



Universidad de Santiago de Chile
Facultad de Ingeniería
Departamento de Ingeniería Mecánica



Ayudantía 4 código G

SISTEMAS MODERNOS DE MANUFACTURA

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1. Código

```
1
2 O2000;
3 S1500;
4 F200;
5 G90;
6
7 (operaci n face, fresa 15mm)
8 G00 Z10.;
9 G30 Z10.;
10 T01 M06;
11 G43 H01 Z10.;
12
13 G00 X[7.5-2.5] Y100.;
14 G00 Z10.;
15 G01 Z0.;
16 G91;
17 M98 P2001;(Ciclo mecanizado)
18 G90;
19
20 G00 X[75] Y100.;
21 G00 Z0.;
22 G91;
23 M98 P2002;
24 G90;
25
26 G00 X[50.] Y0.;
27 G00 Z0.;
28 G91;
29 M98 P2003;
30 G90;
31
32
33 M05;
34 M30;
35
36 O2001;
37 #1=1.;
38 #2=1
39 #3=1.;(Alternador)
40 WHILE [#1 LE 20] DO 1
41 G01 Z-1.;
42 WHILE [#2 LE 6] DO 2
43 G01 Y[-125.*#3];
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44 IF [#2 EQ 6] GOTO 100
45 G01 X[12.5];
46 N100;
47 #2=[#2+1];
48 #3=[-#3];
49 END 2;
50 Z50.;
51 G90;
52 IF[#1 EQ 20] GOTO 101
53 G00 X[7.5-2.5] Y100.;
54 G91;
55 Z-50.;
56 N101;
57 #1=[#1+1];
58 #2=1;
59 #3=1;
60 END 1;
61 M99;
62
63 O2002;(MILANO EN X)
64 #1=1.;
65 #2=1
66 #3=1.;(Alternador)
67 WHILE [#1 LE 5] DO 1
68 G01 Z-0.866;
69 WHILE [#2 LE 6] DO 2
70 G01 Y[-125.*#3];
71 IF [#2 EQ 6] GOTO 102
72 G01 X[15.];
73 N102;
74 #2=[#2+1];
75 #3=[-#3];
76 END 2;
77 Z50.;
78 G90;
79 IF[#1 EQ 5] GOTO 103
80 G00 X[75] Y100.;
81 G91;
82 Z-50.;
83 N103;
84 #1=[#1+1];
85 #2=1;
86 #3=1;
87 END 1;
88 M99;

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```
89 O2003;(MILANO EN X)
90 #1=1.;
91 #2=1
92 #3=1.;(Alternador)
93 WHILE [#1 LE 5] DO 1
94 G01 Z-0.866;
95 WHILE [#2 LE 6] DO 2
96 G01 X[125.*#3];
97 IF [#2 EQ 6] GOTO 102
98 G01 Y[15.];
99 N102;
100 #2=[#2+1];
101 #3=[-#3];
102 END 2;
103 Z50.;
104 G90;
105 IF[#1 EQ 5] GOTO 103
106 G00 X[50] Y0.;
107 G91;
108 Z-50.;
109 N103;
110 #1=[#1+1];
111 #2=1;
112 #3=1;
113 END 1;
114 M99;
```