ΠΟΛΥΤΕΧΝΕΙΟ ΚΡΗΤΗΣ
ΣΧΟΛΗ ΜΗΧΑΝΙΚΩΝ ΠΑΡΑΓΩΓΗΣ & ΔΙΟΙΚΗΣΗΣ
ΕΡΓΑΣΤΗΡΙΟ ΜΙΚΡΟΚΟΠΗΣ & ΚΑΤΑΣΚΕΥΑΣΤΙΚΗΣ ΠΡΟΣΟΜΟΙΩΣΗΣ

ΣΧΕΔΙΑΣΗ ΚΑΙ ΚΑΤΑΣΚΕΥΗ ΜΗΧΑΝΟΛΟΓΙΚΩΝ ΤΕΜΑΧΙΩΝ ΜΕ ΤΗ ΒΟΗΘΕΙΑ ΛΟΓΙΣΜΙΚΟΥ CAD/CAM

ΜΑΡΑΖΙΩΤΗ ΜΑΡΙΑ
ΜΠΑΧΤΑΛΙΑ ΑΝΑΣΤΑΣΙΑ

ΕΠΙΒΛΕΠΩΝ: ΑΡΙΣΤΟΜΕΝΗΣ ΑΝΤΩΝΙΑΔΗΣ
ΚΑΘΗΓΗΤΗΣ

ΑΡ. ΔΙΠΛ. : 99

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Στους γονείς μας

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Περιεχόμενα

1.   Εισαγωγή

Η παρούσα πτυχιακή εργασία αποσκοπεί στην δημιουργία πολύπλοκων τεμαχίων στην εργαλειομηχανή ψηφιακής καθοδήγησης Siemens 810D και με κέντρο κατεργασίας DMU 50 eco του εργαστηρίου Μικροκοπής και Κατασκευαστικής Προσομοίωσης (m3). Ο σχεδιασμός των τεμαχίων καθώς και οι εξαγώμενοι κώδικες που χρησιμοποιήθηκαν για την κοπή των παρακάτω κομματιών πραγματοποιήθηκαν σε λογισμικό CAD/CAM. Στόχος της είναι η εκμάθηση και η εξοικίωση του χειριστή με την χρήση και τον προγραμματισμό της εργαλειομηχανής.

Στο Κεφάλαιο 2 παρατίθεται ένας οδηγός για αρχάριους χειριστές με σαφής οδηγίες και εικόνες ούτως ώστε να τους βοηθήσει να εισαχθούν στον κόσμο των εργαλειομηχανών ψηφιακής καθοδήγησης καθώς και να τους βοηθήσει να αποκτήσουν άνεση με βασικές διαδικασίες και κατεργασίες της μηχανής.

Στο κεφάλαιο 3 παρουσιάζονται τα μηχανολογικά σχέδια των τεμαχίων που κατασκευάστηκαν καθώς και τα φασεολόγια τους. Αναλυτικά αναφέρονται τα βήματα που ακολουθήθηκαν για την επεξεργασία τους, δίνονται τα χαρακτηριστικά του κάθε βήματος (χρόνοι κατεργασίας, προώσεις, στροφές και εργαλεία που χρειάστηκαν για την πραγματοποίηση του κάθε βήματος) και παρουσιάζονται με εικόνες τα τελικά τεμάχια τα οποία παράχθηκαν.

Κατά την ολοκλήρωση της πτυχιακής εργασίας παρουσιάζονται μία Σύνοψη, η Βιβλιογραφία που χρησιμοποιήθηκε καθώς και ένα παράρτημα το οποίο περιέχει του κώδικες οι οποίοι δημιουργήθηκαν και εκτελέστηκαν κατά την εκπόνηση της εργασίας.

Τα λογισμικά CAD/CAM τα οποία χρησιμοποιήθηκαν για την δημιουργία του εκάστοτε κώδικα και των μηχανολογικών σχεδίων των τεμαχίων είναι το NX12 της Siemens και το Inventor της Autodesk. Τα παραπάνω λογισμικά παρέχονται από το εργαστήριο Μικροκοπής και Κατασκευαστικής Προσομοίωσης (m3). Για την εκμάθηση της εργαλειομηχανής χρησιμοποιήθηκε το λογισμικό προσομοίωσης των εργαλειομηχανών ψηφιακής καθοδήγηση SinuTrain της Siemens. Τέλος, τα σχέδια των τεμαχίων που κατασκευάστηκαν λήφθηκαν από το βιβλίο του Α. Θ. Αντωνιάδη «Μηχανολογικό Σχέδιο» ,Εκδόσεις Τζίολα 2η έκδοση, 2015.

2.   Εκπαίδευση σε εργαλειομηχανές

Σε αυτό το κεφάλαιο παρουσιάζεται ένας οδηγός χρήσης της εργαλειομηχανής ψηφιακής καθοδήγησης Siemens 810D με κέντρο κατεργασίας DMU50 eco, το οποίο βρίσκεται στο εργαστήριο Μικροκοπής και Κατασκευαστικής Προσομοίωσης (m3) της σχολής του Πολυτεχνείου Κρήτης, καθώς και αναλυτικές οδηγίες για την δημιουργία ενός απλού κομματιού. Σκοπός αυτού του κεφαλαίου είναι η εκμάθηση χρήσης της μηχανής καθώς και η εξοικίωση του χρήστη με αυτή.

Οι οδηγίες αποτελούνται από αναλυτικά βήματα και φωτογραφίες ώστε να είναι ευκολότερη η κατανόηση από τον χρήστη. Ταυτόχρονα, τα βήματα χωρίζονται σε κεφάλαια ώστε να υπάρξει μία διακριτή διαφοροποίηση των φάσεων και των κατεργασιών.

Το παράδειγμα το οποίο δίνεται απευθύνεται σε τεμάχια τα οποία είναι κατασκευασμένα από μαλακό αλουμίνιο τύπου AL6082. Σε περίπτωση που χρησιμοποιηθεί κάποιος άλλος τύπος υλικού οι προώσεις καθώς και οι στροφές περιστροφής για τα κοπτικά εργαλεία αλλάζουν με βάση τους πίνακες των κατασκευαστών των εργαλείων.

Συνολικά τα εργαλεία που χρησιμοποιήθηκαν για το παρακάτω παράδειγμα είναι τα εξής:
1. Ηλεκτρονικό παχύμετρο
2. Μετρητικό ρολόι
3. Φραιζοκεφαλή (D63)
4. Κονδύλι (D6)
5. Τρυπάνι (D6.7)
6. Λίμα
7. Ματσόλα
8. Χάρακας ορθής γωνίας(για γώνιασμα)

2.1 Οδηγίες χρήσης της μηχανής για την κατεργασία ενός τεμαχίου

2.1.1 Άνοιγμα Εργαλειομηχανής και Μετρητικής Μηχανής

1. Αρχικά, ο χειριστής ανοίγει την βάνα του αέρα γυρνώντας τον μοχλό προς τα δεξιά (είναι σίγουρος ότι ανοίξε η παροχή και περνάει αέρας διότι ακούγεται).

2. Ελέγχει το μανόμετρο της πίεσης για να σιγουρευτείτε πως είναι κοντά στα 7.5 bar.

3. Ανοίγει την παροχή του ρεύματος στον ηλεκτρολογικό πίνακα που βρίσκεται πίσω από τη μηχανή, σηκώνοντας τον διακόπτη προς τα πάνω (μόλις ανοίξει τον διακόπτη ανάβουν τρία λαμπάκια στα δεξιά του).

4. Ανοίγει τον διακόπτη του μετρητικού μηχανήματος για τα εργαλεία, ο οποίος βρίσκεται κάτω δεξιά, ώστε να ανοίξει ο υπολογιστής της μηχανής (πρέπει να περιμένει να ολοκληρωθεί πρώτα η διαδικασία εκκίνησης του Η/Υ και μετά μεταβαίνει στο επόμενο βήμα).
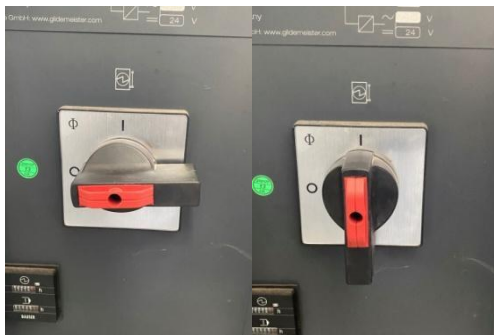
5. Γυρνάει προς τα δεξιά τον διακόπτη της μηχανής.

6. Όταν παρουσιαστεί στην οθόνη το μήνυμα: «Do you want to start the HMI Embedded System with network connection </n> ?» πατάει το γράμμα 'Y' στο πληκτρολόγιο της μηχανής.
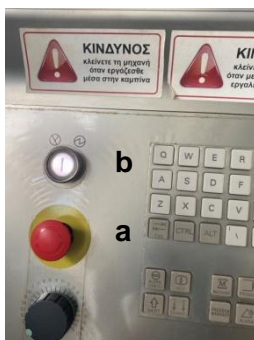
7. Πρώτα πρέπει να περιμένει να ολοκληρωθεί το άνοιγμα της μηχανής και στην συνέχεια:
a. Απασφαλίζει το κουμπί έκτακτης ανάγκης (emergencybutton) γυρνώντας δεξιά και τραβώντας το προς τα πάνω και
b. Πατάει το στρογγυλό κουμπί για να πάρει αέρα η μηχανή (μόλις πραγματοποιηθεί αυτό ακούγεται ένας δυνατός ήχος από τη μηχανή).

8. Πατάει το 2ο κουμπί κάτω αριστερά στην οθόνη της μηχανής για μετάβαση στο κεντρικό μενού.
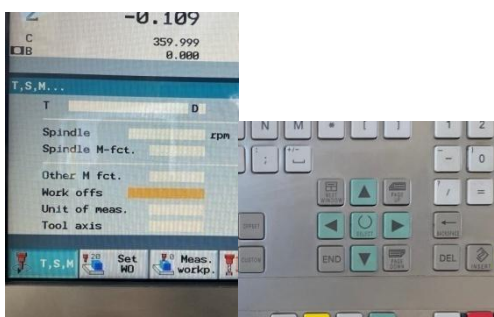
9. Με τα βελάκια του πληκτρολογίου κατευθείνεται στην 6η γραμμή του κεντρικού μενού που γράφει "Workoffs".
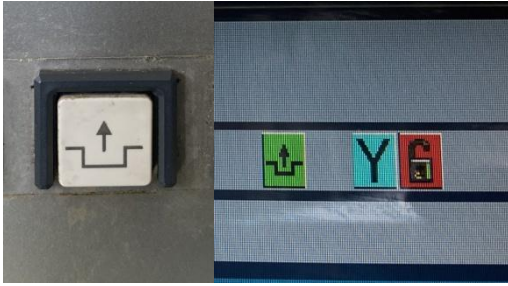
10. Κλείνει την πόρτα της μηχανής και την ασφαλίζει με το κουμπί στο πληκτρολόγιο. Μόλις πραγματοποιηθεί η ενέργεια αυτή εμφανίζεται και το χαρακτηριστικό σύμβολο στην οθόνη.
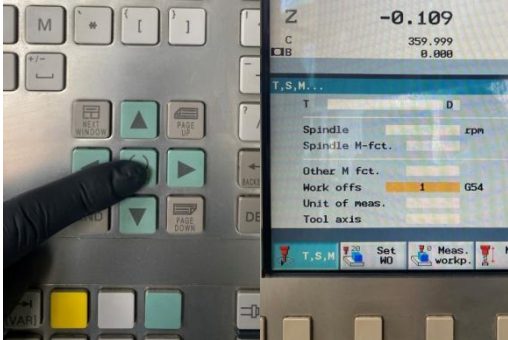
11. Πατώντας το κεντρικό κουμπί στο πληκτρολόγιο όπως φαίνεται στην εικόνα αριστερά 2 φορές εμφανίζεται στο μενού η ένδειξη "1 G54".
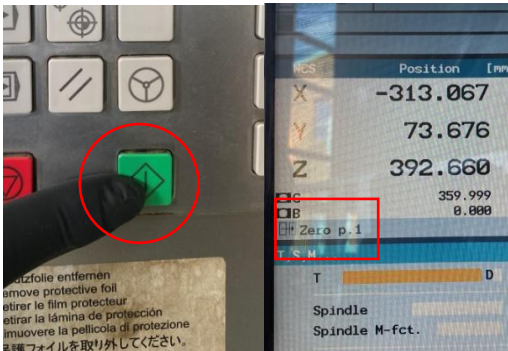
12. Πατώντας το κουμπί "Enter" παρατηρείται ότι εμφανίζεται το μήνυμα "Zero p.1" στην κεντρική οθόνη, το οποίο σημαίνει ότι η μηχανή δέχθηκε την εντολή την οποία μόλις εισάχθηκε (η εντολή μπορεί να μην περαστεί με την πρώτη φορά οπότε σε αυτήν την περίπτωση επαναλαμβάνουμε την ιδια διαδικασια 2-3 φορές έως ότου εμφανιστεί στην οθόνη.)

2.1.2   Μέτρηση Κοπτικών Εργαλείων

13. Στη συνέχεια, ο χειριστής μετράει τα κοπτικά εργαλεία τα οποία θα χρησιμοποιήσει ούτως ώστε να υπάρχει ακρίβεια στις μετρήσεις. Γι' αυτό ανοίγει το πρόγραμμα "Microvision" στον Η/Υ της μηχανής.
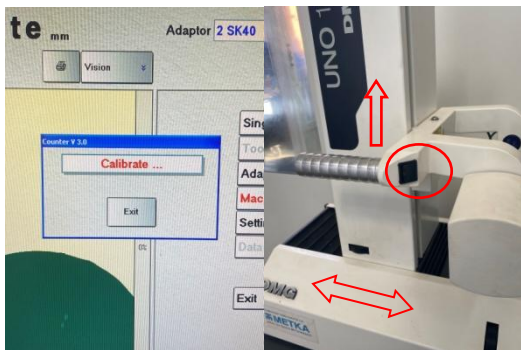
14. Μόλις ανοίξει το πρόγραμμα, εμφανίζεται το μήνυμα στην αριστερή εικόνα και για να εξαφανιστεί πατάει συνεχόμενα το κουμπί του μετρητικού και κουνάει τον μοχλό προς τα πάνω και μπρος πίσω.

15. Στο μήνυμα που εμφανίζεται πατάει το κουμπί κλείσιμο.

16. Πρέπει να εξαχθούν όλα τα εργαλεία με προσοχή, ώστε να μην χτυπηθούν, μέσα από τη μηχανή τραβώντας τα προς τα έξω από τη βάση τους.

17. Για να περιστραφεί η βάση των εργαλείων, πρέπει να πατήσει τα δύο κουμπιά όπως φαίνονται στην εικόνα (το πάτημα των κουμπιών γίνεται ταυτόχρονα).
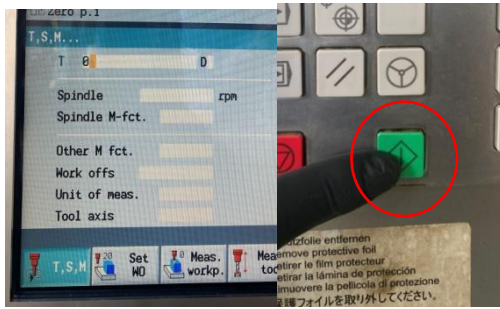
18. Για να εξαχθεί και το εργαλείο που βρίσκεται μέσα στην κεφαλή της μηχανής πρέπει πρώτα να ασφαλιστεί η πόρτα της βάσης των εργαλείων και στη συνέχεια, πληκτρολογώντας στην πρώτη γραμμή του μενού τον αριθμό 0 και πατώντας το πράσινο κουμπί "Enter" το εργαλείο τοποθείται πίσω στην βάση με τα υπόλοιπα.

19. Για να ξεκινήσει η μέτρηση των κοπτικών εργαλείων, ο χειριστής τα τοποθετεί ένα - ένα στο μετρητικό μηχάνημα. Αρχικά, πρέπει να τοποθετήσει το ρολόι με όνομα 3D-probe στη βάση του μετρητικού προσέχοντας να θηλυκώσει σωστά στις εγκοπές, καθώς και το λέιζερ του μετρητικού να ανακλάται στην κορυφή του εργαλείου (το λέιζερ πρέπει να εφάπτεται στην κορυφή του εργαλείου).
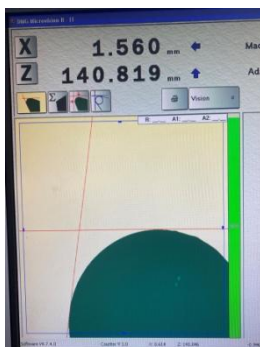
20. Προσπαθώντας να μετρήσει το κάθε εργαλείο είναι σημαντικό να πετύχει υψηλό ποσοστό ακρίβειας (η ακρίβεια μεταβάλλεται κατά τη μέτρηση στη δεξιά μεριά της οθόνης με μια πράσινη μπάρα). Για να βελτιωθεί η ακρίβεια μπορεί ο χειριστής να περιστρέψει τη βάση του μετρητικού αν χρειάζεται. Στις μετρήσεις των εργαλείων, ενδιαφέρον παρουσιάζει μόνο η παράμετρος Ζ.
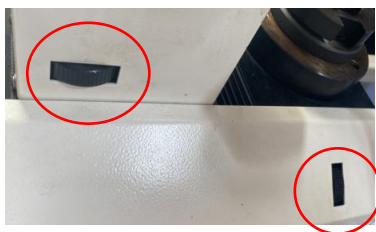
21. Για να μετακινηθεί λίγο το λέιζερ προς την επιθυμητή κατεύθυνση μπορεί ο χρήστης να χρησιμοποιήσει τις 2 πλαϊνές ροδέλες του μετρητικού.
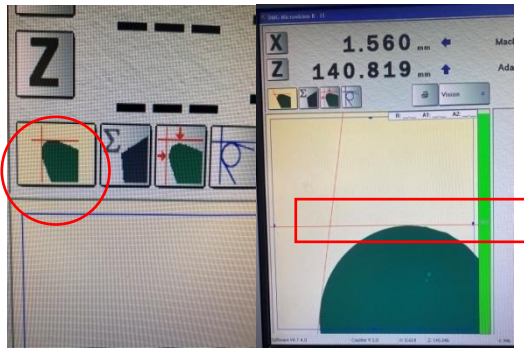
22. Ανάλογα την ακμή του κάθε κοπτικού που μετριέται επιλέγονται οι γραμμές οι οποίες βοηθούν στην επίτευξη της βέλτιστης ακρίβειας (επιδιώκεται η γραμμή που εφάπτεται με την κορυφή του κοπτικού να είναι πάντα οριζόντια).

Σημείωση:Η ακρίβεια θεωρείται καλή όταν έχει τιμές πάνω από το 85%.
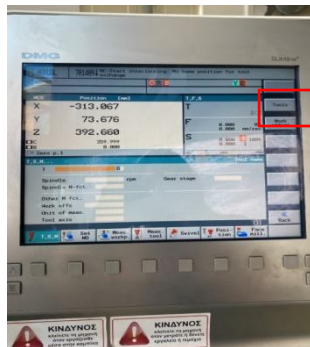
23. Μόλις μετρηθεί το κάθε εργαλείο, ο χρήστης σημειώνει τη μέτρηση σε ένα χαρτί και στη συνέχεια, εισάγει τις μετρήσεις του στη μηχανή πηγαίνοντας στο κεντρικό μενού της μηχανής και πατώντας το δεξιά πάνω κουμπί "Tools" (γενικά επιλέγεται να εισάγονται οι μετρήσεις των εργαλείων στις ήδη υπάρχουσες καταχωρημένες θέσεις).

24. Μόλις επιλεγεί στο μενού "Tools", πηγαίνει στην αντίστοιχη θέση του κάθε εργαλείου και εισάγει, δίπλα από τα χαρακτηριστικά του, τη μέτρηση του άξονα Z δίπλα από το όνομα του εργαλείου, στη στήλη "Length" (στο μενού ο χρήστης περιηγείτε με τα βελάκια του πληκτρολογίου).

25. Για να εισάγει τα δεδομένα, κινείτε στον πίνακα με τα βελάκια του πληκτρολογίου και μόλις φτάσει στο κουτί το οποίο επιθυμεί να επεξεργαστεί πατάει το κουμπί "Insert", εισάγει τη μέτρηση του και στο τέλος, πατάει το κουμπί "Input".

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26. Μόλις εισάγει τα δεδομένα του εκάστοτε εργαλείου, το τοποθετεί στη μηχανή στην κατάλληλη θέση με βάση τον πίνακα "Tools". **Μεγάλη προσοχή:** Το εργαλείο πρέπει να τοποθετηθεί σωστά με τις εσοχές να θηλυκώνουν στη μηχανή, ώστε να μην κουνιέται και προκληθεί κάποιο ατύχημα.

27. Στη συνέχεια, πρέπει να μετρηθεί το τρυπάνι με διάμετρο D6.7 και όνομα Drill67 στο μετρητικό και να εισαχθούν τα δεδομένα του εργαλείου στο μενού "Tools" (στο τρυπάνι μετρούνται όλες του οι ακμές και επικρατεί η μεγαλύτερη τιμή). Σε περίπτωση που υπάρχει κάποιο γρέζι στο εργαλείο πρέπει να καθαριστεί προσεκτικά ώστε να μην επηρεάσει την μέτρηση του.

Σημείωση: Για να μετρηθούν όλες οι ακμές του κοπτικού δεν χρειάζεται να βγει από τη θέση του απλά περιστρέφεται η βάση του.

28. Έπειτα, πρέπει να μετρηθεί το κονδύλι με διάμετρο D6 και όνομα MILL6 στο μετρητικό και στη συνέχεια, να εισαχθούν τα δεδομένα του εργαλείου στο μενού "Tools" (στο κονδύλι μετρούνται όλες του οι ακμές και επικρατεί η μεγαλύτερη τιμή).

    Σημείωση: Στο κονδύλι πρέπει το λέιζερ να προσκρούει κάθετα στην κοπτική του ακμή.
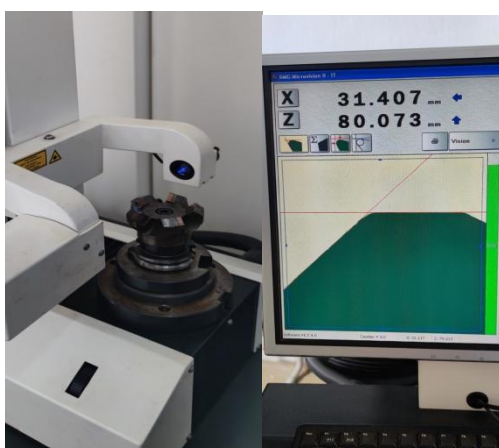
29. Τέλος, πρέπει να μετρηθεί η φρεζοκεφαλή με όνομα FACE63 και διάμετρο D63 στο μετρητικό και στη συνέχεια, να εισαχθούν τα δεδομένα του εργαλείου στο μενού "Tools" (στη φρεζοκεφαλή μετρούνται όλες της οι ακμές και κρατείται η μεγαλύτερη τιμή).

30. Για να οριστικοποιηθούν οι αλλαγές στις τιμές των εργαλείων πρέπει ο χειριστής να κλείσει την πόρτα της βάσης υποδοχής των εργαλείων.

2.1.3   Αρχική διαμόρφωση τεμαχίου- Φραιζάρισμα

31. Πριν ξεκινήσει οποιαδήποτε διαδικασία επιλέγεται το κουμπί "Reset" (Εικόνα a) και το κουμπί "Alarm Cancel" (Εικόνα b).
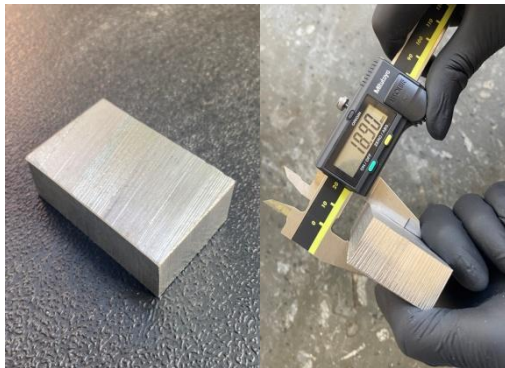
32. Το αρχικό τεμάχιο δεν έχει τις διαστάσεις οι οποίες επιθυμούνται ενώ δεν είναι λείες και οι επιφάνειες του, γι' αυτό το λόγο πρέπει να μετρηθεί το τεμάχιο ώστε να φραιζαριστεί σε όλες του τις πλευρές και ο χειριστής θα πρέπει να σημειώσει τις μετρήσεις όλων των πλευρών σε ένα χαρτί.

Για παράδειγμα, αρχικά το τεμάχιο της εικόνας ήταν (70x37x20) ενώ οι επιθυμητές διαστάσεις του τεμαχίου ήταν (60x30x17).

Σημείωση: Ισχύει ότι ο χειριστής θα πρέπει να γνωρίζει τις τελικές διαστάσεις του τεμαχίου για να γνωρίζει πόσο θα φραιζάρει την κάθε πλευρά.
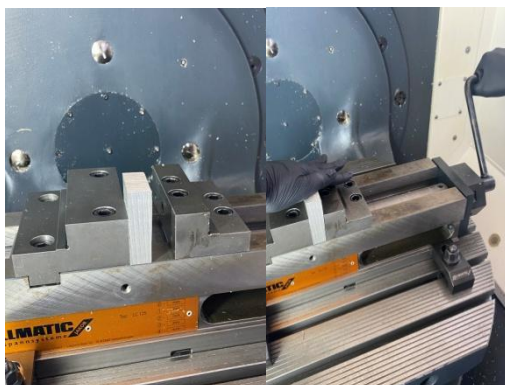
33. Για την εκκίνηση της διαδικασίας, αρχικά, απασφαλίζει την πόρτα της μηχανής και στη συνέχεια, τοποθετεί το τεμάχιο στη μηχανή και το σφίγγει καλά στη μέγγενη γυρνώντας την μανιβέλα μέχρι να μην γυρνάει άλλο, ώστε να μην προκληθεί κάποιο ατύχημα λόγω των μεγάλων τάσεων που ασκούνται. Για να μην κουνηθεί το τεμάχιο καθώς σφίγγεται η μέγγενη πρέπει να πιέζεται με το χέρι μας από πάνω. Μόλις σφίξει η μέγγενη αφαιρείτε ο μοχλός.

34. Έπειτα, επιλέγοντας το κουμπί "Machine" το οποίο βρίσκεται αριστερά κάτω από την οθόνη μεταβαίνει στο κεντρικό μενού.
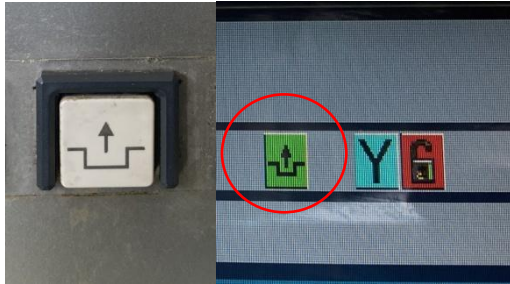
35. Ο χρήστης κλείνει την πόρτα της μηχανής και πατάει το κουμπί στο πληκτρολόγιο για να ασφαλίσει. Μόλις γίνει αυτή η ενέργεια εμφανίζεται και το χαρακτηριστικό σύμβολο στην οθόνη.
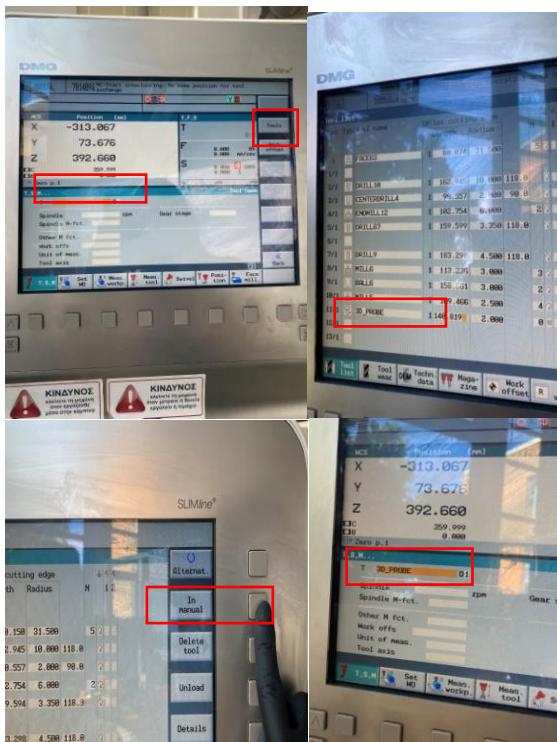
36. Τώρα ο χειριστής είναι έτοιμος να ξεκινήσει το μηδενισμό του τεμαχίου στους άξονες (x,y,z) με τη χρήση του μετρητικού ρολογιού. Για να εισαχθεί το ρολόι 3D-probe στη μηχανή πηγαίνει στο κεντρικό μενού στην πρώτη γραμμή και επιλέγει το κουμπί "Tools". Στο μενού των εργαλείων διαλέγει το ρολόι με τα βελάκια του πληκτρολογίου και επιλέγει το κουμπί "In manual".
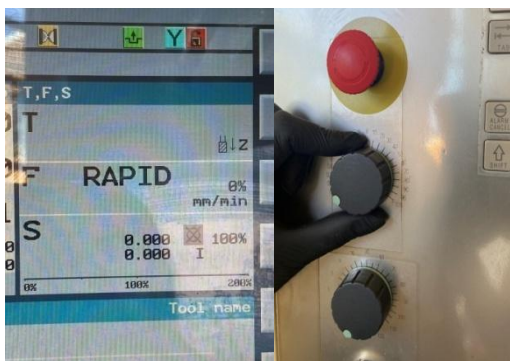
37. Στη συνέχεια, πατάει το κουμπί "Enter" και δίνει στη μηχανή μία σταθερή γρήγορη ταχύτητα (η ταχύτητα της μηχανής η οποία ορίζεται δεν πρέπει να ξεπεράσει το 6-8% της συνολικής ταχύτητας της μηχανής). Μόλις ολοκληρωθεί η διαδικασία κλείνει την ταχύτητα.
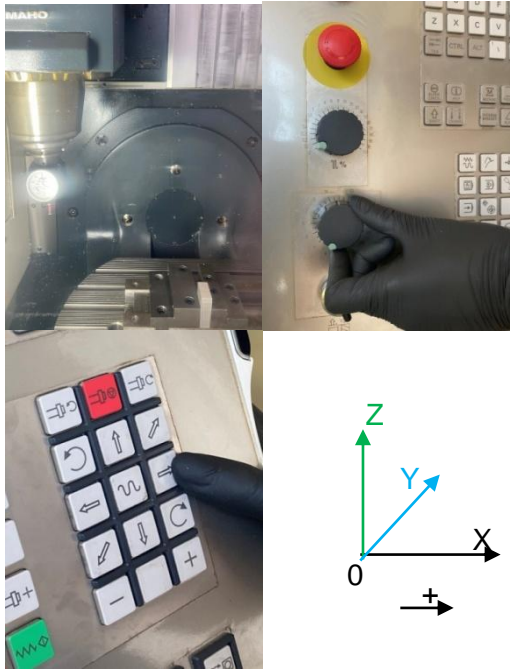
38. Μόλις εισαχθεί το ρολόι στη μηχανή το κουνάει με αργή ταχύτητα (από 0-20%) και με τη χρήση των βελών του πληκτρολογίου το κινεί στους άξονες τους οποίους επιθυμεί (οι άξονες της μηχανής φαίνονται στο διπλανό σχήμα).

Σημείωση:Όταν βρίσκεται πολύ κοντά στο τεμάχιο η ταχύτητά δεν πρέπει να ξεπερνά το 1-2% της ταχύτητας.

39. Μόλις η στρογγυλή μύτη του ρολογιού ακουμπήσει από την αριστερή πλαϊνή πλευρά το τεμάχιο, πρέπει ο κεντρικός δείκτης του ρολογιού (μαύρος) να πραγματοποιήσει δύο πλήρεις περιστροφές. Για να είναι πιο ακριβής ο μηδενισμός μπορεί να χρησιμοποιηθεί το χειριστήριο. Όταν ολοκληρωθεί η διαδικασία αυτή ο χειριστής κλείνει την ταχύτητα.

40. Το χειριστήριο λειτουργεί επιλέγοντας αρχικά τον άξονα ο οποίος μηδενίζεται και στη συνέχεια, κρατώντας πατημένο το πλαϊνό κουμπί περιστρέφεται η ροδέλα. Μόλις ολοκληρωθεί η μέτρηση ο χρήστης γυρνάει πάλι το μοχλό με τον άξονα στο 0 και τοποθετείται το χειριστήριο στην θέση του.
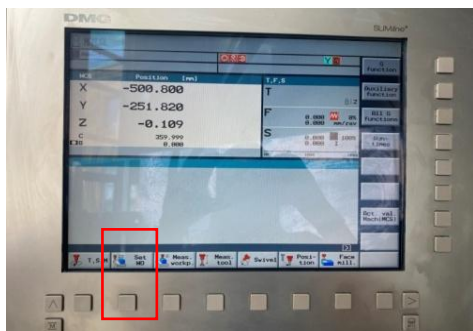
41. Για να εισαχθεί ο μηδενισμός του άξονα Χ στη μηχανή από το κεντρικό μενού ο χειριστής πρέπει να επιλέξει το κουμπί "Set WO" και στο μενού που εμφανίζεται επιλέγει το κουμπί Χ=0. Έτσι, παρατηρείται στην οθόνη ότι ο άξονας Χ μηδενίστηκε.
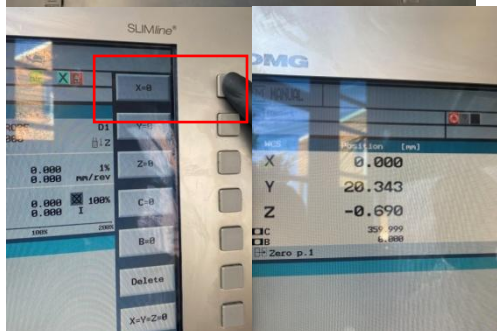
    Σημείωση: Μόλις μηδενιστεί απομακρύνεται το ρολόι από την πλευρά που ακουμπούσε το τεμάχιο με αργή πρόωση.
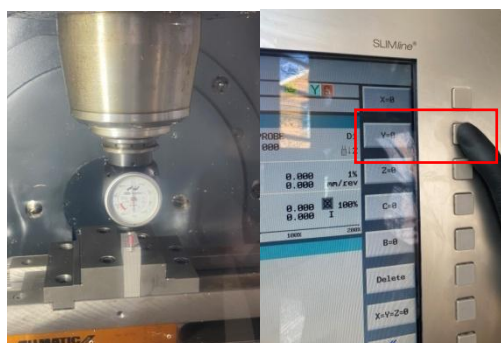
42. Για να μηδενιστεί ο άξονας Υ, ο χειριστής πλησιάζει τη στρογγυλή μύτη του ρολογιού από την μπροστινή μεριά του τεμαχίου και μόλις ο δείκτης ολοκληρώσει δύο πλήρεις περιστροφές επιλέγει το κουμπί "Set WO" και το κουμπί Υ=0 και εμφανίζεται ο μηδενισμός του άξονα στην οθόνη.

    Σημείωση: Όταν το ρολόι βρίσκεται πολύ κοντά στο τεμάχιο η ταχύτητά δεν ξεπερνά το 1-2% της ταχύτητας.

    Σημείωση: Μόλις μηδενιστεί ο άξονας ο χειριστής απομακρύνει το ρολόι από την πλευρά που ακουμπούσε το τεμάχιο και κλείνει την ταχύτητα.

43. Για να μηδενιστεί ο άξονας Ζ πρέπει να πλησιάσει το ρολόι από την πάνω μεριά του τεμαχίου και μόλις ο δείκτης ολοκληρώσει δύο πλήρεις περιστροφές επιλέγει το κουμπί "Set WO" και το κουμπί Ζ=0 και εμφανίζεται ο μηδενισμός του άξονα στην οθόνη.

    Σημείωση: Όταν το ρολόι βρίσκεται πολύ κοντά στο τεμάχιο η ταχύτητά δεν ξεπερνά το 1-2% της ταχύτητας.

Σημείωση: Μόλις μηδενιστεί ο άξονας απομακρύνεται το ρολόι από την πλευρά που ακουμπούσε το τεμάχιο και ο χρήστης κλείνει την ταχύτητα.
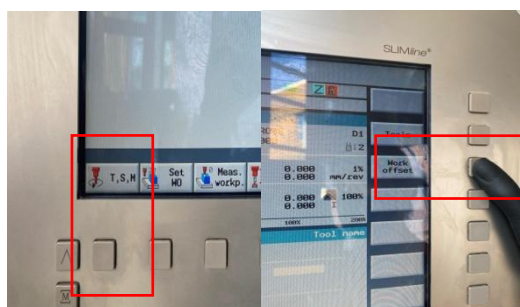
44. Για να ολοκληρωθεί σωστά ο μηδενισμός του άξονα Z ο χρήστης πηγαίνει στο κεντρικό μενού με το κουμπί "T,S,M" και επιλέγοντας το κουμπί "WorkOffset", πηγαίνει στη γραμμή WO1 στον άξονα Z και πατώντας το κουμπί "Insert" προσθέτει το «+2» στο τέλος του αριθμού. Στο τέλος, πατάει το κουμπί "Input" για να οριστικοποιηθεί η νέα τιμή και το κουμπί "Machine" για να επιστρέψει στο κεντρικό μενού.
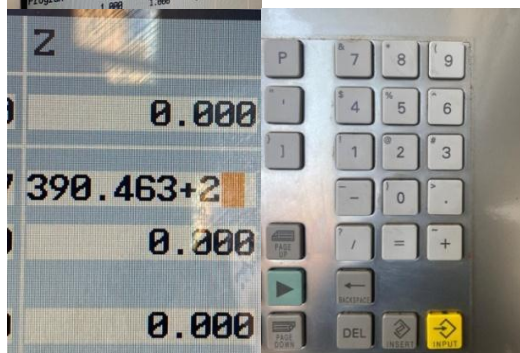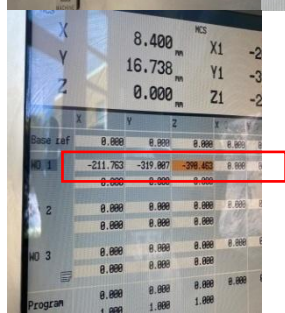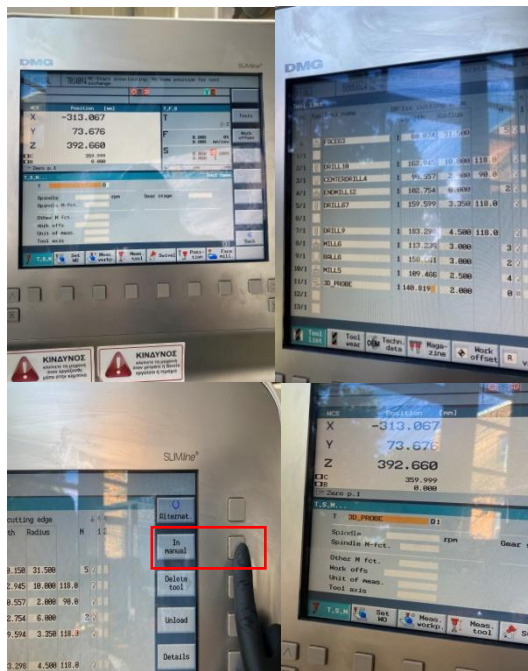
45. Στην συνέχεια, εισάγει τη φρεζοκεφαλή FACE63 στη μηχανή πηγαίνοντας στο μενού "Tools". Ο χειριστής επιλέγει το εργαλείο το οποίο επιθυμεί, επιλέγοντας το κουμπί "In manual" και έπειτα το κουμπί "Enter". Έτσι ξεκινάει η διαδικασία αλλαγής του εργαλείου στην μηχανή. Για να ολοκληρωθεί η διαδικασία πρέπει να δωθεί στη μηχανή γρήγορη ταχύτητα. Μόλις ολοκληρωθεί το παραπάνω βήμα κλείνει την ταχύτητα.
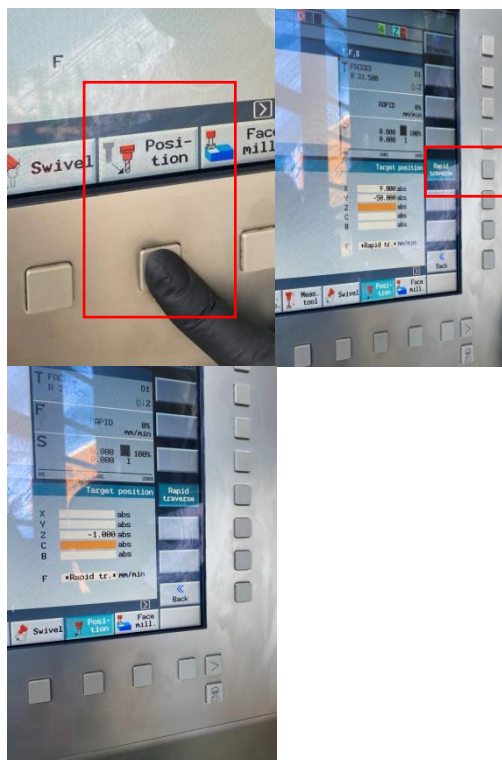
46. Για να φραιζαριστεί η επιφάνεια η οποία επιθυμείται, ο χειριστής πρέπει να επιλέξει το κουμπί "Position" και να εισάγει αρχικά στον άξονα X και Y τις συντεταγμένες τις οποίες επιθυμεί (X=10, το μισό της πλευράς και Y=-50, ώστε να βρίσκεται το εργαλείο μακριά από το τεμάχιο) και επιλέγει το κουμπί "RapidTraverse" για να κινηθέι με γρήγορη πρόωση στη θέση στην οποία επιθυμεί. Με τον ίδιο τρόπο μετακινείται και στον άξονα Z (Z=-1, για να φραιζάρει το τεμάχιο κατά 1mm). Στο τέλος κάθε διαδικασίας κλείνει τις προώσεις.

Σημείωση: Το x και το y στο ίδιο βήμα ενώ το z στο επόμενο.
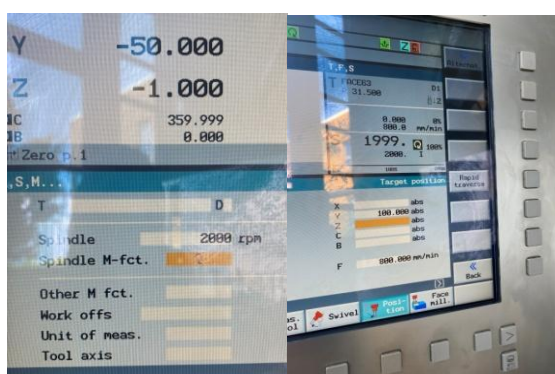
47. Στην συνέχεια, πρέπει να εισαχθούν στο κεντρικό μενού οι στροφές του κοπτικού (2000 rpm) καθώς και η φορά περιστροφής του (δεξιόστροφη) (εισάγεται από το κεντρικό κουμπί των βελών στο πληκτρολόγιο), πατώντας το κουμπί "Enter" και εισάγοντας στο μενού Position την απόσταση που πρέπει να μετακινηθεί κατά Y το κοπτικό (Y=50, για να κόψει όλο το τεμάχιο).

Σημείωση: Η διεργασία αυτή πραγματοποιείται με αργή πρόωση, 800 mm/min.

48. Για να ξεκινήσει η κοπή ο χρήστης επιλέγει "Enter", δίνει αργή πρόωση στο 100% και πατάει το κουμπι του ψυκτικού υγρού παρατεταμένα ώστε να μην σπάσει το κοπτικό. Μόλις ολοκληρωθεί η διαδικασία κλείνει την πρόωση.

Σημείωση: Η διαδικασία του φραιζαρίσματος της κάθε πλευράς γίνεται σταδιακά και με συνεχείς μετρήσεις, ώστε να φτάσει στις επιθυμητές διαστάσεις με μεγάλη ακρίβεια.

49. Μόλις κατεργαστεί η επιθυμητή επιφάνεια αφαιρούνται με μια λίμα τα γρέζια που έχουν παραμείνει πάνω στο τεμάχιο. Η ίδια ακριβώς διαδικασία (βήματα 28-40) ακολουθείται και για την αντίστοιχη πλευρά κάτωθεν του τεμαχίου, γι αυτό πρέπει να γυρήσει το τεμάχιο από την άλλη πλευρά και να τοποθετηθεί στην μηχανή ξανά (στο παράδειγμά το τεμάχιο έχει διάσταση 69mm μετά την εκτέλεση των παραπάνω βημάτων για ακριβώς μία φορά και η επιθυμιτή διάσταση είναι στα 60mm).

Σημείωση: Όταν το τεμάχιο θα φραιζαριστεί απο την κάτω πλευρά θα πρέπει ο χειριστής να φραιζάρει το τεμάχιο κατα 9mm. Αυτή η διαδικασία θα γίνει με βήμα φραιζαρίσματος 1mm. Στο δεύτερο βήμα του φραιζαρίσματος το Z θα πρέπει να μετακινηθεί στο Z=-2 (βήμα 46) διότι το τεμάχιο θα έχει ήδη φραιζαριστεί ένα χιλιοστό στο προηγούμενο βήμα. Κατά αντιστοιχία το ίδιο θα ισχύει και για τα επόμενα βήματα. Πριν την εκκίνηση του δεύτερου βήματος δεν χρειάζεται να ξαναμηδενιστεί το τεμάχιο.
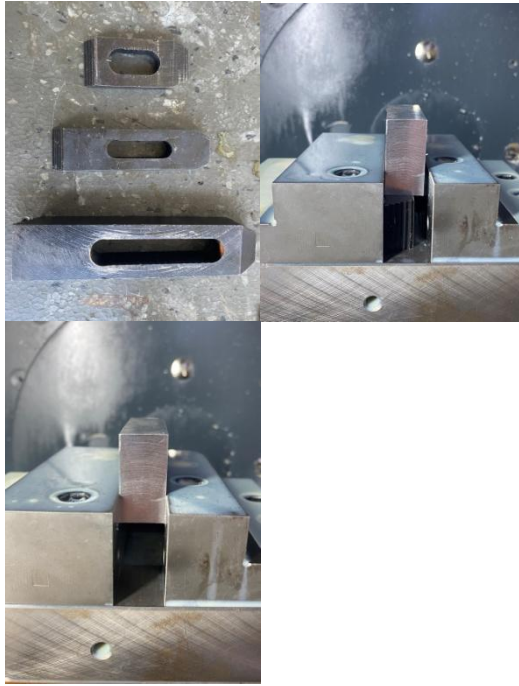
50. Στην συνέχεια, επιθυμείται να φραιζαριστεί και η δεύτερη επιφάνεια του τεμαχίου, οπότε ο χειριστής τοποθετεί το τεμάχιο στη μέγγενη. Το τεμάχιο πρέπει να εξέχει από τα μάγουλα της μέγγενης μεγαλύτερη απόσταση από αυτή που θα φραιζάρει ώστε να μην καταστραφεί η μηχανή. Έτσι για να τοποθετηθεί σωστά το τεμάχιο μπορούν να χρησιμοποιηθούν τα βοηθητικά τουβλάκια για να ανασηκωθεί το τεμάχιο.
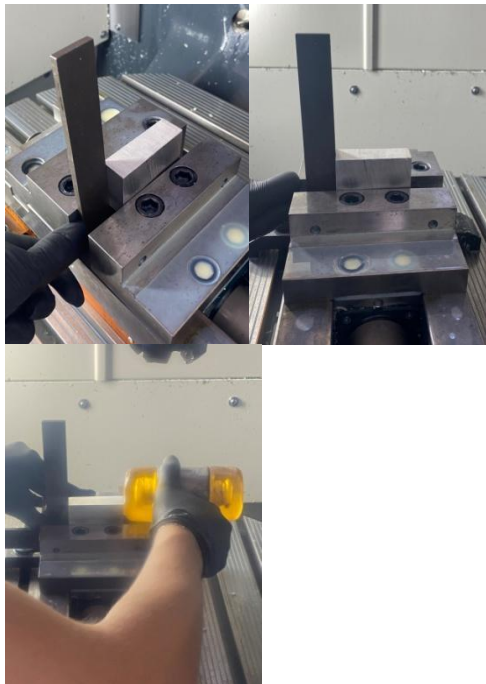
51. Στη συνέχεια, ο χειριστής πρέπει να γωνιάσει το τεμάχιο, ώστε να βγει ίσιο. Μπορεί να χρησιμοποιήσει και το σφυρί (ματσόλα) για να κουνήσει ελαφρώς το τεμάχιο και να το γωνιάσει σωστά. Τέλος, κλείνει την πόρτα της μηχανής και πατάει το κουμπί στο πληκτρολόγιο για να ασφαλίσει.

Σημείωση:Για να γίνει σωστά το γώνιασμα πρέπει οι πλευρές της γωνίας να εφάπτονται πλήρως με τη βάση της μέγγενης καθώς και με τη μπροστινή πλευρά του τεμαχίου.
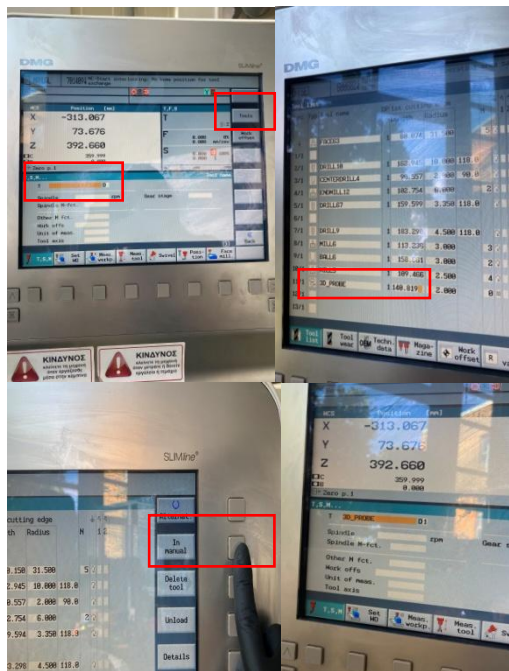
52. Για να ξεκινήσει ο μηδενισμός του τεμαχίου, επιλέγεται το κουμπί "T,M,S" και ο χρήστης μεταβένει στο κεντρικό μενού. Στην συνέχεια, εισάγεται το ρολόι στη μηχανή πηγαίνοντας στην πρώτη γραμμή του μενού και επιλέγοντας το κουμπί "Tools". Μόλις μεταβεί στο μενού των εργαλείων, διαλέγει το ρολόι και επιλέγει το κουμπί "In manual". Έπειτα, πατάει το κουμπί "Enter" και δίνει στην μηχανή μία σταθερή γρήγορη ταχύτητα. Μόλις ολοκληρωθεί η διαδικασία, κλείνει την ταχύτητα.

53. Μόλις εισαχθεί το ρολόι στη μηχανή, το κινεί με αργή ταχύτητα (από 0-20%) και με τη χρήση των βελών του πληκτρολογίου, πλησιάζει το τεμάχιο. Μόλις το ρολόι ακουμπήσει από την αριστερή πλαϊνή πλευρά το τεμάχιο, ο κεντρικός δείκτης του ρολογιού (μαύρος) πρέπει να πραγματοποιήσει δύο πλήρεις περιστροφές. Για να εισάγει τον μηδενισμό του άξονα Χ στη μηχανή από το κεντρικό μενού, επιλέγει το κουμπί "Set WO" και στο μενού που εμφανίζεται επιλέγει Χ=0. Έτσι, παρατηρείται στην οθόνη ότι ο άξονας Χ μηδενίστηκε.
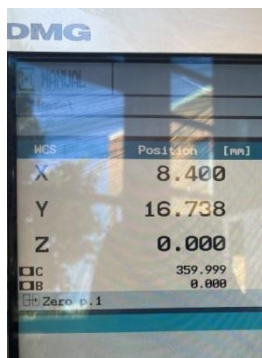
Σημείωση: Μόλις μηδενιστεί απομακρύνει το ρολόι από την πλευρά που ακουμπούσε το τεμάχιο με αργή πρόωση και κλείνει την ταχύτητα.

54. Για να μηδενιστεί ο άξονας Y, ο χειριστής πλησιάζει το ρολόι από τη μπροστινή μεριά του τεμαχίου και μόλις ο δείκτης ολοκληρώσει δύο πλήρεις περιστροφές, επιλέγει το κουμπί "Set WO" και το κουμπί Y=0, οπότε και εμφανίζεται ο μηδενισμός στην οθόνη.

    Σημείωση: Μόλις μηδενιστεί απομακρύνει το ρολόι από την πλευρά που ακουμπούσε το τεμάχιο με αργή πρόωση και κλείνει την ταχύτητα.
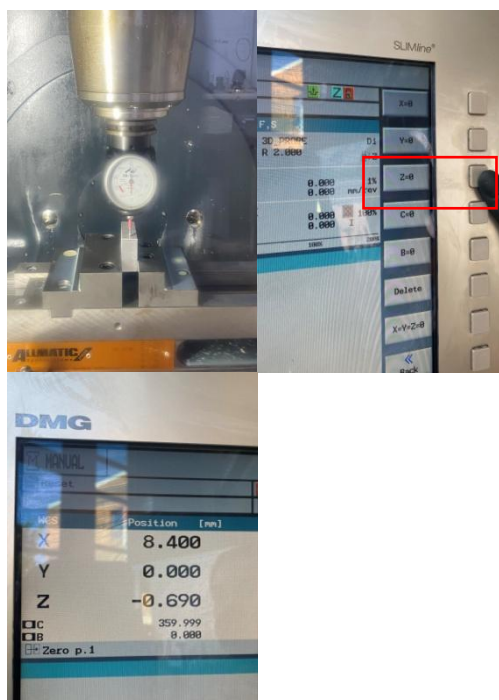

55. Για να μηδενιστεί ο άξονας Z, πλησιάζει το ρολόι από την πάνω μεριά του τεμαχίου και μόλις ο δείκτης ολοκληρώσει δύο πλήρεις περιστροφές επιλέγει το κουμπί "Set WO" και το κουμπί Z=0 και εμφανίζεται ο μηδενισμός στην οθόνη.

   **Σημείωση:** Μόλις μηδενιστεί απομακρύνει το ρολόι από την πλευρά που ακουμπούσε το τεμάχιο με αργή πρόωση και κλείνει την ταχύτητα.
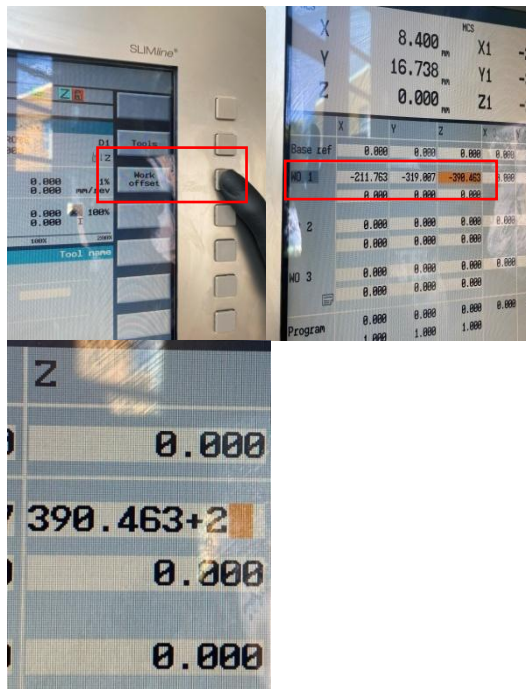
56. Για να ολοκληρωθεί σωστά ο μηδενισμός του άξονα Z, πηγαίνει στο κεντρικό μενού επιλέγοντας το κουμπί "T,M,S" και έπειτα, το κουμπί "WorkOffset". Πηγαίνοντας στη γραμμή WO1 στον άξονα Z και πατώντας το κουμπί "Insert" προσθέτει «+2» στο τέλος του αριθμού. Στο τέλος, πατάει το κουμπί "Input" για να οριστικοποιηθεί η νέα τιμή και για να επιστρέψει στο κεντρικό μενού επιλέγει το κουμπί "Machine".
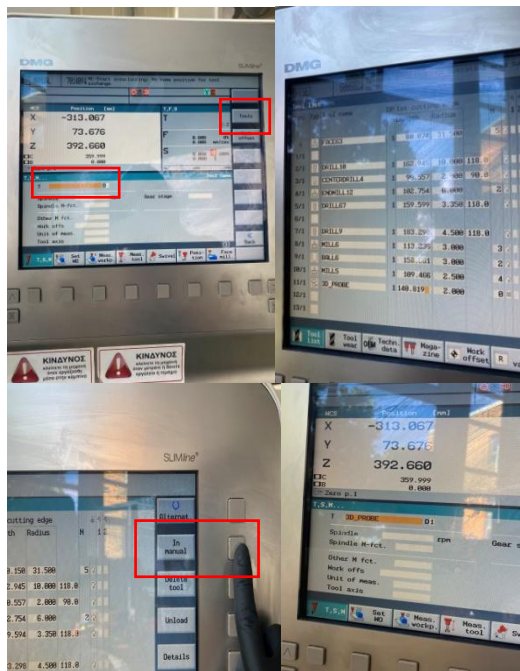
57. Στην συνέχεια, εισάγει τη φρεζοκεφαλή FACE63 στη μηχανή πηγαίνοντας στην πρώτη γραμμή του κεντρικό μενού και επιλέγοντας το κουμπί "Tools" . Ο χειριστής επιλέγει το εργαλείο το οποίο επιθυμεί από το μενού των εργαλείων. Μόλις το επιλέξει, πατάει το κουμπί "In manual". Έπειτα, πατάει το κουμπί "Enter" και ξεκινάει η διαδικασία αλλαγής του εργαλείου στην μηχανή. Για να ολοκληρωθεί η διαδικασία πρέπει να δωθεί στη μηχανή γρήγορη ταχύτητα. Μόλις ολοκληρωθεί η διαδικασία ο χειριστής κλείνει την πρόωση.
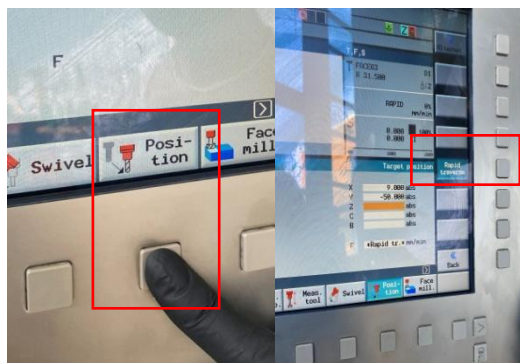
58. Για να φραιζαριστεί η επιθυμητή επιφάνεια επιλέγεται το κουμπί "Position" και εισάγονται οι συντεταγμένες των αξόνων Χ και Υ που επιθυμούνται (Χ=10, το μισό της πλευράς και Υ=-50, ώστε να βρίσκεται το εργαλείο μακριά από το τεμάχιο) και επιλέγεται το κουμπί "Rapid Traverse" για να κινηθεί με γρήγορη πρόωση σε αυτή τη θέση. Με τον ίδιο τρόπο κινείται και στον άξονα Ζ (Ζ=-1, για να φραιζάρει το τεμάχιο κατά 1mm). Μόλις ολοκληρωθεί η εκάστοτε διαδικασία πρέπει να κλείσει την πρόωση.

    Σημείωση: Το x και το y μετακινούνται στο ίδιο βήμα ενώ το z στο επόμενο.
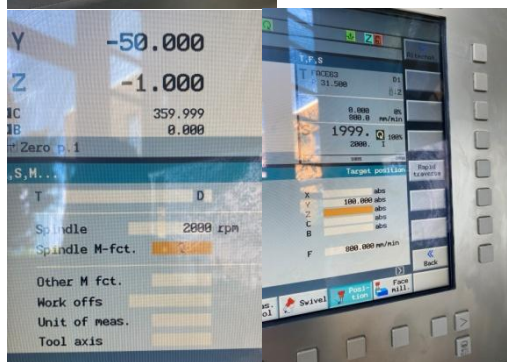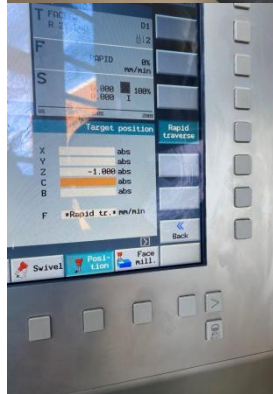
59. Ο χειριστής μεταβαίνει στο κεντρικό μενού επιλέγοντας το κουμπί "T,M,S" και εισάγοντας τις στροφές του κοπτικού (2000rpm), καθώς και τη φορά περιστροφής του (δεξιόστροφα - εισάγεται από το κεντρικό κουμπί των βελών στο πληκτρολόγιο). Η διαδικασία ολοκληρώνεται πατώντας το κουμπί "Enter" . Στην συνέχεια, μεταβαίνει στο μενού Position και εισάγει πόσο επιθυμεί να μετακινηθεί το κοπτικό κατά Υ (Υ=100, για να κόψει όλη την επιφάνεια του τεμαχίου). Η διεργασία αυτή πραγματοποιείται με αργή πρόωση, 800 mm/min.
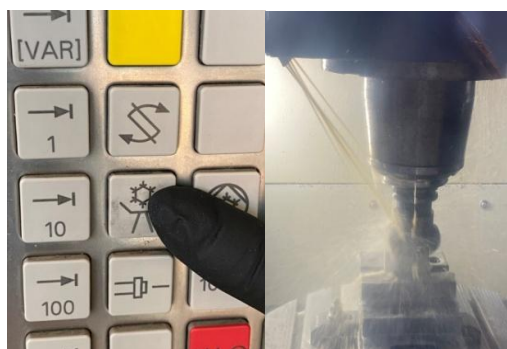
60. Για να ξεκινήσει η κοπή, επιλέγει "Enter", δίνει αργή πρόωση στο 100% και πατάει το κουμπί της εικόνας καθ'όλη τη διάρκεια της κατεργασίας για να πετάξει ψυκτικό υγρό ώστε να μην σπάσει το κοπτικό, λόγω των υψηλών θερμοκρασιών στην περιοχή της κοπής. Μόλις ολοκληρωθεί η διαδικασία κλείνει την πρόωση.

Σημείωση: Επαναλαμβάνεται η παραπάνω διαδικασία (βήματα 42-51) και για την αντίστοιχη πλευρά κάτωθεν του τεμαχίου, γι' αυτό ο χειριστής πρέπει να γυρίσει το τεμάχιο από την άλλη πλευρά και να το τοποθετήσει στη μηχανή (το τεμάχιο τώρα βρίσκεται στα 36mm ενώ η επιθυμιτή τελικλη διάσταση είναι στα 30mm).

Σημείωση: Όταν το τεμάχιο θα φραιζαριστεί απο την κάτω πλευρά θα πρέπει ο χειριστής να φραιζάρει το τεμάχιο κατα 6mm. Αυτή η διαδικασία θα γίνει με βήμα φραιζαρίσματος 1mm. Στο δεύτερο βήμα του φραιζαρίσματος το Z θα πρέπει να μετακινηθεί στο Z=-2 (βήμα 58) διότι το τεμάχιο θα έχει ήδη φραιζαριστεί ένα χιλιοστό στο προηγούμενο βήμα. Κατά αντιστοιχία το ίδιο θα ισχύει και για τα επόμενα βήματα. Πριν την εκκίνηση του δεύτερου βήματος δεν χρειάζεται να ξαναμηδενιστεί το τεμάχιο.
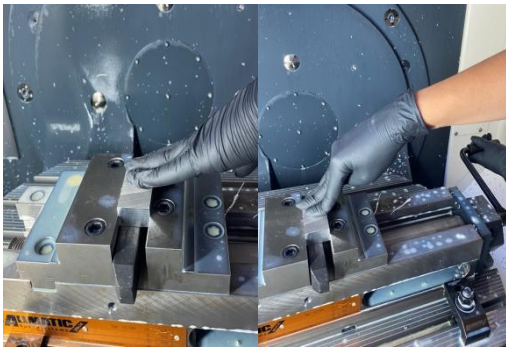
61. Τέλος, πρέπει να φραιζαριστεί και η τρίτη επιφάνεια του τεμαχίου, οπότε ο χειριστής πρέπει να τοποθετήσει το τεμάχιο στην μέγγενη και να το σφίξει. Έπειτα, κλείνει την πόρτα της μηχανής και επιλέγει το κουμπί στο πληκτρολόγιο να ασφαλίσει.

Σημείωση:Μπορεί να χρησιμοποιηθεί ένα βοηθητικό τουβλάκι για την σωστότερη τοποθέτηση του τεμαχίου στη μέγγενη.
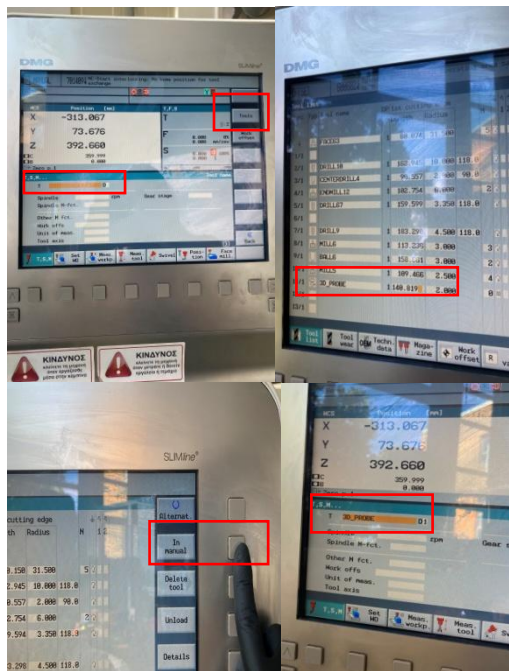
62. Για να ξεκινήσει ο μηδενισμός του τεμαχίου, ο χρήστης μεταβαίνει στο κεντρικό μενού επιλέγοντας το κουμπί "T,M,S" και εισάγει το ρολόι 3D-probe στη μηχανή. Στην συνέχεια, από την πρώτη γραμμή επιλέγει το κουμπί "Tools". Μόλις εμφανιστεί το μενού των εργαλείων, διαλέγει με τη χρήση των βελών του πληκτρολογίου το ρολόι και πατάει το κουμπί "In manual". Στην συνέχεια, πατάει το κουμπί "Enter" και δίνει στη μηχανή μια σταθερή γρήγορη ταχύτητα. Μόλις ολοκληρωθεί η διαδικασία κλείνει την ταχύτητα.

63. Μόλις εισαχθεί το ρολόι στη μηχανή, το κινεί με αργή ταχύτητα (από 0-20%) και με τη χρήση των βελών του πληκτρολογίου πλησιάζει το τεμάχιο. Μόλις το ρολόι ακουμπήσει από την αριστερή πλαϊνή πλευρά το τεμάχιό μας, ο κεντρικός δείκτης του ρολογιού (μαύρος) πρέπει να πραγματοποιήσει δύο πλήρεις περιστροφές. Για να εισάγει τον μηδενισμό του άξονα Χ στη μηχανή επιλέγει το κουμπί "Set WO" και στο μενού που εμφανίζεται επιλέγει Χ=0. Έτσι, παρατηρείται στην οθόνη ότι ο άξονας Χ μηδενίστηκε.

Σημείωση: Μόλις μηδενιστεί ο άξονας απομακρύνει το ρολόι από την πλευρά την οποία ακουμπούσε με αργή πρόωση.

64. Για να μηδενιστεί ο άξονας Υ, ο χρήστης πλησιάζει το ρολόι από την μπροστινή μεριά του τεμαχίου και μόλις ο δείκτης ολοκληρώσει δύο πλήρεις περιστροφές επιλέγει το κουμπί "Set WO" και Υ=0, οπότε και εμφανίζεται ο μηδενισμός του άξονα στην οθόνη.

Σημείωση: Μόλις μηδενιστεί ο άξονας απομακρύνει το ρολόι από την πλευρά την οποία ακουμπούσε και κλείνει την πρόωση.
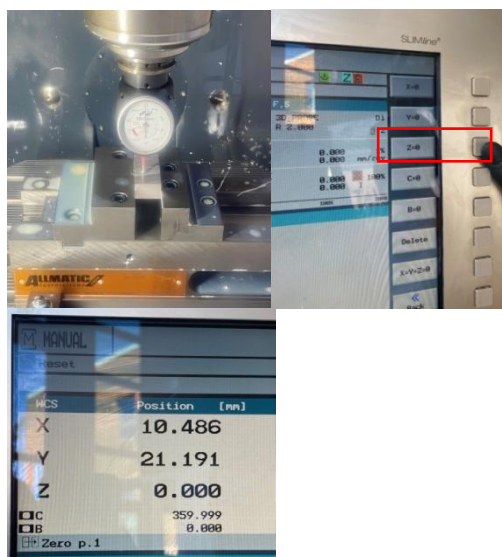
65. Για να μηδενιστεί ο άξονας Ζ ο χρήστης πλησιάζει το ρολόι από την πάνω μεριά του τεμαχίου και μόλις ο δείκτης ολοκληρώσει δύο πλήρεις περιστροφές επιλέγει το κουμπί "Set WO" και Ζ=0 και εμφανίζεται ο μηδενισμός του άξονα στην οθόνη.

Σημείωση: Μόλις μηδενιστεί ο άξονας απομακρύνει το ρολόι από την πλευρά την οποία ακουμπούσε και κλείνει την πρόωση.
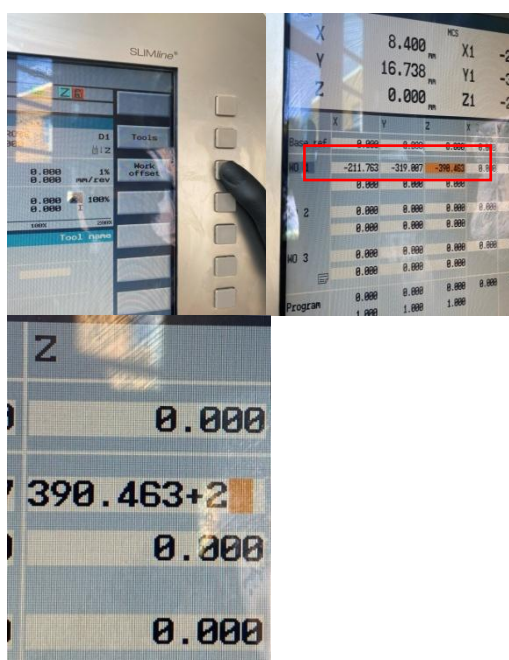
66. Για να ολοκληρωθεί σωστά ο μηδενισμός του άξονα Ζ ο χειριστής κατευθείνεται στο κεντρικό μενού επιλέγοντας το κουμπί "T.M,S" και έπειτα, "WorkOffset". Κατόπιν, πάει στην γραμμή WO1 στον άξονα Ζ και πατώντας το κουμπί "Insert", προσθέτει «+2» μονάδες. Στο τέλος, πατάει "input" για να οριστικοποιηθεί η νέα τιμή. Μόλις ολοκληρωθεί το παραπάνω βήμα επιλέγει το κουμπί "Machine" για να επιστρέψει στο κεντρικό μενού.
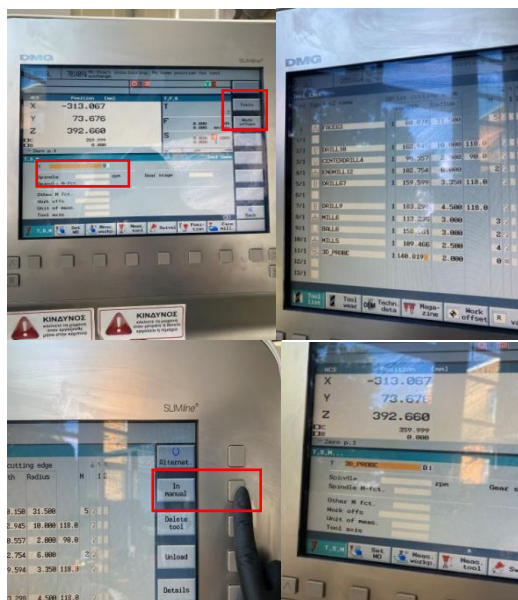
67. Στην συνέχεια, εισάγει τη φραιζοκεφαλή FACE63 στη μηχανή πηγαίνοντας στην πρώτη γραμμή στο κεντρικό μενού και πατώντας το κουμπί "Tools". Επιλέγεται το εργαλείο το οποίο επιθυμείται από το μενού των εργαλείων και τοποθετείται στην μηχανή με το κουμπί "In manual" και έπειτα "Enter". Για να ολοκληρωθεί η διαδικασία πρέπει να δωθεί στη μηχανή γρήγορη ταχύτητα ενώ μόλις ολοκληρωθεί η αλλαγή ο χειριστής κλείνει την πρόωση.

68. Για το φραιζάρισμα της επιθυμητής επιφάνειας, επιλέγεται το κουμπί "Position" και εισάγονται αρχικά στον άξονα Χ και Υ οι συντεταγμένες οι οποίες επιθυμούνται (X=10, το μισό της πλευράς και Y=-50, ώστε να βρίσκεται το εργαλείο μακριά από το τεμάχιο) και επιλέγοντας το κουμπί "Rapid Traverse" για να κινηθεί με γρήγορη πρόωση στη θέση την οποία επιθυμεί. Το ίδιο συμβαίνει και για να μετακινηθεί στον άξονα Z (Z=-1, θέλει στο πρώτο πέρασμα να φραιζάρει 1mm της επιφάνειάς).
Μόλις ολοκληρωθεί η εκάστοτε διαδικασία πρέπει ο χειριστής να κλείσει την πρόωση.

Σημείωση: Το x και το y μετακινούνται στο ίδιο βήμα ενώ το z στο επόμενο.
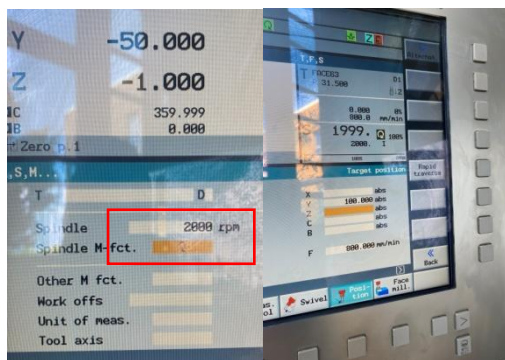
69. Ο χειριστής μεταβαίνει στο κεντρικό μενού επιλέγοντας το κουμπί "T,M,S" και εισάγει τις στροφές (2000 rpm) του κοπτικού, καθώς και τη φορά περιστροφής του (δεξιόστροφη - εισάγεται από το κεντρικό κουμπί των βελών στο πληκτρολόγιο). Πατάει το κουμπί "Enter" και εισάγει στο μενού Position πόσο χρειάζεται να μετακινηθεί κατά Y το κοπτικό (Y=100, για να φραιζάρει το κοπτικό όλη την επιφάνεια και να απομακρυνθεί από αυτό). Η διεργασία αυτή πραγματοποιείται με αργή πρόωση, 800 mm/min.
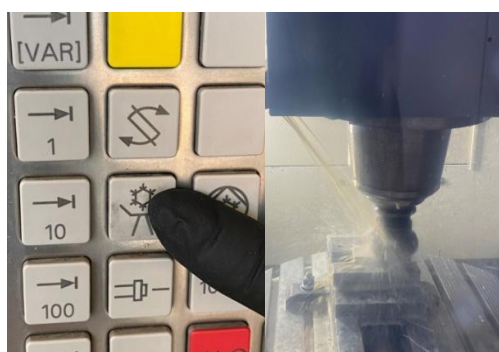
70. Για να ξεκινήσει η κοπή επιλέγεται "Enter", δίνεται αργή πρόωση (στο 100%) και πατιέται παρατεταμένα το κουμπί για να πετάξει ψυκτικό υγρό ώστε να μην σπάσει το κοπτικό μας λόγω των υψηλών θερμοκρασιών στην περιοχή της κοπής. Μόλις ολοκληρωθεί το παραπάνω βήμα ο χειριστής απομακρύνει το κοπτικό από το τεμάχιο και κλείνει την πρόωση.

Τέλος, επαναλαμβάνει την παραπάνω διαδικασία (βήματα 61-70) και για την αντίστοιχη πλευρά κάτωθεν του τεμαχίου, γι' αυτό γυρνάει το τεμάχιό από την άλλη πλευρά και το τοποθετεί στη μηχανή. Το τεμάχιο σε αυτήν τη φάση της διαδικασίας είναι 19mm ενώ η επιθυμητή διάσταση είναι τα 17mm.

Σημείωση: Όταν το τεμάχιο θα φραιζαριστεί απο την κάτω πλευρά θα πρέπει ο χειριστής να φραιζάρει το τεμάχιο κατα 3mm. Αυτή η διαδικασία θα γίνει με βήμα φραιζαρίσματος 1mm. Στο δεύτερο βήμα του φραιζαρίσματος το Z θα πρέπει να μετακινηθεί στο Z=-2 (βήμα 68) διότι το τεμάχιο θα έχει ήδη φραιζαριστεί ένα χιλιοστό στο προηγούμενο βήμα. Κατά αντιστοιχία το ίδιο θα ισχύει και για τα επόμενα βήματα. Πριν την εκκίνηση του δεύτερου βήματος δεν χρειάζεται να ξαναμηδενιστεί το τεμάχιο.

2.1.4   Εκκίνηση βασικής κατεργασίας τεμαχίου- Μηδενισμός
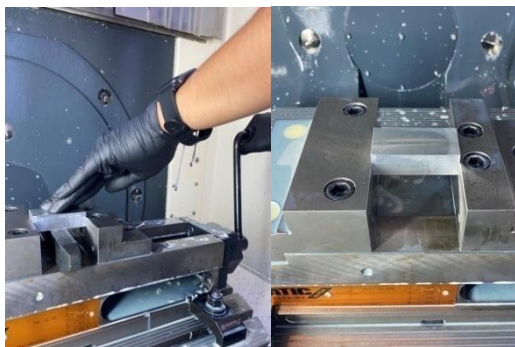
71. Τώρα εφόσον έχει λειανθεί το κομμάτι και έχει έρθει στις επιθυμητές διαστάσεις, ο χειριστής πρέπει να ξεκινήσει τις κατεργασίες για την τελική του διαμόρφωση. Τοποθετεί το τεμάχιο στη μέγγενη και το σφίγγει. Έπειτα, κλείνει την πόρτα της μηχανής και πατάει το κουμπί στο πληκτρολόγιο για να την ασφαλίσει.

    Σημείωση: Το τεμάχιο είναι σημαντικό να τοποθετηθεί με τον ίδιο τρόπο όπου έχει μηδενιστεί στο λογισμικό CAD/CAM.
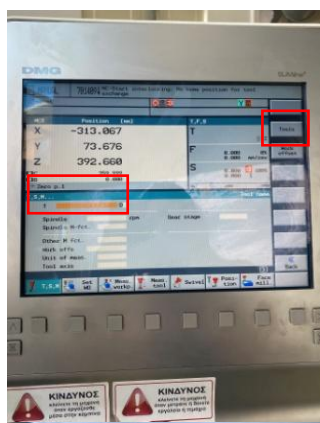
72. Για να ξεκινήσει το μηδενισμό του τεμαχίου, εισάγει το ρολόι 3D-probe στην μηχανή πηγαίνοντας στο κεντρικό μενού και επιλέγοντας το κουμπί "T,M,S". Από την πρώτη γραμμή πατάει το κουμπί "Tools". Μόλις εισαχθεί στο μενού των εργαλείων διαλέγει το ρολόι και επιλέγει το κουμπί "In manual". Στη συνέχεια, πατάει το κουμπί "Enter" και δίνει στη μηχανή μια σταθερή γρήγορη ταχύτητα. Μόλις ολοκληρωθεί το παραπάνω βήμα κλείνει την ταχύτητα.
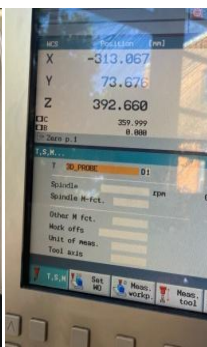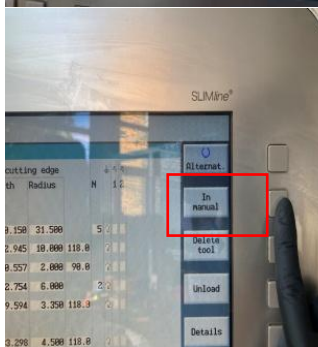
73. Μόλις εισαχθεί το ρολόι στη μηχανή το κουνάει με αργή ταχύτητα (από 0-20%) και με τη χρήση των βελών του πληκτρολογίου πλησιάζει το τεμάχιο. Μόλις το ρολόι ακουμπήσει από την αριστερή πλαϊνή πλευρά το τεμάχιο, ο κεντρικός δείκτης του ρολογιού πρέπει να πραγματοποιήσει δύο πλήρεις περιστροφές. Για να εισαχθεί ο μηδενισμός του άξονα Χ στη μηχανή από το κεντρικό μενού επιλέγεται το κουμπί "Set WO" και έπειτα, Χ=0. Έτσι, παρατηρείται στην οθόνη ότι ο άξονας Χ μηδενίστηκε.

    Σημείωση: Μόλις ολοκληρωθεί ο μηδενισμός του άξονα ο χειριστής απομακρύνει το ρολόι από την πλευρά όπου ακουμπούσε με αργή πρόωση.
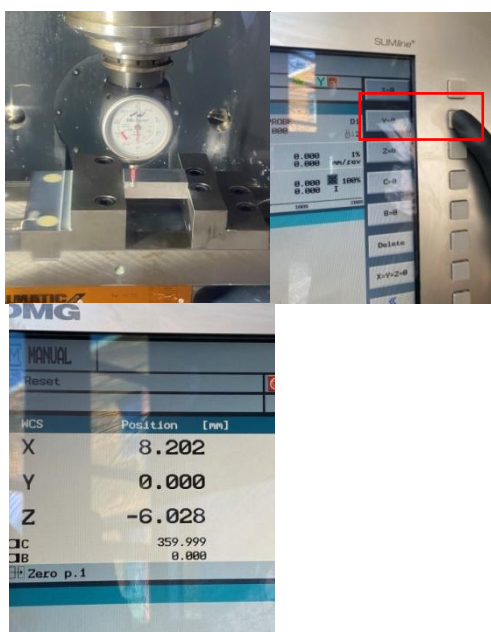
74. Για να μηδενιστεί ο άξονας Υ, πλησιάζει το ρολόι από την μπροστινή μεριά του τεμαχίου και μόλις ο δείκτης ολοκληρώσει δύο πλήρεις περιστροφές επιλέγει το κουμπί "Set WO" και έπειτα, Υ=0 και εμφανίζεται ο μηδενισμός του άξονα στην οθόνη.

    Σημείωση:Μόλις ολοκληρωθεί ο μηδενισμός του άξονά απομακρύνει το ρολόι από την πλευρά όπου ακουμπούσε και κλείνει την ταχύτητα.

75. Για να μηδενιστεί ο άξονας Z, πλησιάζει το ρολόι από την πάνω μεριά του τεμαχίου και μόλις ο δείκτης ολοκληρώσει δύο πλήρεις περιστροφές επιλέγει το κουμπί "Set WO" και το κουμπί Z=0 και εμφανίζεται ο μηδενισμός του άξονα στην οθόνη.
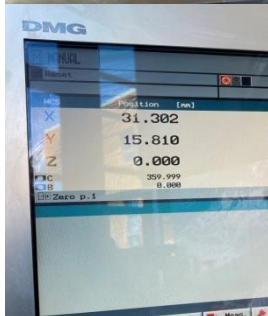
Σημείωση: Μόλις ολοκληρωθεί ο μηδενισμός του άξονα απομακρύνει το ρολόι από την πλευρά όπου ακουμπούσε καθώς και κλείνει την ταχύτητα.
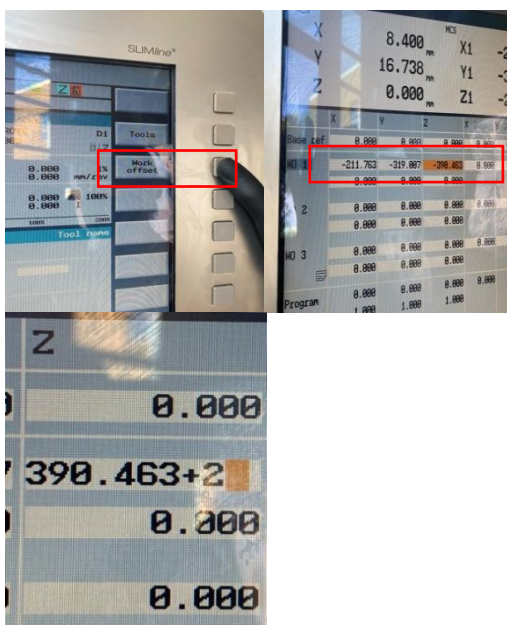
76. Για να ολοκληρωθεί σωστά ο μηδενισμός του άξονα Z πηγαίνει στο κεντρικό μενού και επιλέγει το κουμπί "WorkOffset", κατευθείνεται στη γραμμή WO1 στον άξονα Z και πατώντας το κουμπί "Insert" προσθέτει «+2» μονάδες στο τέλος του αριθμού. Στο τέλος πατάει "Input" για να οριστικοποιηθεί η νέα τιμή. Τέλος, επιλέγει το κουμπί "Machine" για να επιστρέψει στο κεντρικό μενού.

2.1.5 Εισαγωγή κώδικα στη μηχανή
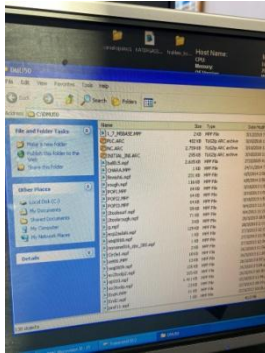
77. Μόλις μηδενιστεί το τεμάχιο πρέπει να εισαχθεί ο κώδικας ο οποίος κατασκευάστηκε σε συμβατό λογισμικό CAD/CAM. Ο χρήστης αφού έχει περάσει τον κώδικα σε ένα USB stick, τον αντιγράφει στον Η/Υ της μηχανής στο φάκελο DMU50.
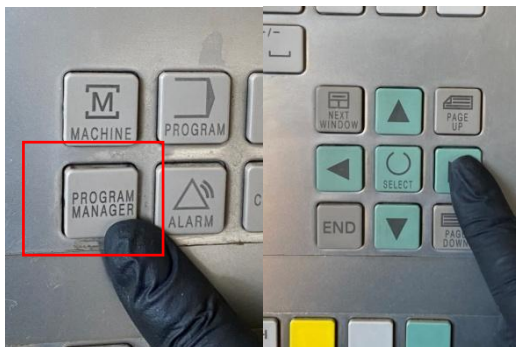
78. Για να εισαχθεί ο κώδικας στη μηχανή ο χρήστης επιλέγει το κουμπί "ProgramManager", έπειτα το κουμπί "PC EXTERN" και περιηγείται στο μενού με τα βελάκια.

    Σημείωση: Για να εισαχθεί μέσα σε κάποιο φάκελο πρέπει να πατήσει το δεξί βελάκι.
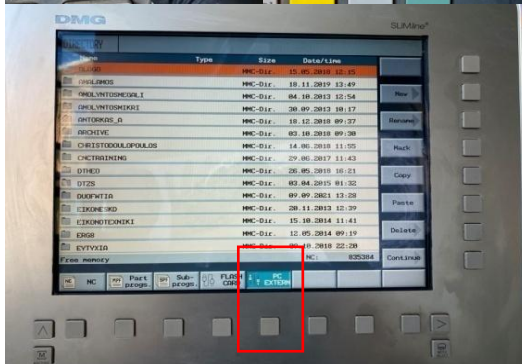
79. Μόλις βρεί το αρχείο με τον κώδικα, (KEFALAIO2), επιλέγει το κουμπί "Copy" στα δεξιά.
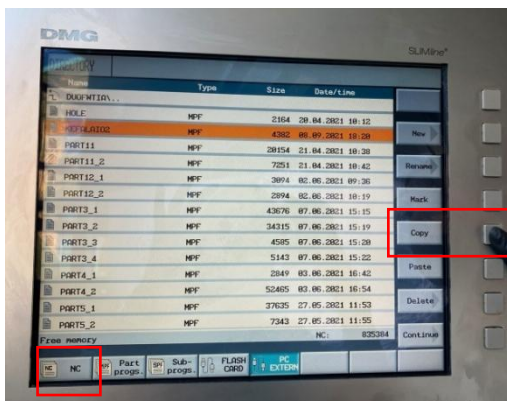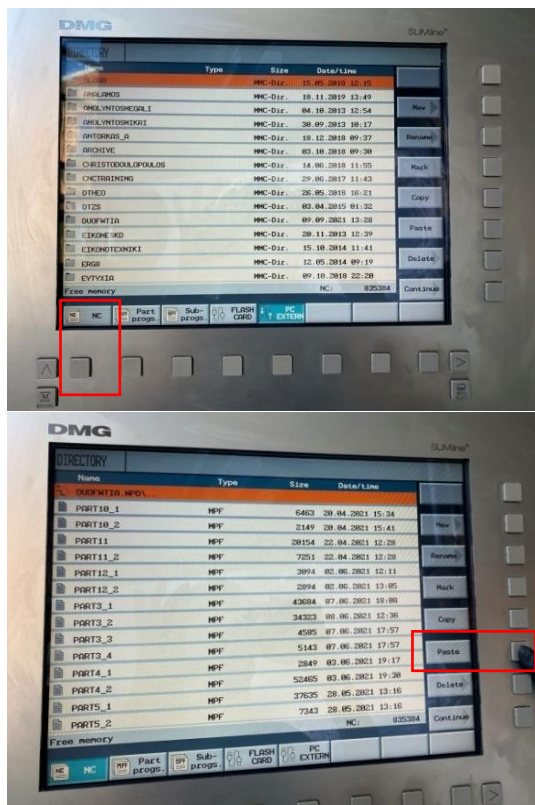
80. Στην συνέχεια, επιλέγει το κουμπί "NC" και μπαίνει στο φάκελο όπου θέλει να αποθηκεύσει τον κώδικα και πατώντας το κουμπί "Paste" αντιγραφεί το αρχείο του κώδικα στη μηχανή.
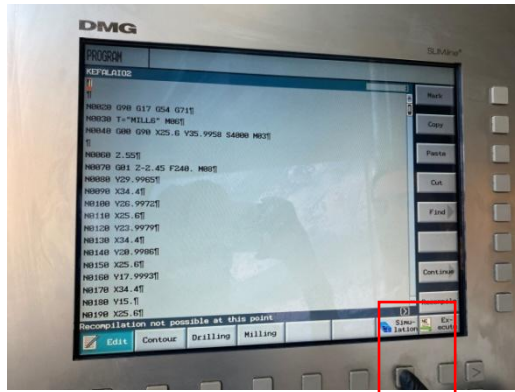
81. Μόλις ανοίξει τον κώδικα, (KEFALAIO2), πρέπει να επιλέξει το κουμπί "Simulation" για να ελέγξει αν υπάρχουν λάθη στον κώδικα που δεν αναγνωρίζει η μηχανή ή τυχόν λάθη στον τρόπο κατεργασίας.

82. Μόλις μπεί στο παράθυρο του Simulation ο χειριστής επιλέγει το κουμπί "Details" και έπειτα, "Settings" για να εισάγει τις διαστάσεις του τεμαχίου. Μόλις εισάγει τα δεδομένα (X1=60, Y1=30 και Z1=-17) πατάει το κουμπί "Back".
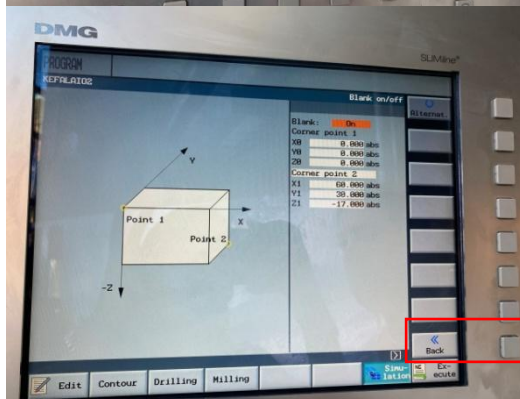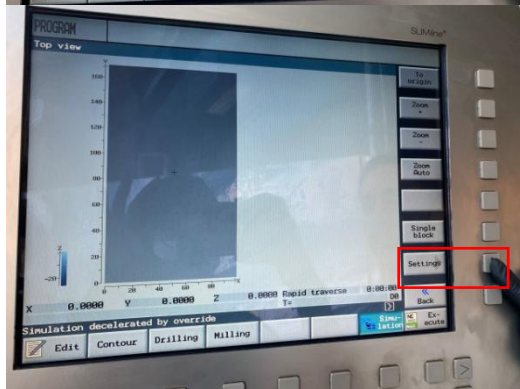
83. Για να ξεκινήσει το Simulation, επιλέγει το κουμπί δεξιά όπου φαίνονται όλες οι όψεις και δίνει αργή και γρήγορη πρόωση. Αργή πρόωση: 80%. Γρήγορη πρόωση: 20%.

84. Σε αυτό το σημείο πρέπει να προσέξει την πορεία του κοπτικού και τον τρόπο με τον οποίο υλοποιείται η κάθε κατεργασία, ώστε σε περίπτωση που υπάρχει κάποιο λάθος να το διορθώσει πριν φτάσει στο στάδιο της κατεργασίας. Μόλις ολοκληρωθεί η προσομοίωση επιλέγει το κουμπί "End".

Σημείωση: Όταν πατάει το "End" πριν προχωρήσει στο επόμενο βήμα πρέπει να κλείσει τις προώσεις για να μην υπάρξει κάποιο ατύχημα.

85. Όταν είναι έτοιμη να ξεκινήσει η κατεργασία, ο χειριστής επιλέγει το κουμπί "Execute", το οποίο μεταβαίνει αυτόματα στο αρχικό μενού όπου εμφανίζεται ο κώδικας. Εκεί, πατάει το "Enter" και δίνει μία σταθερή γρήγορη (20%) και αργή πρόωση (100%).

Σημείωση: Πριν πατήσει το Execute πρέπει να βρίσκεται στην πρώτη γραμμή του κώδικα αλλιώς η κατεργασία δεν θα ξεκινήσει από την αρχή.

86. Κατά την διάρκεια της κατεργασίας δίνεται ιδιαίτερη προσοχή στις κινήσεις του κοπτικού, προς αποφυγή τυχόν ατυχημάτων.
Μόλις τελειώσει η πρώτη κατεργασία, εάν επιθυμεί ο χειριστής μπορεί να σταματήσει προσωρινά τον κώδικα ώστε να δει το τεμάχιο μέχρι εκείνο το σημείο. Για να πραγματοποιηθεί αυτό πατάει το κόκκινο κουμπί της εικόνας, κλείνει τις προώσεις και ανοίγει την πόρτα της μηχανής.

87. Για να συνεχιστεί η διαδικασία πρέπει να κλείσει την πόρτα της μηχανής και να την ασφαλίσει. Για να ξεκινήσει η διεργασία πάλι πρέπει να πατήσει το κουμπί "Enter" και να δώσει σταθερές προώσεις.

Εικόνα 2

88. Όταν ολοκληρωθεί ο κώδικας ο χειριστής πατάει το κόκκινο κουμπί της εικόνας, κλείνει τις προώσεις και πατάει το κουμπί της εικόνας 2 ώστε να φύγει ο κώδικας μας από το κεντρικό μενού. Τέλος, απομακρύνει το κοπτικό από το τεμάχιο.
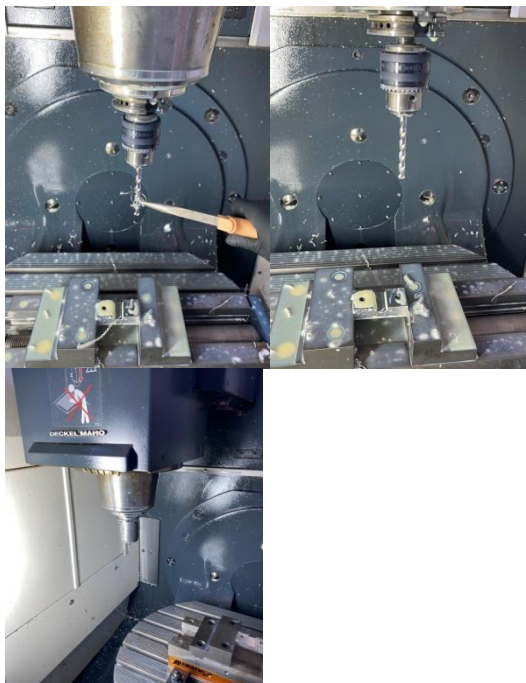
89. Στην συνέχεια, ανοίγει την πόρτα της μηχανής, καθαρίζει το εργαλείο από γρέζια με μία πένσα ή ένα μυτοτσίμπιδο. Στο τέλος της κατεργασίας, πρέπει να παραμένει πάντα ένα εργαλείο πάνω στην κεφαλή της μηχανής. Έπειτα, μετακινεί την κεφαλή με το κοπτικό στο πλάι, ώστε ο χώρος πάνω από τη μέγγενη να είναι κενός.
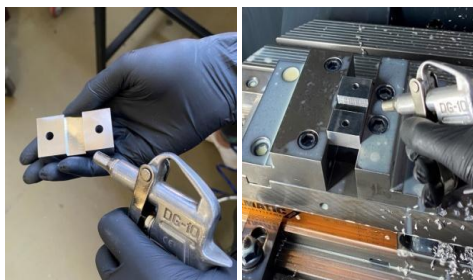
90. Τέλος, καθαρίζει το τελικό τεμάχιο με τη βοήθεια του αέρα ή χρησιμοποιώντας κάποιο πανί.

2.1.7   Κλείσιμο Εργαλειομηχανής- Η/Υ και Μετρητικής Μηχανής

91. Για να κλείσει η μηχανή ο χειριστής
a: Πατάει προς τα μέσα το κουμπί έκτακτης ανάγκης (emergency button), ώστε να σταματήσει να περνάει αέρας στη μηχανή. Μόλις γίνει αυτό σταματάει ο χαρακτηριστικός ήχος της μηχανής και
b: παρατηρεί ότι σβήνει το φως στο κουμπί της εικόνας .
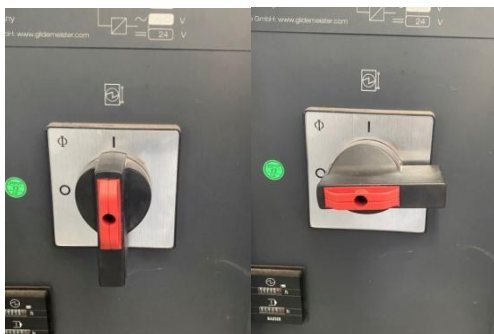
92. Εφόσον έχει ολοκληρώσει τις δουλειές στη μηχανή, την κλείνει γυρνώντας το διακόπτη προς τα αριστερά.
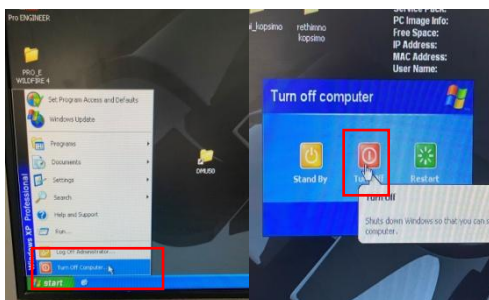
93. Κλείνει τον Η/Υ πατώντας "TurnOff" καθώς και το πράσινο κουμπί στην μετρητική μηχανή.

94. Κλείνει τον διακόπτη του ρεύματος από τον ηλεκτρολογικό πίνακα του εργαστηρίου κατεβάζοντας τον προς τα κάτω.
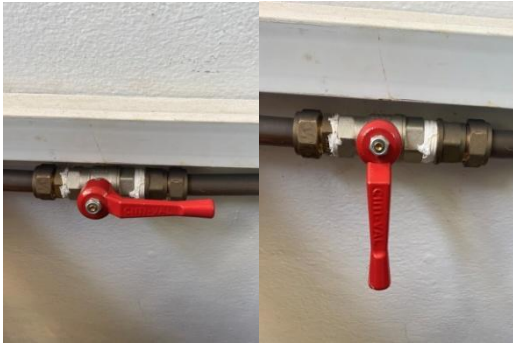
95. Τέλος, κλείνει τη βάνα της παροχής αέρα γυρνώντας τον διακόπτη προς τα αριστερά (ακούγεται ότι σταματάει η παροχή αέρα).

2.1.8   Καθαρισμός Μηχανής

96. Όταν ο χειριστής ολοκληρώσει τις εργασίες στη μηχανή υποχρεούται να την αφήνει πάντα καθαρή. Η διαδικασία του καθαρισμού της γίνεται με τη χρήση του αέρα και της σκούπας.

3. Κατεργασία τεμαχίων με χρήση λογισμικού CAD/CAM

Σε αυτό το κεφάλαιο παρουσιάζονται οι διαδικασίες που ακολουθήθηκαν για την κατεργασία 10 τεμαχίων τα οποία σχεδιάστηκαν και κατεργάστηκαν σε κέντρο κατεργασίας DMU50 eco, το οποίο καθοδηγείται με ψηφιακή καθοδήγηση Siemens 810D. Επεξεργάστηκαν τεμάχια μαλακού αλουμινίου AL6082 διαστάσεων 20x40x70 mm, τα οποία με χρήση φραιζοκεφαλής διαμέτρου D63 φραιζαρίστηκαν και λειάνθηκαν, ώστε να καταλήξουν στις επιθυμητές διαστάσεις πριν την έναρξη των κατεργασιών.

Συνολικά τα εργαλεία που χρησιμοποιήθηκαν για την κατεργασία των παρακάτω τεμαχίων είναι:

a. Ηλεκτρονικό παχύμετρο
b. Μετρητικό ρολόι
c. Φραιζοκεφαλή (D63)
d. Κονδύλι (D5)
e. Κονδύλι (D6)
f. Τρυπάνι (D6.7)
g. Τρυπάνι (D9)
h. Κεντραδόρος (D4)
i. Ball (D6)
j. Λίμα
k. Ματσόλα
l. Χάρακας ορθής γωνίας(για γώνιασμα)
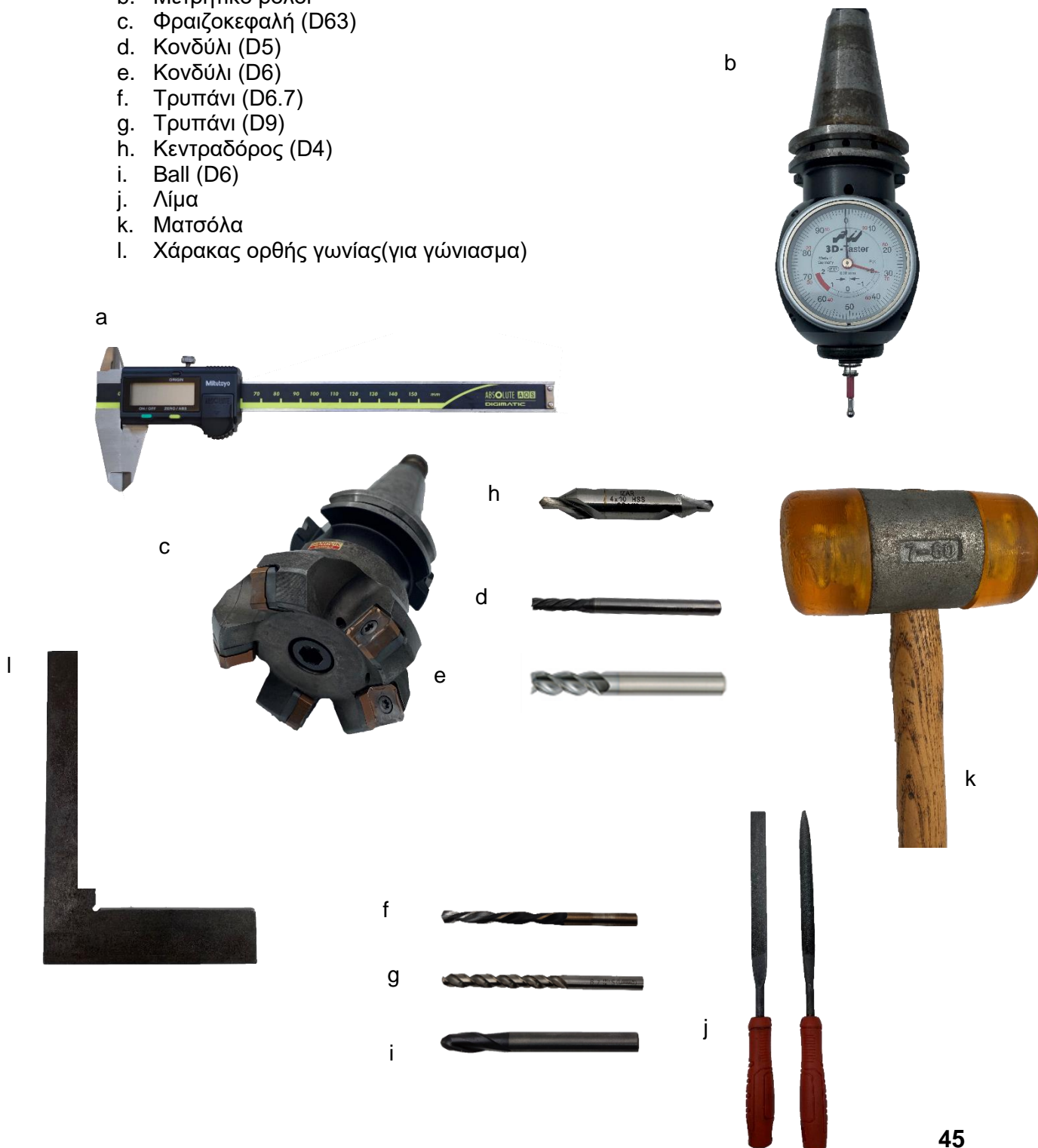
3.1 Τεμάχιο 1

3.1.1 Μηχανολογικό σχέδιο τεμαχίου 1
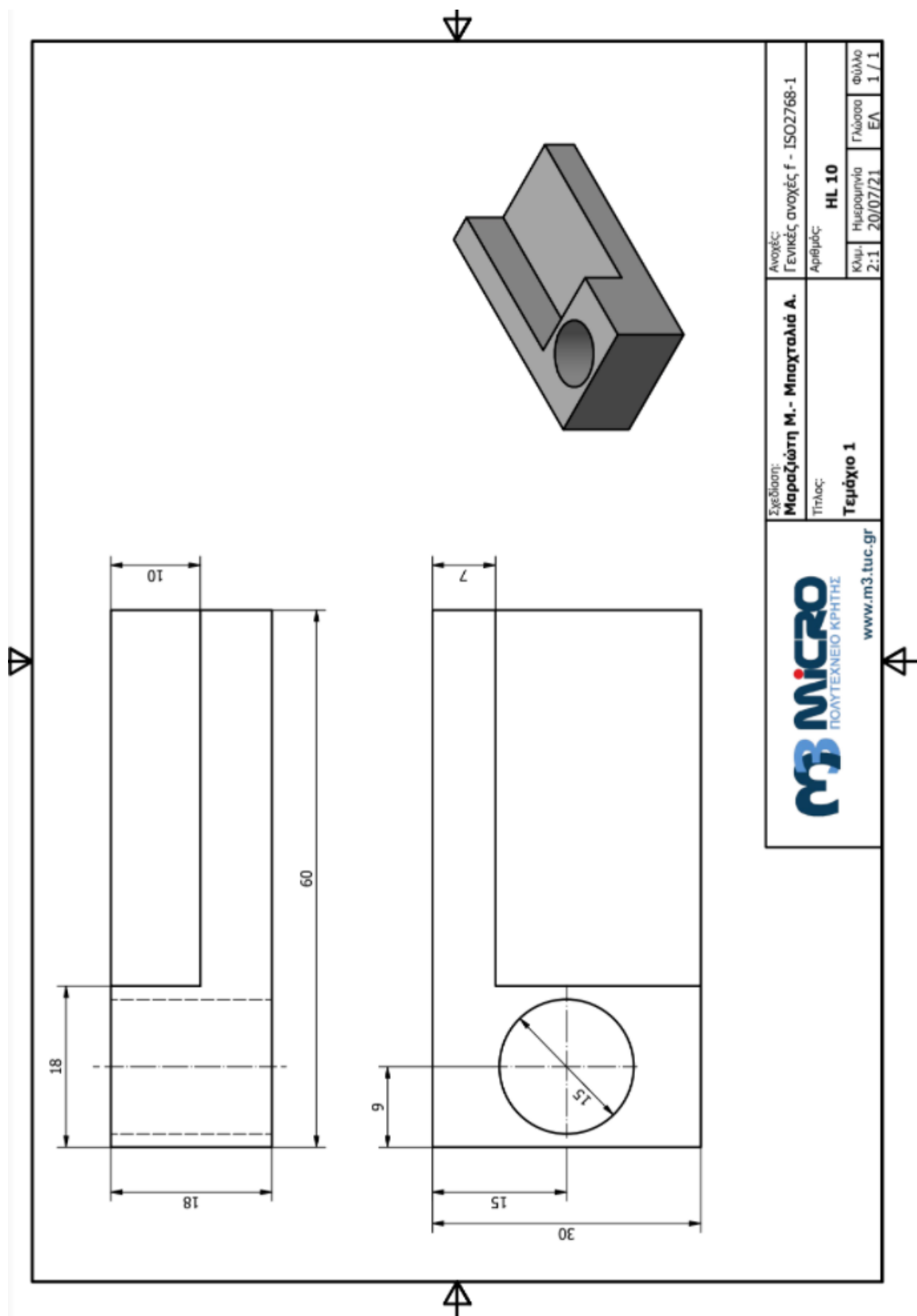
Σχήμα 3.1: Μηχανολογικό Σχέδιο τεμαχίου 1

3.1.2 Φασεολόγιο κατεργασίας τεμαχίου 1

Παρακάτω παρουσιάζονται οι 3 διαδοχικές φάσεις οι οποίες οδήγησαν στην κατεργασία του τεμαχίου με χρήση κώδικα CNC καθώς και τα εργαλεία με τις συνθήκες κοπής που χρησιμοποιήθηκαν για το αποτέλεσμα του τεμαχίου 1.

Φάση 1: Φραιζάρισμα εσοχής	
	Στην 1η φάση γίνεται κατεργασία φραιζαρίσματος βάθους 10mm με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής είναι 3mm, ενώ χρησιμοποιείται το 50% της συνολικής διαμέτρου για κάθε πέρασμα κοπής. **Συνολικός χρόνος κοπής:**06:47min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4000rpm, πρόωση f=240mm/min **Φινίρισμα** n=1200rpm, πρόωση f=240mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL6 Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600 Εταιρεία: Kennametal Γεωμετρία: Φ6

Φάση 2: Διάτρηση	
	Στην 2η φάση γίνεται η κατεργασία της οπής βάθους 17mm με τρυπάνι διαμέτρου 6.7mm. Το βάθος κοπής για το τρυπάνι διαμέτρου 6.7mm είναι 3mm σε κάθε πέρασμα. **Συνολικός χρόνος κοπής:**00:52min **Συνθήκες κοπής:** n=800rpm, πρόωση f=61mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL67 Περιγραφή: Solid Carbide Drill HSS M4 Εταιρεία: Werkö Γεωμετρία: Φ6.7

Φάση 3: Κατεργασία οπής	
	Στην 3^η φάση γίνεται η κατεργασία της οπής βάθους 17mm με κονδύλι διαμέτρου 6mm, ώστε να φτάσει την επιθυμητή διάμετρο των 15mm. Το βάθος κοπής για κάθε πέρασμα του κοπτικού είναι 3mm και χρησιμοποιείται το 50% της διαμέτρου του. **Συνολικός χρόνος κοπής:** 01:26min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4000rpm, πρόωση f=240mm/min **Φινίρισμα** n=1200rpm, πρόωση f=240mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL6 Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600 Εταιρεία: Kennametal Γεωμετρία: Φ6
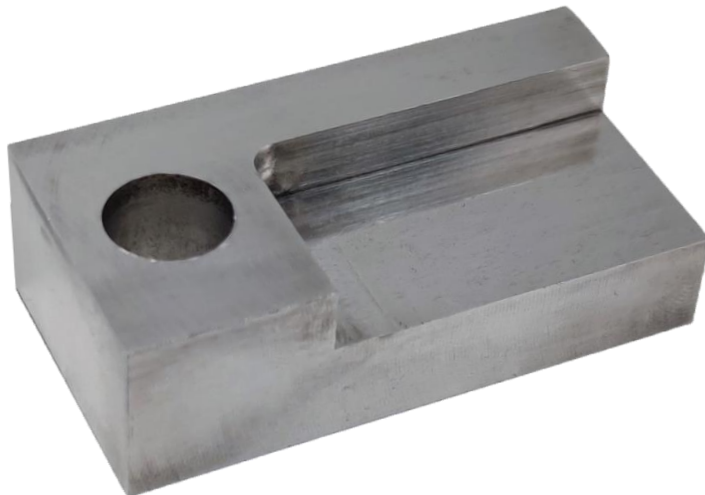
Σχήμα 3.2: Τελικό τεμάχιο 1

3.2 Τεμάχιο 2

3.2.1 Μηχανολογικό σχέδιο τεμαχίου 2
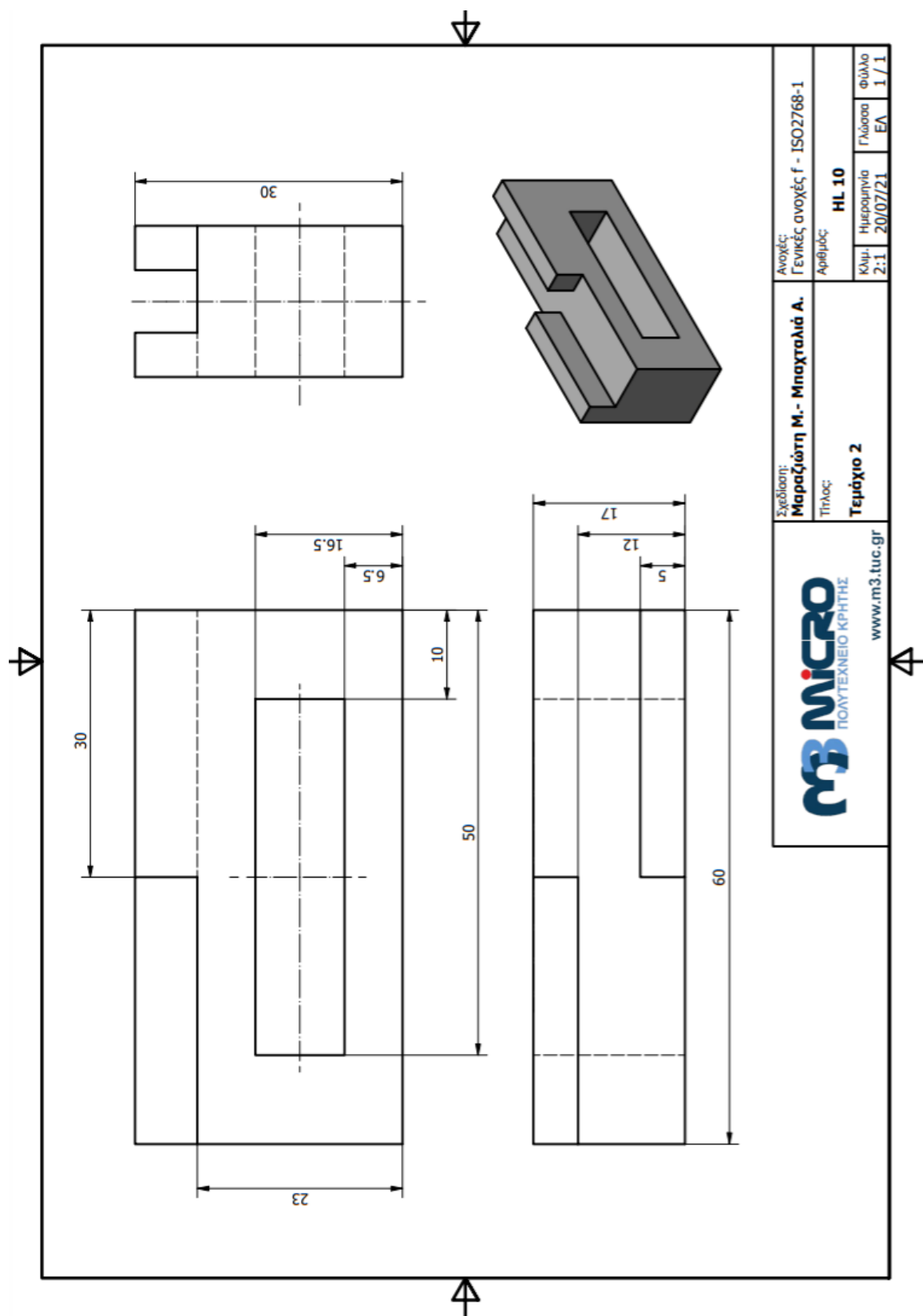
Σχήμα 3.3: Μηχανολογικό Σχέδιο τεμαχίου 2

3.2.2 Φασεολόγιο κατεργασίας τεμαχίου 2

Παρακάτω παρουσιάζονται οι 4 διαδοχικές φάσεις οι οποίες οδήγησαν στην κατεργασία του τεμαχίου με χρήση κώδικα CNC καθώς και τα εργαλεία με τις συνθήκες κοπής που χρησιμοποιήθηκαν για το αποτέλεσμα του τεμαχίου 2.

Φάση 1: Διάτρηση	
	Στην 1η φάση γίνεται διάτρηση με εργαλείο διαμέτρου 6.7mm Το συνολικό βάθος κοπής είναι 17mm και το βάθος κοπής για κάθε πέρασμα 3mm. **Συνολικός χρόνος κοπής:** 00:52min **Συνθήκες κοπής:** n=800rpm, πρόωση f=61mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL67 Περιγραφή: Solid Carbide Drill HSS M4 Εταιρεία: Werkö Γεωμετρία: Φ6.7

Φάση 2: Διάτρηση	
	Στην 2η φάση γίνεται διάτρηση με εργαλείο διαμέτρου 9mm. Το συνολικό βάθος κοπής είναι 17mm και το βάθος κοπής για κάθε πέρασμα 4.5mm. **Συνολικός χρόνος κοπής:** 00:45min **Συνθήκες κοπής:** n=600rpm, πρόωση f=72mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL9 Περιγραφή: High-Speed Steel Drill Εταιρεία: Werkö Γεωμετρία: Φ9

Φάση 3: Κατεργασία κεντρικής εσοχής

Στην 3^η φάση γίνεται η παραλληλόγραμμη διατομή βάθους 17mm χρησιμοποιώντας κονδύλι διαμέτρου 6mm, το οποίο εισέρχεται στην οπή που δημιουργήθηκε προηγουμένως. Το εργαλείο έχει βάθος κοπής 3mm για κάθε πέρασμα, ενώ χρησιμοποιείται το 50% της διαμέτρου του.

Συνολικός χρόνος κοπής: 04:15min

Συνθήκες κοπής:
Εκχόνδρυνση
n=4000rpm, πρόωση f=240mm/min
Φινίρισμα
n=1200rpm, πρόωση f=240mm/min

Εργαλεία που χρησιμοποιήθηκαν:
Ονομασία στον κώδικα: MILL6
Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600
Εταιρεία: Kennametal
Γεωμετρία: Φ6

Φάση 4: Κατεργασία άνω εσοχής

Στην 4^η φάση το τεμάχιο τοποθετείται με διαφορετική κατεύθυνση αλλάζοντας το σύστημα συντεταγμένων, ώστε να γίνει η κατεργασία φραιζαρίσματος για την εσοχή βάθους 7mm στο άνω μέρος του. Για την κατεργασία αυτή χρησιμοποιείται κοπτικό εργαλείο διαμέτρου 6mm, με βάθος κοπής 3mm για κάθε πέρασμα, ενώ χρησιμοποιείται το 50% της διαμέτρου του.

Συνολικός χρόνος κοπής: 05:17min

Συνθήκες κοπής:
Εκχόνδρυνση
n=4000rpm, πρόωση f=240mm/min
Φινίρισμα
n=1200rpm, πρόωση f=120mm/min

Εργαλεία που χρησιμοποιήθηκαν:
Ονομασία στον κώδικα: MILL6
Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600
Εταιρεία: Kennametal
Γεωμετρία: Φ6
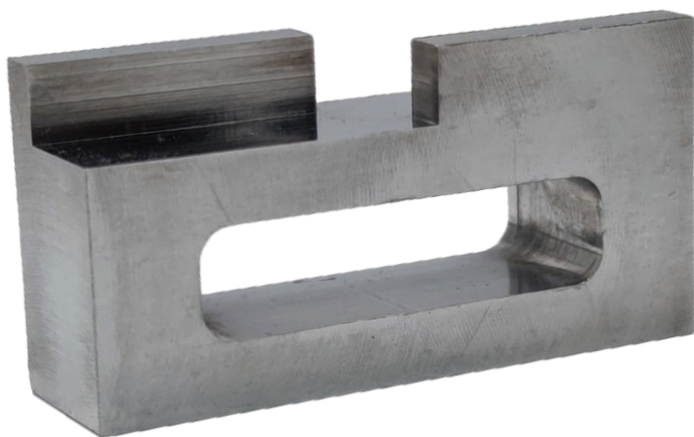
Σχήμα 3.4: Τελικό τεμάχιο 2

3.3 Τεμάχιο 3

3.3.1 Μηχανολογικό σχέδιο τεμαχίου 3
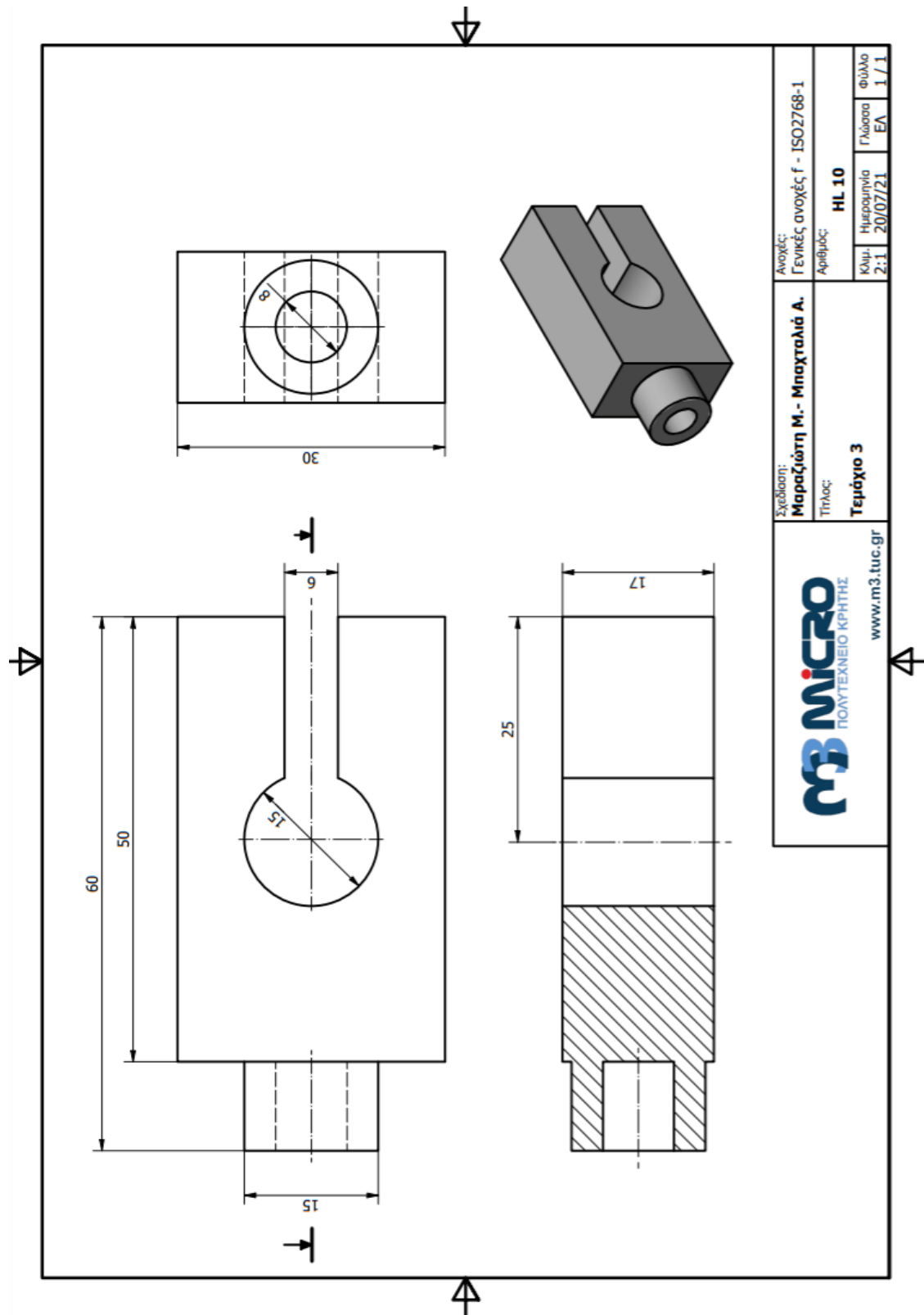
Σχήμα 3.5: Μηχανολογικό Σχέδιο τεμαχίου 3

3.3.2 Φασεολόγιο κατεργασίας τεμαχίου 3

Παρακάτω παρουσιάζονται οι 7 διαδοχικές φάσεις οι οποίες οδήγησαν στην κατεργασία του τεμαχίου με χρήση κώδικα CNC καθώς και τα εργαλεία με τις συνθήκες κοπής που χρησιμοποιήθηκαν για το αποτέλεσμα του τεμαχίου 3.

Φάση 1: Διάτρηση	
	Στην 1η φάση γίνεται η διάτρηση βάθους 17mm με τρυπάνι διαμέτρου 6.7mm. Το βάθος κοπής για το τρυπάνι διαμέτρου 6.7mm είναι 3mm σε κάθε πέρασμα. **Συνολικός χρόνος κοπής:** 01:29min **Συνθήκες κοπής:** n=800rpm, πρόωση f=61mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL67 Περιγραφή: Solid Carbide Drill HSS M4 Εταιρεία: Werkö Γεωμετρία: Φ6.7

Φάση 2: Διάτρηση	
	Στην 2η φάση γίνεται η διάτρηση βάθους 17mm με τρυπάνι διαμέτρου 9mm. Το βάθος κοπής για το τρυπάνι διαμέτρου 9mm είναι 4.5mm για κάθε πέρασμα. **Συνολικός χρόνος κοπής:** 01:24min **Συνθήκες κοπής:** n=600rpm, πρόωση f=72mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL9 Περιγραφή: High-Speed Steel Drill Εταιρεία: Werkö Γεωμετρία: Φ9
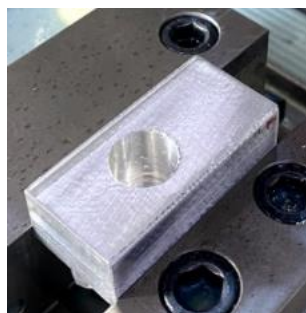
Φάση 3: Φραιζάρισμα οπής
Στην 3η φάση γίνεται φραιζάρισμα της οπής βάθους 17mm με κονδύλι διαμέτρου 6mm εσωτερικά και περιμετρικά της οπής, ώστε να φτάσει την επιθυμητή διάμετρο των 15mm. Το βάθος κοπής για το κονδύλι διαμέτρου 6mm είναι 3mm και χρησιμοποιείται το 50% της διαμέτρου του. **Συνολικός χρόνος κοπής:** 02:58min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4000rpm, πρόωση f=240mm/min **Φινίρισμα** n=1200rpm, πρόωση f=240mm/min
Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL6 Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600 Εταιρεία: Kennametal Γεωμετρία: Φ6

Φάση 4: Κατεργασία φραιζαρίσματος εσοχής
Στην 4η φάση το τεμάχιο τοποθετείται με διαφορετική κατεύθυνση αλλάζοντας το σύστημα συντεταγμένων, ώστε να γίνει η κατεργασία φραιζαρίσματος για την εσοχή βάθους 17mm με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής του εργαλείου είναι 3mm για κάθε πέρασμα, ενώ χρησιμοποιείται το 50% της διαμέτρου του. **Συνολικός χρόνος κοπής:**04:23 min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4000rpm, πρόωση f=240mm/min **Φινίρισμα** n=1200rpm, πρόωση f=240mm/min
Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL6 Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600 Εταιρεία: Kennametal Γεωμετρία: Φ6

Φάση 5: Διάτρηση
Στην 5^η φάση το τεμάχιο τοποθετείται ανάποδα αλλάζοντας το σύστημα συντεταγμένων και γίνεται διάτρηση βάθους 10mm με τρυπάνι διαμέτρου 6.7mm. Το βάθος κοπής για το τρυπάνι διαμέτρου 6.7mm είναι 3mm σε κάθε πέρασμα. **Συνολικός χρόνος κοπής:** 00:26min **Συνθήκες κοπής:** n=800rpm, πρόωση f=61mm/min
Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL67 Περιγραφή: Solid Carbide Drill HSS M4 Εταιρεία: Werkö Γεωμετρία: Φ6.7
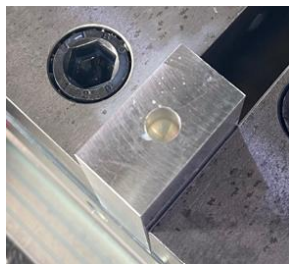
Φάση 6: Διάτρηση
Στην 6^η φάση γίνεται φραιζάρισμα της οπής με κονδύλι διαμέτρου 6mm, ώστε να φτάσει την επιθυμητή διάμετρο των 8mm. Το βάθος κοπής για το κονδύλι διαμέτρου 6mm είναι 3mm για κάθε πέρασμα και χρησιμοποιείται το 50% της διαμέτρου του. **Συνολικός χρόνος κοπής:** 00:57min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4000rpm, πρόωση f=240mm/min **Φινίρισμα** n=1200rpm, πρόωση f=240mm/min
Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL6 Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600 Εταιρεία: Kennametal Γεωμετρία: Φ6

Φάση 7: Κατεργασία φραιζαρίσματος	
	Στην 7^η φάση γίνεται κατεργασία φραιζαρίσματος, περιμετρικά της οπής, βάθους 10mm με κοπτικό εργαλείο διαμέτρου 6mm.Το βάθος κοπής του εργαλείου είναι 3mm για κάθε πέρασμα, ενώ χρησιμοποιείται το 50% της διαμέτρου του. **Συνολικός χρόνος κοπής:** 06:53min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4000rpm, πρόωση f=240mm/min **Φινίρισμα** n=1200rpm, πρόωση f=240mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL6 Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600 Εταιρεία: Kennametal Γεωμετρία: Φ6
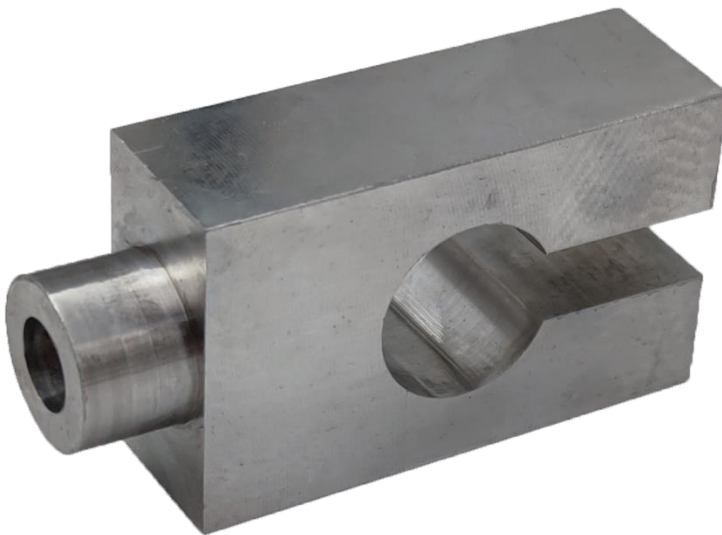
Σχήμα 3.6: Τελικό τεμάχιο 3

3.4 Τεμάχιο 4

3.4.1 Μηχανολογικό σχέδιο τεμαχίου 4
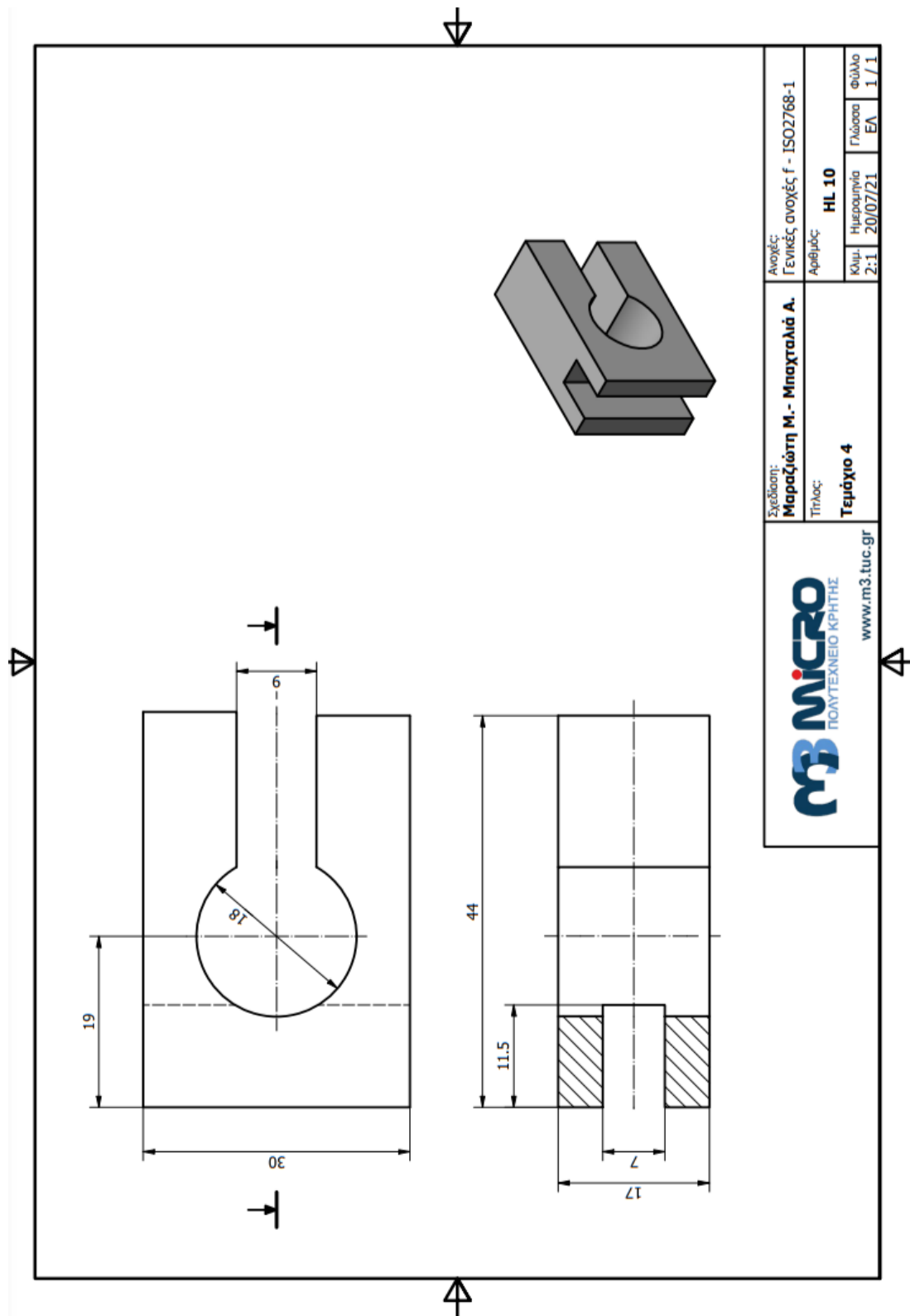
Σχήμα 3.7: Μηχανολογικό Σχέδιο τεμαχίου 4

3.4.2 Φασεολόγιο κατεργασίας τεμαχίου 4

Παρακάτω παρουσιάζονται οι 5 διαδοχικές φάσεις οι οποίες οδήγησαν στην κατεργασία του τεμαχίου με χρήση κώδικα CNC καθώς και τα εργαλεία με τις συνθήκες κοπής που χρησιμοποιήθηκαν για το αποτέλεσμα του τεμαχίου 4.

Φάση 1: Διάτρηση	
	Στην 1η φάση γίνεται η διάτρηση βάθους 17mm με τρυπάνι διαμέτρου 6.7mm.Το βάθος κοπής για το τρυπάνι διαμέτρου 6.7mm είναι 3mm σε κάθε πέρασμα. **Συνολικός χρόνος κοπής:** 00:52min **Συνθήκες κοπής:** n=800rpm, πρόωση f=61mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL67 Περιγραφή: Solid Carbide Drill HSS M4 Εταιρεία: Werkö Γεωμετρία: Φ6.7

Φάση 2: Διάτρηση	
	Στην 2η φάση γίνεται η διάτρηση βάθους 17mm με τρυπάνι διαμέτρου 9mm.Το βάθος κοπής για το τρυπάνι διαμέτρου 9mm είναι 4.5mm για κάθε πέρασμα. **Συνολικός χρόνος κοπής:** 00:45min **Συνθήκες κοπής:** n=600rpm, πρόωση f=72mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL9 Περιγραφή: High-Speed Steel Drill Εταιρεία: Werkö Γεωμετρία: Φ9

Φάση 3: Φραιζάρισμα οπής

Στην 3η φάση γίνεται φραιζάρισμα της οπής βάθους 17mm με κονδύλι διαμέτρου 6mm εσωτερικά και περιμετρικά της οπής, ώστε να φτάσει την επιθυμητή διάμετρο των 18mm. Το βάθος κοπής για το κονδύλι διαμέτρου 6mm είναι 3mm για κάθε πέρασμα και χρησιμοποιείται το 50% της διαμέτρου του.

Συνολικός χρόνος κοπής: 04:23min

Συνθήκες κοπής:
Εκχόνδρυνση
n=4000rpm, πρόωση f=240mm/min
Φινίρισμα
n=1200rpm, πρόωση f=240mm/min

Εργαλεία που χρησιμοποιήθηκαν:
Ονομασία στον κώδικα: MILL6
Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600
Εταιρεία: Kennametal
Γεωμετρία: Φ6

Φάση 4: Κατεργασία φραιζαρίσματος εσοχής

Στην 4η φάση το τεμάχιο τοποθετείται με διαφορετική κατεύθυνση αλλάζοντας το σύστημα συντεταγμένων, ώστε να γίνει η κατεργασία φραιζαρίσματος για την εσοχή βάθους 17mm με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής του εργαλείου είναι 3mm για κάθε πέρασμα, ενώ χρησιμοποιείται το 50% της διαμέτρου του.

Συνολικός χρόνος κοπής: 03:33min

Συνθήκες κοπής:
Εκχόνδρυνση
n=4000rpm, πρόωση f=240mm/min
Φινίρισμα
n=1200rpm, πρόωση f=240mm/min

Εργαλεία που χρησιμοποιήθηκαν:
Ονομασία στον κώδικα: MILL6
Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600
Εταιρεία: Kennametal
Γεωμετρία: Φ6

Φάση 5: Κατεργασία άνω εσοχής
Στην 5η φάση το τεμάχιο τοποθετείται πάλι με διαφορετική κατεύθυνση αλλάζοντας το σύστημα συντεταγμένων, ώστε να γίνει η κατεργασία φραιζαρίσματος για την άνω εσοχή βάθους 11.5mm με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής του εργαλείου είναι 3mm για κάθε πέρασμα, ενώ χρησιμοποιείται το 50% της διαμέτρου του. **Συνολικός χρόνος κοπής:** 02:38min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4000rpm, πρόωση f=240mm/min **Φινίρισμα** n=1200rpm, πρόωση f=240mm/min
Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL6 Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600 Εταιρεία: Kennametal Γεωμετρία: Φ6

Σχήμα 3.8: Τελικό τεμάχιο

3.5 Τεμάχιο 5

3.5.1 Μηχανολογικό σχέδιο τεμαχίου 5
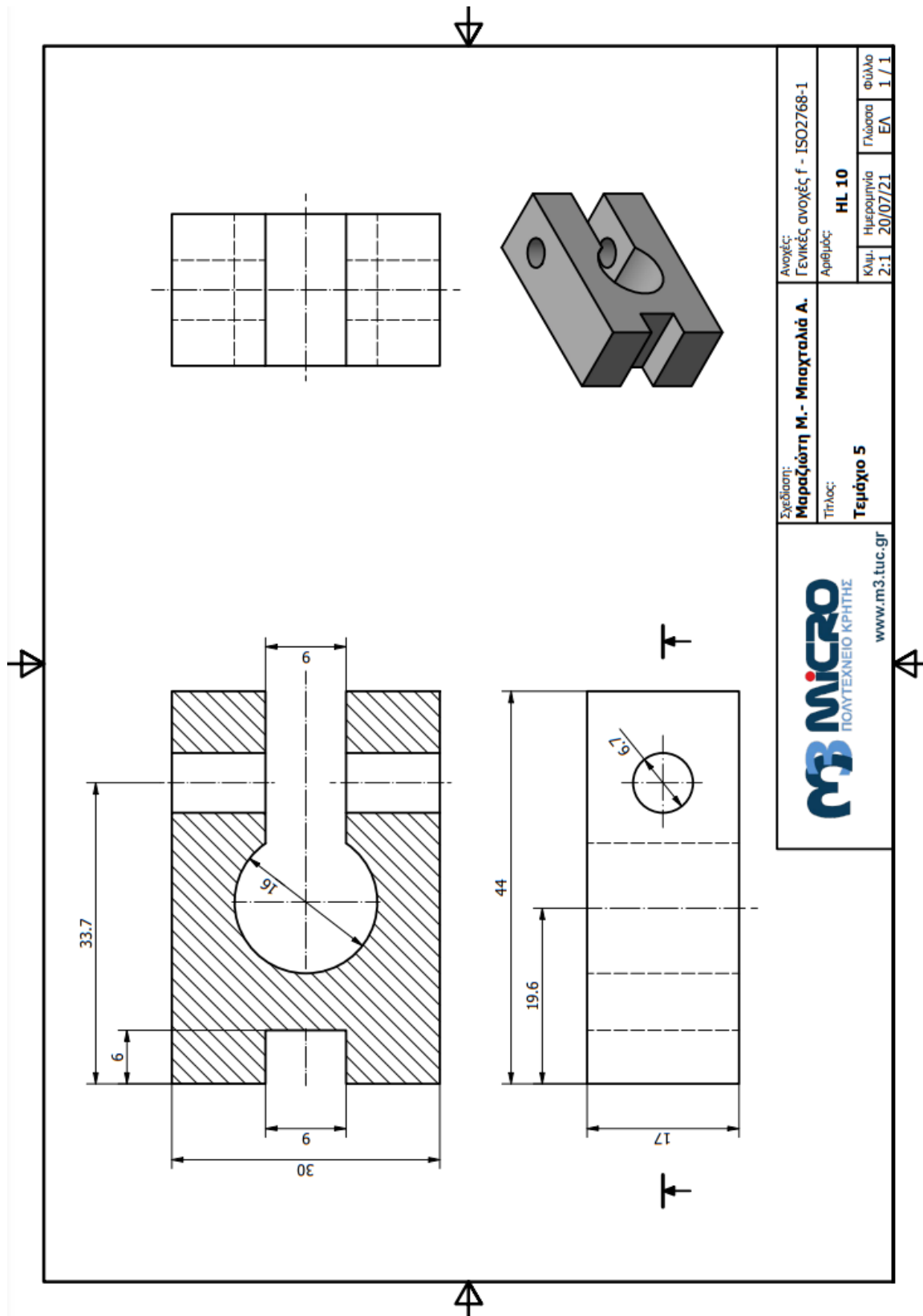
Σχήμα 3.9: Μηχανολογικό Σχέδιο τεμαχίου

3.5.2 Φασεολόγιο κατεργασίας τεμαχίου 5

Παρακάτω παρουσιάζονται οι 7 διαδοχικές φάσεις οι οποίες οδήγησαν στην κατεργασία του τεμαχίου με χρήση κώδικα CNC καθώς και τα εργαλεία με τις συνθήκες κοπής που χρησιμοποιήθηκαν για το αποτέλεσμα του τεμαχίου 5.

Φάση 1: Διάτρηση	
	Στην 1η φάση γίνεται η διάτρηση βάθους 17mm με τρυπάνι διαμέτρου 6.7mm. Το βάθος κοπής για το τρυπάνι διαμέτρου 6.7mm είναι 3mm σε κάθε πέρασμα. **Συνολικός χρόνος κοπής:** 01:10min **Συνθήκες κοπής:** n=800rpm, πρόωση f=61mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL67 Περιγραφή: Solid Carbide Drill HSS M4 Εταιρεία: Werkö Γεωμετρία: Φ6.7

Φάση 2: Διάτρηση	
	Στην 2η φάση γίνεται η διάτρηση βάθους 17mm με τρυπάνι διαμέτρου 9mm. Το βάθος κοπής για το τρυπάνι διαμέτρου 9mm είναι 4.5mm για κάθε πέρασμα. **Συνολικός χρόνος κοπής:** 01:03min **Συνθήκες κοπής:** n=600rpm, πρόωση f=72mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL9 Περιγραφή: High-Speed Steel Drill Εταιρεία: Werkö Γεωμετρία: Φ9
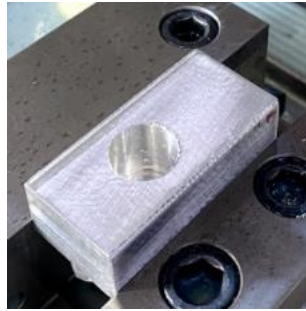
| Φάση 3: Φραιζάρισμα οπής |
|---|
| Στην 3η φάση γίνεται φραιζάρισμα της οπής βάθους 17mm με κονδύλι διαμέτρου 6mm εσωτερικά και περιμετρικά της οπής, ώστε να φτάσει την επιθυμητή διάμετρο των 16mm. Το βάθος κοπής για το κονδύλι διαμέτρου 6mm είναι 3mm και χρησιμοποιείται το 50% της διαμέτρου του.

Συνολικός χρόνος κοπής: 03:25min

Συνθήκες κοπής:
Εκχόνδρυνση
n=4000rpm, πρόωση f=240mm/min
Φινίρισμα
n=1200rpm, πρόωση f=240mm/min |
| **Εργαλεία που χρησιμοποιήθηκαν:**
Ονομασία στον κώδικα: MILL6
Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600
Εταιρεία: Kennametal
Γεωμετρία: Φ6 |

Φάση 4: Κεντράρισμα οπής
Στην 4η φάση το τεμάχιο τοποθετείται στο πλάι και γίνεται σημειακή διάτρηση βάθους 0.5mm με κοπτικό εργαλείο διαμέτρου 4mm. **Συνολικός χρόνος κοπής:** 00:11min **Συνθήκες κοπής:** n=1000rpm, πρόωση f=37mm/min
Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: CENTERDRILL4 Περιγραφή: Centerdrill HSS DIN333A Εταιρεία: IZAR Γεωμετρία: Φ4

Φάση 5: Διάτρηση μικρής οπής

Στην 5η φάση γίνεται διάτρηση βάθους 30mm με κοπτικό εργαλείο διαμέτρου 6.7mm. Το βάθος κοπής του εργαλείου είναι 3mm για κάθε πέρασμα κοπής.

Συνολικός χρόνος κοπής: 01:01min

Συνθήκες κοπής:
n=800rpm, πρόωση f=61mm/min

Εργαλεία που χρησιμοποιήθηκαν:
Ονομασία στον κώδικα: DRILL67
Περιγραφή: Solid Carbide Drill HSS M4
Εταιρεία: Werkö
Γεωμετρία: Φ6.7

Φάση 6: Κατεργασία φραιζαρίσματος πλαϊνής εσοχής
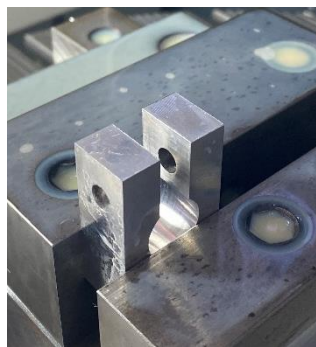
Στην 6η φάση το τεμάχιο τοποθετείται πάλι με διαφορετική κατεύθυνση αλλάζοντας το σύστημα συντεταγμένων, ώστε να γίνει η κατεργασία φραιζαρίσματος για την εσοχή βάθους 14mm με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής του εργαλείου είναι 3mm για κάθε πέρασμα, ενώ χρησιμοποιείται το 50% της διαμέτρου του.

Συνολικός χρόνος κοπής: 04:36min

Συνθήκες κοπής:
Εκχόνδρυνση
n=4000rpm, πρόωση f=240mm/min
Φινίρισμα
n=1200rpm, πρόωση f=240mm/min

Εργαλεία που χρησιμοποιήθηκαν:
Ονομασία στον κώδικα: MILL6
Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600
Εταιρεία: Kennametal
Γεωμετρία: Φ6

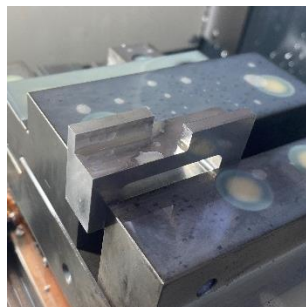| Φάση 7: Κατεργασία άνω εσοχής |
|---|
| | Στην 7η φάση το τεμάχιο τοποθετείται πάλι διαφορεικά αλλάζοντας το σύστημα συντεταγμένων, ώστε να γίνει η κατεργασία φραιζαρίσματος για την άνω εσοχή βάθους 6mmμε κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής του εργαλείου είναι 3mm για κάθε πέρασμα, ενώ χρησιμοποιείται το 50% της διαμέτρου του.

Συνολικός χρόνος κοπής: 01:07min

Συνθήκες κοπής:
Εκχόνδρυνση
n=4000rpm, πρόωση f=240mm/min
Φινίρισμα
n=1200rpm, πρόωση f=240mm/min |
| | **Εργαλεία που χρησιμοποιήθηκαν:**
Ονομασία στον κώδικα: MILL6
Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600
Εταιρεία: Kennametal
Γεωμετρία: Φ6 |

Σχήμα 3.10: Τελικό τεμάχιο 5

3.6   Τεμάχιο 6

3.6.1   Μηχανολογικό σχέδιο τεμαχίου
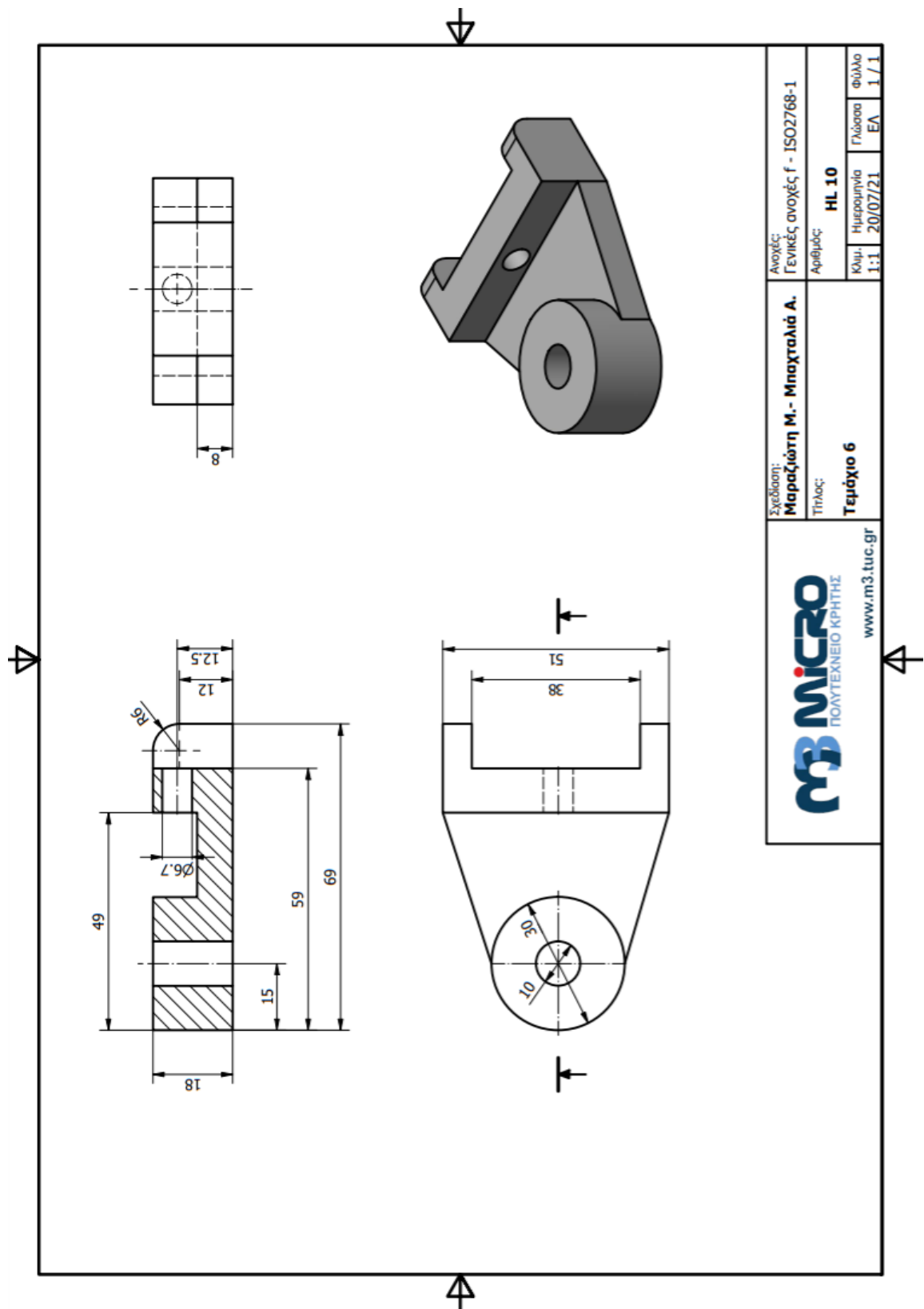
Σχήμα 3.11: Μηχανολογικό Σχέδιο τεμαχίου 6

3.6.2   Φασεολόγιο κατεργασίας τεμαχίου 6

Παρακάτω παρουσιάζονται οι 8 διαδοχικές φάσεις οι οποίες οδήγησαν στην κατεργασία του τεμαχίου με χρήση κώδικα CNC καθώς και τα εργαλεία με τις συνθήκες κοπής που χρησιμοποιήθηκαν για το αποτέλεσμα του τεμαχίου 6.

| Φάση 1: Κατεργασία φραιζαρίσματος άνω εσοχής	
	Στην 1η φάση γίνεται κατεργασία φραιζαρίσματος βάθους 10mmμε κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής είναι 3mm, ενώ χρησιμοποιείται το 50% της συνολικής διαμέτρου για κάθε πέρασμα κοπής. **Συνολικός χρόνος κοπής:** 08:03min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4000rpm, πρόωση f=240mm/min **Φινίρισμα** n=1200rpm, πρόωση f=240mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL6 Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600 Εταιρεία: Kennametal Γεωμετρία: Φ6

Φάση 2: Διάτρηση οπής	
	Στην 2η φάση γίνεται διάτρηση βάθους 10mm με κοπτικό εργαλείο διαμέτρου 6.7mm. Το βάθος κοπής του εργαλείου είναι 3mm για κάθε πέρασμα κοπής. **Συνολικός χρόνος κοπής:** 01:14 min **Συνθήκες κοπής:** n=800rpm, πρόωση f=61mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL67 Περιγραφή: Solid Carbide Drill HSS M4 Εταιρεία: Werkö Γεωμετρία: Φ6.7

Φάση 3: Κατεργασία πλαϊνών εξοχών

Στην 3η φάση γίνεται κατεργασία φραιζαρίσματος για τη διαμόρφωση της καμπυλότητας στις πλαϊνές εξοχές του τεμαχίου με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής είναι 3mm, ενώ χρησιμοποιείται το 50% της συνολικής διαμέτρου για κάθε πέρασμα κοπής.

Συνολικός χρόνος κοπής: 05:06 min

Συνθήκες κοπής:
Εκχόνδρυνση
n=4000rpm, πρόωση f=240mm/min
Φινίρισμα
n=1200rpm, πρόωση f=240mm/min

Εργαλεία που χρησιμοποιήθηκαν:
Ονομασία στον κώδικα: MILL6
Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600
Εταιρεία: Kennametal
Γεωμετρία: Φ6

Φάση 4: Κατεργασία λείανσης πλαϊνών εξοχών

Στην 4η φάση γίνεται κατεργασία φραιζαρίσματος για τη λείανση της καμπυλότητας που δημιουργήθηκε με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής είναι 3mm, ενώ χρησιμοποιείται το 50% της συνολικής διαμέτρου για κάθε πέρασμα κοπής.

Συνολικός χρόνος κοπής: 25:59min

Συνθήκες κοπής:
n=3000rpm, πρόωση f=70mm/min

Εργαλεία που χρησιμοποιήθηκαν:
Ονομασία στον κώδικα: BALL_MILL6
Περιγραφή: Ball EndMill HP421-2362-BN
Εταιρεία: OSG
Γεωμετρία: Φ6

Φάση 5: Διάτρηση	
	Στη 5ης φάση γίνεται η διάτρηση βάθους 17mm με τρυπάνι διαμέτρου 6.7mm. Το βάθος κοπής για το τρυπάνι διαμέτρου 6.7mm είναι 3mm σε κάθε πέρασμα. **Συνολικός χρόνος κοπής:** 01:40min **Συνθήκες κοπής:** n=800rpm, πρόωση f=61mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL67 Περιγραφή: Solid Carbide Drill HSS M4 Εταιρεία: Werkö Γεωμετρία: Φ6.7

Φάση 6: Διάτρηση	
	Στην 6ης φάση γίνεται η διάτρηση βάθους 17mm με τρυπάνι διαμέτρου 9mm. Το βάθος κοπής για το τρυπάνι διαμέτρου 9mm είναι 4.5mm για κάθε πέρασμα. **Συνολικός χρόνος κοπής:**01:29min **Συνθήκες κοπής:** n=600rpm, πρόωσηf=72mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL9 Περιγραφή: Τρυπάνι High-Speed Steel Drill Εταιρεία: Werkö Γεωμετρία: Φ9

Φάση 7: Φραιζάρισμα οπής
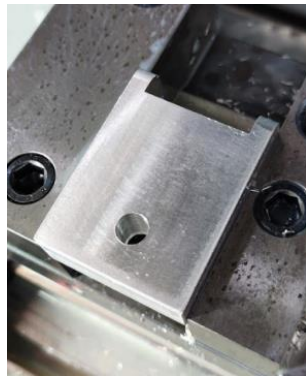
Στην 7η φάση γίνεται φραιζάρισμα της οπής βάθους 17mm με κονδύλι διαμέτρου 6mm εσωτερικά και περιμετρικά της οπής, ώστε να φτάσει την επιθυμητή διάμετρο των 10mm. Το βάθος κοπής για το κονδύλι διαμέτρου 6mm είναι 3mm για κάθε πέρασμα και χρησιμοποιείται το 50% της διαμέτρου του.

Συνολικός χρόνος κοπής: 01:05min

Συνθήκες κοπής:
n=4000rpm, πρόωση f=240mm/min

Εργαλεία που χρησιμοποιήθηκαν:
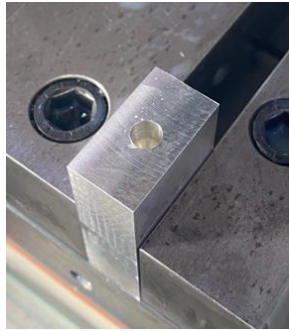Ονομασία στον κώδικα: MILL6
Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600
Εταιρεία: Kennametal
Γεωμετρία: Φ6

Φάση 8: Κατεργασία μεσαίας εσοχής και πλαϊνής τριγωνικής διατομής

Στην 8η φάση γίνεται κατεργασία φραιζαρίσματος για τη διαμόρφωση της τελικής διατομής του τεμαχίου με κοπτικό εργαλείο διαμέτρου 5mm. Το βάθος κοπής είναι 2.5mm, ενώ χρησιμοποιείται το 50% της συνολικής διαμέτρου για κάθε πέρασμα κοπής.

Συνολικός χρόνος κοπής: 01:25:33h

Συνθήκες κοπής:
Εκχόνδρυνση
n=4200rpm, πρόωση f=240mm/min
Φινίρισμα
n=1260rpm, πρόωση f=240mm/min

Εργαλεία που χρησιμοποιήθηκαν:
Ονομασία στον κώδικα: MILL5
Περιγραφή: Solid Carbide EndMill, EMSA 4310L 0500
Εταιρεία: DUTCH
Γεωμετρία: Φ5

Σχήμα 3.12: Τελικό τεμάχιο 6

3.7 Τεμάχιο 7

3.7.1 Μηχανολογικό σχέδιο τεμαχίου 7
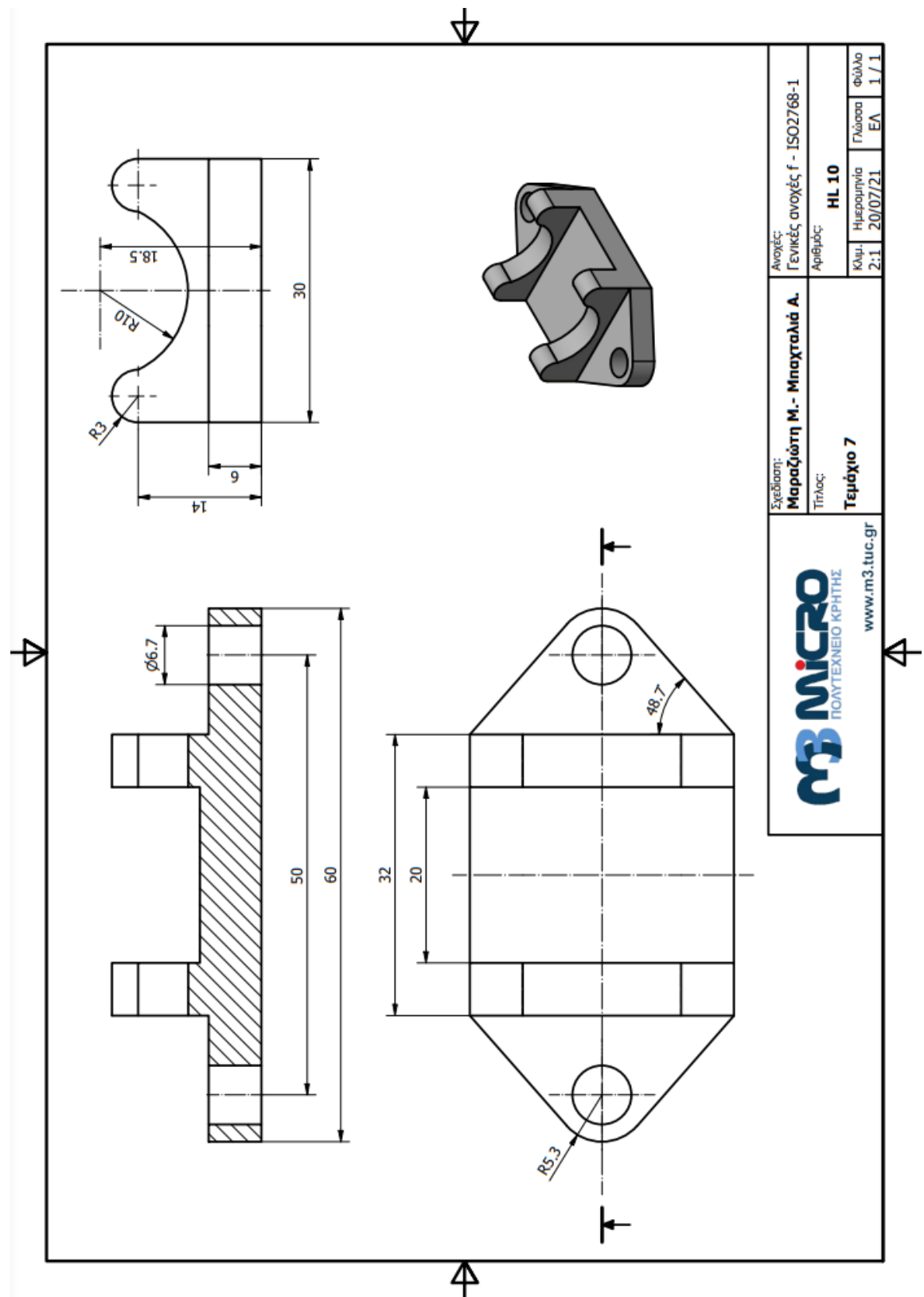
Σχήμα 3.13: Μηχανολογικό Σχέδιο τεμαχίου 7

3.7.2   Φασεολόγιο κατεργασίας τεμαχίου 7

Παρακάτω παρουσιάζονται οι 5 διαδοχικές φάσεις οι οποίες οδήγησαν στην κατεργασία του τεμαχίου με χρήση κώδικα CNC καθώς και τα εργαλεία με τις συνθήκες κοπής που χρησιμοποιήθηκαν για το αποτέλεσμα του τεμαχίου 7.

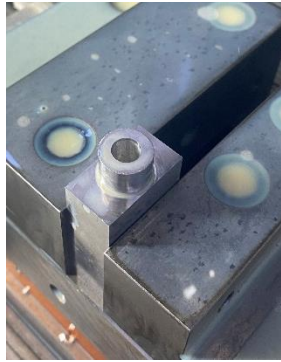| Φάση 1: Κατεργασία φραιζαρίσματος άνω διατομής	
	Στην 1η φάση γίνεται κατεργασία φραιζαρίσματος για τη διαμόρφωση του τεμαχίου με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής είναι 3mm, ενώ χρησιμοποιείται το 50% της συνολικής διαμέτρου για κάθε πέρασμα κοπής. **Συνολικός χρόνος κοπής:** 29:20min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4000rpm, πρόωση f=240mm/min **Φινίρισμα** n=1200rpm, πρόωση f=240mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL6 Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600 Εταιρεία: Kennametal Γεωμετρία: Φ6
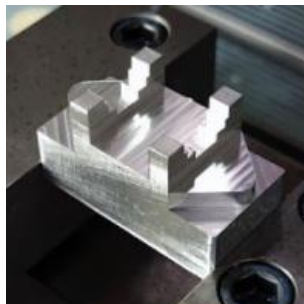
Φάση 2: Κατεργασία οπών	
	Στην 2η φάση γίνεται διάτρηση για τη δημιουργία των δύο οπών βάθους 6mm με κοπτικό εργαλείο διαμέτρου 6.7mm. Το βάθος κοπής του εργαλείου είναι 3mm για κάθε πέρασμα κοπής. **Συνολικός χρόνος κοπής:** 01:40min **Συνθήκες κοπής:** n=800rpm, πρόωση f=61mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL67 Περιγραφή: Solid Carbide Drill HSS M4 Εταιρεία: Werkö Γεωμετρία: Φ6.7

Φάση 3: Κατεργασία λείανσης των κυκλικών διατομών
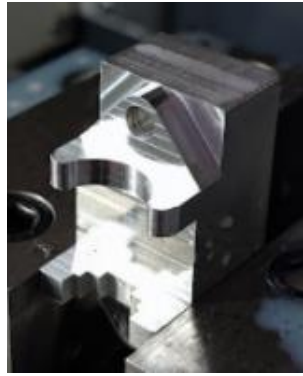
Στην 3η φάση γίνεται κατεργασία φραιζαρίσματος για τη λείανση των κυκλικών διατομών με κοπτικό εργαλείο διαμέτρου 5mm. Το βάθος κοπής είναι 2.5mm, ενώ χρησιμοποιείται το 50% της συνολικής διαμέτρου για κάθε πέρασμα κοπής.

Συνολικός χρόνος κοπής: 00:46 min

Συνθήκες κοπής:
Εκχόνδρυνση
n=4200rpm, πρόωση f=240mm/min
Φινίρισμα
n=1260rpm, πρόωση f=240mm/min

Εργαλεία που χρησιμοποιήθηκαν:
Ονομασία στον κώδικα: MILL5
Περιγραφή: Solid Carbide EndMill, EMSA 4310L 0500
Εταιρεία: DUTCH
Γεωμετρία: Φ5

Φάση 4: Κατεργασία λείανσης των κυκλικών διατομών

Στην 4η φάση το τεμάχιο τοποθετείται με διαφορετική κατεύθυνση αλλάζοντας το σύστημα συντεταγμένων και γίνεται πάλι η κατεργασία φραιζαρίσματος για τη λείανση των κυκλικών διατομών με κοπτικό εργαλείο διαμέτρου 5mm. Το βάθος κοπής είναι 2.5mm, ενώ χρησιμοποιείται το 50% της συνολικής διαμέτρου για κάθε πέρασμα κοπής.

Συνολικός χρόνος κοπής: 00:46 min

Συνθήκες κοπής:
Εκχόνδρυνση
n=4200rpm, πρόωση f=240mm/min
Φινίρισμα
n=1260rpm, πρόωση f=240mm/min

Εργαλεία που χρησιμοποιήθηκαν:
Ονομασία στον κώδικα: MILL5
Περιγραφή: Solid Carbide EndMill, EMSA 4310L 0500
Εταιρεία: DUTCH
Γεωμετρία: Φ5

Φάση 5: Κατεργασία φραιζαρίσματος κάτω πλευράς	
	Στην 5η φάση γίνεται, με κύκλο κατεργασίας, φραιζάρισμα για την αφαίρεση του επιπλέον υλικού στο κάτω μέρος του τεμαχίου βάθους 10mm με κοπτικό εργαλείο διαμέτρου 63mm. Το βάθος κοπής είναι 1mm για κάθε πέρασμα κοπής. **Συνολικός χρόνος κοπής:** 3:00min **Συνθήκες κοπής:** n=2000rpm, πρόωση f=800mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: FACE63 Περιγραφή: General Face Milling Εταιρεία: SANDVIK Coromant Γεωμετρία: Φ6

Σχήμα 3.14: Τελικό τεμάχιο 7

3.8   Τεμάχιο 8
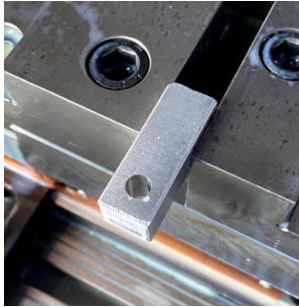
3.8.1   Μηχανολογικό σχέδιο τεμαχίου 8
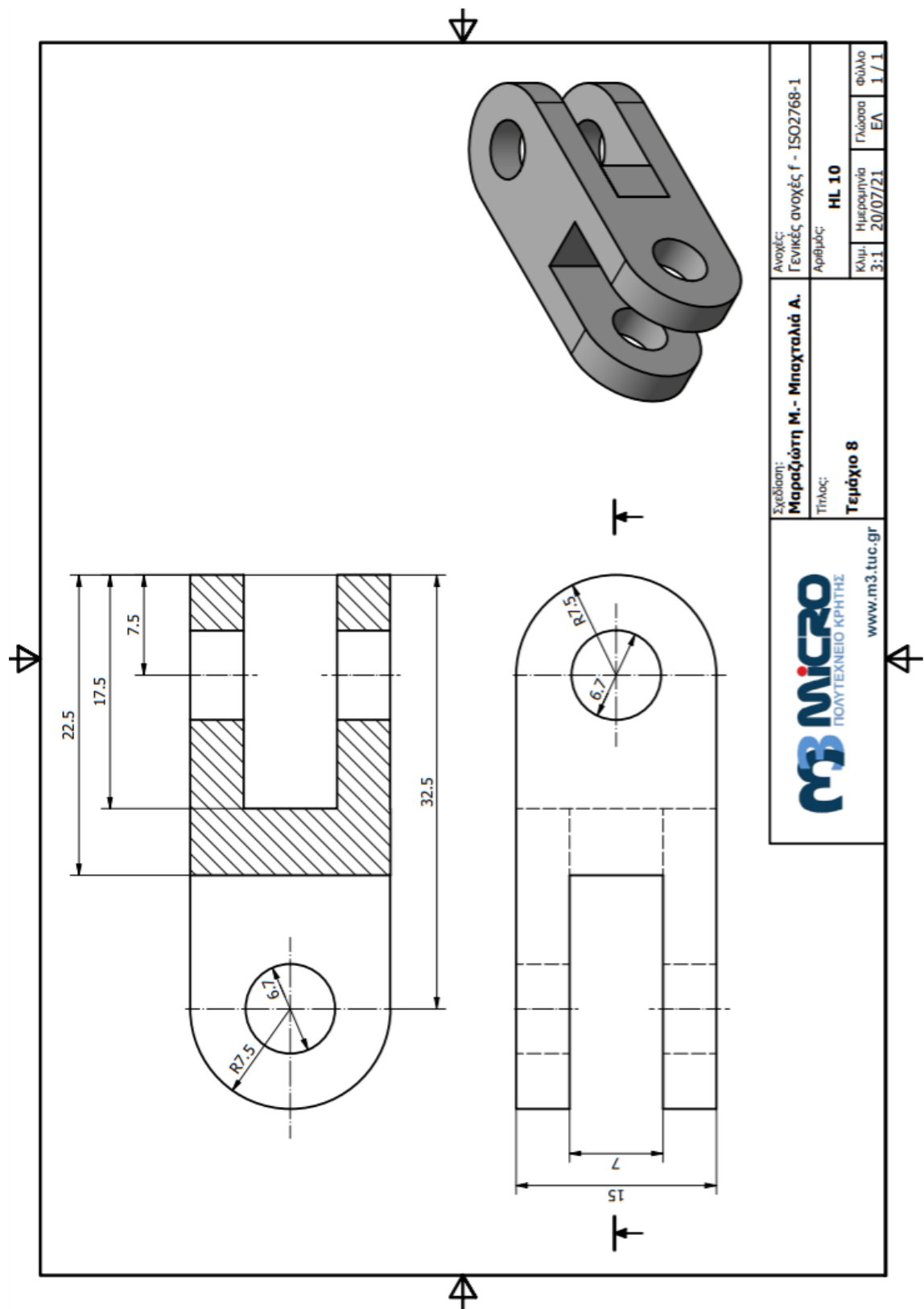
Σχήμα 3.15: Μηχανολογικό Σχέδιο τεμαχίου 8

3.8.2   Φασεολόγιο κατεργασίας τεμαχίου 8

Παρακάτω παρουσιάζονται οι 6 διαδοχικές φάσεις οι οποίες οδήγησαν στην κατεργασία του τεμαχίου με χρήση κώδικα CNC καθώς και τα εργαλεία με τις συνθήκες κοπής που χρησιμοποιήθηκαν για το αποτέλεσμα του τεμαχίου 8.

Φάση 1: Διάτρηση	
	Στην 1η φάση γίνεται διάτρηση με εργαλείο διαμέτρου 6.7mm. Το συνολικό βάθος κοπής είναι 15mm και το κοπτικό εργαλείο έχει βάθος κοπής για κάθε πέρασμα 3mm. **Συνολικός χρόνος κοπής:** 01:28min **Συνθήκες κοπής:** n=800rpm, πρόωση f=61mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL67 Περιγραφή: Solid Carbide Drill HSS M4 Εταιρεία: Werkö Γεωμετρία: Φ6.7

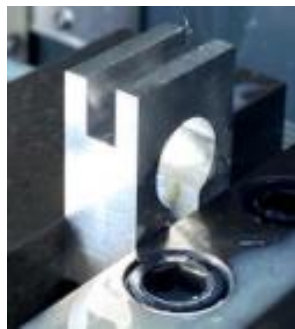| Φάση 2: Κατεργασία φραιζαρίσματος	
	Στην 2η φάση γίνεται κατεργασία φραιζαρίσματος στο πλαϊνό μέρος του τεμαχίου, βάθους 15mm με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής του εργαλείου είναι 3mm για κάθε πέρασμα, ενώ χρησιμοποιείται το 50% της διαμέτρου του. **Συνολικός χρόνος κοπής:** 02:24 min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4000rpm, πρόωση f=240mm/min **Φινίρισμα** n=1200rpm, πρόωση f=240mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL6 Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600 Εταιρεία: Kennametal Γεωμετρία: Φ6

Φάση 3: Διάτρηση	
	Στην 3η φάση το τεμάχιο τοποθετείται διαφορετικά αλλάζοντας το σύστημα συντεταγμένων και γίνεται διάτρηση βάθους 15mm με κοπτικό εργαλείο διαμέτρου 6.7mm. Το εργαλείο έχει βάθος κοπής 3mm για κάθε πέρασμα. **Συνολικός χρόνος κοπής:** 01:28min **Συνθήκες κοπής:** n=800rpm, πρόωση f=61mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL67 Περιγραφή: Solid Carbide Drill HSS M4 Εταιρεία: Werkö Γεωμετρία: Φ6.7

Φάση 4: Κατεργασία φραιζαρίσματος	
	Στην 4η φάση γίνεται κατεργασία φραιζαρίσματος στο πλαϊνό μέρος του τεμαχίου, βάθους 15mm με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής του εργαλείου είναι 3mm για κάθε πέρασμα, ενώ χρησιμοποιείται το 50% της διαμέτρου του. **Συνολικός χρόνος κοπής:** 02:24 min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4000rpm, πρόωση f=240mm/min **Φινίρισμα** n=1200rpm, πρόωση f=240mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL6 Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600 Εταιρεία: Kennametal Γεωμετρία: Φ6

Φάση 5: Κατεργασία φραιζαρίσματος

Στην 5η φάση το τεμάχιο τοποθετείται ξανά σε διαφορετική κατεύθυνση αλλάζοντας το σύστημα συντεταγμένων και γίνεται κατεργασία φραιζαρίσματος βάθους 17.5mm με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής του εργαλείου είναι 3mm για κάθε πέρασμα, ενώ χρησιμοποιείται το 50% της διαμέτρου του.

Συνολικός χρόνος κοπής: 01:38 min

Συνθήκες κοπής:
Εκχόνδρυνση
n=4000rpm, πρόωση f=240mm/min
Φινίρισμα
n=1200rpm, πρόωση f=240mm/min

Εργαλεία που χρησιμοποιήθηκαν:
Ονομασία στον κώδικα: MILL6
Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600
Εταιρεία: Kennametal
Γεωμετρία: Φ6

Φάση 6: Κατεργασία φραιζαρίσματος

Στην 6η φάση το τεμάχιο τοποθετείται και από την άλλη πλευρά αλλάζοντας πάλι το σύστημα συντεταγμένων και γίνεται κατεργασία φραιζαρίσματος βάθους 17.5mm με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής του εργαλείου είναι 3mm για κάθε πέρασμα, ενώ χρησιμοποιείται το 50% της διαμέτρου του.

Συνολικός χρόνος κοπής: 01:38min

Συνθήκες κοπής:
Εκχόνδρυνση
n=4000rpm, πρόωση f=240mm/min
Φινίρισμα
n=1200rpm, πρόωση f=240mm/min

Εργαλεία που χρησιμοποιήθηκαν:
Ονομασία στον κώδικα: MILL6
Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600
Εταιρεία: Kennametal
Γεωμετρία: Φ6

Σχήμα 3.16: Τελικό τεμάχιο 8

3.9 Τεμάχιο 9

3.9.1 Μηχανολογικό σχέδιο τεμαχίου 9
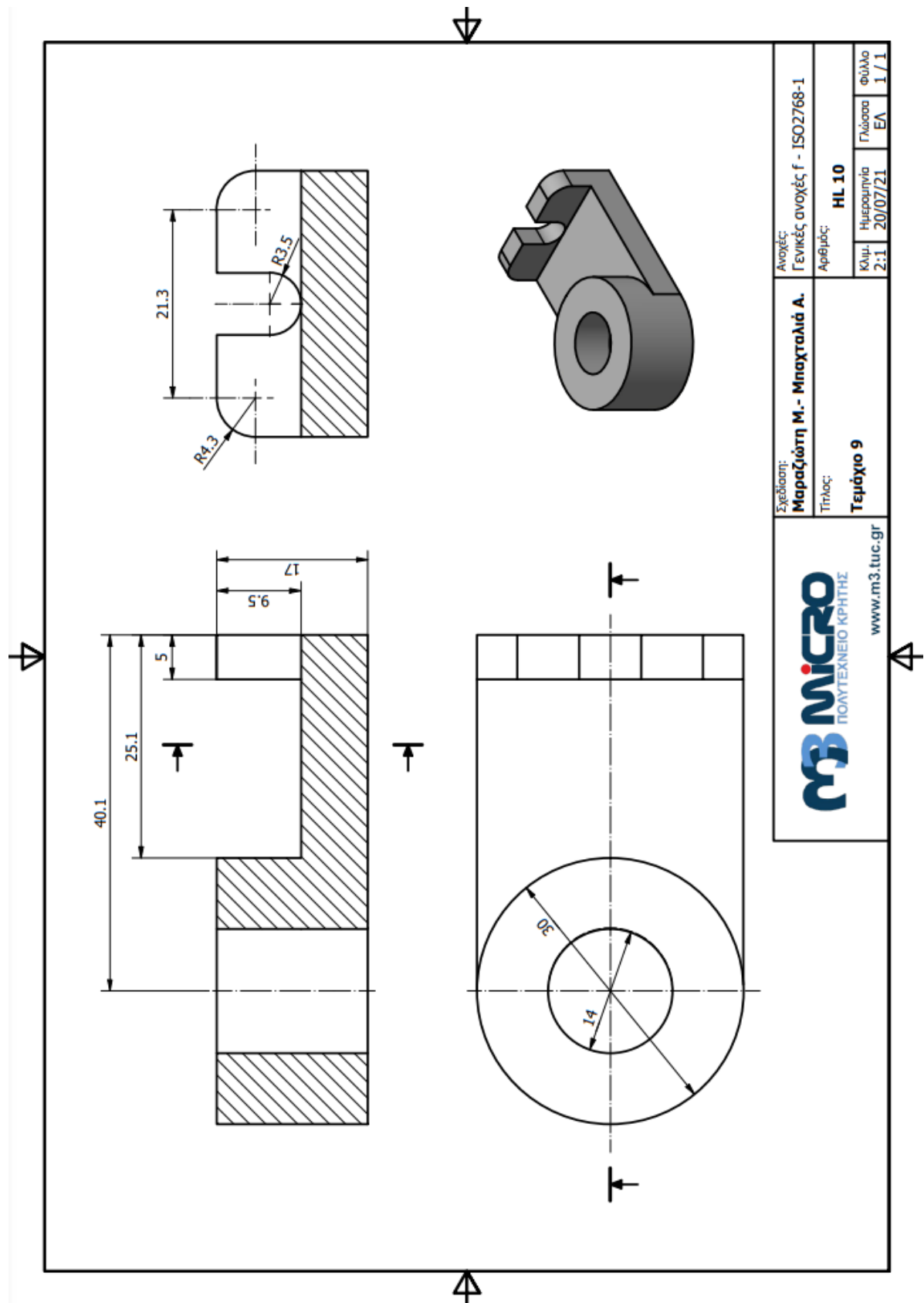
Σχήμα 3.17: Μηχανολογικό Σχέδιο τεμαχίου 9

3.9.2 Φασεολόγιο κατεργασίας τεμαχίου 9

Παρακάτω παρουσιάζονται οι 6 διαδοχικές φάσεις οι οποίες οδήγησαν στην κατεργασία του τεμαχίου με χρήση κώδικα CNC καθώς και τα εργαλεία με τις συνθήκες κοπής που χρησιμοποιήθηκαν για το αποτέλεσμα του τεμαχίου 9.
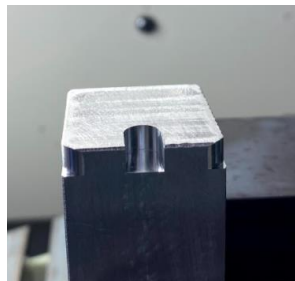
Φάση 1: Κατεργασία φραιζαρίσματος	
	Στην 1η φάση γίνεται κατεργασία φραιζαρίσματος στο πλαϊνό τμήμα του τεμαχίου βάθους 5mm με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής του εργαλείου είναι 3mm για κάθε πέρασμα, ενώ χρησιμοποιείται το 50% της διαμέτρου του. **Συνολικός χρόνος κοπής:** 01:53min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4000rpm, πρόωση f=240mm/min **Φινίρισμα** n=1200rpm, πρόωση f=240mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL6 Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600 Εταιρεία: Kennametal Γεωμετρία: Φ6
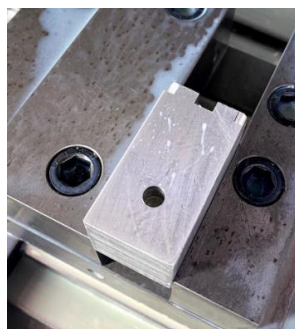
| Φάση 2: Διάτρηση	
	Στην 2η φάση το τεμάχιο τοποθετείται με διαφορετική κατεύθυνση αλλάζοντας σύστημα συντεταγμένων και γίνεται διάτρηση βάθους 17mm με τρυπάνι διαμέτρου 6.7mm. Το βάθος κοπής για το τρυπάνι διαμέτρου 6.7mm είναι 3mm σε κάθε πέρασμα. **Συνολικός χρόνος κοπής:** 01:40min **Συνθήκες κοπής:** n=800rpm, πρόωση f=61mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL67 Περιγραφή: Solid Carbide Drill HSS M4 Εταιρεία: Werkö Γεωμετρία: Φ6.7
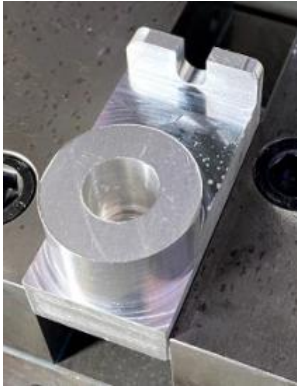
Φάση 3: Διάτρηση	
	Στην 3η φάση γίνεται διάτρηση βάθους 17mm με τρυπάνι διαμέτρου 9mm. Το βάθος κοπής για κάθε πέρασμα για το τρυπάνι διαμέτρου 9mm είναι 4.5mm **Συνολικός χρόνος κοπής:** 01:25min **Συνθήκες κοπής:** n=600rpm, πρόωση f=72mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL9 Περιγραφή: High-Speed Steel Drill Εταιρεία: Werkö Γεωμετρία: Φ9

| Φάση 4: Φραιζάρισμα οπής	
	Στην 4η φάση γίνεται φραιζάρισμα της οπής βάθους 17mm με κονδύλι διαμέτρου 6mm εσωτερικά και περιμετρικά της οπής, ώστε να φτάσει την επιθυμητή διάμετρο των 14mm. Το βάθος κοπής για το κονδύλι διαμέτρου 6mm είναι 3mm για κάθε πέρασμα και χρησιμοποιείται το 50% της διαμέτρου του. **Συνολικός χρόνος κοπής:** 02:50min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4000rpm, πρόωση f=240mm/min **Φινίρισμα** n=1200rpm, πρόωση f=240mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL6 Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600 Εταιρεία: Kennametal Γεωμετρία: Φ6

Φάση 5: Κατεργασία φραιζαρίσματος

Στην 5η φάση γίνεται κατεργασία φραιζαρίσματος βάθους 9.5mm και περιμετρικά 17mm με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής του εργαλείου είναι 3mm για κάθε πέρασμα, ενώ χρησιμοποιείται το 50% της διαμέτρου του.

Συνολικός χρόνος κοπής: 32:30min

Συνθήκες κοπής:
Εκχόνδρυνση
n=4000rpm, πρόωση f=240mm/min
Φινίρισμα
n=1200rpm, πρόωση f=240mm/min

Εργαλεία που χρησιμοποιήθηκαν:
Ονομασία στον κώδικα: MILL6
Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600
Εταιρεία: Kennametal
Γεωμετρία: Φ6

Φάση 6: Κατεργασία φραιζαρίσματος

Στην 6η φάση γίνεται κατεργασία φραιζαρίσματος βάθους 15mm με κοπτικό εργαλείο διαμέτρου 63mm. Το βάθος κοπής του εργαλείου είναι 1mm για κάθε πέρασμα, ενώ χρησιμοποιείται το 50% της διαμέτρου του.

Συνολικός χρόνος κοπής: 5:00min

Συνθήκες κοπής:
n=2000rpm, πρόωση f=800mm/min

Εργαλεία που χρησιμοποιήθηκαν:
Ονομασία στον κώδικα: FACE63
Περιγραφή: General Face Milling
Εταιρεία: SANDVIK Coromant
Γεωμετρία: Φ63

Σχήμα 3.18: Τελικό τεμάχιο 9

3.10 Τεμάχιο 10
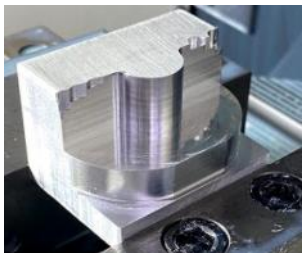
3.10.1 Μηχανολογικό σχέδιο τεμαχίου 10
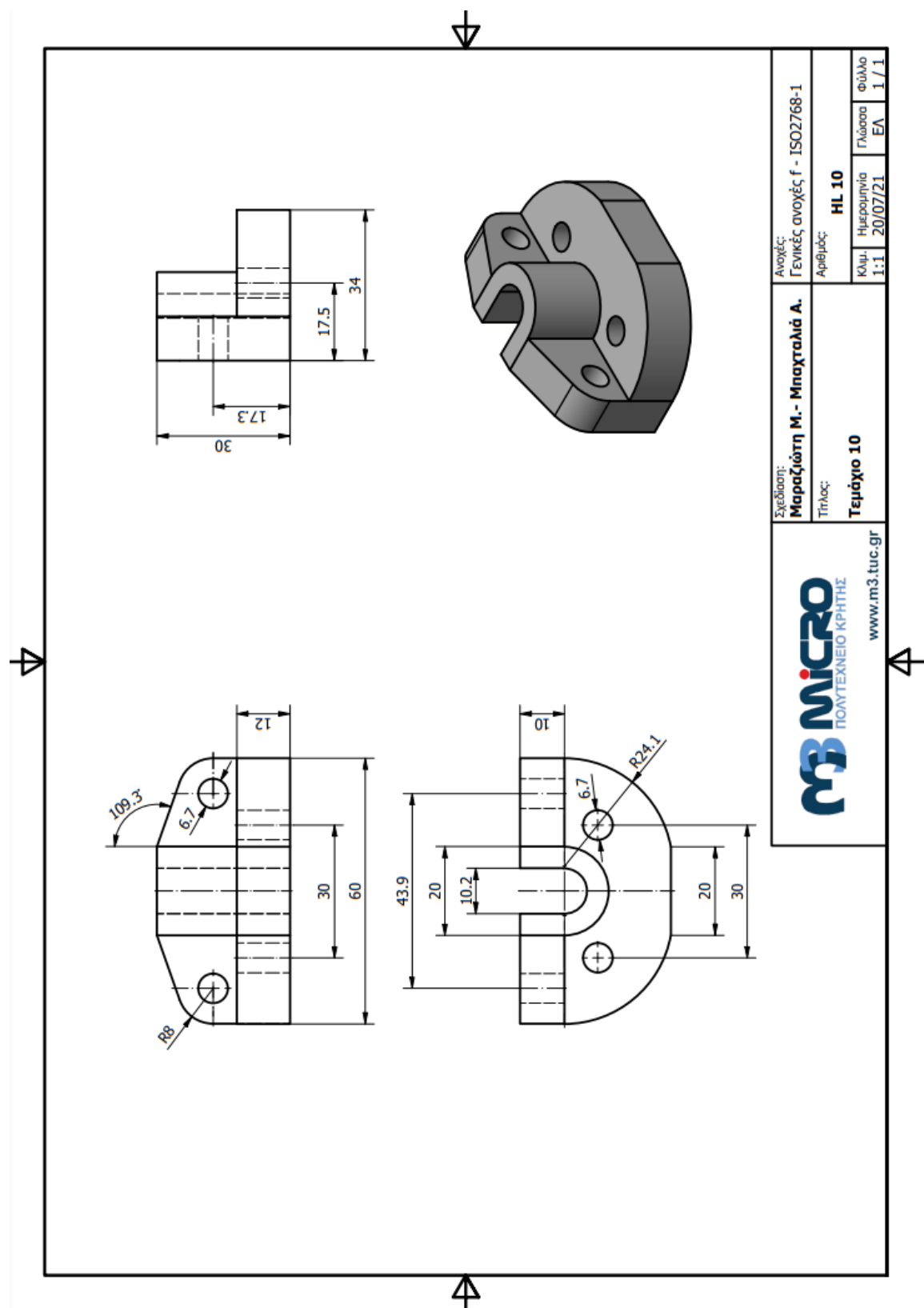
Σχήμα 3.19: Μηχανολογικό Σχέδιο τεμαχίου 10

3.10.2 Φασεολόγιο κατεργασίας τεμαχίου 10

Παρακάτω παρουσιάζονται οι 9 διαδοχικές φάσεις οι οποίες οδήγησαν στην κατεργασία του τεμαχίου με χρήση κύκλων κατεργασίας καθώς και τα εργαλεία με τις συνθήκες κοπής που χρησιμοποιήθηκαν για το αποτέλεσμα του τεμαχίου 1.

Φάση 1: Κατεργασία φραιζαρίσματος	
	Στην 1η φάση γίνεται κατεργασία φραιζαρίσματος βάθους 18mm με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής είναι 3mm, ενώ χρησιμοποιείται το 50% της συνολικής διαμέτρου για κάθε πέρασμα κοπής. **Συνολικός χρόνος κοπής:** 22:11min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4000rpm, πρόωση f=240mm/min **Φινίρισμα** n=1200rpm, πρόωση f=240mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL6 Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600 Εταιρεία: Kennametal Γεωμετρία: Φ6

Φάση 2: Κατεργασία φραιζαρίσματος	
	Στην 2η φάση γίνεται κατεργασία φραιζαρίσματος βάθους 30mm με κοπτικό εργαλείο διαμέτρου 5mm. Το βάθος κοπής είναι 2.5mm, ενώ χρησιμοποιείται το 50% της συνολικής διαμέτρου για κάθε πέρασμα κοπής. **Συνολικός χρόνος κοπής:** 34:26min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4200rpm, πρόωση f=240mm/min **Φινίρισμα** n=1260rpm, πρόωση f=240mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL5 Περιγραφή: Solid Carbide EndMill, EMSA 4310L 0500 Εταιρεία: DUTCH Γεωμετρία: Φ5

Φάση 3: Κατεργασία οπών	
	Στην 3 η φάση γίνεται διάτρηση για την δημιουργία οπών στο κάτω τμήμα του τεμαχίου βάθους 12mm με κοπτικό εργαλείο διαμέτρου 6.7mm. Το βάθος κοπής είναι 3mm για κάθε πέρασμα κοπής. **Συνολικός χρόνος κοπής:** 02:31min **Συνθήκες κοπής:** n=800rpm, πρόωση f=61mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL67 Περιγραφή: Solid Carbide Drill HSS M4 Εταιρεία: Werkö Γεωμετρία: Φ6.7
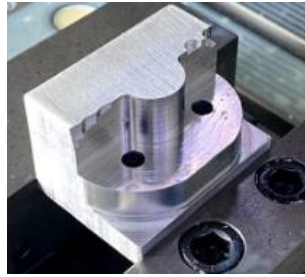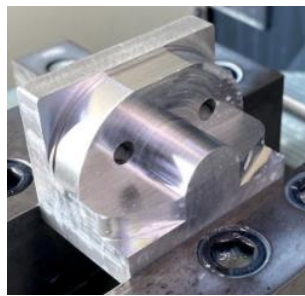
| Φάση 4: Κατεργασία φραιζαρίσματος	
	Στην 4 η φάση γυρνάμε το τεμάχιο αλλάζοντας σύστημα συντεταγμένων και γίνεται κατεργασία φραιζαρίσματος βάθους 30mm για τη διαμόρφωση της καμπυλότητας στο άνω μέρος του τεμαχίου με κοπτικό εργαλείο διαμέτρου 5mm. Το βάθος κοπής είναι 2.5mm, ενώ χρησιμοποιείται το 50% της συνολικής διαμέτρου για κάθε πέρασμα κοπής. **Συνολικός χρόνος κοπής:** 31:12min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4200rpm, πρόωση f=240mm/min **Φινίρισμα** n=1260rpm, πρόωση f=240mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL5 Περιγραφή: Solid Carbide EndMill, EMSA 4310L 0500 Εταιρεία: DUTCH Γεωμετρία: Φ5

Φάση 5: Κατεργασία οπών	
	Στην 5^η φάση γίνεται διάτρηση για την δημιουργία οπών βάθους 10mm με κοπτικό εργαλείο διαμέτρου 6.7mm. Το βάθος κοπής είναι 3mm για κάθε πέρασμα κοπής. **Συνολικός χρόνος κοπής:** 02:27min **Συνθήκες κοπής:** n=800rpm, πρόωση f=61mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: DRILL67 Περιγραφή: Solid Carbide Drill HSS M4 Εταιρεία: Werkö Γεωμετρία: Φ6.7
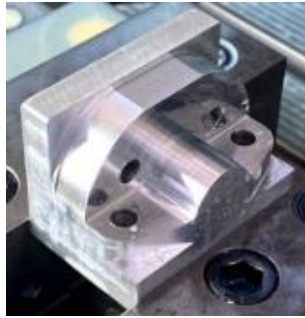
Φάση 6: Κατεργασία φραιζαρίσματος	
	Στην 6^η φάση γίνεται, με κύκλο κατεργασίας, φραιζάρισμα για την αφαίρεση του επιπλέον υλικού στην μία πλευρά του τεμαχίου βάθους 10mm με κοπτικό εργαλείο διαμέτρου 63mm. Το βάθος κοπής είναι 1mm για κάθε πέρασμα κοπής. **Συνολικός χρόνος κοπής:** 3:00 min **Συνθήκες κοπής:** n=2000rpm, πρόωση f=800mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: FACE63 Περιγραφή: General Face Milling Εταιρεία: SANDVIK Coromant Γεωμετρία: Φ6

Φάση 7: Κατεργασία φραιζαρίσματος

Στην 7η φάση το τεμάχιο τοποθετείται και από την άλλη πλευρά ώστε να γίνει, με κύκλο κατεργασίας, φραιζάρισμα για την αφαίρεση του επιπλέον υλικού βάθους 12mm με κοπτικό εργαλείο διαμέτρου 63mm. Το βάθος κοπής είναι 1mm για κάθε πέρασμα κοπής.

Συνολικός χρόνος κοπής:3:00 min

Συνθήκες κοπής:
n=2000rpm, πρόωσηf=800mm/min

**Εργαλεία που χρησιμοποιήθηκαν:**
Ονομασία στον κώδικα: FACE63
Περιγραφή: General Face Milling
Εταιρεία: SANDVIK Coromant
Γεωμετρία: Φ6

Φάση 8: Κατεργασία φραιζαρίσματος εσοχής
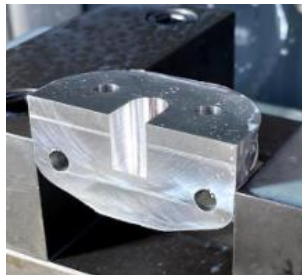
Στην 8η φάση γίνεται κατεργασία φραιζαρίσματος για την πλαϊνή εσοχή βάθους 16mm με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής είναι 3mm, ενώ χρησιμοποιείται το 50% της συνολικής διαμέτρου για κάθε πέρασμα κοπής.

Συνολικός χρόνος κοπής: 2:33min

Συνθήκες κοπής:
Εκχόνδρυνση
n=4000rpm, πρόωση f=240mm/min
Φινίρισμα
n=1200rpm, πρόωση f=240mm/min

Εργαλεία που χρησιμοποιήθηκαν:
Ονομασία στον κώδικα: MILL6
Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600
Εταιρεία: Kennametal
Γεωμετρία: Φ6

Φάση 9: Κατεργασία φραιζαρίσματος εσοχής	
	Στην 9η φάση το τεμάχιο τοποθετείται με διαφορετική κατεύθυνση αλλάζοντας το σύστημα συντεταγμένων και γίνεται πάλι η κατεργασία φραιζαρίσματος για την πλαϊνή εσοχή βάθους 18mm με κοπτικό εργαλείο διαμέτρου 6mm. Το βάθος κοπής είναι 3mm, ενώ χρησιμοποιείται το 50% της συνολικής διαμέτρου για κάθε πέρασμα κοπής. **Συνολικός χρόνος κοπής:** 2:32 min **Συνθήκες κοπής:** **Εκχόνδρυνση** n=4000rpm, πρόωση f=240mm/min **Φινίρισμα** n=1200rpm, πρόωση f=240mm/min
	Εργαλεία που χρησιμοποιήθηκαν: Ονομασία στον κώδικα: MILL6 Περιγραφή: Slot EndMill 1805931 F3AA0600AWS45 K600 Εταιρεία: Kennametal Γεωμετρία: Φ6

Σχήμα 3.20: Τελικό τεμάχιο 10

5.　Σύνοψη

Εν κατακλείδι, στόχος της παρούσας διπλωματικής εργασίας ήταν η κατασκευή 10 πολύπλοκων τεμαχίων σε εργαλειομηχανή ψηφιακής καθοδήγησης καθώς και η εξοικίωση του χρήστη με τις κατεργασίες και τον προγραμμτισμό αυτής. Για την επίτευξη αυτού, χρησιοποιήθηκε λογισμικό CAD/CAM, και λογισμικό προσομοίωσης ούτως ώστε σε πρώτο επίπεδο να διερευνηθεί ο τρόπος με τον οποίο λειτουργεί η μηχανή καθώς και πως εκτελεί τις διάφορες διεργασίες. Σε δεύτερο επίπεδο, μελετήθηκαν οι συνθήκες κοπείς διάφορων υλικλων και πραγματοποιήθηκαν πειραματικές κοπές. Μέσα απο αυτή την διαδικασία αποκτήθηκε εμπειρία πάνω στην εκπόνηση διαφόρων κατεργασιών.

Έπειτα, σχεδιάστηκαν τα τεμάχια σε τρισδιάστατη μορφή και γράφτηκε ο κώδικάς τους με την χρήση του αντίστοιχου λογισμικού. Ήταν αναγκαίο να προσαρμοστούν οι κώδικες ώστε να τους διαβάζει σωστά η μηχανή διότι υπήρχαν κάποιες μικρές διαφορές. Στην συνέχεια, με την βοήθεια του προσομοιωτή της μηχανής ελέγχθηκαν εκ νέου οι κώδικες και εκτελέσθηκαν με τελικό στόχο την δημιουργία των δοκιμίων. Τέλος, χρησιμοποιήθηκε διαφορετικό λογισμικό CAD/CAM για την δημιουργία των μηχανολογικών σχεδίων.

Κατά την εκπόνηση της εργασίας διαπιστώθηκε απαραίτητη η γνώση ενός γενικού πλαισίου όπως είναι τα χαρακτηριστικά των τεμαχίων, της κατεργασιμότητας των υλικών καθώς και των εργαλείων που θα χρησιμοποιούνταν.

Άλλη μία διαπίστωση ήταν ότι το λογισμικό πρόγραμμα CAD/CAM παρουσιάζει διαφορές στην σειρά που ακολουθεί μια κατεργασία. Έτσι, πρέπει να επιλεχθεί η βέλτιστη διαδρομή για την δημιουργία του κάθε δοκιμίου με την επιλογή των κατάλληλων παραμέτρων, ώστε να έχει μία πολύ καλή επιφάνεια με τις μικρότερες δυνατές φθορές για τα εργαλεία και για την μηχανή.

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Παράρτημα

Κώδικες τεμαχίων με χρήση λογισμικού CAD/CAM

Στο παράρτημα αυτό παρουσιάζονται οι κώδικες που προέκυψαν από το λογισμικό CAD/CAM για τα τεμάχια που αναλύθηκαν στο κεφάλαιο 3.

Τεμάχιο 1

Κώδικας 1

N0020 G54 G71 G17 G90
N0030 T="MILL6" M06
N0040 G00 G90 X30.0816 Y63.1589
S4000 M03
N0060 Z.7
N0070 G01 Z-2.3 F240. M08
N0080 X30.0996 Y60.1252
N0090 X30.1 Y41.0998
N0100 X30.16 Y41.0994
N0110 X33.16 Y41.0766
N0120 Z.7
N0130 G00 Z10.1
N0140 X27.0728 Y63.16
N0150 Z.7
N0160 G01 Z-2.3
N0170 X27.0993 Y60.16
N0180 G02 X27.1 Y60. I-18.0993 J-.16
N0190 G01 Y38.1
N0200 X30.16 Y38.0993
N0210 X33.16 Y38.0728
N0220 Z.7
N0230 G00 Z10.1
N0240 X24.0674 Y63.16
N0250 Z.7
N0260 G01 Z-2.3
N0270 X24.0992 Y60.16
N0280 G02 X24.1 Y60. I-15.0992 J-.16
N0290 G01 Y35.1
N0300 X30.
N0310 G02 X30.16 Y35.0992 I0.0 J-15.1
N0320 G01 X33.16 Y35.0674
N0330 Z.7
N0340 G00 Z10.1
N0350 X21.0593 Y63.16
N0360 Z.7
N0370 G01 Z-2.3
N0380 X21.0989 Y60.16
N0390 G02 X21.1 Y60. I-12.0989 J-.16
N0400 G01 Y32.1
N0410 X30.
N0420 G02 X30.16 Y32.0989 I0.0 J-12.1
N0430 G01 X33.16 Y32.0593
N0440 Z.7

N0450 G00 Z10.1N1340 X15.0979 Y60.16
N0460 X18.0458 Y63.16
N0470 Z.7
N0480 G01 Z-2.3
N0490 X18.0986 Y60.16
N0500 G02 X18.1 Y60. I-9.0986 J-.16
N0510 G01 Y29.1
N0520 X30.
N0530 G02 X30.16 Y29.0986 I0.0 J-9.1
N0540 G01 X33.16 Y29.0458
N0550 Z.7
N0560 G00 Z10.1
N0570 X15.0192 Y63.16
N0580 Z.7
N0590 G01 Z-2.3
N0600 X15.0979 Y60.16
N0610 G02 X15.1 Y60. I-6.0979 J-.16
N0620 G01 Y26.1
N0630 X30.
N0640 G02 X30.16 Y26.0979 I0.0 J-6.1
N0650 G01 X33.16 Y26.0192
N0660 Z.7
N0670 G00 Z10.1
N0680 X11.8051 Y65.9115
N0690 Z.7
N0700 G01 Z-2.3
N0710 X12.096 Y60.1565
N0720 G02 X12.1 Y60. I-3.096 J-.1565
N0730 G01 Y23.1
N0740 X30.
N0750 G02 X30.1565 Y23.096 I0.0 J-3.1
N0760 G01 X35.9108 Y22.8052
N0770 Z.7
N0780 G00 Z10.1
N0790 X30.0816 Y63.1589
N0800 Z-1.6
N0810 G01 Z-4.6
N0820 X30.0996 Y60.1252
N0830 X30.1 Y41.0998
N0840 X30.16 Y41.0994
N0850 X33.16 Y41.0766
N0860 Z-1.6
N0870 G00 Z10.1

N0880 X27.0728 Y63.16
N0890 Z-1.6
N0900 G01 Z-4.6
N0910 X27.0993 Y60.16
N0920 G02 X27.1 Y60. I-18.0993 J-.16
N0930 G01 Y38.1
N0940 X30.16 Y38.0993
N0950 X33.16 Y38.0728
N0960 Z-1.6
N0970 G00 Z10.1
N0980 X24.0674 Y63.16
N0990 Z-1.6
N1000 G01 Z-4.6
N1010 X24.0992 Y60.16
N1020 G02 X24.1 Y60. I-15.0992 J-.16
N1030 G01 Y35.1
N1040 X30.
N1050 G02 X30.16 Y35.0992 I0.0 J-15.1
N1060 G01 X33.16 Y35.0674
N1070 Z-1.6
N1080 G00 Z10.1
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N1100 Z-1.6
N1110 G01 Z-4.6
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N1140 G01 Y32.1
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N1180 Z-1.6
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N1210 Z-1.6
N1220 G01 Z-4.6
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N1240 G02 X18.1 Y60. I-9.0986 J-.16
N1250 G01 Y29.1
N1260 X30.
N1270 G02 X30.16 Y29.0986 I0.0 J-9.1
N1280 G01 X33.16 Y29.0458
N1290 Z-1.6
N1300 G00 Z10.1

N1310 X15.0192 Y63.16

N1320 Z-1.6

N1330 G01 Z-4.6

N1350 G02 X15.1 Y60. I-6.0979 J-.16

N1360 G01 Y26.1

N1370 X30.

N1380 G02 X30.16 Y26.0979 I0.0 J-6.1

N1390 G01 X33.16 Y26.0192

N1400 Z-1.6

N1410 G00 Z10.1

N1420 X11.8051 Y65.9122

N1430 Z-1.6

N1440 G01 Z-4.6

N1450 X12.096 Y60.1565

N1460 G02 X12.1 Y60. I-3.096 J-.1565

N1470 G01 Y23.1

N1480 X30.

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N1500 G01 X35.9114 Y22.8051

N1510 Z-1.6

N1520 G00 Z10.1

N1530 X30.0816 Y63.1589

N1540 Z-3.9

N1550 G01 Z-6.9

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N1580 X30.16 Y41.0994

N1590 X33.16 Y41.0766

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N1610 G00 Z10.1

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N1630 Z-3.9

N1640 G01 Z-6.9

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N1660 G02 X27.1 Y60. I-18.0993 J-.16

N1670 G01 Y38.1

N1680 X30.16 Y38.0993

N1690 X33.16 Y38.0728

N1700 Z-3.9

N1710 G00 Z10.1

N1720 X24.0674 Y63.16

N1730 Z-3.9

N1740 G01 Z-6.9

N1750 X24.0992 Y60.16

N1760 G02 X24.1 Y60. I-15.0992 J-.16

N1770 G01 Y35.1

N1780 X30.

N1790 G02 X30.16 Y35.0992 I0.0 J-15.1

N1800 G01 X33.16 Y35.0674

N1810 Z-3.9

N1820 G00 Z10.1

N1830 X21.0593 Y63.16

N1840 Z-3.9

N1850 G01 Z-6.9

N1860 X21.0989 Y60.16

N1870 G02 X21.1 Y60. I-12.0989 J-.16

N1880 G01 Y32.1

N1890 X30.

N1900 G02 X30.16 Y32.0989 I0.0 J-12.1

N1910 G01 X33.16 Y32.0593

N1920 Z-3.9

N1930 G00 Z10.1

N1940 X18.0458 Y63.16

N1950 Z-3.9

N1960 G01 Z-6.9

N1970 X18.0986 Y60.16

N1980 G02 X18.1 Y60. I-9.0986 J-.16

N1990 G01 Y29.1

N2000 X30.

N2010 G02 X30.16 Y29.0986 I0.0 J-9.1

N2020 G01 X33.16 Y29.0458

N2030 Z-3.9

N2040 G00 Z10.1

N2050 X15.0192 Y63.16

N2060 Z-3.9

N2070 G01 Z-6.9

N2080 X15.0979 Y60.16

N2090 G02 X15.1 Y60. I-6.0979 J-.16

N2100 G01 Y26.1

N2110 X30.

N2120 G02 X30.16 Y26.0979 I0.0 J-6.1

N2130 G01 X33.16 Y26.0192

N2140 Z-3.9

N2150 G00 Z10.1

N2160 X11.8051 Y65.9128

N2170 Z-3.9

N2180 G01 Z-6.9

N2190 X12.096 Y60.1565

N2200 G02 X12.1 Y60. I-3.096 J-.1565

N2210 G01 Y23.1

N2220 X30.

N2230 G02 X30.1565 Y23.096 I0.0 J-3.1

N2240 G01 X35.9121 Y22.8051

N2250 Z-3.9

N2260 G00 Z10.1

N2270 G00 X11.8955 Y65.2551 S4000 M03

N2280 Z10.

N2290 Z.6667

N2300 G01 Z-2.3333 F240.

N2310 X11.9994 Y60.06

N2320 X12. Y23.

N2330 X30.0587 Y22.9994

N2340 X35.2538 Y22.8978

N2350 Z.6667

N2360 G00 Z10.

N2370 X11.8955 Y65.2551

N2380 Z-1.6667

N2390 G01 Z-4.6667

N2400 X11.9994 Y60.06

N2410 X12. Y23.

N2420 X30.0587 Y22.9994

N2430 X35.2538 Y22.8978

N2440 Z-1.6667

N2450 G00 Z10.

N2460 X29.9987 Y63.06

N2470 Z-4.

N2480 G01 Z-7.

N2490 X29.9988 Y60.06

N2500 X29.9995 Y41.0005

N2510 X30.06 Y41.0006

N2520 X33.06 Y41.0004

N2530 Z-4.

N2540 G00 Z10.

N2550 X26.9987 Y63.06

N2560 Z-4.

N2570 G01 Z-7.

N2580 X26.9988 Y60.06

N2590 X26.9996 Y38.

N2600 X30.06 Y38.0006

N2610 X33.06 Y38.0003

N2620 Z-4.

N2630 G00 Z10.

N2640 X23.9987 Y63.06

N2650 Z-4.

N2660 G01 Z-7.

N2670 X23.9988 Y60.06

N2680 X23.9997 Y35.

N2690 X29.9413

N2700 G02 X30.06 Y35.0006 I.1174 J-11.9994

N2710 G01 X33.06 Y35.0003

N2720 Z-4.

N2730 G00 Z10.

N2740 X20.9987 Y63.06

N2750 Z-4.

N2760 G01 Z-7.

N2770 X20.9988 Y60.06

N2780 X20.9998 Y32.

N2790 X29.957

N2800 G02 X30.06 Y32.0006 I.1017 J-8.9994

N2810 G01 X33.06 Y32.0001

N2820 Z-4.

N2830 G00 Z10.

N2840 X17.9987 Y63.06

N2850 Z-4.

N2860 G01 Z-7.

N2870 X17.9988 Y60.06

N2880 X17.9999 Y29.

N2890 X30.06 Y29.0006

N2900 X33.06 Y28.9999

N2910 Z-4.

N2920 G00 Z10.

N2930 X14.9987 Y63.06

N2940 Z-4.

N2950 G01 Z-7.

N2960 X14.9988 Y60.06

N2970 X15. Y26.

N2980 X30.06 Y26.0006

N2990 X33.06 Y25.9993

N3000 Z-4.

N3010 G00 Z10.

N3020 X11.8955 Y65.2551

N3030 Z-4.

N3040 G01 Z-7.

N3050 X11.9994 Y60.06

N3060 X12. Y23.

N3070 X30.0587 Y22.9994

N3080 X35.2538 Y22.8978

N3090 Z-4.

N3100 G00 Z10.

N3110 M02

Κώδικας 2

N0020 G54 G71 G17 G90

N0030 T="DRILL67" M06

N0040 G00 G90 X15. Y10. S1300 M03

N0060 Z3.

N0070 G01 Z-5.8782 F30.5 M08

N0080 G04 P1.

N0090 G00 Z3.

N0100 Z-5.8782

N0110 G01 Z-11.7564 F61.

N0120 G00 Z3.

N0130 Z-11.7564

N0140 G01 Z-17.6347

N0150 G00 Z3.

N0160 Z-17.6347

N0170 G01 Z-23.5129

N0180 Z3.

N0190 G00 Z10.

N0210 T="MILL6" M06

N0220 G00 G90 X15. Y10. S4000 M03

N0230 Z10

N0240 G01 Z-2.75

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N0260 X14.017 Y9.6908 I0.0 J-1.0626

N0270 X14.2623 Y8.5521 I.952 J-.3907

N0280 X17.1196 Y8.6084 I1.4 J1.4818

N0290 X17.3461 Y11.7046 I-1.7196 J1.6822

N0300 I-2.3461 J-1.7046

N0310 X15. Y10. I-1.1731 J-.8523

N0320 G01 Z-8.5

N0330 G03 Y10.35 I0.0 J.175

N0340 X14.017 Y9.6908 I0.0 J-1.0626

N0350 X14.2623 Y8.5521 I.952 J-.3907

N0360 X17.1196 Y8.6084 I1.4 J1.4818

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N0380 I-2.3461 J-1.7046

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N0400 G01 Z-14.25

N0410 G03 Y10.35 I0.0 J.175

N0420 X14.017 Y9.6908 I0.0 J-1.0626

N0430 X14.2623 Y8.5521 I.952 J-.3907

N0440 X17.1196 Y8.6084 I1.4 J1.4818

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N0460 I-2.3461 J-1.7046

N0470 X15. Y10. I-1.1731 J-.8523

N0480 G01 Z-20.

N0490 G03 Y10.35 I0.0 J.175

N0500 X14.017 Y9.6908 I0.0 J-1.0626

N0510 X14.2623 Y8.5521 I.952 J-.3907

N0520 X17.1196 Y8.6084 I1.4 J1.4818

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N0550 X15. Y10. I-1.1731 J-.8523

N0560 G01 Z10.

N0570 G00 X15. Y10. S4000 M03

N0580 Z10.

N0590 G01 Z-2.75

N0600 G03 Y12.9 I0.0 J1.45 F240.

N0610 X12.8637 Y12.0363 I0.0 J-3.0737

N0620 X12. Y10. I1.9684 J-2.0363

N0630 I3. J0.0

N0640 X15. I1.5 J0.0

N0650 G01 Z-8.5

N0660 G03 Y12.9 I0.0 J1.45

N0670 X12.8637 Y12.0363 I0.0 J-3.0737

N0680 X12. Y10. I1.9684 J-2.0363

N0690 I3. J0.0

N0700 X15. I1.5 J0.0

N0710 G01 Z-14.25

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N0730 X12.8637 Y12.0363 I0.0 J-3.0737

N0740 X12. Y10. I1.9684 J-2.0363

N0750 I3. J0.0

N0760 X15. I1.5 J0.0

N0770 G01 Z-20.

N0780 G03 Y12.9 I0.0 J1.45

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N0800 X12. Y10. I1.9684 J-2.0363

N0810 I3. J0.0

N0820 X15. I1.5 J0.0

N0830 G01 Z10.

N0840 M02

Τεμάχιο 2

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N0020 G71 G54 G17 G90
N0030 T="DRILL67" M06
N0040 G00 G90 X11.5 Y30. S800 M03
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N0080 G00 Z3.
N0090 Z-6.671
N0100 G01 Z-13.3419 F61.
N0110 G00 Z3.
N0120 Z-13.3419
N0130 G01 Z-20.0129
N0140 G00 Z3.
N0150 Z10.
N0170 T="DRILL9" M06
N0180 G00 G90 X11.5 Y30. S600 M03
N0200 Z3.
N0210 G01 Z-6.9013 F36.
N0220 G00 Z3.
N0230 Z-6.9013
N0240 G01 Z-13.8026 F72.
N0250 G00 Z3.
N0260 Z-13.8026
N0270 G01 Z-20.7039
N0280 G00 Z3.
N0290 Z10.
N0310 T="MILL6" M06
N0320 G00 G90 X9.7612 Y30.6765 S4000
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N0380 X12.6777 Y29.9155 Z2.5333
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N0930 X9.7612 Y30.6765
N0940 Z.1667
N0950 G01 X9.658 Y29.3542 Z.05
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N1080 X9.7856 Y30.8767 Z-1.4667
N1090 X9.5909 Y29.5319 Z-1.5833
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N1340 X12.4594 Y30.8052 Z-4.5
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N1370 X9.5229 Y29.905 Z-4.85
N1380 X10.1799 Y28.7156 Z-4.9667
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N1400 X12.5463 Y29.3638 Z-5.2
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N1440 X9.6 Y30. Z-5.6667
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N1460 X13.4
N1470 Y46.9
N1480 X9.6

N1490 Y30.

N1500 X12.6

N1510 Z-2.6667

N1520 G00 Z10.1

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N1540 Z-2.6667

N1550 G01 X9.658 Y29.3542 Z-2.7833

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N1680 X9.7856 Y30.8767 Z-4.3

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N1940 X12.4594 Y30.8052 Z-7.3333

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N1970 X9.5229 Y29.905 Z-7.6833

N1980 X10.1799 Y28.7156 Z-7.8

N1990 X11.5174 Y28.4761 Z-7.9167

N2000 X12.5463 Y29.3638 Z-8.0333

N2010 X12.5054 Y30.722 Z-8.15

N2020 X11.4251 Y31.5462 Z-8.2667

N2030 X10.1043 Y31.2268 Z-8.3833

N2040 X9.6 Y30. Z-8.5

N2050 Y13.1

N2060 X13.4

N2070 Y46.9

N2080 X9.6

N2090 Y30.

N2100 X12.6

N2110 Z-5.5

N2120 G00 Z10.1

N2130 X9.7612 Y30.6765

N2140 Z-5.5

N2150 G01 X9.658 Y29.3542 Z-5.6167

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N2390 X12.637 Y29.6337 Z-8.4167

N2400 X12.353 Y30.9625 Z-8.5333

N2410 X11.1422 Y31.5794 Z-8.65

N2420 X9.9003 Y31.0281 Z-8.7667

N2430 X9.5457 Y29.7164 Z-8.8833

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N2630 X10.1043 Y31.2268 Z-11.2167

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N2660 X13.4

N2670 Y46.9

N2680 X9.6

N2690 Y30.

N2700 X12.6

N2710 Z-8.3333

N2720 G00 Z10.1

N2730 X9.7612 Y30.6765

N2740 Z-8.3333

N2750 G01 X9.658 Y29.3542 Z-8.45

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N1640 G01 Y30.9735

N1650 X-.1565 Y30.096

N1660 G02 X0.0 Y30.1 I.1565 J-3.096

N1670 G01 X5.

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N1740 G00 Z10.1

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N1770 G01 Z-6.9

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N2340 X16.9033

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N2370 G02 X16.9148 Y22.8 I-.0013 J7.2

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N2580 X10.3989 Y-3.06

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N2630 G01 Z-7.

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N2660 X.0967

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N2830 G01 X.043

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N2940 Y29.7027

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N2970 G02 X9. Y33. I0.0 J3.

104

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N3060 X9.2 Y27.
N3070 G03 X5. Y31.2 I-4.2 J0.0
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N3110 X5. Y30.

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N3160 G00 Z10.
N3170 M02

Τεμάχιο 3

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N0140 G00 Z-.8876
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N0190 M09
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N0370 M09
N0380 G00 Z3.
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N1790 X16.9006 Y20.2977 I4.3583 J1.4383
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N0090 X17.0477
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N0140 Z.1243
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N0170 X-.042
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N0130 M05
N0140 M09
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N0280 X7.9172 Y14.2425 Z1.075
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Τεμάχιο 4

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N0710 G01 Z-14.1667
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N0730 X17.0418
N0740 X22.9588 Y13.52
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N0760 G00 Z10.1
N0770 X22.9599 Y16.4767
N0780 Z-11.1667
N0790 G01 Z-14.1667
N0800 X17.04 Y16.4003
N0810 X-.0399
N0820 X-5.9626 Y16.4764
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N0840 G00 Z10.1
N0850 X22.9603 Y16.4767

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N1050 X-.0125 Y13.5
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N1070 X22.3686 Y13.4776
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N1120 G01 Z-2.8333
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N1140 X-.0125
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N1190 Z-2.6667
N1200 G01 Z-5.6667
N1210 X17.0125 Y16.5
N1220 X-.0125
N1230 X-5.3818 Y16.5224
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N1250 G00 Z10.
N1260 X-5.369 Y13.4776
N1270 Z-2.6667

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N1320 Z-2.6667
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N1340 X-5.3696
N1350 Z-5.5
N1360 G01 Z-8.5
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N1380 X17.0125
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N1430 Z-5.5
N1440 G01 Z-8.5
N1450 X17.0125 Y16.5
N1460 X-.0125
N1470 X-5.3823 Y16.5224
N1480 Z-5.5
N1490 G00 Z10.
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N1510 Z-8.3333

N1520 G01 Z-11.3333
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N1540 X-.0125
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N1670 Z-11.1667
N1680 G01 Z-14.1667
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N1700 X17.0125
N1710 X22.3708 Y13.4776
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N1730 G00 Z10.
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N1760 G01 Z-14.1667
N1770 X17.0125 Y16.5
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N1800 Z-11.1667
N1810 G00 Z10.
N1820 X22.384
N1830 Z-14.
N1840 G01 Z-17.
N1850 X17.0125 Y16.5
N1860 X-.0125
N1870 X-5.384 Y16.5224
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N1890 G00 Z10.
N1900 X-5.3713 Y13.4776
N1910 Z-14.
N1920 G01 Z-17.
N1930 X-.0125 Y13.5
N1940 X17.0125
N1950 X22.3714 Y13.4776
N1960 Z-14.
N1970 G00 Z10.
N1980 M02

Κώδικας 3

 N0020 G54 G17 G71 G90
N0030 T="MILL6" M06
N0040 G00 G90 X9.3868 Y-5.889 S4000 M03
N0060 Z.15
N0070 G01 Z-2.85 F240. M08
N0080 X8.911 Y-.2611
N0090 G02 X8.9 Y0.0 I3.089 J.2611
N0100 G01 Y30.
N0110 G02 X8.911 Y30.2611 I3.1 J0.0
N0120 G01 X8.446 Y30.1629
N0130 X8.0921 Y30.2207
N0140 G02 X8.1 Y30. I-3.0921 J-.2207
N0150 G01 Y0.0
N0160 G02 X8.0921 Y-.2207 I-3.1 J0.0
N0170 G01 X7.6871 Y-5.8954
N0180 Z.15
N0190 G00 Z10.1
N0200 X9.3868 Y-5.8893
N0210 Z-2.7
N0220 G01 Z-5.7
N0230 X8.911 Y-.2611
N0240 G02 X8.9 Y0.0 I3.089 J.2611
N0250 G01 Y30.

N0260 G02 X8.911 Y30.2611 I3.1 J0.0
N0270 G01 X8.446 Y30.1629
N0280 X8.0921 Y30.2207
N0290 G02 X8.1 Y30. I-3.0921 J-.2207
N0300 G01 Y0.0
N0310 G02 X8.0921 Y-.2207 I-3.1 J0.0
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N0330 Z-2.7
N0340 G00 Z10.1
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N0360 Z-5.55
N0370 G01 Z-8.55
N0380 X8.911 Y-.2611
N0390 G02 X8.9 Y0.0 I3.089 J.2611
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N0410 G02 X8.911 Y30.2611 I3.1 J0.0
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N0520 G01 Z-11.4
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N0540 G02 X8.9 Y0.0 I3.089 J.2611
N0550 G01 Y30.
N0560 G02 X8.911 Y30.2611 I3.1 J0.0
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N0580 X8.0921 Y30.2207
N0590 G02 X8.1 Y30. I-3.0921 J-.2207
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N0610 G02 X8.0921 Y-.2207 I-3.1 J0.0
N0620 G01 X7.687 Y-5.8964
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N0640 G00 Z10.1
N0650 G00 X9.1599 Y-5.3773 S4000 M03
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N0680 G01 Z-2.875 F240.
N0690 X9.0013 Y-.0899
N0700 G02 X9. Y0.0 I2.9987 J.0899
N0710 G01 Y30.
N0720 G02 X9.0013 Y30.0899 I3. J0.0
N0730 G01 X8.5 Y30.0601

N0740 X7.9987 Y30.0899

N0750 G02 X8. Y30. I-2.9987 J-.0899

N0760 G01 Y0.0

N0770 G02 X7.9987 Y-.0899 I-3. J0.0

N0780 G01 X7.8401 Y-5.3773

N0790 Z.125

N0800 G00 Z10.

N0810 X9.16 Y-5.3778

N0820 Z-2.75

N0830 G01 Z-5.75

N0840 X9.0013 Y-.0899

N0850 G02 X9. Y0.0 I2.9987 J.0899

N0860 G01 Y30.

N0870 G02 X9.0013 Y30.0899 I3. J0.0

N0880 G01 X8.5 Y30.0601

N0890 X7.9987 Y30.0899

N0900 G02 X8. Y30. I-2.9987 J-.0899

N0910 G01 Y0.0

N0920 G02 X7.9987 Y-.0899 I-3. J0.0

N0930 G01 X7.84 Y-5.3778

N0940 Z-2.75

N0950 G00 Z10.

N0960 X9.16 Y-5.3783

N0970 Z-5.625

N0980 G01 Z-8.625

N0990 X9.0013 Y-.0899

N1000 G02 X9. Y0.0 I2.9987 J.0899

N1010 G01 Y30.

N1020 G02 X9.0013 Y30.0899 I3. J0.0

N1030 G01 X8.5 Y30.0601

N1040 X7.9987 Y30.0899

N1050 G02 X8. Y30. I-2.9987 J-.0899

N1060 G01 Y0.0

N1070 G02 X7.9987 Y-.0899 I-3. J0.0

N1080 G01 X7.84 Y-5.3783

N1090 Z-5.625

N1100 G00 Z10.

N1110 X9.16 Y-5.3788

N1120 Z-8.5

N1130 G01 Z-11.5

N1140 X9.0013 Y-.0899

N1150 G02 X9. Y0.0 I2.9987 J.0899

N1160 G01 Y30.

N1170 G02 X9.0013 Y30.0899 I3. J0.0

N1180 G01 X8.5 Y30.0601

N1190 X7.9987 Y30.0899

N1200 G02 X8. Y30. I-2.9987 J-.0899

N1210 G01 Y0.0

N1220 G02 X7.9987 Y-.0899 I-3. J0.0

N1230 G01 X7.84 Y-5.3788

N1240 Z-8.5

N1250 G00 Z10.

N1260 M02

Τεμάχιο 5

Κώδικας 1

N0020 G71 G17 G54 G90

N0030 T="DRILL67" M06

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N0060 Z3.

N0070 S800 M03

N0080 G01 Z-5.3629 F30.5 M08

N0100 G00 Z4.6371

N0110 G01 Z-13.65 F61.

N0120 G00 Z-3.65

N0130 G01 Z-21.5129 F30.5

N0140 M05

N0150 M09

N0160 G00 Z3.

N0170 Z10.

N0190 T="DRILL9" M06

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N0230 S600 M03

N0240 G01 Z-7.2039 F36. M08

N0260 G00 Z2.7961

N0270 G01 Z-12.5 F72.

N0280 G00 Z-2.5

N0290 G01 Z-22.2039 F36.

N0300 M05

N0310 M09

N0320 G00 Z3.

N0330 Z10.

N0350 T="MILL6" M06

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N0380 Z3.

N0390 G01 X15.0008 Y23.6136 F240. M08

N0400 X15.0015 Y23.6144

N0410 X14.9985 Y23.616 Z2.4444

N0420 X14.9999 Y23.6121 Z1.8889

N0430 X15.0017 Y23.6158 Z1.3333

N0440 X14.9978 Y23.6146 Z.7778

N0450 X15.0013 Y23.6126 Z.2222

N0460 X15.0003 Y23.6159 Z-.3333

N0470 G03 X14.2622 Y23.369 I-.1416 J-.8032

N0480 X14.1631 Y22.7183 I.4266 J-.3979

N0490 X15.7402 Y21.9822 I1.2382 J.5953

N0500 X17.3789 Y24.2035 I-.5375 J2.1116

N0510 X15.2944 Y26.6416 I-2.6226 J-.1322

N0520 X11.5277 Y24.8191 I-.702 J-3.3529

N0530 X12.6678 Y19.7559 I3.6712 J-1.8333

N0540 X18.0046 Y19.7437 I2.6763 J3.4152

N0550 I-3.0046 J3.8707

N0560 X15. Y23.6144 I-1.5023 J1.9354

N0570 G01 X15.0008 Y23.6136

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N0680 X17.3789 Y24.2035 I-.5375 J2.1116

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N0700 X11.5277 Y24.8191 I-.702 J-3.3529

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N0730 I-3.0046 J3.8707

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N0790 X15.0017 Y23.6158 Z-5.3333

N0800 X14.9978 Y23.6146 Z-5.8889

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N0820 X15.0003 Y23.6159 Z-7.

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N0840 X14.1631 Y22.7183 I.4266 J-.3979

N0850 X15.7402 Y21.9822 I1.2382 J.5953

N0860 X17.3789 Y24.2035 I-.5375 J2.1116

N0870 X15.2944 Y26.6416 I-2.6226 J-.1322

N0880 X11.5277 Y24.8191 I-.702 J-3.3529

N0890 X12.6678 Y19.7559 I3.6712 J-1.8333

N0900 X18.0046 Y19.7437 I2.6763 J3.4152

N0910 I-3.0046 J3.8707

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N1040 X17.3789 Y24.2035 I-.5375 J2.1116

N1050 X15.2944 Y26.6416 I-2.6226 J-.1322

N1060 X11.5277 Y24.8191 I-.702 J-3.3529

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N1080 X18.0046 Y19.7437 I2.6763 J3.4152

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N1100 X15. Y23.6144 I-1.5023 J1.9354

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N1190 G03 X14.2622 Y23.369 I-.1416 J-.8032

N1200 X14.1631 Y22.7183 I.4266 J-.3979

N1210 X15.7402 Y21.9822 I1.2382 J.5953

N1220 X17.3789 Y24.2035 I-.5375 J2.1116

N1230 X15.2944 Y26.6416 I-2.6226 J-.1322

N1240 X11.5277 Y24.8191 I-.702 J-3.3529

N1250 X12.6678 Y19.7559 I3.6712 J-1.8333

N1260 X18.0046 Y19.7437 I2.6763 J3.4152

N1270 I-3.0046 J3.8707

N1280 X15. Y23.6144 I-1.5023 J1.9354

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N1400 X17.3789 Y24.2035 I-.5375 J2.1116

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N1420 X11.5277 Y24.8191 I-.702 J-3.3529

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N1440 X18.0046 Y19.7437 I2.6763 J3.4152

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N1500 Z3.

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N1580 X15.0003 Y23.6159 Z-.3333

N1590 G03 X14.2612 Y23.3469 I-.1366 J-.7747

N1600 X14.195 Y22.6566 I.4684 J-.3932

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N1620 X17.3513 Y24.466 I-.7274 J2.1025

N1630 X14.8972 Y26.7164 I-2.6479 J-.4242

N1640 X11.3081 Y24.2743 I-.2527 J-3.4871

N1650 X13.3785 Y19.3076 I3.9927 J-1.2505

N1660 X18.8201 Y20.3884 I2.0435 J3.9504

N1670 I-3.8201 J3.226

N1680 X15. Y23.6144 I-1.9101 J1.613

N1690 G01 X15.0008 Y23.6136

N1700 X15.0015 Y23.6144

N1710 X14.9985 Y23.616 Z-.8889

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N1730 X15.0017 Y23.6158 Z-2.

N1740 X14.9978 Y23.6146 Z-2.5556

N1750 X15.0013 Y23.6126 Z-3.1111

N1760 X15.0003 Y23.6159 Z-3.6667

N1770 G03 X14.2612 Y23.3469 I-.1366 J-.7747

N1780 X14.195 Y22.6566 I.4684 J-.3932

N1790 X15.8819 Y22.0116 I1.2276 J.6824

N1800 X17.3513 Y24.466 I-.7274 J2.1025

N1810 X14.8972 Y26.7164 I-2.6479 J-.4242

N1820 X11.3081 Y24.2743 I-.2527 J-3.4871

N1830 X13.3785 Y19.3076 I3.9927 J-1.2505

N1840 X18.8201 Y20.3884 I2.0435 J3.9504

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N2040 X15. Y23.6144 I-1.9101 J1.613

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N2060 X15.0015 Y23.6144

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N2080 X14.9999 Y23.6121 Z-8.1111

N2090 X15.0017 Y23.6158 Z-8.6667

N2100 X14.9978 Y23.6146 Z-9.2222

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N2130 G03 X14.2612 Y23.3469 I-.1366 J-.7747

N2140 X14.195 Y22.6566 I.4684 J-.3932

N2150 X15.8819 Y22.0116 I1.2276 J.6824

N2160 X17.3513 Y24.466 I-.7274 J2.1025

N2170 X14.8972 Y26.7164 I-2.6479 J-.4242

N2180 X11.3081 Y24.2743 I-.2527 J-3.4871

N2190 X13.3785 Y19.3076 I3.9927 J-1.2505

N2200   X18.8201   Y20.3884   I2.0435   J3.9504
N2210 I-3.8201 J3.226
N2220 X15. Y23.6144 I-1.9101 J1.613
N2230 G01 X15.0008 Y23.6136
N2240 X15.0015 Y23.6144
N2250 X14.9985 Y23.616 Z-10.8889
N2260 X14.9999 Y23.6121 Z-11.4444
N2270 X15.0017 Y23.6158 Z-12.
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N2300 X15.0003 Y23.6159 Z-13.6667
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N2390 I-3.8201 J3.226
N2400 X15. Y23.6144 I-1.9101 J1.613
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N2450 X15.0017 Y23.6158 Z-15.3333
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N2470 X15.0013 Y23.6126 Z-16.4444

N2480 X15.0003 Y23.6159 Z-17.
N2490 G03 X14.2612 Y23.3469 I-.1366 J-.7747
N2500 X14.195 Y22.6566 I.4684 J-.3932
N2510 X15.8819 Y22.0116 I1.2276 J.6824
N2520 X17.3513 Y24.466 I-.7274 J2.1025
N2530 X14.8972 Y26.7164 I-2.6479 J-.4242
N2540 X11.3081 Y24.2743 I-.2527 J-3.4871
N2550 X13.3785 Y19.3076 I3.9927 J-1.2505
N2560 X18.8201 Y20.3884 I2.0435 J3.9504
N2570 I-3.8201 J3.226
N2580 X15. Y23.6144 I-1.9101 J1.613
N2590 G00 Z10.
N2600 M02

Κώδικας 2

N0020 G71 G17 G54 G90
N0030 T="CENTERDRILL4" M06
N0040 G00 G90 X8. Y33.7412 S1000 M03
N0060 G81 X8. Y33.7412 Z-.5032 R3. F37.
N0070 G80
N0090 T=DRILL67" M06
N0100 G00 G90 X8. Y33.7412 S800 M05
N0120 Z3.
N0130 S800 M03
N0140 G01 Z-5.3629 F30.5 M08
N0160 G00 Z4.6371

N0170 G01 Z-8.0238 F61.
N0180 G00 Z1.9762
N0190 G01 Z-10.6847
N0200 G00 Z-.6847
N0210 G01 Z-13.3456
N0220 G00 Z3.
N0230 Z-3.3456
N0240 G01 Z-16.0064
N0250 G00 Z-6.0064
N0260 G01 Z-18.6673
N0270 G00 Z-8.6673
N0280 G01 Z-21.3282

N0290 G00 Z-11.3282
N0300 G01 Z-23.9891
N0310 G00 Z3.
N0320 Z-13.9891
N0330 G01 Z-26.65
N0340 G00 Z-16.65
N0350 G01 Z-34.5129 F30.5
N0360 M05
N0370 M09
N0380 G00 Z3.
N0390 Z10.
N0400 M02

Κώδικας 3

N0020 G71 G17 G54 G90
N0030 T="MILL6" M06
N0040 G00 G90 X-5.9583 Y13.5234 S4000 M03
N0060 Z.1667
N0070 G01 Z-2.8333 F240. M08
N0080 X-.04 Y13.5997
N0090 X17.04
N0100 X22.9583 Y13.5234
N0110 Z.1667
N0120 G00 Z10.1
N0130 X22.96 Y16.4798
N0140 Z.1667
N0150 G01 Z-2.8333
N0160 X17.0416 Y16.4003
N0170 X-.0416
N0180 X-5.96 Y16.4798
N0190 Z.1667
N0200 G00 Z10.1

N0210 X22.9604
N0220 Z-2.6667
N0230 G01 Z-5.6667
N0240 X17.0416 Y16.4003
N0250 X-.0416
N0260 X-5.9604 Y16.4798
N0270 Z-2.6667
N0280 G00 Z10.1
N0290 X-5.9587 Y13.5234
N0300 Z-2.6667
N0310 G01 Z-5.6667
N0320 X-.04 Y13.5997
N0330 X17.04
N0340 X22.9587 Y13.5234
N0350 Z-2.6667
N0360 G00 Z10.1
N0370 X-5.9591
N0380 Z-5.5
N0390 G01 Z-8.5

N0400 X-.04 Y13.5997
N0410 X17.04
N0420 X22.9591 Y13.5233
N0430 Z-5.5
N0440 G00 Z10.1
N0450 X22.9608 Y16.4798
N0460 Z-5.5
N0470 G01 Z-8.5
N0480 X17.0416 Y16.4003
N0490 X-.0416
N0500 X-5.9608 Y16.4798
N0510 Z-5.5
N0520 G00 Z10.1
N0530 X22.9612
N0540 Z-8.3333
N0550 G01 Z-11.3333
N0560 X17.0416 Y16.4003
N0570 X-.0416
N0580 X-5.9612 Y16.4798

119

N0590 Z-8.3333

N0600 G00 Z10.1

N0610 X-5.9595 Y13.5233

N0620 Z-8.3333

N0630 G01 Z-11.3333

N0640 X-.04 Y13.5997

N0650 X17.04

N0660 X22.9595 Y13.5233

N0670 Z-8.3333

N0680 G00 Z10.1

N0690 X-5.9599

N0700 Z-11.1667

N0710 G01 Z-14.1667

N0720 X-.04 Y13.5997

N0730 X17.04

N0740 X22.9599 Y13.5233

N0750 Z-11.1667

N0760 G00 Z10.1

N0770 X22.9615 Y16.4798

N0780 Z-11.1667

N0790 G01 Z-14.1667

N0800 X17.0416 Y16.4003

N0810 X-.0416

N0820 X-5.9615 Y16.4798

N0830 Z-11.1667

N0840 G00 Z10.1

N0850 X22.9619

N0860 Z-14.

N0870 G01 Z-17.

N0880 X17.0416 Y16.4003

N0890 X-.0416

N0900 X-5.9619 Y16.4798

N0910 Z-14.

N0920 G00 Z10.1

N0930 X-5.9603 Y13.5233

N0940 Z-14.

N0950 G01 Z-17.

N0960 X-.04 Y13.5997

N0970 X17.04

N0980 X22.9603 Y13.5233

N0990 Z-14.

N1000 G00 Z10.1

N1010 G00 X-5.2086 Y13.4783 S4000 M03

N1020 Z10.

N1030 Z1.1111

N1040 G01 Z-1.8889 F240.

N1050 X-.0125 Y13.5

N1060 X17.0125

N1070 X22.2086 Y13.4783

N1080 Z1.1111

N1090 G00 Z10.

N1100 Y16.5217

N1110 Z1.1111

N1120 G01 Z-1.8889

N1130 X17.0125 Y16.5

N1140 X-.0125

N1150 X-5.2086 Y16.5217

N1160 Z1.1111

N1170 G00 Z10.

N1180 X22.2086

N1190 Z-.7778

N1200 G01 Z-3.7778

N1210 X17.0125 Y16.5

N1220 X-.0125

N1230 X-5.2086 Y16.5217

N1240 Z-.7778

N1250 G00 Z10.

N1260 Y13.4783

N1270 Z-.7778

N1280 G01 Z-3.7778

N1290 X-.0125 Y13.5

N1300 X17.0125

N1310 X22.2086 Y13.4783

N1320 Z-.7778

N1330 G00 Z10.

N1340 X-5.2086

N1350 Z-2.6667

N1360 G01 Z-5.6667

N1370 X-.0125 Y13.5

N1380 X17.0125

N1390 X22.2086 Y13.4783

N1400 Z-2.6667

N1410 G00 Z10.

N1420 Y16.5217

N1430 Z-2.6667

N1440 G01 Z-5.6667

N1450 X17.0125 Y16.5

N1460 X-.0125

N1470 X-5.2086 Y16.5217

N1480 Z-2.6667

N1490 G00 Z10.

N1500 X22.2086

N1510 Z-4.5556

N1520 G01 Z-7.5556

N1530 X17.0125 Y16.5

N1540 X-.0125

N1550 X-5.2086 Y16.5217

N1560 Z-4.5556

N1570 G00 Z10.

N1580 Y13.4783

N1590 Z-4.5556

N1600 G01 Z-7.5556

N1610 X-.0125 Y13.5

N1620 X17.0125

N1630 X22.2086 Y13.4783

N1640 Z-4.5556

N1650 G00 Z10.

N1660 X-5.2086

N1670 Z-6.4444

N1680 G01 Z-9.4444

N1690 X-.0125 Y13.5

N1700 X17.0125

N1710 X22.2086 Y13.4783

N1720 Z-6.4444

N1730 G00 Z10.

N1740 Y16.5217

N1750 Z-6.4444

N1760 G01 Z-9.4444

N1770 X17.0125 Y16.5

N1780 X-.0125

N1790 X-5.2086 Y16.5217

N1800 Z-6.4444

N1810 G00 Z10.

N1820 X22.2086

N1830 Z-8.3333

N1840 G01 Z-11.3333

N1850 X17.0125 Y16.5

N1860 X-.0125

N1870 X-5.2086 Y16.5217

N1880 Z-8.3333

N1890 G00 Z10.

N1900 Y13.4783

N1910 Z-8.3333

N1920 G01 Z-11.3333

N1930 X-.0125 Y13.5

N1940 X17.0125

N1950 X22.2086 Y13.4783

N1960 Z-8.3333

N1970 G00 Z10.

N1980 X-5.2086

N1990 Z-10.2222

N2000 G01 Z-13.2222

N2010 X-.0125 Y13.5

N2020 X17.0125

N2030 X22.2086 Y13.4783

N2040 Z-10.2222

N2050 G00 Z10.

N2060 Y16.5217

N2070 Z-10.2222

N2080 G01 Z-13.2222

N2090 X17.0125 Y16.5

N2100 X-.0125

N2110 X-5.2086 Y16.5217

N2120 Z-10.2222

N2130 G00 Z10.

N2140 X22.2086

N2150 Z-12.1111

N2160 G01 Z-15.1111

N2170 X17.0125 Y16.5

N2180 X-.0125

N2190 X-5.2086 Y16.5217

N2200 Z-12.1111

N2210 G00 Z10.

N2220 Y13.4783

N2230 Z-12.1111

N2240 G01 Z-15.1111

N2250 X-.0125 Y13.5

N2260 X17.0125

N2270 X22.2086 Y13.4783

N2280 Z-12.1111

N2290 G00 Z10.

N2300 X-5.2086

N2310 Z-14.

N2320 G01 Z-17.

N2330 X-.0125 Y13.5

N2340 X17.0125

N2350 X22.2086 Y13.4783

N2360 Z-14.

N2370 G00 Z10.

N2380 Y16.5217

N2390 Z-14.

N2400 G01 Z-17.

N2410 X17.0125 Y16.5

N2420 X-.0125

N2430 X-5.2086 Y16.5217

N2440 Z-14.

N2450 G00 Z10.

N2460 M02

Κώδικας 4

N0020 G71 G17 G54 G90

N0030 T="MILL6" M06

N0040 G00 G90 X22.9118 Y16.6949 S4000 M03

N0060 Z.05

N0070 G01 Z-2.95 F240. M08

N0080 X17.1565 Y16.404

N0090 G02 X17. Y16.4 I-.1565 J3.096

N0100 G01 X0.0

N0110 G02 X-.1565 Y16.404 I0.0 J3.1

N0120 G01 X-.16 Y15.4729

N0130 Y14.5271

N0140 X-.1565 Y13.596

N0150 G02 X0.0 Y13.6 I.1565 J-3.096

N0160 G01 X17.

N0170 G02 X17.1565 Y13.596 I0.0 J-3.1

N0180 G01 X22.9118 Y13.3051

N0190 Z.05

N0200 G00 Z10.1

N0210 X22.9122 Y16.6949

N0220 Z-2.9

N0230 G01 Z-5.9

N0240 X17.1565 Y16.404

N0250 G02 X17. Y16.4 I-.1565 J3.096

N0260 G01 X0.0

N0270 G02 X-.1565 Y16.404 I0.0 J3.1

N0280 G01 X-.16 Y15.4729

N0290 Y14.5271

N0300 X-.1565 Y13.596

N0310 G02 X0.0 Y13.6 I.1565 J-3.096

N0320 G01 X17.

N0330 G02 X17.1565 Y13.596 I0.0 J-3.1

N0340 G01 X22.9122 Y13.3051

N0350 Z-2.9

N0360 G00 Z10.1

N0370 G00 X22.3782 Y16.6047 S4000 M03

N0380 Z10.

N0390 Z0.0

N0400 G01 Z-3. F240.

N0410 X17.0587 Y16.5006

N0420 X-.0587

N0430 X-.06 Y16.1701

N0440 Y13.8299

N0450 X-.0587 Y13.4994

N0460 X17.0587

N0470 X22.3782 Y13.3953

N0480 Z0.0

N0490 G00 Z10.

N0500 X22.3788 Y16.6047

N0510 Z-3.

N0520 G01 Z-6.

N0530 X17.0587 Y16.5006

N0540 X-.0587

N0550 X-.06 Y16.1701

N0560 Y13.8299

N0570 X-.0587 Y13.4994

N0580 X17.0587

N0590 X22.3788 Y13.3953

N0600 Z-3.

N0610 G00 Z10.

N0620 M02

Τεμάχιο 6

Κώδικας 1

N0020 G71 G17 G54 G90

N0030 T="MILL6" M06

N0040 G00 G90 X21.16 Y24.9865 S4000 M03

N0060 Z.525

N0070 G01 Z-2.475 F240. M08

N0080 G02 X18.16 Y24.5506 I-2.4828 J6.5449

N0090 G03 X17.0306 Y24.599 I-1.3418 J-18.1112

N0100 G01 X1.3396 Y24.5999

N0110 G03 X-.16 Y23.1004 I.0004 J-1.5

N0120 G01 Y22.9495

N0130 G03 X1.1895 Y21.5999 I1.35 J.0004

N0140 G01 X16.8105 Y21.5992

N0150 G02 X18.16 Y20.2496 I-.0005 J-1.35

N0160 G01 Y19.949

N0170 G02 X16.8104 Y18.5994 I-1.35 J.0004

N0180 G01 X1.3396 Y18.6

N0190 G03 X-.16 Y17.1004 I.0004 J-1.5

N0200 G01 Y16.9495

N0210 G03 X1.1896 Y15.6 I1.35 J.0004

N0220 G01 X16.8105 Y15.5996

N0230 G02 X18.16 Y14.25 I-.0005 J-1.35

N0240 G01 Y13.9494

N0250 G02 X16.8104 Y12.5998 I-1.35 J.0004

N0260 G01 X1.3396 Y12.6

N0270 G03 X-.16 Y11.1004 I.0004 J-1.5

N0280 G01 Y10.4626

N0290 X-.4027 Y9.9707

N0300 G03 X-.1565 Y9.596 I.2331 J-.115

N0310 G02 X0.0 Y9.6 I.1565 J-3.096

N0320 G01 X16.8549

N0330 G02 X17.818 Y9.4379 I-.0368 J-3.1606

N0340 G03 X23.6112 Y10.0625 I2.2143 J6.6405

N0350 G01 Z.525

N0360 G00 X-3.16 Y25.7545

N0370 G01 Z-2.475

N0380 G02 X-.16 Y26.4007 I2.9381 J-6.3535

N0390 G03 X0.0 Y26.4 I.16 J18.0993

N0400 G01 X16.8104

N0410 G03 X18.16 Y27.7496 I-.0004 J1.35

N0420 G01 Y28.0504

N0430 G03 X16.8104 Y29.4 I-1.35 J-.0004

N0440 G01 X1.3396

N0450 G02 X-.16 Y30.8996 I.0004 J1.5

N0460 G01 Y31.0504

N0470 G02 X1.1896 Y32.4 I1.35 J-.0004

N0480 G01 X16.8104

N0490 G03 X18.16 Y33.7496 I-.0004 J1.35

N0500 G01 Y34.0504

N0510 G03 X16.8104 Y35.4 I-1.35 J-.0004

N0520 G01 X1.3396

N0530 G02 X-.16 Y36.8996 I.0004 J1.5

N0540 G01 Y37.0504

N0550 G02 X1.1896 Y38.4 I1.35 J-.0004

N0560 G01 X16.8104

N0570 G03 X18.16 Y39.7496 I-.0004 J1.35

N0580 G01 Y40.5373

N0590 X18.1591 Y41.4025

N0600 G03 X17.9989 Y41.5624 I-.16 J-.0002

N0610 G01 X17.8274 Y41.5635

N0620 X17.8186 Y41.5621

N0630 G02 X16.8549 Y41.4 I-.9998 J2.9979

N0640 G01 X0.0

N0650 G02 X-.1565 Y41.404 I0.0 J3.1

N0660 G03 X-4.7577 Y39.9767 I-.3534 J-6.9911

N0670 G01 Z.525

N0680 G00 X21.16 Y25.2274

N0690 Z-1.95

N0700 G01 Z-4.95

N0710 G02 X18.16 Y24.5982 I-2.9019 J6.3702

N0720 G03 X17.8994 Y24.6 I-.2537 J-18.1009

N0730 G01 X1.3395

N0740 G03 X-.16 Y23.1005 I.0005 J-1.5

N0750 G01 Y22.9496

N0760 G03 X1.1896 Y21.6 I1.35 J.0004

N0770 G01 X16.6604

N0780 G02 X18.16 Y20.1004 I-.0004 J-1.5

N0790 G01 Y19.9496

N0800 G02 X16.8104 Y18.6 I-1.35 J.0004

N0810 G01 X1.3395

N0820 G03 X-.16 Y17.1004 I.0005 J-1.5

N0830 G01 Y16.9496

N0840 G03 X1.1896 Y15.6 I1.35 J.0004

N0850 G01 X16.6604

N0860 G02 X18.16 Y14.1005 I-.0004 J-1.5

N0870 G01 Y13.9496

N0880 G02 X16.8105 Y12.6 I-1.35 J.0004

N0890 G01 X1.3396

N0900 G03 X-.16 Y11.1004 I.0004 J-1.5

N0910 G01 Y10.4626

N0920 X-.4027 Y9.9707

N0930 G03 X-.1565 Y9.596 I.2331 J-.115

N0940 G02 X0.0 Y9.6 I.1565 J-3.096

N0950 G01 X17.9036

N0960 G02 X18.1589 Y9.5897 I.0027 J-3.1027

N0970 G03 X22.8787 Y10.9292 I.57 J6.9768

N0980 G01 Z-1.95

N0990 G00 X-3.16 Y25.7545

N1000 G01 Z-4.95

N1010 G02 X-.16 Y26.4007 I2.9381 J-6.3535

N1020 G03 X0.0 Y26.4 I.16 J18.0993

N1030 G01 X16.6605

N1040 G03 X18.16 Y27.8995 I-.0005 J1.5

N1050 G01 Y28.0504

N1060 G03 X16.8104 Y29.4 I-1.35 J-.0004

N1070 G01 X1.3396

N1080 G02 X-.16 Y30.8996 I.0004 J1.5

N1090 G01 Y31.0505

N1100 G02 X1.1896 Y32.4 I1.35 J-.0005

N1110 G01 X16.6605

N1120 G03 X18.16 Y33.8996 I-.0005 J1.5

N1130 G01 Y34.0504

N1140 G03 X16.8104 Y35.4 I-1.35 J-.0004

N1150 G01 X1.3396

N1160 G02 X-.16 Y36.8995 I.0004 J1.5

N1170 G01 Y37.0504

N1180 G02 X1.1896 Y38.4 I1.35 J-.0004

N1190 G01 X16.6604

N1200 G03 X18.16 Y39.8995 I-.0004 J1.5

N1210 G01 Y40.5373

N1220 X18.4132 Y41.0295

N1230 G03 X18.1589 Y41.4103 I-.2329 J.1198

N1240 G02 X17.9036 Y41.4 I-.2526 J3.0923

N1250 G01 X0.0

N1260 G02 X-.1565 Y41.404 I0.0 J3.1

N1270 G03 X-4.7579 Y39.9765 I-.3534 J-6.9911

N1280 G01 Z-1.95

N1290 G00 X21.16 Y25.2455

N1300 Z-4.425

N1310 Z-7.425

N1320 G02 X18.16 Y24.5993 I-2.9381 J6.3535

N1330 G03 X18. Y24.6 I-.16 J-18.0993

N1340 G01 X1.3395

N1350 G03 X-.16 Y23.1004 I.0005 J-1.5

N1360 G01 Y22.9496

N1370 G03 X1.1896 Y21.6 I1.35 J.0004

N1380 G01 X16.6604

N1390 G02 X18.16 Y20.1004 I-.0004 J-1.5

N1400 G01 Y19.9496

N1410 G02 X16.8104 Y18.6 I-1.35 J.0004

N1420 G01 X1.3396

N1430 G03 X-.16 Y17.1004 I.0004 J-1.5

N1440 G01 Y16.9496

N1450 G03 X1.1896 Y15.6 I1.35 J.0004

N1460 G01 X16.6604

N1470 G02 X18.16 Y14.1004 I-.0004 J-1.5

N1480 G01 Y13.9496

N1490 G02 X16.8104 Y12.6 I-1.35 J.0004

N1500 G01 X1.3396

N1510 G03 X-.16 Y11.1005 I.0004 J-1.5

N1520 G01 Y10.4626

N1530 X-.4027 Y9.9707

N1540 G03 X-.1565 Y9.596 I.2331 J-.115

N1550 G02 X0.0 Y9.6 I.1565 J-3.096

N1560 G01 X18.

N1570 G02 X18.1591 Y9.5959 I0.0 J-3.1

N1580 G03 X22.7616 Y11.0194 I.3593 J6.9908

N1590 G01 Z-4.425

N1600 G00 X-3.16 Y25.7545

N1610 G01 Z-7.425

N1620 G02 X-.16 Y26.4007 I2.9381 J-

6.3535

N1630 G03 X0.0 Y26.4 I.16 J18.0993

N1640 G01 X16.6605

N1650 G03 X18.16 Y27.8996 I-.0005 J1.5

N1660 G01 Y28.0504

N1670 G03 X16.8104 Y29.4 I-1.35 J-.0004

N1680 G01 X1.3396

N1690 G02 X-.16 Y30.8995 I.0004 J1.5

N1700 G01 Y31.0504

N1710 G02 X1.1896 Y32.4 I1.35 J-.0004

N1720 G01 X16.6604

N1730 G03 X18.16 Y33.8996 I-.0004 J1.5

N1740 G01 Y34.0505

N1750 G03 X16.8104 Y35.4 I-1.35 J-.0005

N1760 G01 X1.3396

N1770 G02 X-.16 Y36.8996 I.0004 J1.5

N1780 G01 Y37.0504

N1790 G02 X1.1896 Y38.4 I1.35 J-.0004

N1800 G01 X16.6604

N1810 G03 X18.16 Y39.8996 I-.0004 J1.5

N1820 G01 Y40.5373

N1830 X18.4051 Y41.0282

N1840 G03 X18.1591 Y41.4041 I-.2327 J.1162

N1850 G02 X18. Y41.4 I-.1591 J3.0959

N1860 G01 X0.0

N1870 G02 X-.1565 Y41.404 I0.0 J3.1

N1880 G03 X-4.7582 Y39.9763 I-.3534 J-6.9911

N1890 G01 Z-4.425

N1900 G00 X21.16 Y25.2455

N1910 Z-6.9

N1920 G01 Z-9.9

N1930 G02 X18.16 Y24.5993 I-2.9381 J6.3535

N1940 G03 X18. Y24.6 I-.16 J-18.0993

N1950 G01 X1.3395

N1960 G03 X-.16 Y23.1004 I.0005 J-1.5

N1970 G01 Y22.9496

N1980 G03 X1.1895 Y21.6 I1.35 J.0004

N1990 G01 X16.6604

N2000 G02 X18.16 Y20.1004 I-.0004 J-1.5

N2010 G01 Y19.9496

N2020 G02 X16.8105 Y18.6 I-1.35 J.0004

N2030 G01 X1.3396

N2040 G03 X-.16 Y17.1004 I.0004 J-1.5

N2050 G01 Y16.9496

N2060 G03 X1.1895 Y15.6 I1.35 J.0004

N2070 G01 X16.6604

N2080 G02 X18.16 Y14.1004 I-.0004 J-1.5

N2090 G01 Y13.9496

N2100 G02 X16.8105 Y12.6 I-1.35 J.0004

N2110 G01 X1.3396

N2120 G03 X-.16 Y11.1005 I.0004 J-1.5

N2130 G01 Y10.4626

N2140 X-.4027 Y9.9707

N2150 G03 X-.1565 Y9.596 I.2331 J-.115

N2160 G02 X0.0 Y9.6 I.1565 J-3.096

N2170 G01 X18.

N2180 G02 X18.1591 Y9.5959 I0.0 J-3.1

N2190 G03 X22.7619 Y11.0196 I.3593 J6.9908

N2200 G01 Z-6.9

N2210 G00 X-3.16 Y25.7545

N2220 G01 Z-9.9

N2230 G02 X-.16 Y26.4007 I2.9381 J-6.3535

N2240 G03 X0.0 Y26.4 I.16 J18.0993

N2250 G01 X16.6605

N2260 G03 X18.16 Y27.8995 I-.0005 J1.5

N2270 G01 Y28.0504

N2280 G03 X16.8104 Y29.4 I-1.35 J-.0004

N2290 G01 X1.3396

N2300 G02 X-.16 Y30.8996 I.0004 J1.5

N2310 G01 Y31.0504

N2320 G02 X1.1896 Y32.4 I1.35 J-.0004

N2330 G01 X16.6604

N2340 G03 X18.16 Y33.8996 I-.0004 J1.5

N2350 G01 Y34.0504

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N2380 G02 X-.16 Y36.8995 I.0004 J1.5

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N2420 G03 X18.16 Y39.8996 I-.0004 J1.5

N2430 G01 Y40.5373

N2440 X18.4051 Y41.0282

N2450 G03 X18.1591 Y41.4041 I-.2327 J.1162

N2460 G02 X18. Y41.4 I-.1591 J3.0959

N2470 G01 X0.0

N2480 G02 X-.1565 Y41.404 I0.0 J3.1

N2490 G03 X-4.7585 Y39.9761 I-.3534 J-6.9911

N2500 G01 Z-6.9

N2510 G00 Z10.1

N2520 G00 X-5.2538 Y9.3978 S4000 M03

N2530 Z10.

N2540 Z1.

N2550 G01 Z-2. F240.

N2560 X-.0587 Y9.4994

N2570 X16.4723 Y9.5

N2580 G02 X17.0434 Y9.44 I-.0296 J-3.0294

N2590 G01 X22.525 Y8.3312

N2600 Z1.

N2610 G00 Z10.

N2620 Y42.6688

N2630 Z1.

N2640 G01 Z-2.

N2650 X17.0434 Y41.56

N2660 G02 X16.4723 Y41.5 I-.6007 J2.9694

N2670 G01 X-.0587 Y41.5006

N2680 X-5.2538 Y41.6022

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N2700 G00 Z10.

N2710 X23.2044 Y42.2143

N2720 Z-1.

N2730 G01 Z-4.

N2740 X18.0539 Y41.5264

N2750 G02 X17.6565 Y41.5 I-.3972 J2.9737

N2760 G01 X-.0587 Y41.5006

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N2790 G00 Z10.

N2800 Y9.3978

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N2820 G01 Z-4.

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N2860 G01 X23.2044 Y8.7857

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N2890 X-5.2538 Y9.3978

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N2910 G01 Z-6.

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N2950 Z-3.

N2960 G00 Z10.

N2970 Y41.6045

N2980 Z-3.

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123

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N3230 G01 Z-10.
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N3320 G01 Y22.7015
N3330 G03 X17.8608 Y22.7 I0.0 J-13.2
N3340 G01 X.1361
N3350 G03 X-.06 Y22.7014 I-.1949 J-13.1986
N3360 G01 Y21.5014
N3370 G02 X.1271 Y21.5 I.0013 J-12.
N3380 G01 X17.8701
N3390 G02 X18.06 Y21.5015 I.1899 J-11.9985
N3400 G01 Y20.3015
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N3430 G03 X-.06 Y20.3014 I-.1763 J-10.7986
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N3450 G02 X.1074 Y19.1 I.0013 J-9.6
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N3470 G02 X18.06 Y19.1015 I.1699 J-9.5985
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N3630 G02 X18.06 Y14.3015 I.1201 J-4.7985
N3640 G01 Y13.1015
N3650 G03 X17.956 Y13.1 I0.0 J-3.6
N3660 G01 X.043
N3670 G03 X-.06 Y13.1014 I-.1017 J-3.5986
N3680 G01 Y11.9014
N3690 X17.9751 Y11.9
N3700 G02 X18.06 Y11.9015 I.0849 J-2.3985
N3710 G01 Y10.7015
N3720 X-.06 Y10.7014
N3730 Y10.0084
N3740 X-.0587 Y9.4994
N3750 X18.06
N3760 X23.2551 Y9.3955
N3770 Z-7.
N3780 G00 Z10.
N3790 X-3.06 Y25.8988
N3800 Z-7.
N3810 G01 Z-10.
N3820 X-.06 Y25.8986
N3830 G03 X.1531 Y25.9 I.0013 J15.6
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N3850 G03 X18.06 Y25.8985 I.2166 J15.5985
N3860 G01 Y27.0985
N3870 G02 X17.852 Y27.1 I0.0 J14.4
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N3900 G01 Y28.2986
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N3930 G03 X18.06 Y28.2985 I.1992

J13.1985
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N3960 G01 X.1271
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N3980 G01 Y30.6986
N3990 G03 X.1175 Y30.7 I.0013 J10.8
N4000 G01 X17.8799
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N4030 G02 X17.8902 Y31.9 I0.0 J9.6
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N4050 G02 X-.06 Y31.8986 I-.1662 J9.5986
N4060 G01 Y33.0986
N4070 G03 X.0967 Y33.1 I.0013 J8.4
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N4100 G01 Y34.2985
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N4140 G01 Y35.4986
N4150 G03 X.0726 Y35.5 I.0013 J6.
N4160 G01 X17.9257
N4170 G03 X18.06 Y35.4985 I.1343 J5.9985
N4180 G01 Y36.6985
N4190 G02 X17.9399 Y36.7 I0.0 J4.8
N4200 G01 X.0588
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N4220 G01 Y37.8986
N4230 G03 X.043 Y37.9 I.0013 J3.6
N4240 G01 X17.956
N4250 G03 X18.06 Y37.8985 I.104 J3.5985
N4260 G01 Y39.0985
N4270 G02 X17.9751 Y39.1 I0.0 J2.4
N4280 G01 X-.06 Y39.0986
N4290 Y40.2986
N4300 X18.06 Y40.2985
N4310 Y41.5006
N4320 X-.0587
N4330 X-5.2538 Y41.6022
N4340 Z-7.
N4350 G00 Z10.
N4370 T="DRILL67" M06
N4380 G00 G90 X12.4973 Y26.0143 S800 M03
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N4420 G00 Z-7.

N4430 Z-2.7521

N4440 G01 Z-15.5043 F61.

N4450 G00 Z-7.

N4460 Z-5.5043

N4470 G01 Z-18.2564

N4480 G00 Z-7.

N4490 Z-8.2564

N4500 G01 Z-21.0086

N4510 G00 Z-7.

N4520 Z-11.0086

N4530 G01 Z-23.7607

N4540 G00 Z-7.

N4550 Z-13.7607

N4560 G01 Z-26.5129

N4570 G00 Z-7.

N4580 Z10.

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N4610 G00 G90 X19.356 Y53.8815 S4000 M03

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N4640 G01 Z-.2 F240.

N4650 G03 X17.1909 Y51. I.8349 J-2.8815

N4660 G01 Y44.5

N4670 G03 X19.3839 Y41.6106 I3. J0.0

N4680 G01 Z2.8

N4690 G00 X19.8833 Y41.6025

N4700 Z2.6

N4710 G01 Z-.4

N4720 G02 X17.6608 Y44.5 I.7776 J2.8975

N4730 G01 Y51.

N4740 G02 X19.859 Y53.8909 I3. J0.0

N4750 G01 Z2.6

N4760 G00 X20.2764 Y53.8996

N4770 Z2.4

N4780 G01 Z-.6

N4790 G03 X18.0463 Y51. I.7699 J-2.8995

N4800 G01 Y44.5

N4810 G03 X20.2592 Y41.6051 I3. J0.0

N4820 G01 Z2.4

N4830 G00 X20.6192 Y41.5971

N4840 Z2.2

N4850 G01 Z-.8

N4860 G02 X18.3764 Y44.5 I.7572 J2.9029

N4870 G01 Y51.

N4880 G02 X20.6192 Y53.9029 I3. J0.0

N4890 G01 Z2.2

N4900 G00 X20.9144 Y53.9043

N4910 Z2.

N4920 G01 Z-1.

N4930 G03 X18.6661 Y51. I.7517 J-2.9043

N4940 G01 Y44.5

N4950 G03 X20.9144 Y41.5957 I3. J0.0

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N4970 G00 X21.1431 Y41.6035

N4980 Z1.8

N4990 G01 Z-1.2

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N5010 G01 Y51.

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N5060 G01 Z-1.4

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N5080 G01 Y44.5

N5090 G03 X21.3858 Y41.6008 I3. J0.0

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N5110 G00 X21.6264 Y41.5931

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N5130 G01 Z-1.6

N5140 G02 X19.3681 Y44.5 I.7417 J2.9069

N5150 G01 Y51.

N5160 G02 X21.6264 Y53.9069 I3. J0.0

N5170 G01 Z1.4

N5180 G00 X21.8214 Y53.9075

N5190 Z1.2

N5200 G01 Z-1.8

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N5220 G01 Y44.5

N5230 G03 X21.8214 Y41.5925 I3. J0.0

N5240 G01 Z1.2

N5250 G00 X21.9771 Y41.5978

N5260 Z1.

N5270 G01 Z-2.

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N5290 G01 Y51.

N5300 G02 X22. Y53.9081 I3. J0.0

N5310 G01 Z1.

N5320 G00 X22.1632 Y53.9084

N5330 Z.8

N5340 G01 Z-2.2

N5820 Z-.6

N5830 G01 Z-3.6

N5840 G02 X20.7166 Y44.5 I.7293 J2.91

N5850 G01 Y51.

N5860 G02 X22.9874 Y53.91 I3. J0.0

N5350 G03 X19.899 Y51. I.7358 J-2.9084

N5360 G01 Y44.5

N5370 G03 X22.1381 Y41.5981 I3. J0.0

N5380 G01 Z.8

N5390 G00 X22.2927 Y41.5966

N5400 Z.6

N5410 G01 Z-2.4

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N5430 G01 Y51.

N5440 G02 X22.3133 Y53.9087 I3. J0.0

N5450 G01 Z.6

N5460 G00 X22.4515 Y53.9091

N5470 Z.4

N5480 G01 Z-2.6

N5490 G03 X20.1846 Y51. I.7331 J-2.909

N5500 G01 Y44.5

N5510 G03 X22.4515 Y41.5909 I3. J0.0

N5520 G01 Z.4

N5530 G00 X22.5786 Y41.5906

N5540 Z.2

N5550 G01 Z-2.8

N5560 G02 X20.3104 Y44.5 I.7317 J2.9094

N5570 G01 Y51.

N5580 G02 X22.5786 Y53.9094 I3. J0.0

N5590 G01 Z.2

N5600 G00 X22.6946 Y53.9095

N5610 Z0.0

N5620 G01 Z-3.

N5630 G03 X20.4259 Y51. I.7313 J-2.9095

N5640 G01 Y44.5

N5650 G03 X22.6946 Y41.5905 I3. J0.0

N5660 G01 Z0.0

N5670 G00 X22.8012 Y41.5903

N5680 Z-.2

N5690 G01 Z-3.2

N5700 G02 X20.5317 Y44.5 I.7305 J2.9097

N5710 G01 Y51.

N5720 G02 X22.8012 Y53.9097 I3. J0.0

N5730 G01 Z-.2

N5740 G00 X22.899 Y53.91

N5750 Z-.4

N5760 G01 Z-3.4

N5770 G03 X20.6285 Y51. I.7295 J-2.91

N5780 G01 Y44.5

N5790 G03 X22.899 Y41.59 I3. J0.0

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N5810 G00 X22.9874

N5870 G01 Z-.6

N5880 G00 X23.0678 Y53.9102

N5890 Z-.8

N5900 G01 Z-3.8

N5910 G03 X20.7966 Y51. I.7287 J-2.9102

N5920 G01 Y44.5

N5930 G03 X23.0678 Y41.5898 I3. J0.0

N5940 G01 Z-.8

N5950 G00 X23.1406 Y41.5896

N5960 Z-1.

N5970 G01 Z-4.

N5980 G02 X20.8686 Y44.5 I.7279 J2.9103

N5990 G01 Y51.

N6000 G02 X23.1406 Y53.9104 I3. J0.0

N6010 G01 Z-1.

N6020 G00 X23.2052

N6030 Z-1.2

N6040 G01 Z-4.2

N6050 G03 X20.933 Y51. I.7278 J-2.9104

N6060 G01 Y44.5

N6070 G03 X23.2052 Y41.5896 I3. J0.0

N6080 G01 Z-1.2

N6090 G00 X23.2628 Y41.5894

N6100 Z-1.4

N6110 G01 Z-4.4

N6120 G02 X20.99 Y44.5 I.7272 J2.9105

N6130 G01 Y51.

N6140 G02 X23.2628 Y53.9106 I3. J0.0

N6150 G01 Z-1.4

N6160 G00 X23.313

N6170 Z-1.6

N6180 G01 Z-4.6

N6190 G03 X21.0399 Y51. I.7269 J-2.9106

N6200 G01 Y44.5

N6210 G03 X23.313 Y41.5894 I3. J0.0

N6220 G01 Z-1.6

N6230 G00 X23.356 Y41.5893

N6240 Z-1.8

N6250 G01 Z-4.8

N6260 G02 X21.0828 Y44.5 I.7267 J2.9106

N6270 G01 Y51.

N6280 G02 X23.356 Y53.9107 I3. J0.0

N6290 G01 Z-1.8

N6300 G00 X23.3445 Y53.8984

N6310 Z-2.

N6320 G01 Z-5.

N6330 G03 X21.1188 Y51. I.7743 J-2.8984

N6340 G01 Y44.5

N6350 G03 X23.3927 Y41.5892 I3. J0.0

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N6370 G00 X23.4218

N6380 Z-2.2

N6390 G01 Z-5.2

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N6410 G01 Y51.

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N6440 G00 X23.4448 Y53.9108

N6450 Z-2.4

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N6470 G03 X21.1709 Y51. I.7261 J-2.9108

N6480 G01 Y44.5

N6490 G03 X23.4448 Y41.5892 I3. J0.0

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N6520 Z-2.6

N6530 G01 Z-5.6

N6540 G02 X21.1871 Y44.5 I.7261 J2.9108

N6550 G01 Y51.

N6560 G02 X23.461 Y53.9108 I3. J0.0

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N6580 G00 X23.4706

N6590 Z-2.8

N6600 G01 Z-5.8

N6610 G03 X21.1968 Y51. I.7262 J-2.9108

N6620 G01 Y44.5

N6630 G03 X23.4706 Y41.5892 I3. J0.0

N6640 G01 Z-2.8

N6650 G00 X23.8418 Y42.4585

N6660 Z-3.

N6670 G01 Z-6.

N6680 G02 X21.1975 Y45.4374 I.3557 J2.9788

N6690 G01 Y51.

N6700 G02 X23.4721 Y53.911 I3. J0.0

N6710 G01 Z-3.

N6720 G00 Z2.8

N6730 X19.3801 Y9.3884

N6740 G01 Z-.2

N6750 G03 X17.1909 Y6.5 I.8108 J-2.8884

N6760 G01 Y0.0

N6770 G03 X19.3845 Y-2.8896 I3. J0.0

N6780 G01 Z2.8

N6790 G00 X19.8683 Y-2.8935

N6800 Z2.6

N6810 G01 Z-.4

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N6830 G01 Y6.5

N6840 G02 X19.8833 Y9.3975 I3. J0.0

N6850 G01 Z2.6

N6860 G00 X20.2543 Y9.3936

N6870 Z2.4

N6880 G01 Z-.6

N6890 G03 X18.0463 Y6.5 I.7921 J-2.8936

N6900 G01 Y0.0

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N6940 Z2.2

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N6960 G02 X18.3764 Y0.0 I.7717 J2.899

N6970 G01 Y6.5

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N7000 G00 X20.9144 Y9.4043

N7010 Z2.

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N7070 G00 X21.1546 Y-2.8996

N7080 Z1.8

N7090 G01 Z-1.2

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N7120 G02 X21.1534 Y9.3993 I3. J0.0

N7130 G01 Z1.8

N7140 G00 X21.3878 Y9.3998

N7150 Z1.6

N7160 G01 Z-1.4

N7170 G03 X19.1569 Y6.5 I.7691 J-2.8997

N7180 G01 Y0.0

N7190 G03 X21.3891 Y-2.9001 I3. J0.0

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N7220 Z1.4

N7230 G01 Z-1.6

N7240 G02 X19.3681 Y0.0 I.7417 J2.9069

N7250 G01 Y6.5

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N7270 G01 Z1.4

N7280 G00 X21.8214 Y9.4075

N7290 Z1.2

N7300 G01 Z-1.8

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N7320 G01 Y0.0

N7330 G03 X21.8214 Y-2.9075 I3. J0.0

N7340 G01 Z1.2

N7350 G00 X22. Y-2.9081

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N7370 G01 Z-2.

N7380 G02 X19.7371 Y0.0 I.7371 J2.908

N7390 G01 Y6.5

N7400 G02 X22. Y9.4081 I3. J0.0

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N7420 G00 X22.1632 Y9.4084

N7430 Z.8

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N7450 G03 X19.899 Y6.5 I.7358 J-2.9084

N7460 G01 Y0.0

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N7480 G01 Z.8

N7490 G00 X22.2892 Y-2.9025

N7500 Z.6

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N7790 G01 Z-3.2

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2.9092

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127

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N9990 Z-.4

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N0070 Z-.6

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N1960 Z-6.

N1970 G01 Z-9.

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N1990 G01 X20.999 Y.1005

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N2040 G01 Z-.2

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J1.25

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J1.25

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N2440 M02

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N3630 Y24.4701

N3640 X50.5512 Y14.4454

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N3690 Y28.0147

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N3720 G01 X39.8348

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N3930 Y42.1934

N3940 X45.5873 Y15.2879

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N3980 G01 X53.4991 Y43.9657

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N4000 X44.592 Y15.4479

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N4060 X-5.1 Y50.032

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N4120 G03 X44.094 Y15.5266 I18.0928 J.5112

N4130 G01 X53.4991 Y47.5104

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N4150 X43.5957 Y15.6045

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N4240 Z-.3333

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N4330 X26. Y-4.0466

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N4630 X49.2366

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N4760 X49.9718 Y37.5

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N4820 X50.2658 Y38.5

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14.1541

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N5030 G01 X2.5436 Y33.8833

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N5070 X5.0063

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N5180 X1.212 Y38.

N5190 X10.3568

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N5250 X13.8881

N5260 G03 X3.9001 Y29.6899 I12.1119 J-23.0066

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N5310 X19.0226

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N5390 G01 X46.6349 Y26.1523

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N5620 X6.0332 Y14.2822

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N5650 X53.4598 Y40.5

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N5670 G01 Z-10.

N5680 X50.854

N5690 X.4034

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N5750 X-.082 Y42.0004

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N5790 G01 X51.446 Y42.5133

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146

N6120 Y46.9395

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N6170 Y47.5268

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N6200 G03 X52.698 Y47.5268 I0.0 J3.

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N6290 Z-7.

N6300 G01 Z-10.

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N6360 G00 Z50.

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N6380 Z-11.

N6390 G01 Z-14.

N6400 X53.4043 Y49.3145

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N6460 X-4.9035 Y49.0226

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N6540 X43.496 Y15.6199

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N6580 X-4.9047 Y49.0286

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N6610 M02

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Τεμάχιο 7

Κώδικας 1

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N0120 G02 X-6.2382 Y5.7265 I-6.8224 J1.5668

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N0150 X-.4186 Y-5.9842

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N0180 G03 X-.3833 Y-2.9835 I-6.8192 J1.5809

N0190 G02 X-.7 Y.2549 I14.9488 J3.0966

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N0240 G01 Y29.5444

N0250 G02 X-.596 Y31.4713 I15.2658 J.1423

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N0270 G01 X1.2357

N0280 G02 X2.4233 Y31.4259 I-.0003 J-1.2

N0290 G03 X2.3 Y29.5591 I12.1425 J-1.7393

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N0440 G01 Y29.5758

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N0460 G03 X6.2119 Y35.7957 I-6.5942 J2.3486

N0470 G01 Z-.45

N0480 G00 Z9.2

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N0490 X67.2382 Y5.7265
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N0750 G03 X56.3591 Y13.1366 I-12.2025 J.0052
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N1030 G03 X31.394 Y15.73 I-1.1764 J.2479
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N1050 X29.627 Y14.0463 I.8964 J-.8012
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N1070 G01 X34.1222 Y13.1684
N1080 G03 X35.2011 Y13.4316 I.2093 J1.4853
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N1100 G03 X36.7812 Y15.4336 I-.2472 J.5467
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N1120 G01 Y29.8227
N1130 G02 X31.5068 Y31.6114 I9.2985 J-.1689
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N3720 G03 X8.3 Y7.2685 I.021 J-6.2143

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N4680 G02 X55.7 Y29.8 I-9.0325 J-1.7475
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N5580 G03 X34.3 Y10.3146 I5.5388 J-3.0153

N5590 G01 Y0.0

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N5610 X35.6489 Y-3.2029 I1.3867 J.5718

N5620 G01 X38.8786 Y-4.3582

N5630 G03 X39.3772 Y-2.9966 I.2442 J.6827

N5640 G02 X37.3 Y0.0 I1.1228 J2.9966

N5650 G01 Y10.3545

N5660 G02 X40.5 Y13.7639 I3.3047 J.1047

N5670 G01 X46.5

N5680 G02 X49.7 Y10.3545 I-.1047 J-3.3047

N5690 G01 Y0.0

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N5710 G03 X43.9334 Y-6.2 I2.4561 J-6.555

N5720 G01 Z-5.35

N5730 G00 Z9.2

N5740 X28.8537 Y35.7966

N5750 Z-5.35

N5760 G01 Z-8.35

N5770 G03 X29.1983 Y32.7966 I6.9629 J-.72

N5780 G02 X29.7 Y29.8 I-8.6983 J-2.9966

N5790 G01 Y19.6172

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N5810 G03 X29.0716 Y13.8252 I2.7986 J-1.0805

N5820 G02 X29.7 Y10.2835 I-8.6763 J-3.366

N5830 G01 Y0.0

N5840 G02 X29.5246 Y-1.7881 I-9.2 J0.0

N5850 X28.0532 Y-2.9966 I-1.4714 J.2915

N5860 G01 X27.2831

N5870 G02 X26.4234 Y-1.8311 I.0003 J.9

N5880 G03 X26.7 Y0.0 I-5.9234 J1.8311

N5890 G01 Y10.3146

N5900 G03 X25.9341 Y13.4745 I-6.3047 J.1447

N5910 G02 X25.9328 Y16.3347 I2.6366 J1.4313

N5920 G03 X26.7 Y19.5732 I-5.5825

J3.0325

N5930 G01 Y29.8

N5940 G03 X26.2323 Y32.1624 I-6.2 J0.0

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N6150 G01 X40.5

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N6290 G01 X20.5

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N6330 G03 X17.9334 Y-6.2 I2.4561 J-6.555

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N6350 G00 Z9.2

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N6370 Z-7.8

N6380 G01 Z-10.8

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N6690 G00 Z9.2

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N6710 Z-7.8

N6720 G01 Z-10.8

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N6910 G00 Z9.2

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N7130 G00 Z9.2

N7140 X61.4596 Y35.7842

N7150 Z-7.8

N7160 G01 Z-10.8

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N7180 G02 X61.7 Y29.8 I-14.9043 J-2.9837

N7190 G01 Y0.0

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N7220 G01 X59.7785

N7230 G02 X58.5897 Y-1.6365 I.0005 J1.2

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N7250 G01 Y29.8

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N7280 G01 X56.5629

N7290 G03 X55.5324 Y31.548 I.0005 J-1.05

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N7360 G03 X52.7 Y0.0 I-5.9233 J1.8316

N7370 G01 Y29.8

N7380 G03 X52.2322 Y32.1626 I-6.2 J0.0

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N7470 G00 Z9.2

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N7490 Z-8.8

N7500 G01 Z-11.8

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N7960 G01 X4.4371

N7970 G03 X5.4676 Y-1.7481 I-.0005 J1.05

N7980 G02 X5.3 Y0.0 I9.0324 J1.7481

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N8140 G01 Z-8.8

N8150 G00 Z9.2

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N8170 Z-10.8667

N8180 G01 Z-13.8667

N8190 G02 X-3.1313 Y-.765 I-1.5089 J-6.8354

N8200 G01 X-1.0178 Y-2.6184

N8210 G03 X-.0411 Y-2.9904 I.9887 J1.128

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N8230 X.8815 Y-2.9976

N8240 X2.7692

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N8280 G01 Y5.9918

N8290 G02 X-2.2334 Y6.4327 I.6 J-.0003

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N8340 G00 Z9.2

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N8360 Z-10.8667

N8370 G01 Z-13.8667

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N8390 G01 X-2.7206 Y30.9252

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N8410 G01 X-3.24 Y28.6864

N8420 X-3.2401 Y28.6753

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N8530 G00 Z9.2

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N8560 G01 Z-13.8667

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N8630 G03 X17.0734 Y36. I-2.4502 J6.5572

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N8650 G00 Z9.2

N8660 X67.2377 Y28.9925

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N8680 G01 Z-13.8667

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N8770 G02 X64.2401 Y25.8002 I-.9893 J-1.1275

N8780 G01 Y23.8082

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N8840 G00 Z9.2

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N8870 G01 Z-13.8667

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N8890 G01 X63.7206 Y-1.1252

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4.5044
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N9290 G02 X63.2338 Y23.3669 I-.6 J.0002
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N9860 Z-12.9333
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N9890 G01 X-2.7209 Y30.9249
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N1910 Y11.8222

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N2230 Y14.5891

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N2280 G01 Z-7.

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N2480 Y18.2244

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N3090 Y-.06

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N3130 Y-.06

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N3280 Y29.86

N3290 X33.9008

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N3740 X11.3696 Y29.9433 I2.5988 J-1.8781

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N4040 X49.1454 Y31.0831

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N4060 X49.3017 Y30.6362

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N5180 G01 Z-6.5

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N5220 X11.5604 Y20.2718

N5230 X11.5609 Y20.8687

N5240 X11.5605 Y21.4024

N5250 G02 X11.5 Y21.9778 I3.0749 J.614

N5260 G01 Y29.8

N5270 G02 X12.4578 Y31.9976 I3. J0.0

N5280 G01 X16.5496 Y35.8

N5290 Z-3.5

N5300 G00 X44.4504

N5310 G01 Z-6.5

N5320 X48.5422 Y31.9976

N5330 G02 X49.5 Y29.8 I-2.0422 J-2.1976

N5340 G01 Y21.9778

N5350 G02 X49.4395 Y21.3927 I-3.0624 J.0208

N5360 G01 X49.4391 Y20.8686

N5370 X49.4396 Y20.2718

N5380 X49.4388 Y19.675

N5390 X49.4384 Y18.4812

N5400 Y18.2259

N5410 Y15.2259

N5420 Z-3.5

N5430 G00 X49.4385 Y14.5898

N5440 G01 Z-6.5

N5450 X49.4384 Y11.5898

N5460 Y11.3188

N5470 X49.4388 Y10.125

N5480 X49.4396 Y9.5282

N5490 X49.4391 Y8.9313

N5500 X49.4396 Y8.3795

N5510 G02 X49.5 Y7.8003 I-3.0693 J-.6131

N5520 G01 Y0.0

N5530 G02 X48.5422 Y-2.1976 I-3. J0.0

N5540 G01 X44.4504 Y-6.

N5550 Z-3.5

N5560 G00 Z9.

N5570 X50.394 Y14.8895

N5580 Z-5.3333

N5590 G01 Z-8.3333

N5600 X49.4385 Y14.5898

N5610 X49.4384 Y11.5898

N5620 Y11.3188

N5630 X49.4385 Y10.9602

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N5660 G02 X48.5418 Y-2.198 I-3. J0.0

N5670 G01 X44.4489 Y-6.

N5680 Z-5.3333

N5690 G00 Z9.

N5700 Y35.8

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N5720 G01 Z-8.3333

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N5740 G02 X49.5 Y29.8 I-2.0418 J-2.198

N5750 G01 Y19.4593

N5760 G02 X49.4385 Y18.817 I-2.912 J-.0454

N5770 G01 X49.4384 Y18.4812

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N5790 Y15.2259
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N5830 X10.606
N5840 Z-5.3333
N5850 G01 Z-8.3333
N5860 X11.5616 Y15.226
N5870 Y18.226
N5880 Y18.4812
N5890 X11.5615 Y18.817
N5900 G02 X11.5 Y19.4593 I2.8505 J.5969
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N5920 G02 X12.4582 Y31.998 I3. J0.0
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N5950 G00 Z9.
N5960 Y-6.
N5970 Z-5.3333
N5980 G01 Z-8.3333
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N6080 G00 Z9.
N6090 X16.5526 Y-6.
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N6110 G01 Z-10.1667
N6120 X12.4586 Y-2.1984
N6130 G02 X11.5 Y0.0 I2.0414 J2.1984
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N6190 G01 Z-10.1667
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N6260 G00 X62.7 Y6.1461
N6270 Z-9.

N6280 G01 Z-12.
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N6300 Y19.0111
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N6320 G01 Y9.1321
N6330 G02 X60.8068 Y8.4763 I-6.163 J5.8193
N6340 G01 X60.3 Y8.0308
N6350 Y21.7659
N6360 X59.1 Y22.8184
N6370 Y6.976
N6380 X57.9 Y5.9213
N6390 Y23.871
N6400 X56.7 Y24.9235
N6410 Y4.8666
N6420 X55.5 Y3.8119
N6430 Y25.9761
N6440 X54.3 Y27.0287
N6450 Y2.7571
N6460 X53.1 Y1.7024
N6470 Y28.0812
N6480 X51.9 Y29.1338
N6490 Y.6477
N6500 X50.6783 Y-.4261
N6510 G03 X50.7 Y0.0 I-4.1783 J.4261
N6520 G01 Y29.8
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N6610 G00 Z9.
N6620 X-1.7 Y23.6501
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N6660 Y10.7786
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N6680 G01 Y20.659
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N6700 G01 X.7 Y21.7648
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N6720 X1.9 Y6.9795
N6730 Y22.8174
N6740 X3.1 Y23.8701
N6750 Y5.9271

N6760 X4.3 Y4.8748
N6770 Y24.9228
N6780 X5.5 Y25.9754
N6790 Y3.8225
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N6810 Y27.0281
N6820 X7.9 Y28.0807
N6830 Y1.7178
N6840 X9.1 Y.6655
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N7010 X12.4577 Y-2.1992
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N7040 G01 X-4.5028 Y20.1389
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N7170 G02 X63.4412 Y17.1173 I-5.4857 J-6.2556
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N7230 G02 X60.9076 Y8.6444 I-8.0193

J2.2173

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N7270 G00 Z9.

N7280 X65.5004 Y20.1358

N7290 Z-13.

N7300 G01 Z-16.

N7310 X63.4416 Y12.6843

N7320 G02 X60.9076 Y8.6444 I-8.0197 J2.2157

N7330 G01 X48.5418 Y-2.1996

N7340 X44.2081 Y-6.

N7350 Z-13.

N7360 G00 Z9.

N7370 Y35.8

N7380 Z-13.

N7390 G01 Z-16.

N7400 X48.5418 Y31.9996

N7410 X60.9076 Y21.1556

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N7440 Z-13.

N7450 G00 Z9.

N7460 X-4.5024 Y9.6567

N7470 Z-13.

N7480 G01 Z-16.

N7490 X-2.4416 Y17.1157

N7500 G02 X.0924 Y21.1556 I8.0197 J-2.2157

N7510 G01 X12.4582 Y31.9996

N7520 X16.7919 Y35.8

N7530 Z-13.

N7540 G00 Z9.

N7550 Y-6.

N7560 Z-13.

N7570 G01 Z-16.

N7580 X12.4582 Y-2.1996

N7590 X.0924 Y8.6444

N7600 G02 X-2.4416 Y12.6843 I5.4857 J6.2556

N7610 G01 X-4.5018 Y20.141

N7620 Z-13.

N7630 G00 Z9.

N7640 X16.7919 Y-6.

N7650 Z-15.

N7660 G01 Z-18.

N7670 X12.4587 Y-2.2

N7680 X.0924 Y8.6444

N7690 G02 X-2.4421 Y12.6859 I5.4857 J6.2556

N7700 G01 X-4.5007 Y20.143

N7710 Z-15.

N7720 G00 X-4.5014 Y9.6546

N7730 G01 Z-18.

N7740 X-2.4421 Y17.1141

N7750 G02 X.0924 Y21.1556 I8.0202 J-2.2141

N7760 G01 X12.4587 Y32.

N7770 X16.7919 Y35.8

N7780 Z-15.

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N7800 G01 Z-18.

N7810 X48.5414 Y32.

N7820 X60.9076 Y21.1556

N7830 G02 X63.4421 Y17.1141 I-5.4857 J-6.2556

N7840 G01 X65.507 Y9.634

N7850 Z-15.

N7860 G00 X65.4993 Y20.1379

N7870 G01 Z-18.

N7880 X63.4421 Y12.6859

N7890 G02 X60.9076 Y8.6444 I-8.0202 J2.2141

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N7910 X44.2081 Y-6.

N7920 Z-15.

N7930 G00 Z9.

N7950 T="DRILL67" M06

N7960 G00 G90 X5.5781 Y14.9 S800 M03

N7980 Z-9.

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N8000 G00 Z-9.

N8010 Z-4.8782

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N8040 Z-7.7564

N8050 G01 Z-20.6347

N8060 G00 Z-9.

N8070 Z-10.6347

N8080 G01 Z-23.5129

N8090 G00 Z-9.

N8100 Z9.

N8110 X55.4219

N8120 Z-9.

N8130 G01 Z-14.8782 F30.5

N8140 G00 Z-9.

N8150 Z-4.8782

N8160 G01 Z-17.7564 F61.

N8170 G00 Z-9.

N8180 Z-7.7564

N8190 G01 Z-20.6347

N8200 G00 Z-9.

N8210 Z-10.6347

N8220 G01 Z-23.5129

N8230 G00 Z-9.

N8240 Z9.

N8250 M02

Κώδικας 2

N0020 G71 G17 G54 G90

N0030 T="MILL5" M06

N0040 G00 G90 X34.8 Y-7.4385 S6000 M03

N0060 Z1.

N0070 G01 Z-2. F240. M08

N0080 X32.8154

N0090 X31.9969 Y-9.8007

N0100 G02 X21.3427 Y-8.6837 I-5.1969 J1.8007

N0110 G03 X8.4522 Y-8.7233 I-6.4334 J-3.855

N0120 G02 X-2.1969 Y-9.8007 I-5.4522 J.7233

N0130 G01 X-3.0154 Y-7.4385

N0140 X-5.

N0150 Z1.

N0160 G00 Z24.2421

N0170 X34.8 Y-7.438

N0180 Z-1.

N0190 G01 Z-4.

N0200 X32.8153

N0210 X31.997 Y-9.8003

N0220 G02 X21.3427 Y-8.6837 I-5.197

J1.8003

N0230 G03 X8.4522 Y-8.7233 I-6.4334 J-3.855

N0240 G02 X-2.197 Y-9.8003 I-5.4522 J.7233

N0250 G01 X-3.0153 Y-7.438

N0260 X-5.

N0270 Z-1.

N0280 G00 Z24.2421

N0290 X34.8 Y-7.4375

N0300 Z-3.

N0310 G01 Z-6.

N0320 X32.8153
N0330 X31.9972 Y-9.7999
N0340 G02 X21.3427 Y-8.6837 I-5.1972 J1.7999
N0350 G03 X8.4522 Y-8.7233 I-6.4334 J-3.855

N0360 G02 X-2.1972 Y-9.7999 I-5.4522 J.7233
N0370 G01 X-3.0153 Y-7.4375
N0380 X-5.
N0390 Z-3.

N0400 G00 Z24.2421
N0410 M02

Τεμάχιο 8

Κώδικας 1

N0020 G17 G71 G54 G90
N0030 T="DRILL67" M06
N0040 G00 G90 X7.5 Y8.5 S800 M03
N0060 Z2.
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N0080 G00 Z2.
N0090 Z6.0696
N0100 G01 Z-6.8608 F61.
N0110 G00 Z2.
N0120 Z3.1392
N0130 G01 Z-9.7912
N0140 G00 Z2.
N0150 Z.2088
N0160 G01 Z-12.7216
N0170 G00 Z2.
N0180 Z-2.7216
N0190 G01 Z-15.6521
N0200 G00 Z2.
N0210 Z-5.6521
N0220 G01 Z-18.5825
N0230 G00 Z2.
N0240 Z-8.5825
N0250 G01 Z-21.5129
N0260 G00 Z2.
N0270 Z9.
N0290 T="MILL6" M06
N0300 G00 G90 X21.1 Y10.145 S4000 M03
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N0330 G01 Z-3.6667 F240.
N0340 X18.3928
N0350 X18.0161 Y7.1687
N0360 G02 X-2.9964 Y7.0216 I-10.5161 J1.3313
N0370 G01 X-3.4148 Y9.9922
N0380 X-6.1
N0390 Z-.6667
N0400 G00 Z9.1
N0410 X21.1 Y10.1495
N0420 Z-3.3333
N0430 G01 Z-6.3333

N0440 X18.3922
N0450 X18.0166 Y7.1731
N0460 G02 X-2.9969 Y7.0254 I-10.5166 J1.3269
N0470 G01 X-3.4143 Y9.9963
N0480 X-6.1
N0490 Z-3.3333 J2.4144
N0500 G00 Z9.1
N0510 X21.1 Y10.154
N0520 Z-6.
N0530 G01 Z-9.
N0540 X18.3915
N0550 X18.0172 Y7.1774
N0560 G02 X-2.9975 Y7.0294 I-10.5172 J1.3226
N0570 G01 X-3.4137 Y10.0003
N0580 X-6.1
N0590 Z-6.
N0600 G00 Z9.1
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N0620 Z-8.6667
N0630 G01 Z-11.6667
N0640 X18.3908
N0650 X18.0177 Y7.1818
N0660 G02 X-2.998 Y7.0333 I-10.5177 J1.3182
N0670 G01 X-3.4131 Y10.0044
N0680 X-6.1
N0690 Z-8.6667
N0700 G00 Z9.1
N0710 X21.1 Y10.163
N0720 Z-11.3333
N0730 G01 Z-14.3333
N0740 X18.3901
N0750 X18.0183 Y7.1862
N0760 G02 X-2.9986 Y7.0372 I-10.5183 J1.3138
N0770 G01 X-3.4126 Y10.0085
N0780 X-6.1
N0790 Z-11.3333

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N0810 X21.1 Y10.1659
N0820 Z-14.
N0830 G01 Z-17.
N0840 X18.3897
N0850 X18.0186 Y7.1889
N0860 G02 X-2.9989 Y7.0396 I-10.5186 J1.3111
N0870 G01 X-3.4122 Y10.011
N0880 X-6.1
N0890 Z-14.
N0900 G00 Z9.1
N0910 G00 X21. Y8.9913 S4000 M03
N0920 Z9.
N0930 Z-.6667
N0940 G01 Z-3.6667 F240.
N0950 X18.4091
N0960 X17.7156 Y6.0726
N0970 G02 X-2.6959 Y5.9912 I-10.2156 J2.4274
N0980 G01 X-3.4127 Y8.9043
N0990 X-6.
N1000 Z-.6667
N1010 G00 Z9.
N1020 X21. Y8.9948
N1030 Z-3.3333
N1040 G01 Z-6.3333
N1050 X18.4089
N1060 X17.7163 Y6.0758
N1070 G02 X-2.6967 Y5.9943 I-10.2163 J2.4242
N1080 G01 X-3.4126 Y8.9077
N1090 X-6.
N1100 Z-3.3333
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N1120 X21. Y8.9983
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N1140 G01 Z-9.
N1150 X18.4088
N1160 X17.7171 Y6.0791
N1170 G02 X-2.6974 Y5.9975 I-10.2171

J2.4209
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N1200 Z-6.
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N1220 X21. Y9.0017
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N1240 G01 Z-11.6667
N1250 X18.4086
N1260 X17.7179 Y6.0823
N1270 G02 X-2.6982 Y6.0006 I-10.2179 J2.4177
N1280 G01 X-3.4123 Y8.9144

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N1310 G00 Z9.
N1320 X21. Y9.0052
N1330 Z-11.3333
N1340 G01 Z-14.3333
N1350 X18.4085
N1360 X17.7186 Y6.0856
N1370 G02 X-2.699 Y6.0038 I-10.2186
N1380 G01 X-3.4122 Y8.9178
N1390 X-6.
N1400 Z-11.3333
N1410 G00 Z9.

N1420 X21. Y9.0074
N1430 Z-14.
N1440 G01 Z-17.
N1450 X18.4084
N1460 X17.7191 Y6.0876
N1470 G02 X-2.6994 Y6.0057 I-10.2191 J2.4124
N1480 G01 X-3.4121 Y8.9199
N1490 X-6.
N1500 Z-14.
N1510 G00 Z9.
N1520 M02

Κώδικας 2

N0020 G54 G17 G71 G90
N0030 T="MILL6" M06
N0040 G00 G90 X10.1384 Y-5.188 S4000 M03
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N0090 G02 X8. Y1.5695 I2.8893 J.9811
N0100 G01 Y13.4305
N0110 G02 X8.1617 Y14.3668 I3.051 J-.0448
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N0130 Z.0833
N0140 G00 Z10.
N0150 X4.8593 Y20.1885
N0160 Z.0833
N0170 G01 Z-2.9167
N0180 X6.8383 Y14.3427
N0190 G02 X7. Y13.2712 I-2.921 J-.9888
N0200 G01 Y1.7288
N0210 G02 X6.8383 Y.6573 I-3.0827 J-.0827
N0220 G01 X4.8593 Y-5.1885
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N0240 G00 Z10.
N0250 X8.771 Y-5.3828
N0260 Z-2.8333
N0270 G01 Z-5.8333
N0280 X8.0306 Y-.2392
N0290 G02 X8. Y.1891 I2.9702 J.4275
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N0310 G02 X8.0306 Y15.2392 I3.0008 J.0008
N0320 G01 X8.771 Y20.3828
N0330 Z-2.8333
N0340 G00 Z10.

N0350 X6.1413 Y20.3987
N0360 Z-2.8333
N0370 G01 Z-5.8333
N0380 X6.9626 Y15.2316
N0390 G02 X7. Y14.8109 I-3.0242 J-.4807
N0400 G01 Y.1891
N0410 G02 X6.9703 Y-.2332 I-3.0008 J-.0008
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N0460 Z-5.75
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N0530 Z-5.75
N0540 G00 Z10.
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N0570 G01 Z-8.75
N0580 X6.9908 Y15.2354
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N0660 Z-8.6667
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N0870 G01 Z-14.5833
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N0940 G00 Z10.
N0950 X8.4281 Y-5.4208
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N0970 G01 Z-14.5833
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N1010 G02 X8.0097 Y15.2416 I3. J0.0
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N1040 G00 Z10.
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N1060 Z-14.5

N1070 G01 Z-17.5
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N1160 Z-14.5
N1170 G01 Z-17.5
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N1210 G02 X8.0097 Y15.2416 I3. J0.0
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N1240 G00 Z10.
N1250 M02

Τεμάχιο 9

Κώδικας 1

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N0060 Z.5
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N0090 X13.7577 Y33.0125
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N0110 G01 Y18.5
N0120 X20.0951 Y18.3263
N0130 G02 X17. Y15.4 I-3.0951 J.1737
N0140 G01 X11.
N0150 G03 Y14.6 I0.0 J-.4
N0160 G01 X17.
N0170 G02 X20.093 Y11.7081 I0.0 J-3.1
N0180 G01 X20.1 Y11.5
N0190 Y4.6005
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N0290 X13.7568 Y33.0126
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N0460 Z10.
N0470 Z.5
N0480 G01 Z-2.5 F240.
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N0510 G02 X20. Y25.4027 I-2.0417 J-7.0988
N0520 G01 X19.9994 Y18.44
N0530 X19.9394 Y15.4406
N0540 X21.9544 Y15.0125
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N0640 G03 Y14.5 I0.0 J-.5
N0650 G01 X17.
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N0670 G01 X20.1233 Y8.6285
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N0760 X20. Y4.6055

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N1040 X19.9994 Y11.56
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N1160 G01 X17.

N1170 G02 X19.9974 Y11.6259 I0.0 J-3.

N1180 G01 X20.1233 Y8.6285

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N1220 X11.7742 Y36.

N1230 Z-2.

N1240 G01 Z-5.

N1250 Y33.5414

N1260 X14.6574 Y32.7124

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N1290 X19.9394 Y15.4406

N1300 X21.9544 Y15.0125

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N1320 G00 Z10.

N1330 M02

Κώδικας 2

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N0130 G01 Z-8.4423

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N0390 G01 Z-5.801 F72.

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N0680 X15.0018 Y15.9987 Z2.0238

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N0970 I-1.8201 J3.4492

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N1100 X16.0186 Y17.6082 I-1.2122 J.8242

N1110 X12.9541 Y17.6053 I-1.5306 J-1.7381

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N1140 I-1.8201 J3.4492

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J.1283

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N1450 X12.9541 Y17.6053 I-1.5306 J-1.7381

N1460 X12.5535 Y13.4876 I2.0101 J-2.2739

N1470 X16.8201 Y12.5508 I2.6875 J2.0555

N1480 I-1.8201 J3.4492

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2.2739

N1640 X16.8201 Y12.5508 I2.6875 J2.0555

N1650 I-1.8201 J3.4492

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N1740 X14.1724 Y15.5757 Z2.5119

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N1760 X15.2444 Y15.1027 Z2.1865

N1770 X15.7551 Y15.4571 Z2.0238

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N1790 X15.687 Y16.6269 Z1.6984

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N1830 X14.1184 Y15.7038 Z1.0476

N1840 X14.5019 Y15.2146 Z.8849

N1850 X15.108 Y15.0763 Z.7222

N1860 X15.6658 Y15.3506 Z.5595

N1870 X15.9261 Y15.9151 Z.3968

N1880 X15.7727 Y16.5175 Z.2341

N1890 X15.2741 Y16.8887 Z.0714

N1900 X14.653 Y16.8629 Z-.0913

N1910 X14.187 Y16.4515 Z-.254

N1920 X14.1137 Y15.8437 Z-.4167

N1930 G03 X15.0042 Y14.5958 I1.7527 J.309

N1940 X16.343 Y14.6093 I.6575 J1.1874

N1950 X17.3643 Y16.5553 I-1.0355 J1.7844

N1960 X15.6168 Y18.9018 I-2.7381 J-.2151

N1970 X12.0122 Y18.1242 I-1.2108 J-3.1308

N1980 X11.2913 Y14.5016 I2.4018 J-2.361

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N2190 X15.2741 Y16.8887 Z-3.3452

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N2210 X14.187 Y16.4515 Z-3.6706

N2220 X14.1137 Y15.8437 Z-3.8333

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N2260 X15.6168 Y18.9018 I-2.7381 J-.2151

N2270 X12.0122 Y18.1242 I-1.2108 J-3.1308

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N2570 X12.0122 Y18.1242 I-1.2108 J-3.1308

N2580 X11.2913 Y14.5016 I2.4018 J-2.361

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N2770 X15.9261 Y15.9151 Z-9.8532

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N2870 X12.0122 Y18.1242 I-1.2108 J-3.1308

N2880 X11.2913 Y14.5016 I2.4018 J-2.361

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N6360 X18.1246 Y45.641

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J-20.605
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J18.997

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N6360 X14.7105 Y48.1933

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J5.42

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J5.4583

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J4.2998

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J18.997

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186

J5.456

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N9180 Y2.4978

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J7.634

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N2180 Y-5.9977

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N3150 G01 Y7.1625
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N3170 G01 X18.3993
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N6030 X-1.662 Y48.693

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N6220 Y-5.9888

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N8960 G01 Y.128

N8970 G02 X22.9996 Y.038 I-3.0305 J-.0305

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N0890 G03 X27.8543 Y9.8328 I-2.135
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N0990 G01 Z-3.75

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N1630 G01 Z-11.25

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N1680 X32.1196 Y9.9081

N1690 G03 X27.8543 Y9.8328 I-2.135
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N2080 G00 Z10.

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