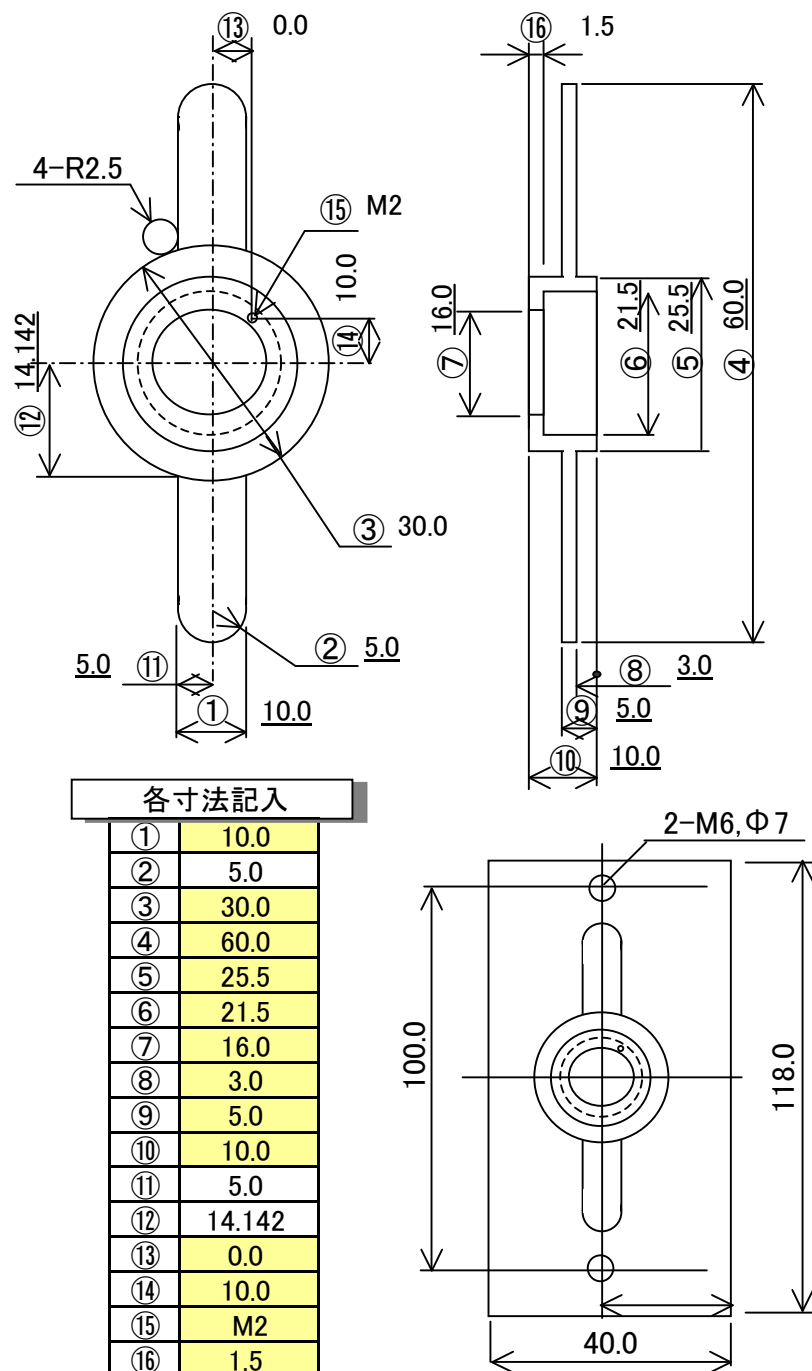


製作部品図(加工は -90° 回転)



プログラム

O****(SYATYOU1)	X-21.5;	G01X-25.0;
G90G54G00Z50.0	G03X0Y-21.5R21.5;	G02Y5.0R5.0;
X0Y0;	G02X0Y-30.0R4.25;	G01X-15.811;
Z2.0;	G01X0Y0;	G03X-13.569Y6.394R2.5;
M03;	G00Z50.0;	G02X13.569R15.0;
G01Z-8.0;	M30;	G03X15.811Y5.0R2.5;
G03Y2.5R1.25;	%;	G01X25.0;
J-2.5;		G02Y-5.0R5.0;
Y0R1.25;		G01X15.811;
G01Z-8.5;	O****(SYATYOU3)	G03X13.569Y-6.394R2.5;
G03Y2.75R1.375;	G90G54G00Z50.0;	G02X0Y-15.0R15.0;
J-2.75;	X0Y0;	G40Y-30.0;
Y0R1.375;	Y-30.0;	G00Z50.0;
G00Z50.0;	Z2.0	X0Y0;
M30;	M03;	M30;
%;	G01Z-3.0F50;	%;
	G02Y-20.75R4.625;	
O****(SYATYOU2)	G03J20.75	
G90G54G00Z50.0;	G02Y-30.0R4.625;	O****(SYATYOU1)
X0Y0;	G01X0Y0;	=内径加工
Y-30.0;	G00Z50.0;	EndMill16Φ
Z2.0	M30;	
M03;	%;	O****(SYATYOU2)
G01Z-2.0F50;		=裏表段加工
G02Y-21.5R4.25;		EndMill16Φ
G03X21.5Y0R21.5;	O****(SYATYOU4)	
G01Y4.0;	G90G54G00Z50.0;	O****(SYATYOU3)
X35.0;	X0Y0;	=Φ25.5仕上げZ修正
Y-4.0;	Y-30.0;	EndMill16Φ
X21.5;	Z2.0	
Y0;	M03;	O****(SYATYOU4)
G03X-21.5R21.5;	G01Z-8.0F50;	=外形加工
Y-4.0;	G41Y-15.0D05;	OffSetD05 3.0→2.5
X-35.0;	G02X-13.569Y-6.394R15.0;	EndMill5Φ
Y4.0;	G03X-15.811Y-5.0R2.5;	

品名			
図番	No	設計製図	
縮尺	/	日付	/ /