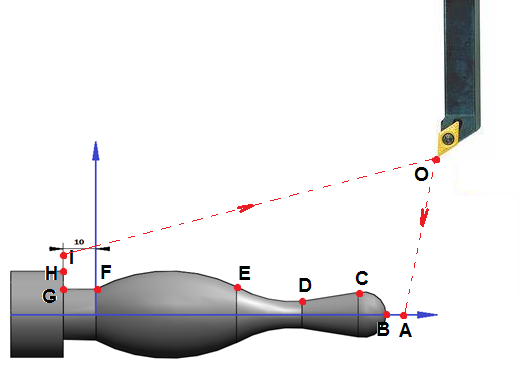
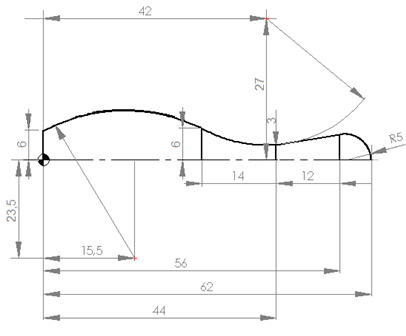
Exercice 3

|  |  |  |
| --- | --- | --- |
| C13 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 | I | | | K | Code G |
| A | 0 | 67 |  |  | | |  | G00 |
| B | 0 | 62 |  |  | | |  | G01 |
| C | 10 | 56 | 5 |  | | |  | G03 |
| D | 6 | 44 |  |  | | |  | G01 |
| E | 12 | 30 |  | 54 | | | 42 | G02 |
| F | 12 | 0 |  | 47 | | | 15 | G03 |
| G | 12 | -10 |  |  | | |  | G01 |
| H | 20 | -10 |  |  | | |  | G01 |
| I | 30 | -10 |  |  | | |  | G01 |
| O | 200 | 200 |  |  | | |  | G00 |
| POINTS  BRUT | X | | | | Z | | | |
| 1 | 30 | | | | | -10 | | |
| 2 | 30 | | | | | 67 | | |
| 3 | 0 | | | | | 67 | | |

* Brut Ø 20
* Remplir le tableau de coordonnées.
* Nommer les axes
* Définir le brut.
* Faire le programme en utilisant la fonction d’usinage paraxial.



|  |  |
| --- | --- |
| PROGRAMME | COMMENTAIRES |
| %1011 (QUILLE) |  |
| N10 G90 G40 G80 G95 M5 M9 |  |
| N20 G0 G52 X0 |  |
| N30 G0 G52 Z0 |  |
| N40 G54 |  |
| N50 G79 N140 |  |
| N60 (Profil extérieur) |  |
| N70 G0 X0 Z67 (A) |  |
| N80 G01 Z62 (B) |  |
| N90 G03 X10 Z56 R5 (C) |  |
| N100 G01 X6 Z44 (D) |  |
| N110 G02 X12 Z30 I54 K42 (E) |  |
| N120 G03 X12 Z0 I47 K15 (F) |  |
| N130 G01 X12 Z-10 (G) |  |
| N140 X20 Z-10 (H) |  |
| N150 X30 Z10 (I) |  |
| N160 G92 (Ebauche extérieur) |  |
| N170 T1 D1 M6 M8 |  |
| N180 G92 M3 S5000 |  |
| N190 G97 S1500 |  |
| N200 G0 X22 Z70 |  |
| N210 G96 S200 |  |
| N220 G64 N150 N70 I0.3 K0.1 P2 F0.05 |  |
| N230 X30 Z-10 (1) |  |
| N240 X30 Z67 (2) |  |
| N250 X0 Z67 (3) |  |
| N260 G80 |  |
| N270 G77 G42 N70 N150 F0.2 |  |
| N280 G77 N10 N40 |  |
| N290 M30 M9 |  |
|  |  |
|  |  |
|  |  |
|  |  |
|  |  |
|  |  |
|  |  |