

ESEMPIO DI SVUOTAMENTO CAVE CON SPOSTAMENTO ORIGINE

Machine position

X	0.000	Z	0.000
Y	0.000	A	0.000

Actual

F	0
S	0

2003 06 09
17:05:45

selca

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N1 $1M0X-33.2I1062.Y-28.8J671.
N2 [ESEMPIO DI SVUOTAMENTO CAVE CON SPOSTAMENTO ORIGINE
N3 G17 [PIANO DI LAVORO
N4 O1 [ORIGINE PEZZO
N5 T1M6 [FRESA CILINDRICA PER SGROSSATURE
N6 F1000 S1500 M13 [DATI TECNOLOGICI
N7 G49I10 [DEFINIZIONE CORRETTORE RAGGIO FRESA
N8 P2=20 [PROFONDITA' TOTALE
N9 P3=20 [PROFONDITA' DI PASSATA
N10 G51X100Y140
N11 L1
N12 G51X120Y400
N13 L2
N14 G51X420Y330
N15 L3
N16 G51X680Y140
N17 L4
N18 G51X750Y340
N19 L5
N20 G51X840Y480
N21 L8
N22 G51X950Y120J90
N23 L7
  
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N24 G51X700Y445
N25 L6
N26 M30
N27 L=1
N28 Z100R
N29 X0Y-80R
N30 Z2R
N31 G77D0=3D8=1D1=0D2=P3D3=-P2
N32 G41K2 D0=1

N33 G13Y-120J0
N34 G21I15
N35 G13X80J90
N36 G21
N37 G13Y120J180
N38 G21
N39 G13X-80J-90
N40 G21
N41 G13X-80Y-120I-35J-45
N42 G21
N43 G13Y-120J0
N44 G40X0Y-80K2
N45 G78X0Y-80
N46 Z100R
N47 G32
N48 L=2
N49 Z100R
N50 X0Y-100R
N51 Z2R
N52 G77D0=3D8=1D1=0D2=P3D3=-P2
N53 G41K2 D0=100
N54 G13Y-120J0
N55 G13X100J-90
N56 G21I15
N57 G13Y-300J0
N58 G20X300Y-300I15
N59 G13X300J90K2
N60 G13Y-260J0
N61 G21I15
N62 G13X330J90
N63 G21
N64 G13Y-150J180
N65 G13X150J90
N66 G13Y-120J0
N67 G21I15
N68 G13X180J90
N69 G21I15
N70 G13Y-20J180
N71 G13X120J90
N72 G21I15
N73 G13Y0J180
N74 G13X80J90
N75 G13Y50J0
N76 G21I15
N77 G13X180J90
N78 G13Y140J0
N79 G13X220J-90
N80 G20X220Y110I15
N81 G13Y110J0K2

N82 G13X260J-90
N83 G21I15
N84 G13Y80J0
N85 G21
N86 G13X500J90
N87 G21
N88 G13Y200J180
N89 G21I15
N90 G13X-100Y200I-45J-135
N91 G21
N92 G13X-100J-90
N93 G21I15
N94 G13Y0J0
N95 G13X-60J-90
N96 G13Y-30J180
N97 G21
N98 G13X-100J-90
N99 G21
N100 G13Y-120J0
N101 G40X0Y-100K2
N102 G78X0Y-100
N103 Z100R
N104 G32
N105 L=3
N106 Z100R
N107 X0Y-40R
N108 Z2R
N109 G77D0=3D8=1D1=0D2=P3D3=-P2
N110 G41K2D0=1
N111 G13Y-60J0
N112 G20X100Y-60I14
N113 G13X100J90K2
N114 G20X100Y60I14
N115 G13Y60J180K2
N116 G20X-100Y60I14
N117 G13X-100J-90K2
N118 G20X-100Y-60I14
N119 G13Y-60J0K2
N120 G40X0Y-40K2
N121 G78X0Y-40
N122 Z100R
N123 G32
N124 L=4
N125 Z100R
N126 X0Y-100R
N127 Z2R
N128 G77D0=3D8=1D1=0D2=P3D3=-P2
N129 G41K2D0=1
N130 G13Y-120J0
N131 G20X180Y-120I20
N132 G13J90
N133 G20X200Y100I20
N134 G13J180
N135 G20X-200Y100I20
N136 G13X-200J-90K2
N137 G20X-180Y-120I20
N138 G13Y-120J0K2
N139 G40X0Y-100K2
N140 G78X0Y-100

N141 Z100R
N142 G32
N143 L=5
N144 Z100R
N145 X0Y-50R
N146 Z2R
N147 G77D0=3D8=1D1=0D2=P3D3=-P2
N148 G41K2 D0=1
N149 G20X0Y0I70
N150 G13Y-50J0K2
N151 G20X150Y0I70
N152 G13Y50J180K2
N153 G20X0Y0I70
N154 G13Y50J180K2
N155 G20X-150Y0I70
N156 G13Y-50J0K2
N157 G20X0Y0I70
N158 G40X0Y-50K2
N159 G78X0Y-50
N160 Z100R
N161 G32
N162 L=6
N163 Z100R
N164 X0Y0R
N165 Z2R
N166 G77D0=3D8=1D1=0D2=P3D3=-P2
N167 G41K2D0=1
N168 G13Y-25J0
N169 G20X300Y0I25
N170 G13J180
N171 G20X-300Y0I25
N172 G13J0
N173 G40X0Y0K2
N174 G78X0Y0
N175 Z100R
N176 G32
N177 L=7
N178 Z100R
N179 X0Y-30R
N180 Z2R
N181 G77D0=3D8=1D1=0D2=P3D3=-P2
N182 G41K2D0=1
N183 G13Y-50J0
N184 G21I20
N185 G13X80J90
N186 G21
N187 G13Y50J180
N188 G21
N189 G13X-80J-90
N190 G21
N191 G13Y-50J0
N192 G40X0Y-30K2
N193 G78X0Y-30
N194 Z100R
N195 G32
N196 L=8
N197 Z100R
N198 X0Y20R
N199 Z2R

N200 G77D0=3D8=1D1=0D2=P3D3=-P2
N201 G41K2D0=1
N202 G13Y0J0
N203 G21I25
N204 G13X200J90
N205 G21
N206 G13X200Y120I-50J135
N207 G21
N208 G13Y120J180
N209 G21
N210 G13X-200J-90
N211 G21
N212 G13Y0J0
N213 G40X0Y20K2
N214 G78X0Y20
N215 Z100R
N216 G32