

Tesla-Turbine

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1. Fräsprogramme für CNC-Fräse (G-Code)

1.1 Platter

(Material: Aluminium)
(Fräser-Durchmesser = 3 mm)
(Eintauchtiefe = 1.000 mm)
(Vorschub: X/Y= 150 mm/min, Z=50 mm/min)
(Max X = 51.646 mm)
(Max Y = 53.497 mm)
(Kreismittelpunkt: x = 30,675 mm / y = 32,475 mm)
%Platter
G90
G71T1M6
M03
G00Z2.000
G00X23.175Y19.475
G01Z-1.000 F50
G00Z2.000
G00X23.150Y45.500
G01Z-1.000
G00Z2.000
G00X45.675Y32.475
G01Z-1.000
G00Z2.000
G00X20.417Y16.481
G00Z2.000
G01Z-1.000
G01X22.752Y15.206 F150
G01X25.254Y14.281
G01X27.881Y13.712
G01X30.602Y13.497
G01X32.112Y13.571
G01X32.680Y13.514
G01X32.980Y13.341
G01X33.217Y13.046
G01X33.328Y12.662
G01X33.289Y12.286
G01X33.102Y11.951
G01X32.837Y11.732
G01X32.329Y11.589
G01X30.644Y11.502
G01X27.617Y11.737
G01X24.695Y12.368
G01X21.919Y13.395
G01X19.332Y14.793
G01X16.979Y16.541
G01X14.878Y18.618
G01X13.057Y21.000
G01X11.638Y23.544
G01X11.527Y24.028
G01X11.583Y24.389
G01X11.773Y24.692
G01X12.099Y24.937
G01X12.458Y25.022
G01X12.841Y24.961
G01X13.159Y24.778
G01X13.511Y24.309
G01X14.738Y22.080
G01X16.370Y19.932
G01X18.274Y18.055
G01X20.417Y16.481
G00Z2.000
G00X20.462Y48.540
G01Z-1.000 F50
G01X18.320Y46.940 F150
G01X16.420Y45.067
G01X14.795Y42.927
G01X13.535Y40.710
G01X13.195Y40.238
G01X12.891Y40.063
G01X12.508Y40.002
G01X12.134Y40.091
G01X11.824Y40.314
G01X11.635Y40.625
G01X11.577Y40.996
G01X11.688Y41.480
G01X13.107Y44.024
G01X14.925Y46.403
G01X17.025Y48.456
G01X19.387Y50.209
G01X21.974Y51.631
G01X24.745Y52.656
G01X27.661Y53.286
G01X30.698Y53.497
G01X32.384Y53.433
G01X32.871Y53.292
G01X33.158Y53.062
G01X33.339Y52.738
G01X33.378Y52.362
G01X33.267Y51.978
G01X33.037Y51.691

G01X32.713Y51.510
G01X32.147Y51.452
G01X30.647Y51.501
G01X27.938Y51.313
G01X25.304Y50.743
G01X22.802Y49.818
G01X20.462Y48.540
G00Z2.000
G00X49.654Y32.500
G01Z-1.000 F50
G01X49.437Y35.400 F150
G01X48.784Y38.229
G01X47.699Y40.888
G01X46.299Y43.299
G01X46.091Y43.779
G01X46.082Y44.137
G01X46.218Y44.488
G01X46.483Y44.772
G01X46.835Y44.925
G01X47.212Y44.925
G01X47.563Y44.798
G01X47.912Y44.461
G01X49.501Y41.783
G01X50.689Y38.823
G01X51.412Y35.700
G01X51.646Y32.500
G01X51.412Y29.299
G01X50.689Y26.176
G01X49.501Y23.216
G01X47.912Y20.538
G01X47.563Y20.201
G01X47.212Y20.075
G01X46.835Y20.075
G01X46.483Y20.227
G01X46.218Y20.511
G01X46.082Y20.862
G01X46.091Y21.220
G01X46.340Y21.795
G01X47.699Y24.110
G01X48.784Y26.796
G01X49.437Y29.597
G01X49.654Y32.500
G00Z2.000
G00X20.417Y16.481
G00Z2.000
G01Z-1.000
G01X22.752Y15.206 F250
G01X25.254Y14.281
G01X27.881Y13.712
G01X30.602Y13.497

G01X32.112Y13.571
G01X32.680Y13.514
G01X32.980Y13.341
G01X33.217Y13.046
G01X33.328Y12.662
G01X33.289Y12.286
G01X33.102Y11.951
G01X32.837Y11.732
G01X32.329Y11.589
G01X30.644Y11.502
G01X27.617Y11.737
G01X24.695Y12.368
G01X21.919Y13.395
G01X19.332Y14.793
G01X16.979Y16.541
G01X14.878Y18.618
G01X13.057Y21.000
G01X11.638Y23.544
G01X11.527Y24.028
G01X11.583Y24.389
G01X11.773Y24.692
G01X12.099Y24.937
G01X12.458Y25.022
G01X12.841Y24.961
G01X13.159Y24.778
G01X13.511Y24.309
G01X14.738Y22.080
G01X16.370Y19.932
G01X18.274Y18.055
G01X20.417Y16.481
G00Z2.000
G00X20.462Y48.540
G01Z-1.000 F50
G01X18.320Y46.940 F250
G01X16.420Y45.067
G01X14.795Y42.927
G01X13.535Y40.710
G01X13.195Y40.238
G01X12.891Y40.063
G01X12.508Y40.002
G01X12.134Y40.091
G01X11.824Y40.314
G01X11.635Y40.625
G01X11.577Y40.996
G01X11.688Y41.480
G01X13.107Y44.024
G01X14.925Y46.403
G01X17.025Y48.456
G01X19.387Y50.209
G01X21.974Y51.631

G01X24.745Y52.656
G01X27.661Y53.286
G01X30.698Y53.497
G01X32.384Y53.433
G01X32.871Y53.292
G01X33.158Y53.062
G01X33.339Y52.738
G01X33.378Y52.362
G01X33.267Y51.978
G01X33.037Y51.691
G01X32.713Y51.510
G01X32.147Y51.452
G01X30.647Y51.501
G01X27.938Y51.313
G01X25.304Y50.743
G01X22.802Y49.818
G01X20.462Y48.540
G00Z2.000
G00X49.654Y32.500
G01Z-1.000 F50
G01X49.437Y35.400 F250
G01X48.784Y38.229
G01X47.699Y40.888
G01X46.299Y43.299
G01X46.091Y43.779
G01X46.082Y44.137
G01X46.218Y44.488

G01X46.483Y44.772
G01X46.835Y44.925
G01X47.212Y44.925
G01X47.563Y44.798
G01X47.912Y44.461
G01X49.501Y41.783
G01X50.689Y38.823
G01X51.412Y35.700
G01X51.646Y32.500
G01X51.412Y29.299
G01X50.689Y26.176
G01X49.501Y23.216
G01X47.912Y20.538
G01X47.563Y20.201
G01X47.212Y20.075
G01X46.835Y20.075
G01X46.483Y20.227
G01X46.218Y20.511
G01X46.082Y20.862
G01X46.091Y21.220
G01X46.340Y21.795
G01X47.699Y24.110
G01X48.784Y26.796
G01X49.437Y29.597
G01X49.654Y32.500
G00Z2.000
M30

1.2 Passscheibe

(Material: Edelstahl)
(Fräser-Durchmesser = 3 mm)
(Eintauchtiefe = 1.000 mm)
(Vorschub: Z=20 mm/min)
(Max X = 32.525 mm)
(Max Y = 36.025 mm)
(Kreismittelpunkt: x = 17,5 mm / y =
22,975 mm)
%Passscheibe
G90
G71T1M6
M03
G00Z2.000

G00X10.000Y10.000
G01Z0.000 F100
G01Z-1.000 F20
G00Z2.000
G00X32.500Y22.975
G01Z0.000 F100
G01Z-1.000 F20
G00Z2.000
G00X10.000Y36.025
G01Z0.000 F100
G01Z-1.000 F20
G00Z10.000
M30

1.3 Gehäuse 5

(Material: Aluminium)
(Fräser-Durchmesser = 6 mm)
(Eintauchtiefe = 2.500 mm)
(Vorschub: X/Y= 100 mm/min, Z=30 mm/min)
(Materialdicke = 10.000 mm)
(Max X = 57.397 mm)
(Max Y = 49.426 mm)
(Kreismittelpunkt: x = 20,325 mm / y = 16 mm)
%Gehäuse 5
G90
G71T3M6
M03
G00Z10.000
G00X36.275Y47.850
G01Z0.000 F100
G01Z-2.500 F30
G01X38.525Y46.850 F100
G01X40.650Y45.700
G01X42.700Y44.400
G01X44.600Y42.950
G01X46.400Y41.375
G01X48.075Y39.675
G01X51.000Y35.900
G01X53.350Y31.750
G01X54.275Y29.550
G01X55.075Y27.300
G01X55.700Y24.975
G01X56.150Y22.575
G01X56.500Y17.700
G01X56.475Y15.750
G01X56.275Y13.800
G01X16.700Y13.800
G01X35.200Y45.825
G01X37.200Y44.950
G01X39.125Y43.925
G01X42.750Y41.425
G01X46.025Y38.425
G01X48.875Y35.000
G01X51.225Y31.225
G01X52.975Y27.200
G01X53.625Y25.125
G01X54.100Y23.000
G01X54.375Y20.850
G01X54.475Y18.700
G01X54.175Y14.500

G01X19.200Y14.500
G01X35.750Y43.125
G01X39.100Y41.500
G01X42.225Y39.325
G01X45.075Y36.725
G01X47.550Y33.750
G01X49.600Y30.500
G01X51.125Y27.000
G01X52.125Y23.375
G01X52.450Y19.675
G01X52.175Y16.100
G01X22.225Y16.075
G01X36.400Y40.625
G01X39.200Y39.225
G01X41.825Y37.375
G01X44.225Y35.150
G01X46.325Y32.600
G01X48.075Y29.800
G01X49.400Y26.825
G01X50.250Y23.775
G01X50.525Y20.675
G01X50.300Y17.675
G01X25.325Y17.675
G01X36.925Y37.700
G01X39.175Y36.600
G01X41.325Y35.100
G01X43.300Y33.275
G01X45.050Y31.200
G01X46.500Y28.925
G01X47.600Y26.500
G01X48.325Y24.025
G01X48.575Y21.550
G01X48.375Y19.150
G01X28.400Y19.150
G01X37.550Y34.975
G01X39.250Y34.125
G01X40.900Y32.975
G01X42.425Y31.550
G01X43.775Y29.925
G01X44.900Y28.175
G01X45.775Y26.300
G01X46.350Y24.400
G01X46.525Y22.525
G01X46.400Y20.725
G01X31.425Y20.725
G01X37.975Y32.100
G01X39.150Y31.525

G01X40.300Y30.725
G01X41.425Y29.750
G01X42.425Y28.625
G01X43.300Y27.400
G01X43.975Y26.125
G01X44.400Y24.850
G01X44.550Y23.575
G01X44.475Y22.375
G01X34.475Y22.375
G01X38.375Y29.125
G01X42.200Y24.575
G00Z10.000
G00X36.275Y47.850
G01Z-2.500 F100
G01Z-5.000 F30
G01X38.525Y46.850 F100
G01X40.650Y45.700
G01X42.700Y44.400
G01X44.600Y42.950
G01X46.400Y41.375
G01X48.075Y39.675
G01X51.000Y35.900
G01X53.350Y31.750
G01X54.275Y29.550
G01X55.075Y27.300
G01X55.700Y24.975
G01X56.150Y22.575
G01X56.500Y17.700
G01X56.475Y15.750
G01X56.275Y13.800
G01X16.700Y13.800
G01X35.200Y45.825
G01X37.200Y44.950
G01X39.125Y43.925
G01X42.750Y41.425
G01X46.025Y38.425
G01X48.875Y35.000
G01X51.225Y31.225
G01X52.975Y27.200
G01X53.625Y25.125
G01X54.100Y23.000
G01X54.375Y20.850
G01X54.475Y18.700
G01X54.175Y14.500
G01X19.200Y14.500
G01X35.750Y43.125
G01X39.100Y41.500
G01X42.225Y39.325
G01X45.075Y36.725
G01X47.550Y33.750

G01X49.600Y30.500
G01X51.125Y27.000
G01X52.125Y23.375
G01X52.450Y19.675
G01X52.175Y16.100
G01X22.225Y16.075
G01X36.400Y40.625
G01X39.200Y39.225
G01X41.825Y37.375
G01X44.225Y35.150
G01X46.325Y32.600
G01X48.075Y29.800
G01X49.400Y26.825
G01X50.250Y23.775
G01X50.525Y20.675
G01X50.300Y17.675
G01X25.325Y17.675
G01X36.925Y37.700
G01X39.175Y36.600
G01X41.325Y35.100
G01X43.300Y33.275
G01X45.050Y31.200
G01X46.500Y28.925
G01X47.600Y26.500
G01X48.325Y24.025
G01X48.575Y21.550
G01X48.375Y19.150
G01X28.400Y19.150
G01X37.550Y34.975
G01X39.250Y34.125
G01X40.900Y32.975
G01X42.425Y31.550
G01X43.775Y29.925
G01X44.900Y28.175
G01X45.775Y26.300
G01X46.350Y24.400
G01X46.525Y22.525
G01X46.400Y20.725
G01X31.425Y20.725
G01X37.975Y32.100
G01X39.150Y31.525
G01X40.300Y30.725
G01X41.425Y29.750
G01X42.425Y28.625
G01X43.300Y27.400
G01X43.975Y26.125
G01X44.400Y24.850
G01X44.550Y23.575
G01X44.475Y22.375
G01X34.475Y22.375

G01X38.375Y29.125
G01X42.200Y24.575
G00Z10.000
G00X36.275Y47.850
G01Z-5.000 F100
G01Z-7.500 F30
G01X38.525Y46.850 F100
G01X40.650Y45.700
G01X42.700Y44.400
G01X44.600Y42.950
G01X46.400Y41.375
G01X48.075Y39.675
G01X51.000Y35.900
G01X53.350Y31.750
G01X54.275Y29.550
G01X55.075Y27.300
G01X55.700Y24.975
G01X56.150Y22.575
G01X56.500Y17.700
G01X56.475Y15.750
G01X56.275Y13.800
G01X16.700Y13.800
G01X35.200Y45.825
G01X37.200Y44.950
G01X39.125Y43.925
G01X42.750Y41.425
G01X46.025Y38.425
G01X48.875Y35.000
G01X51.225Y31.225
G01X52.975Y27.200
G01X53.625Y25.125
G01X54.100Y23.000
G01X54.375Y20.850
G01X54.475Y18.700
G01X54.175Y14.500
G01X19.200Y14.500
G01X35.750Y43.125
G01X39.100Y41.500
G01X42.225Y39.325
G01X45.075Y36.725
G01X47.550Y33.750
G01X49.600Y30.500
G01X51.125Y27.000
G01X52.125Y23.375
G01X52.450Y19.675
G01X52.175Y16.100
G01X22.225Y16.075
G01X36.400Y40.625
G01X39.200Y39.225
G01X41.825Y37.375

G01X44.225Y35.150
G01X46.325Y32.600
G01X48.075Y29.800
G01X49.400Y26.825
G01X50.250Y23.775
G01X50.525Y20.675
G01X50.300Y17.675
G01X25.325Y17.675
G01X36.925Y37.700
G01X39.175Y36.600
G01X41.325Y35.100
G01X43.300Y33.275
G01X45.050Y31.200
G01X46.500Y28.925
G01X47.600Y26.500
G01X48.325Y24.025
G01X48.575Y21.550
G01X48.375Y19.150
G01X28.400Y19.150
G01X37.550Y34.975
G01X39.250Y34.125
G01X40.900Y32.975
G01X42.425Y31.550
G01X43.775Y29.925
G01X44.900Y28.175
G01X45.775Y26.300
G01X46.350Y24.400
G01X46.525Y22.525
G01X46.400Y20.725
G01X31.425Y20.725
G01X37.975Y32.100
G01X39.150Y31.525
G01X40.300Y30.725
G01X41.425Y29.750
G01X42.425Y28.625
G01X43.300Y27.400
G01X43.975Y26.125
G01X44.400Y24.850
G01X44.550Y23.575
G01X44.475Y22.375
G01X34.475Y22.375
G01X38.375Y29.125
G01X42.200Y24.575
G00Z10.000
G00X36.275Y47.850
G01Z-7.500 F100
G01Z-10.000 F30
G01X38.525Y46.850 F100
G01X40.650Y45.700
G01X42.700Y44.400

G01X44.600Y42.950
G01X46.400Y41.375
G01X48.075Y39.675
G01X51.000Y35.900
G01X53.350Y31.750
G01X54.275Y29.550
G01X55.075Y27.300
G01X55.700Y24.975
G01X56.150Y22.575
G01X56.500Y17.700
G01X56.475Y15.750
G01X56.275Y13.800
G01X16.700Y13.800
G01X35.200Y45.825
G01X37.200Y44.950
G01X39.125Y43.925
G01X42.750Y41.425
G01X46.025Y38.425
G01X48.875Y35.000
G01X51.225Y31.225
G01X52.975Y27.200
G01X53.625Y25.125
G01X54.100Y23.000
G01X54.375Y20.850
G01X54.475Y18.700
G01X54.175Y14.500
G01X19.200Y14.500
G01X35.750Y43.125
G01X39.100Y41.500
G01X42.225Y39.325
G01X45.075Y36.725
G01X47.550Y33.750
G01X49.600Y30.500
G01X51.125Y27.000
G01X52.125Y23.375
G01X52.450Y19.675
G01X52.175Y16.100
G01X22.225Y16.075
G01X36.400Y40.625
G01X39.200Y39.225
G01X41.825Y37.375
G01X44.225Y35.150
G01X46.325Y32.600
G01X48.075Y29.800
G01X49.400Y26.825
G01X50.250Y23.775
G01X50.525Y20.675
G01X50.300Y17.675
G01X25.325Y17.675
G01X36.925Y37.700

G01X39.175Y36.600
G01X41.325Y35.100
G01X43.300Y33.275
G01X45.050Y31.200
G01X46.500Y28.925
G01X47.600Y26.500
G01X48.325Y24.025
G01X48.575Y21.550
G01X48.375Y19.150
G01X28.400Y19.150
G01X37.550Y34.975
G01X39.250Y34.125
G01X40.900Y32.975
G01X42.425Y31.550
G01X43.775Y29.925
G01X44.900Y28.175
G01X45.775Y26.300
G01X46.350Y24.400
G01X46.525Y22.525
G01X46.400Y20.725
G01X31.425Y20.725
G01X37.975Y32.100
G01X39.150Y31.525
G01X40.300Y30.725
G01X41.425Y29.750
G01X42.425Y28.625
G01X43.300Y27.400
G01X43.975Y26.125
G01X44.400Y24.850
G01X44.550Y23.575
G01X44.475Y22.375
G01X34.475Y22.375
G01X38.375Y29.125
G01X42.200Y24.575
G00Z10.000
G00X15.199Y13.000
G01Z0.000 F100
G01Z-2.500 F30
G01X36.254Y49.426 F100
G01X36.491Y49.322
G01X38.970Y48.002
G01X41.324Y46.525
G01X43.547Y44.857
G01X45.636Y43.071
G01X47.571Y41.136
G01X49.349Y39.057
G01X50.969Y36.858
G01X52.422Y34.552
G01X53.697Y32.118
G01X54.807Y29.620

G01X55.709Y27.031
G01X56.452Y24.338
G01X56.981Y21.625
G01X57.281Y18.852
G01X57.397Y15.989
G01X57.305Y13.224
G01X57.279Y13.000
G01X15.199Y13.000
G00Z10.000
G00X15.199Y13.000
G01Z-2.500 F100
G01Z-5.000 F30
G01X36.254Y49.426 F100
G01X36.491Y49.322
G01X38.970Y48.002
G01X41.324Y46.525
G01X43.547Y44.857
G01X45.636Y43.071
G01X47.571Y41.136
G01X49.349Y39.057
G01X50.969Y36.858
G01X52.422Y34.552
G01X53.697Y32.118
G01X54.807Y29.620
G01X55.709Y27.031
G01X56.452Y24.338
G01X56.981Y21.625
G01X57.281Y18.852
G01X57.397Y15.989
G01X57.305Y13.224
G01X57.279Y13.000
G01X15.199Y13.000
G00Z10.000
G00X15.199Y13.000
G01Z-5.000 F100
G01Z-7.500 F30
G01X36.254Y49.426 F100
G01X36.491Y49.322
G01X38.970Y48.002
G01X41.324Y46.525
G01X43.547Y44.857

G01X45.636Y43.071
G01X47.571Y41.136
G01X49.349Y39.057
G01X50.969Y36.858
G01X52.422Y34.552
G01X53.697Y32.118
G01X54.807Y29.620
G01X55.709Y27.031
G01X56.452Y24.338
G01X56.981Y21.625
G01X57.281Y18.852
G01X57.397Y15.989
G01X57.305Y13.224
G01X57.279Y13.000
G01X15.199Y13.000
G00Z10.000
G00X15.199Y13.000
G01Z-7.500 F100
G01Z-10.000 F30
G01X36.254Y49.426 F100
G01X36.491Y49.322
G01X38.970Y48.002
G01X41.324Y46.525
G01X43.547Y44.857
G01X45.636Y43.071
G01X47.571Y41.136
G01X49.349Y39.057
G01X50.969Y36.858
G01X52.422Y34.552
G01X53.697Y32.118
G01X54.807Y29.620
G01X55.709Y27.031
G01X56.452Y24.338
G01X56.981Y21.625
G01X57.281Y18.852
G01X57.397Y15.989
G01X57.305Y13.224
G01X57.279Y13.000
G01X15.199Y13.000
G00Z10.000
M30

1.4 Zeiger

(Material: Aluminium)
(Fräser-Durchmesser = 6 mm)
(Eintauchtiefe = 1.000 mm)
(Vorschub: X/Y= 200 mm/min, Z=50 mm/min)
(Materialdicke = 10.000 mm)
(Max X = 23.000 mm)
(Max Y = 61.500 mm)
(Referenzpunkt-rechts unten: X = 20 mm / Y = 10 mm)
%Zeiger
G90
G71T1M6
M03
G00Z10.000
G00X21.242Y7.000
G01Z0.000 F100
G01Z-1.000 F50
G01X23.000Y8.757 F200
G01X23.000Y49.208
G01X16.854Y61.500
G01X13.145Y61.500
G01X7.000Y49.208
G01X7.000Y8.757
G01X8.757Y7.000
G01X21.242Y7.000
G00Z10.000
G00X21.242Y7.000
G01Z0.000 F100
G01Z-2.000 F50
G01X23.000Y8.757 F200
G01X23.000Y49.208
G01X16.854Y61.500
G01X13.145Y61.500
G01X7.000Y49.208
G01X7.000Y8.757
G01X8.757Y7.000
G01X21.242Y7.000
G00Z10.000
G00X21.242Y7.000
G01Z0.000 F100
G01Z-3.000 F50
G01X23.000Y8.757 F200
G01X23.000Y49.208
G01X16.854Y61.500
G01X13.145Y61.500
G01X7.000Y49.208

G01X7.000Y8.757
G01X8.757Y7.000
G01X21.242Y7.000
G00Z10.000
G00X21.242Y7.000
G01Z0.000 F100
G01Z-4.000 F50
G01X23.000Y8.757 F200
G01X23.000Y49.208
G01X16.854Y61.500
G01X13.145Y61.500
G01X7.000Y49.208
G01X7.000Y8.757
G01X8.757Y7.000
G01X21.242Y7.000
G00Z10.000
G00X21.242Y7.000
G01Z0.000 F100
G01Z-5.000 F50
G01X23.000Y8.757 F200
G01X23.000Y49.208
G01X16.854Y61.500
G01X13.145Y61.500
G01X7.000Y49.208
G01X7.000Y8.757
G01X8.757Y7.000
G01X21.242Y7.000
G00Z10.000
G00X21.242Y7.000
G01Z0.000 F100
G01Z-6.000 F50
G01X23.000Y8.757 F200
G01X23.000Y49.208
G01X16.854Y61.500
G01X13.145Y61.500
G01X7.000Y49.208
G01X7.000Y8.757
G01X8.757Y7.000
G01X21.242Y7.000
G00Z10.000
G00X21.242Y7.000
G01Z0.000 F100
G01Z-7.000 F50
G01X23.000Y8.757 F200
G01X23.000Y49.208
G01X16.854Y61.500
G01X13.145Y61.500

G01X7.000Y49.208
G01X7.000Y8.757
G01X8.757Y7.000
G01X21.242Y7.000
G00Z10.000
G00X21.242Y7.000
G01Z0.000 F100
G01Z-8.000 F50
G01X23.000Y8.757 F200
G01X23.000Y49.208
G01X16.854Y61.500
G01X13.145Y61.500
G01X7.000Y49.208
G01X7.000Y8.757
G01X8.757Y7.000
G01X21.242Y7.000
G00Z10.000
G00X21.242Y7.000
G01Z0.000 F100
G01Z-9.000 F50
G01X23.000Y8.757 F200

G01X23.000Y49.208
G01X16.854Y61.500
G01X13.145Y61.500
G01X7.000Y49.208
G01X7.000Y8.757
G01X8.757Y7.000
G01X21.242Y7.000
G00Z10.000
G00X21.242Y7.000
G01Z0.000 F100
G01Z-10.000 F50
G01X23.000Y8.757 F200
G01X23.000Y49.208
G01X16.854Y61.500
G01X13.145Y61.500
G01X7.000Y49.208
G01X7.000Y8.757
G01X8.757Y7.000
G01X21.242Y7.000
G00Z10.000
M30

1.5 Gehäuse 9

(Material: Aluminium)
(Fräser-Durchmesser = 6 mm)
(Eintauchtiefe = 2.650 mm)
(Vorschub: X/Y= 120 mm/min, Z=30 mm/min)
(Materialdicke = 5.300 mm)
(Max X = 46.294 mm)
(Max Y = 49.433 mm)
(Kreismittelpunkt: x = 50.075 mm / y = 16 mm)
%Gehäuse 9
G90
G71T3M6
M03
G00Z10.000
G00X34.125Y47.850
G01Z0.000 F120
G01Z-2.650 F30
G01X31.875Y46.850 F120
G01X29.750Y45.700
G01X27.700Y44.400
G01X25.800Y42.950
G01X24.000Y41.375
G01X22.350Y39.675
G01X19.425Y35.900
G01X17.075Y31.750
G01X16.125Y29.550
G01X15.325Y27.300
G01X14.700Y24.975
G01X14.250Y22.575
G01X13.900Y17.700
G01X13.925Y15.750
G01X14.125Y13.800
G01X36.175Y13.800
G01X36.000Y15.925
G01X36.175Y18.050
G01X36.625Y20.100
G01X37.400Y22.050
G01X38.450Y23.850
G01X39.725Y25.450
G01X41.250Y26.875
G01X43.000Y28.050
G01X44.925Y28.975
G01X35.200Y45.825
G01X33.200Y44.950
G01X31.275Y43.925
G01X27.650Y41.425
G01X24.375Y38.425

G01X21.525Y35.000
G01X19.200Y31.225
G01X17.425Y27.200
G01X16.775Y25.125
G01X16.300Y23.000
G01X16.025Y20.850
G01X15.925Y18.700
G01X16.225Y14.500
G01X34.075Y14.500
G01X34.000Y15.925
G01X34.150Y18.075
G01X34.575Y20.175
G01X35.275Y22.175
G01X36.225Y24.050
G01X37.425Y25.800
G01X38.850Y27.375
G01X40.475Y28.775
G01X42.275Y29.925
G01X34.650Y43.125
G01X31.300Y41.500
G01X28.175Y39.325
G01X25.325Y36.725
G01X22.850Y33.750
G01X20.800Y30.500
G01X19.275Y27.000
G01X18.300Y23.375
G01X17.950Y19.675
G01X18.225Y16.100
G01X32.000Y16.075
G01X32.125Y18.300
G01X32.525Y20.425
G01X33.150Y22.450
G01X34.000Y24.375
G01X35.125Y26.200
G01X36.450Y27.850
G01X37.975Y29.375
G01X39.750Y30.700
G01X34.025Y40.625
G01X31.200Y39.225
G01X28.575Y37.375
G01X26.175Y35.150
G01X24.075Y32.600
G01X22.325Y29.800
G01X21.000Y26.825
G01X20.150Y23.775
G01X19.875Y20.675
G01X20.100Y17.675
G01X30.075Y17.675

G01X30.325Y19.700
G01X30.750Y21.650
G01X31.375Y23.500
G01X32.175Y25.250
G01X33.150Y26.900
G01X34.325Y28.475
G01X35.675Y29.925
G01X37.200Y31.275
G01X33.500Y37.700
G01X31.225Y36.600
G01X29.075Y35.100
G01X27.100Y33.275
G01X25.375Y31.200
G01X23.900Y28.925
G01X22.800Y26.500
G01X22.100Y24.025
G01X21.850Y21.550
G01X22.025Y19.150
G01X28.225Y19.150
G01X29.025Y22.750
G01X30.350Y26.050
G01X32.225Y29.075
G01X34.700Y31.800
G01X32.850Y34.975
G01X31.150Y34.125
G01X29.500Y32.975
G01X28.000Y31.550
G01X26.650Y29.925
G01X25.500Y28.175
G01X24.625Y26.300
G01X24.075Y24.400
G01X23.875Y22.525
G01X24.000Y20.725
G01X26.500Y20.725
G01X27.300Y23.900
G01X28.525Y26.800
G01X30.125Y29.500
G01X32.200Y32.025
G00Z10.000
G00X34.125Y47.850
G01Z0.000 F120
G01Z-5.300 F30
G01X31.875Y46.850 F120
G01X29.750Y45.700
G01X27.700Y44.400
G01X25.800Y42.950
G01X24.000Y41.375
G01X22.350Y39.675
G01X19.425Y35.900
G01X17.075Y31.750

G01X16.125Y29.550
G01X15.325Y27.300
G01X14.700Y24.975
G01X14.250Y22.575
G01X13.900Y17.700
G01X13.925Y15.750
G01X14.125Y13.800
G01X36.175Y13.800
G01X36.000Y15.925
G01X36.175Y18.050
G01X36.625Y20.100
G01X37.400Y22.050
G01X38.450Y23.850
G01X39.725Y25.450
G01X41.250Y26.875
G01X43.000Y28.050
G01X44.925Y28.975
G01X35.200Y45.825
G01X33.200Y44.950
G01X31.275Y43.925
G01X27.650Y41.425
G01X24.375Y38.425
G01X21.525Y35.000
G01X19.200Y31.225
G01X17.425Y27.200
G01X16.775Y25.125
G01X16.300Y23.000
G01X16.025Y20.850
G01X15.925Y18.700
G01X16.225Y14.500
G01X34.075Y14.500
G01X34.000Y15.925
G01X34.150Y18.075
G01X34.575Y20.175
G01X35.275Y22.175
G01X36.225Y24.050
G01X37.425Y25.800
G01X38.850Y27.375
G01X40.475Y28.775
G01X42.275Y29.925
G01X34.650Y43.125
G01X31.300Y41.500
G01X28.175Y39.325
G01X25.325Y36.725
G01X22.850Y33.750
G01X20.800Y30.500
G01X19.275Y27.000
G01X18.300Y23.375
G01X17.950Y19.675
G01X18.225Y16.100

G01X32.000Y16.075
G01X32.125Y18.300
G01X32.525Y20.425
G01X33.150Y22.450
G01X34.000Y24.375
G01X35.125Y26.200
G01X36.450Y27.850
G01X37.975Y29.375
G01X39.750Y30.700
G01X34.025Y40.625
G01X31.200Y39.225
G01X28.575Y37.375
G01X26.175Y35.150
G01X24.075Y32.600
G01X22.325Y29.800
G01X21.000Y26.825
G01X20.150Y23.775
G01X19.875Y20.675
G01X20.100Y17.675
G01X30.075Y17.675
G01X30.325Y19.700
G01X30.750Y21.650
G01X31.375Y23.500
G01X32.175Y25.250
G01X33.150Y26.900
G01X34.325Y28.475
G01X35.675Y29.925
G01X37.200Y31.275
G01X33.500Y37.700
G01X31.225Y36.600
G01X29.075Y35.100
G01X27.100Y33.275
G01X25.375Y31.200
G01X23.900Y28.925
G01X22.800Y26.500
G01X22.100Y24.025
G01X21.850Y21.550
G01X22.025Y19.150
G01X28.225Y19.150
G01X29.025Y22.750
G01X30.350Y26.050
G01X32.225Y29.075
G01X34.700Y31.800
G01X32.850Y34.975
G01X31.150Y34.125
G01X29.500Y32.975
G01X28.000Y31.550
G01X26.650Y29.925
G01X25.500Y28.175
G01X24.625Y26.300

G01X24.075Y24.400
G01X23.875Y22.525
G01X24.000Y20.725
G01X26.500Y20.725
G01X27.300Y23.900
G01X28.525Y26.800
G01X30.125Y29.500
G01X32.200Y32.025
G00Z10.000
G00X36.534Y13.000
G01Z0.000 F120
G01Z-2.650 F30
G01X13.142Y13.000 F120
G01X13.118Y13.224
G01X13.002Y16.001
G01X13.117Y18.839
G01X13.442Y21.625
G01X13.950Y24.349
G01X14.690Y27.031
G01X15.592Y29.620
G01X16.702Y32.118
G01X17.977Y34.552
G01X19.430Y36.858
G01X21.050Y39.057
G01X22.828Y41.136
G01X24.763Y43.071
G01X26.852Y44.857
G01X29.075Y46.525
G01X31.429Y48.002
G01X33.904Y49.320
G01X34.164Y49.433
G01X45.806Y29.267
G01X45.806Y29.267
G01X46.294Y28.422
G01X44.931Y28.004
G01X42.708Y26.795
G01X40.794Y25.205
G01X39.193Y23.277
G01X38.023Y21.068
G01X37.245Y18.636
G01X36.988Y16.030
G01X37.152Y13.927
G01X37.377Y13.000
G01X36.534Y13.000
G00Z10.000
G00X36.534Y13.000
G01Z0.000 F120
G01Z-5.300 F30
G01X13.142Y13.000 F120
G01X13.118Y13.224

G01X13.002Y16.001
G01X13.117Y18.839
G01X13.442Y21.625
G01X13.950Y24.349
G01X14.690Y27.031
G01X15.592Y29.620
G01X16.702Y32.118
G01X17.977Y34.552
G01X19.430Y36.858
G01X21.050Y39.057
G01X22.828Y41.136
G01X24.763Y43.071
G01X26.852Y44.857
G01X29.075Y46.525
G01X31.429Y48.002
G01X33.904Y49.320

G01X34.164Y49.433
G01X45.806Y29.267
G01X45.806Y29.267
G01X46.294Y28.422
G01X44.931Y28.004
G01X42.708Y26.795
G01X40.794Y25.205
G01X39.193Y23.277
G01X38.023Y21.068
G01X37.245Y18.636
G01X36.988Y16.030
G01X37.152Y13.927
G01X37.377Y13.000
G01X36.534Y13.000
G00Z10.000
M30