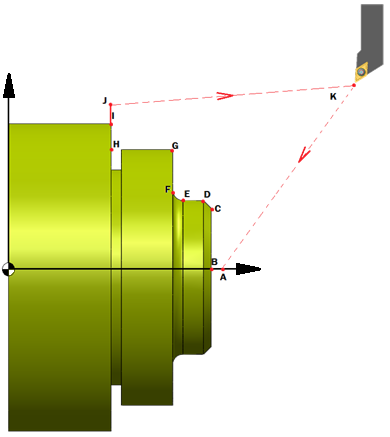
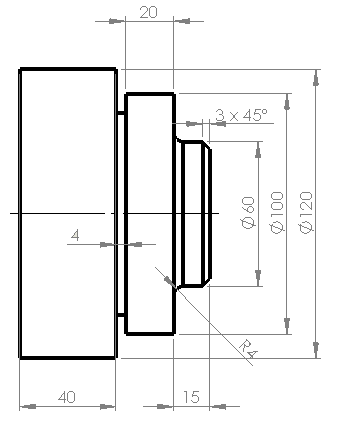
Exercice 2

|  |  |  |
| --- | --- | --- |
| C1,3 Décoder, Exploiter les données techniques relatives à la réalisation d’une pièce  C21 Etablir un processus d'usinage | **S2 Processus de fabrication**  S214 Programmation des machines CN / Organisation d'un prog CN  S63 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 |
| POINTS  BRUT | X | | Z | | |
| 1 | 130 | | | 40 | |
| 2 | 130 | | | 84 | |
| 3 | 0 | | | 84 | |



|  |  |  |  |
| --- | --- | --- | --- |
| 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 | | |  |
|  | | |  |
|  | | |  |