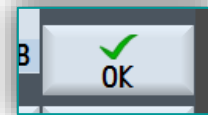
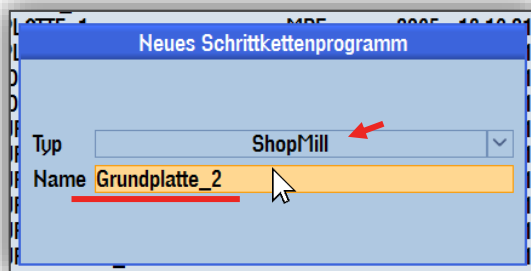


X. Detailing the counterpiece

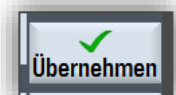
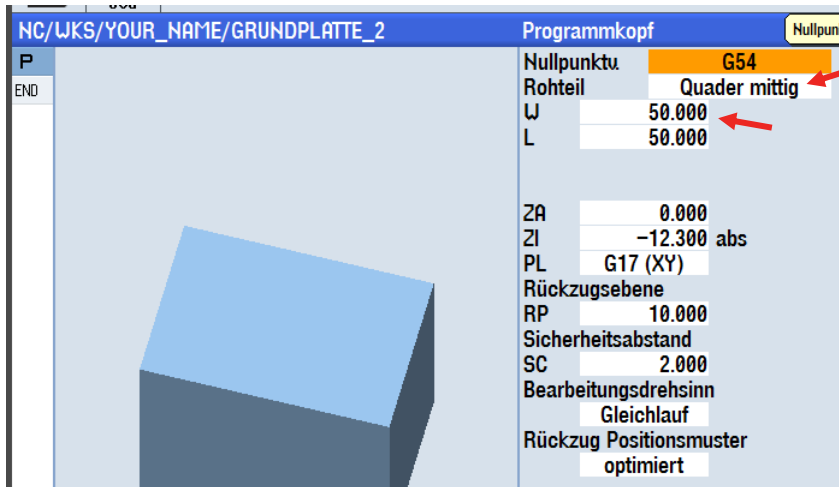
Reference: **Grundplatte_2 – Project 3 Holder (5/5)**

1.

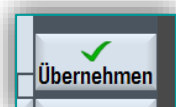
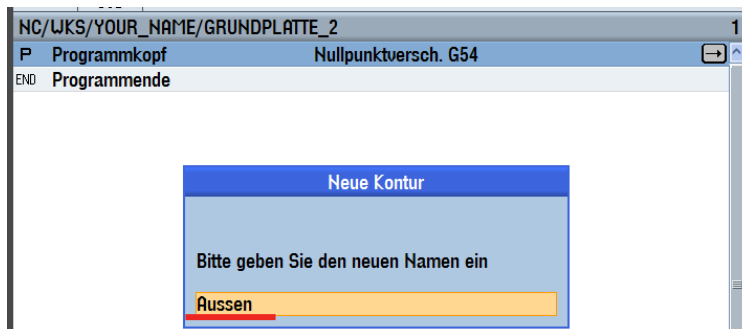
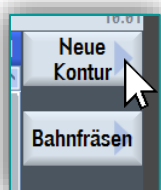
Maschine	Beschreibung	Technol
Drehmaschine mit angetriebenem Werkzeug	SP1-Spindel (Hauptspindel), X-Achse (lineare Geometrieachse), Z-Achse (lineare Geometrie...	Drehen
Einfache vertikale Fräsmaschine	SP1-Spindel (Hauptspindel), X-Achse (lineare Geometrieachse), Y-Achse (lineare Geometrie...	Fräsen



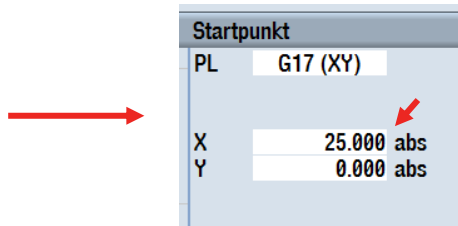
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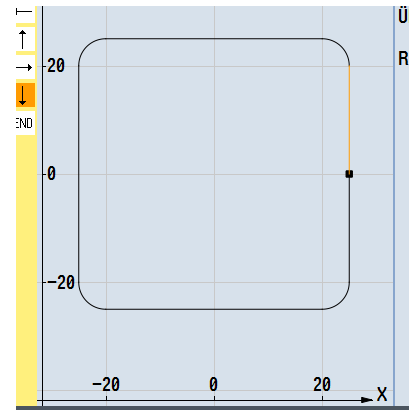
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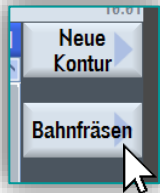
4.



see VIII Nr. 6



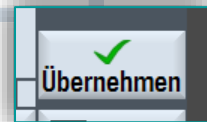
5.



NC/WKS/YOUR_NAME/GRUNDPLATTE_2

Bahnfräsen

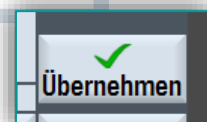
T CUTTER 10 D 1
 F 0.150 mm/Zahn
 U 200 m/min
 Bearbeitung vorwärts
 Radiuskorrektur
 Z0 0.000
 Z1 -10.000 abs
 DZ 3.000
 UZ 0.000
 UXY 0.300
 Anfahren Viertelkreis
 R1 5.000
 FZ 1000.000 mm/min
 Abfahren Viertelkreis
 R2 5.000
 Abhebemodus auf RP



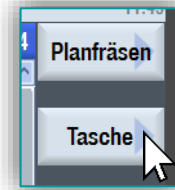
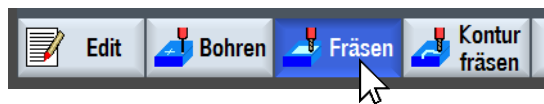
NC/WKS/YOUR_NAME/GRUNDPLATTE_1

Bahnfräsen

T CUTTER 10 D 1
 F 0.150 mm/Zahn
 U 200 m/min
 Bearbeitung vorwärts
 Radiuskorrektur
 Z0 0.000
 Z1 -10.000 abs
 DZ 5.000
 UZ 0.000
 UXY 0.300
 Anfahren Viertelkreis
 R1 5.000
 FZ 1000.000 mm/min
 Abfahren Viertelkreis
 R2 5.000
 Abhebemodus auf RP



6.



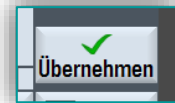
NC/WKS/YOUR_NAME/GRUNDPLATTE_2

Kreistasche

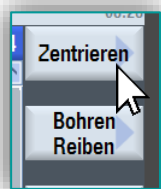
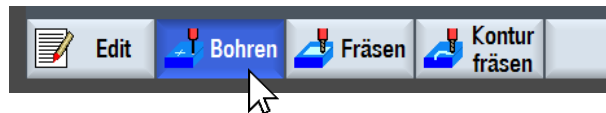
T	CUTTER 10	D 1
F	100.000	mm/min
U	100	m/min
Bearbeitung	helikal	
	Einzelposition	
X0	0.000	
Y0	0.000	
Z0	0.000	
∅	15.000	
Z1	-2.000	abs
DXY	50.000	%
P	1.000	
UXY	0.000	
UZ	0.000	

Werkzeug auswählen
Grafische Ansicht
Rechtecktasche
Kreis-
tasche
Abbruch

Ausräumen Komplettbearb.



7.

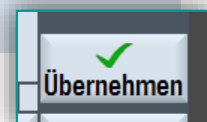


NC/WKS/YOUR_NAME/GRUNDPLATTE_2

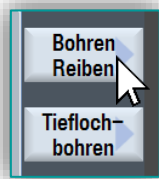
Zentrieren

T	CENTERDRILL 12	D 1
F	150.000	mm/min
S	2000.000	U/min
	Durchmesser	
∅	5.800	
DT	1.000	s

Zentrieren
Bohren
Reiben

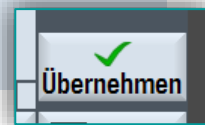


8.

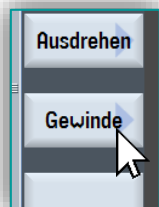


NC/UJS/YOUR_NAME/GRUNDPLATTE_2 Bohren

T	BOHRER	D 1
F	150.000	mm/min
U	35	m/min
	Schaft	
Z1	-9.000	abs
DT	1.000	s

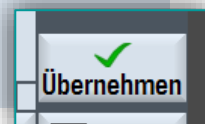


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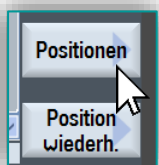


NC/UJS/YOUR_NAME/GRUNDPLATTE_2 Gewindebohren

T	GEWIBO_M5	D 1
Tabelle	ohne	
P	0.800	mm/U
S	120.000	U/min
SR	120.000	U/min
	ohne Ausgleichsfutter	
	1 Schnitt	
Z1	-10.400	abs

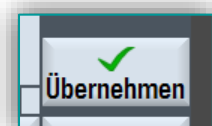


10.

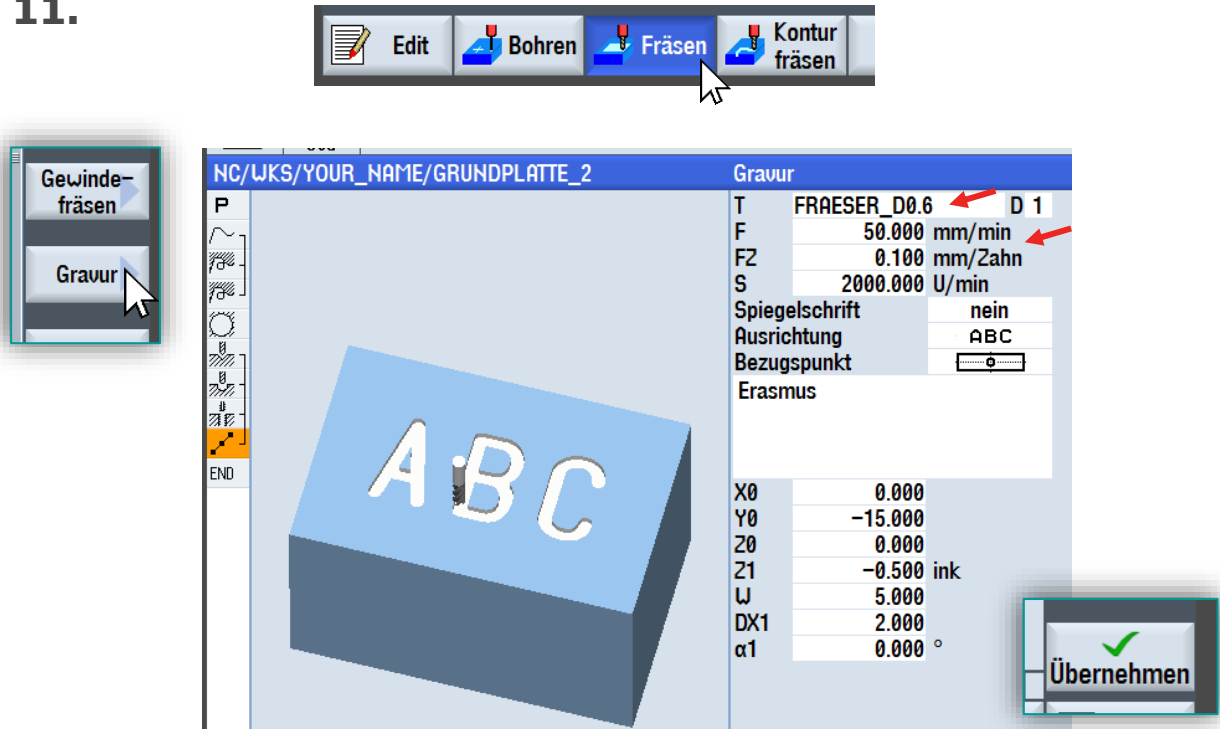


NC/UJS/YOUR_NAME/GRUNDPLATTE_2 Positionsmuster

	Linie
Z0	-2.000
X0	0.000
Y0	0.000
α0	0.000 °
L0	0.000
L	0.000
N	1



11.



12.

