Z0
N450 X[46-0.2] Z-5
N460 Z-20
N480 X48 C0.5
N490 Z-30
G00 U2
G40 G28 W0
M30
```

Programa CNC Fagor 8055

```
%PTD-4 7404-A A1 H27J,MX,
; ALECOP ECLIPSE FAGOR 8055
; AGH-2007.10.03
; DELRIN
; AMARRE 1
G40 G00 Z111
; OP-11 REFRENTADO
N100 G92 S2800
N110 T01 D01
N120 G96 F0.3 S330 M04
N130 G40 G90 G00 X52 Z0
N140 G01 X18
N150 G00 Z3
N160 X55 Z111
; OP-12 DESBASTE INTERIOR
N200 T02 D02
N210 G92 S2800
N220 G96 F0.3 S400 M04
N230 G90 G40 G00 X18 Z3
N240 G68 X26 Z0 C2 L1 M0.2 S350 E370
N250 G00 X55 Z111
; OP-13 ACABADO INTERIOR
N300 T04 D04
N310 G92 S2800
N320 G96 F0.2 S400 M04
N330 G90 G41 G00 X30 Z2
N340 G01 X26 Z0
N350 G01 X28 Z-5
N360 Z-17
N370 Q-162.1 X19
N380 G40 G00 Z11
N390 X55 Z111
; OP-14 ACABADO EXTERIOR
N400 T01 D01
N410 G92 S2800
N420 G96 F0.3 S330 M04
N430 G90 G05 G42 G00 X42 Z2
N440 G01 X42.36 Z0
N450 X45.8 Z-5
N460 Z-20
N470 X47
N480 G39 R0.5 X48
N490 Z-30
G40 G00 X55 Z111
M30
```

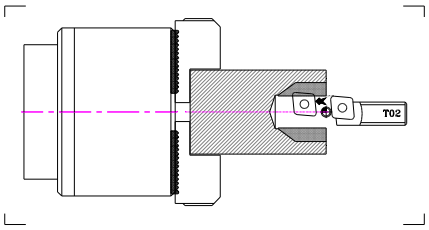
Operaciones Amarre 1

Operación 11 Refrentado



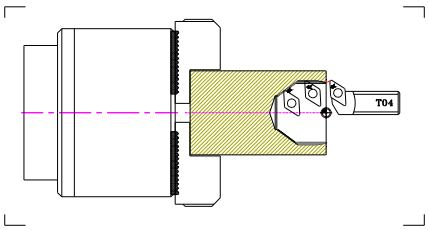
F0595 PTD-05 7404-A-O11-REFRENTADO

Operación 12 Desbaste interior



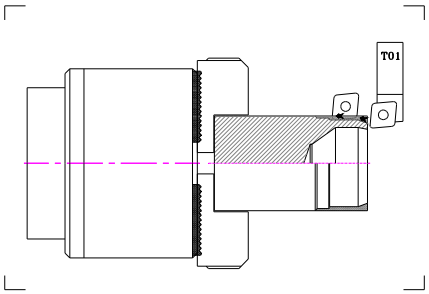
F0594 PTD-05 7404-A-O12-DESBASTE-INT

Operación 13 Acabado interior



F0593 PTD-05 7404-A-O13-ACABADO-INT

Operación 14 Acabado exterior



F0592 PTD-05 7404-A-O14-ACABADO-EXT

Programa CNC Fanuc OT

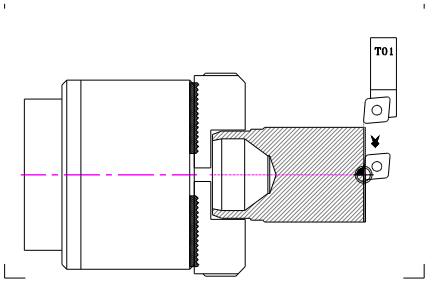
```
:7402 (PTD-4 7404-A A2 H27J)
( ALECOP ECLIPSE FANUC OT )
( AGH-2007.10.03 )
( DELRIN )
( AMARRE 2 )
G40 G00 G28 W0
( OP-21 REFRENTADO )
N100 T0101 G92 S2800
N120 G96 F0.3 S330 M04
N130 G40 G00 X52 Z0
N140 G01 X-1.8
N150 G00 G28 W0
( OP-22 DESBASTE )
N200 T0303 G92 S2800
N230 G96 F0.3 S330 M04
N240 G00 X52 Z2
N250 G71 U1.5 R0.5
N260 G71 P270 Q280 U0.8 W0.2
N270 G00 X-2 Z1
 G02 X0 Z0 R1
 G01 X12.94 ,R10
 X[29-0.2] Z-11.1
 Z-14.1
 X25.42 Z-19.1 R0.5
 X[29-0.2] C0.5
 Z-22.1
 X25.42 Z-27.1 R0.5
 X[29-0.2] C0.5
 X42 Z-42.31
 Z-50.27
 X40 Z-52
 Z-55 ,C0.5
 X48
N280 A135 X50
G40 G00 G28 W0
( OP-23 ACABADO )
N300 T0303 G92 S2290
N310 G96 F0.1 S410 M04
N320 G42 G00 X52 Z3
N330 G70 P270 Q280
N340 G40 G00 G28 W0
( OP-24 ROSCADO )
N400 T0707
N410 G97 S850 M04
N420 G40 G00 X44 Z-52
N430 G76 P020000 Q100 R0.05
N440 G76 X[42-2*0.65*1.5] Z-40 R0
          P[1000*0.65*1.5] Q400 F1.5
N440 X55
N450 G00 G28 W0
M30
```

Programa CNC Fagor 8055

```
%PTD-4 7404-A A2 H27J,MX,
; ALECOP ECLIPSE FAGOR 8055
; AGH-2007.10.03
; DELRIN
; AMARRE 2
; OP-21 REFRENTADO
N100 T01 D01
N110 G92 S2800
N120 G96 F0.3 S330 M04
N130 G40 G90 G00 X52 Z0
N140 G01 X-1.8
N150 G00 Z3
; OP-22 DESBASTE
N200 X52
N210 G68 X0 Z0 C2 L0.8 M0.2 S350 E360
N220 G00 X55 Z111
; OP-23 ACABADO
N300 T03 D03
N310 G92 S2800
N320 G96 F0.2 S410 M04
N330 G90 G42 G05 G00 X0 Z5
N340 G37 R2 G01 Z0
N350 G36 R10 G01 X12.94
 X28.8 Z-11.1
 Z-14.1
 G36 R0.5 X25.42 Z-19.1
 G39 R0.5 X28.8
 Z-22.1
 G36 R0.5 X25.42 Z-27.1
 G39 R0.5 X28.8
 X42 Z-42.31
 Z-50.27
 X40 Z-52
 G39 R0.5 Z-55
 X48
N360 Q135 X50
N370 G40 G00 X55 Z111
; OP-24 ROSCADO
N400 T07 D07
N410 G97 S850 M04
N420 G90 G40 G07 G00 X44 Z-50
N430 G86 X42 Z-52 Q42 R-40 I0.975 B0.4
                          E0.05 D1 C1.5 A-30
N440 G00 X55 Z111
M30
```

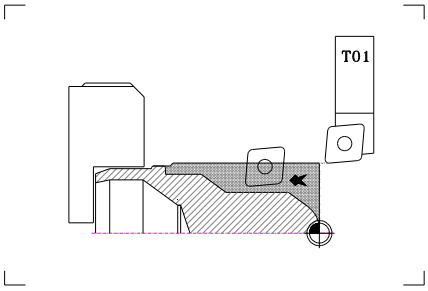
Operaciones Amarre 2

Operación 21 Refrentado



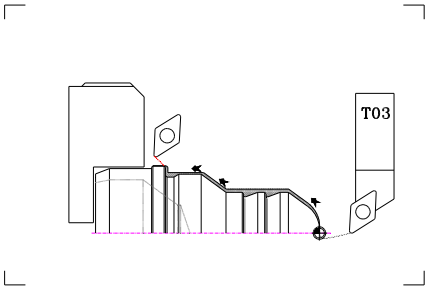
F0591 PTD-05 7404-A-O21-REFRENTADO

Operación 22 Desbaste



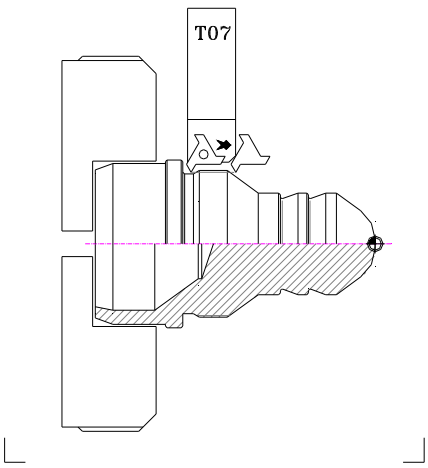
F0590 PTD-05 7404-A-O22-DESBASTE

Operación 23 Acabado



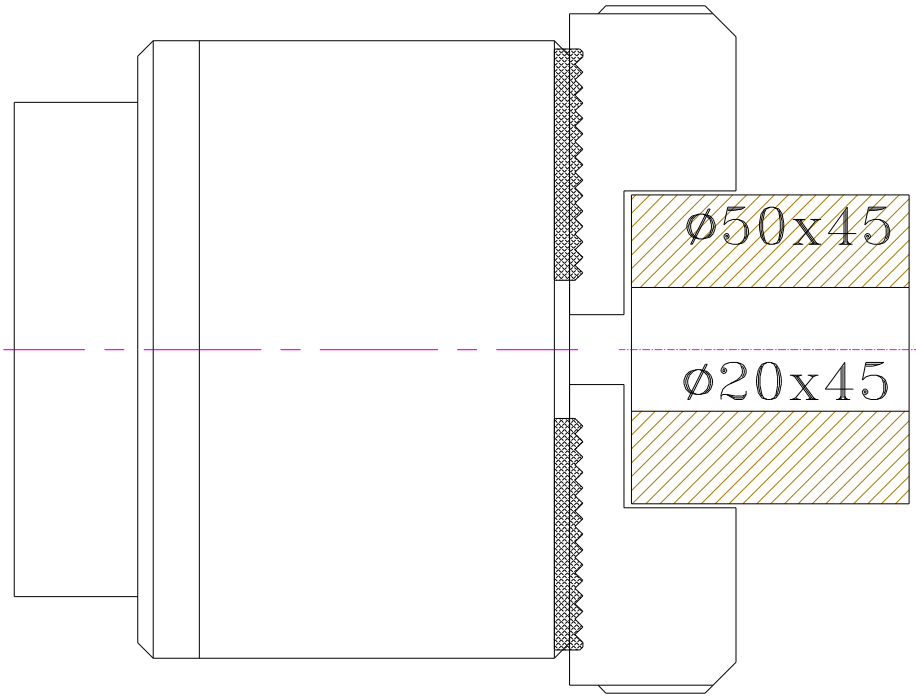
F0589 PTD-05 7404-A-O23-ACABADO

Operación 24 Roscado

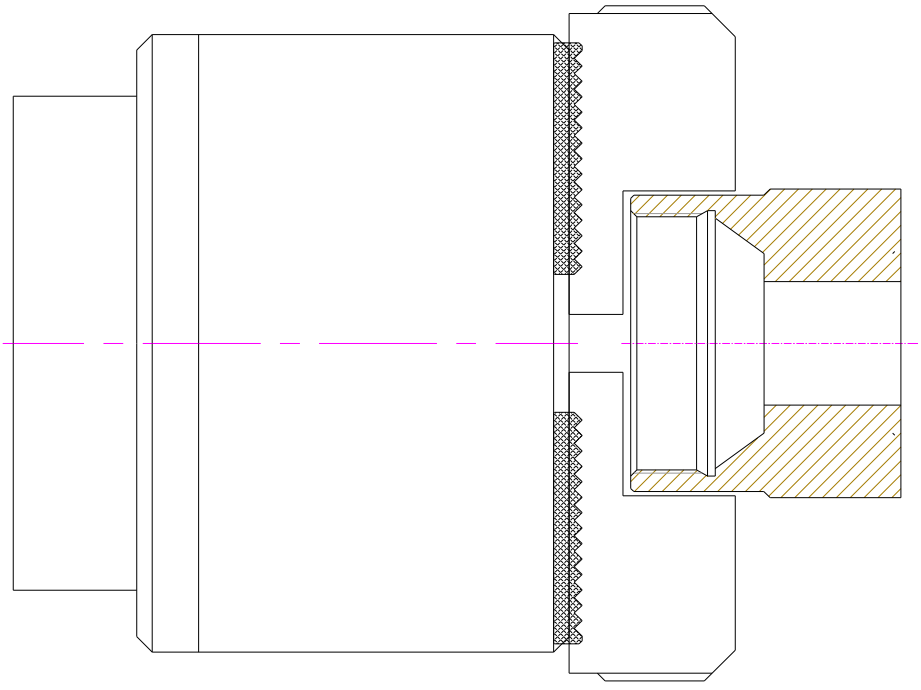


F0588 PTD-05 7404-A-O24-ROSCADO

4. PIEZA B - AMARRE



F0587 PTD-05 7404-B-AMARRE-1



F0586 PTD-05 7404-B-AMARRE-2

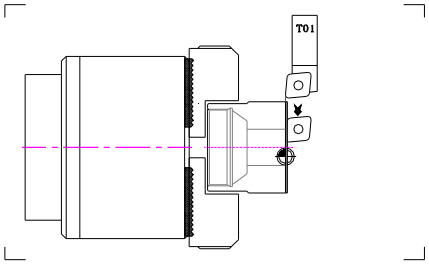
5. PIEZA B - PROGRAMA CNC

Programa CNC Fanuc OT	Programa CNC Fagor 8055	Operaciones Amarre 1

```
:7403 (PTD-4 7404-B A1 H27)
( AGH 2008.06.18 )
( ALECOP ECLIPSE FANUC OT )
( DELRIN )
( AMARRE 1 )
G40 G00 G28 W0
( OP-11 REFRENTADO )
N100 G92 S2800
N110 T0101
N120 G96 F0.30 S330 M04
N130 G40 G00 X52 Z0
N140 G01 X18
N150 G00 Z2
N160 X52
( OP-12 DESBASTE EXTERIOR )
N200 G71 U2 R0.5
N210 G71 P220 Q230 U1 W0.2
N220 G00 X27 Z2
 G01 X30.74 Z0
 X42 Z-7.75
 Z-22.75 C0.5
 X48 C0.5
N230 Z-25
N240 G00 X55
N250 G28 W0
( OP-13 DESBASTE INTERIOR )
N300 T0404
N310 G92 S2800
N320 G96 F0.2 S450 M04
N330 X18 Z2
N340 G71 U1.5 R0.2
N350 G71 P360 Q370 U-1 W0.3
N360 G00 X[29.21+2*1.35] Z1
 G01 X29.21 Z-0.35
 Z-10.84
 X30.06 Z-11.71
 Z-16.15
 X29.21
 Z-23
N370 X25
N380 G00 G28 W0
N390 X55
( OP-14 ACABADO INTERIOR )
```

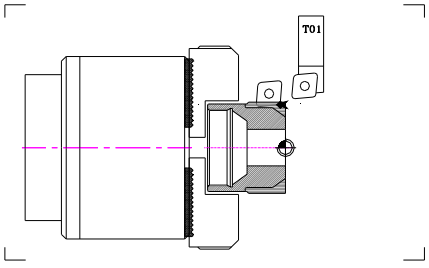
```
%PTD-4 7404-B A1 H27,MX,
; AGH 2008.06.18
; ALECOP ECLIPSE FAGOR 8055
; DELRIN
; AMARRE 1
; OP-11 REFRENTADO
N100 G92 S2800
N110 T01 D01
N120 G96 F0.30 S330 M04
N130 G90 G40 G00 X52 Z0
N140 G01 X18
N150 G00 Z2
N160 X52
; OP-12 DESBASTE EXTERIOR
N200 G68 X30.74 Z0 C2 L1 M0.2 S550 E560
N210 G00 X55 Z99
; OP-13 DESBASTE INTERIOR
N300 T02 D02
N310 G92 S2800
N320 G96 F0.2 S450 M03
N330 X18 Z2
N340 G68 X26.21 Z0 C1.5 L1 M0.3 S450 E460
N350 G00 Z99
N360 X55
; OP-14 ACABADO INTERIOR
N400 T04 D04
N410 G92 S2800
N420 G96 F0.15 S500 M04
N430 G90 G41 G05 G00 X30.91 Z2
N440 G01 X26.21 Z-0.35
N450 G01 Z-10.84
 X30.06 Z-11.71
 Z-16.15
 X26.21
N460 Z-23
N470 X25
N480 G40 G07 G00 Z55
N490 X55
; OP-15 ACABADO EXTERIOR
N500 T03 D03
N510 G92 S2000
N520 G96 F0.2 S500 M04
N530 G90 G42 G05 G00 X27 Z2
```

Operación 11 Refrentado



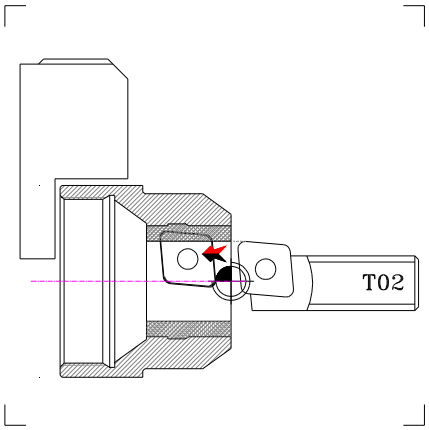
F0580 PTD-05 7404-B-O21-REFRENTADO

Operación 12 Desbaste exterior



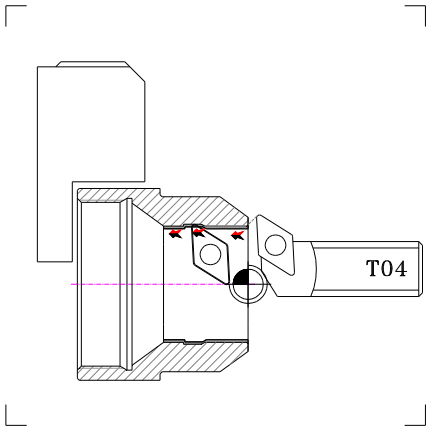
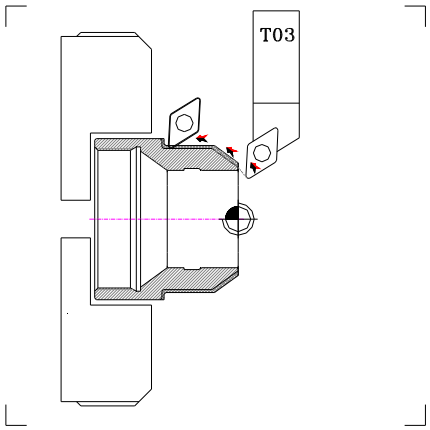
F0579 PTD-05 7404-B-O22-DESBASTE-EXT

Operación 13 Desbaste interior



F0578 PTD-05 7404-B-O23-DESBASTE-INT

Operación 14 Acabado interior

Programa CNC Fanuc OT	Programa CNC Fagor 8055	Operaciones Amarre 1
N400 T0404 N410 G92 S2800 N420 G96 F0.15 S500 M04 N430 G40 G00 X52 Z3 N440 G41 G70 P360 Q370 N490 G40 G00 G28 W0 (OP-15 ACABADO EXTERIOR) N500 T0303 N510 G92 S2000 N520 G96 F0.2 S500 M04 N530 G00 G42 X18 Z3 N540 G70 P220 Q230 N580 G40 G00 X55 N590 G28 W0 M30 %	N540 G01 X30.74 Z0 N550 X42 Z-7.75 G39 R0.5 Z-22.75 N560 X47 N570 Q135 X51 N580 G40 G00 X55 N590 Z99 M30	 *F0577 PTD-05 7404-B-O24-ACABADO-INT* Operación 15 Acabado exterior  *F0576 PTD-05 7404-B-025-ACABADO-EXT*

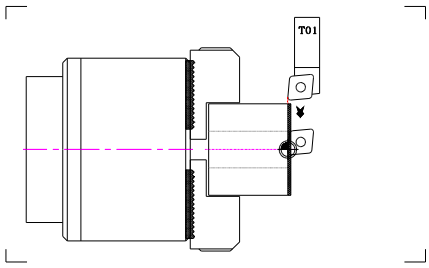
>

Programa CNC Fanuc OT	Programa CNC Fagor 8055	Operaciones Amarre 2

```
:7404 (PTD-4 7404-B A2 H27)
( AGH 2008.06.18 )
( ALECOP ECLIPSE FANUC OT)
( DELRIN )
( AMARRE 2 )
G40 G00 G28 W0
( OP-21 REFRENTADO )
N100 G92 S2800
N110 T0101
N120 G96 F0.30 S330 M04
N130 G40 G00 X52 Z0
N140 G01 X18
N150 G00 Z2
( OP-22 ACABADO EXTERIOR )
N200 X43
N210 G01 X48 Z-0.5
N220 Z-21
N230 X51
N240 G00 X55
N250 G28 W0
( OP-23 DESBASTE INTERIOR )
N300 T0404
N310 G92 S2800
N320 G96 F0.2 S450 M04
N330 X18 Z2
N340 G71 U1.5 R0.5
N350 G71 P360 Q370 U-1 W0.3
N360 G00 X44.35 Z1
 G01 X40.35 Z-1
 Z-10.69
 X43 Z-12.43
 Z-13.69
 X40.55
 X29.21 Z-21.6
N370 X19.5 Z-22
N380 G00 G28 W0
( OP-24 ACABADO INTERIOR )
N400 T0404
N410 G92 S2800
N420 G96 F0.15 S500 M04
N430 G41 G00 X18 Z2
N440 G70 P360 Q370
N450 G40 G00 G28 W0
N460 X55
( OP-25 ROSCADO INTERIOR )
```

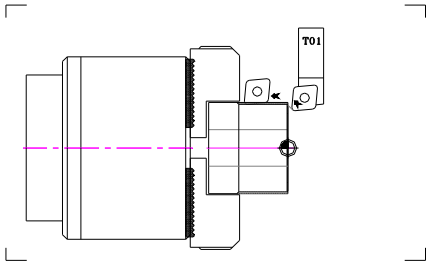
```
%PTD-4 7404-B A2 H27,MX,
; AGH 2008.06.18
; ALECOP ECLIPSE FAGOR 8055
; DELRIN
; AMARRE 2
; OP-21 REFRENTADO
N100 G92 S2800
N110 T01 D01
N120 G96 F0.30 S330 M04
N130 G90 G40 G00 X52 Z0
N140 G01 X18
N150 G00 Z2
; OP-22 ACABADO EXTERIOR
N200 X43
N210 G01 X48 Z-0.5
N220 Z-21
N230 X51
N240 G00 G56 X175 D0
N250 G53 Z333
; OP-23 DESBASTE INTERIOR
N300 T02 D02
N310 G92 S2800
N320 G96 F0.2 S450 M04
N330 X18 Z2
N340 G68 X40.35 Z0 C1.5 L1 M0.3 S440 E450
N350 G00 Z55
N360 Z111
; OP-24 ACABADO INTERIOR
N400 T04 D04
N410 G92 S2800
N420 G96 F0.15 S500 M04
N430 G90 G41 G05 G00 X46.36 Z2
N440 G01 X40.35 Z-1
 Z-10.69
 X43 Z-12.43
 Z-13.69
 X40.55
 X29.21 Z-21.6
N450 X19.5 Z-22
N460 G40 G07 G00 X19
N470 Z55
N480 X111
; OP-25 ROSCADO INTERIOR
N500 T08 D08
N510 G92 S2800
```

Operación 21 Refrentado



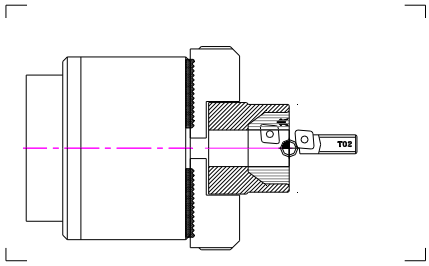
F0585 PTD-05 7404-B-O11-REFRENTADO

Operación 22 Acabado exterior



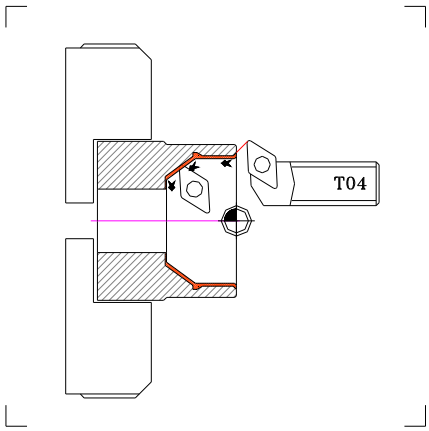
F0584 PTD-05 7404-B-OP11-ACABADO-EXT

Operación 23 Desbaste interior



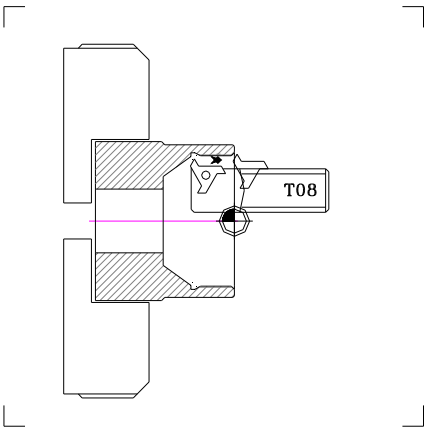
F0583 PTD-05 7404-B-O13-DESBASTE-INT

Operación 24 Acabado interior



F0582 PTD-05 7404-B-O14-ACABADO-INT

Operación 25 Roscado interior

Programa CNC Fanuc OT	Programa CNC Fagor 8055	Operaciones Amarre 2
N500 T0808 N510 G92 S2800 N520 G97 S800 M04 N530 G00 X38 N540 Z-12.5 N550 G76 P010060 Q100 R0.05 N560 G76 X42 Z3 R0 P[1000*0.55*1.5] Q200 F1.5 N570 G00 G28 W0 N580 X55 M30 %	N520 G97 S800 M04 N530 G00 X38 N540 Z-12 N550 G86 X40.35 Z-12.5 Q40.35 R3 I-0.825 B0.2 E0.02 D1 C1.5 A-30 N560 G00 Z11 N570 X55 M30	 F0581 PTD-05 7404-B-015-ROSCADO-INT

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