Exercice 2

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| --- | --- | --- |
| C1,3 Décoder, Exploiter les données techniques relatives à la réalisation d’une pièceC21 Etablir un processus d'usinage | **S2 Processus de fabrication** S214 Programmation des machines CN / Organisation d'un prog CNS63 Langage de programmation | support droit |



  Sécurité de 5mm

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| POINTS | X | Z | R | Code G |
| A | 0 | 84 |  | G00 |
| B | 0 | 79 |  | G01 |
| C | 54 | 79 |  | G01 |
| D | 60 | 76 |  | G01 |
| E | 60 | 68 |  | G01 |
| F | 68 | 64 | 4 | G02 |
| G | 100 | 64 |  | G01 |
| H | 100 | 40 |  | G01 |
| I | 120 | 40 |  | G01 |
| J | 130 | 40 |  | G01 |
| K | 200 | 200 |  | G00 |
| POINTSBRUT | X | Z |
| 1 | 130 | 40 |
| 2 | 130 | 84 |
| 3 | 0 | 84 |



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| PROGRAMME | COMMENTAIRES |
| %2209 |  |
| N10 G90 G40 G80 G95 M5 M9 |  |
| N20 G0G52 X0 |  |
| N30 G0 G52 Z0 |  |
| N40 G54 |  |
| N50 G79 N |  |
| N60 (PROFIL EXTERIEUR) |  |
| N70 G0 X0 Z84 | A |  |
| N80 G01 X0 Z79 F0.1 | B |  |
| N90 X54 Z79 | C |  |
| N100 X60 Z76 | D |  |
| N110 Z68 | E |  |
| N120 G02 X68 Z64 R4 | F |  |
| N130 G01 X100 Z64 | G |  |
| N140 Z40 | H |  |
| N150 X120 Z40 | I |  |
| N160 X130  | J |  |
| N170 (Ebauche extérieure) |  |
| N180 M6 T1 D1 |  |
| N200 G92 S4000 |  |
| N205 G97 S1000 |  |
| N210 G0 X135 Z89 (point d’approche) |  |
| N220 G96 S100 |  |
| N230 G64 N160 N70 I0.3 K 0.05 P2 F0.1 |  |
| N240 X130 Z40  | 1 | Profil brut |
| N250 X130 Z84 | 2 |  |
| N260 X0 Z84 | 3 |  |
| N270 G80 |  |
| N280 G77 N10 N40 |  |
| N290 M6 T2 D2 M8 |  |
| N300 G92 S4000 M3 |  |
| N310 G97 S400 |  |
| N320 G96 S150 |  |
| N330 G77 G42 N70 N160 F0.05 |  |
| N340 G77 N10 N40 |  |
| N350 M30 |  |
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