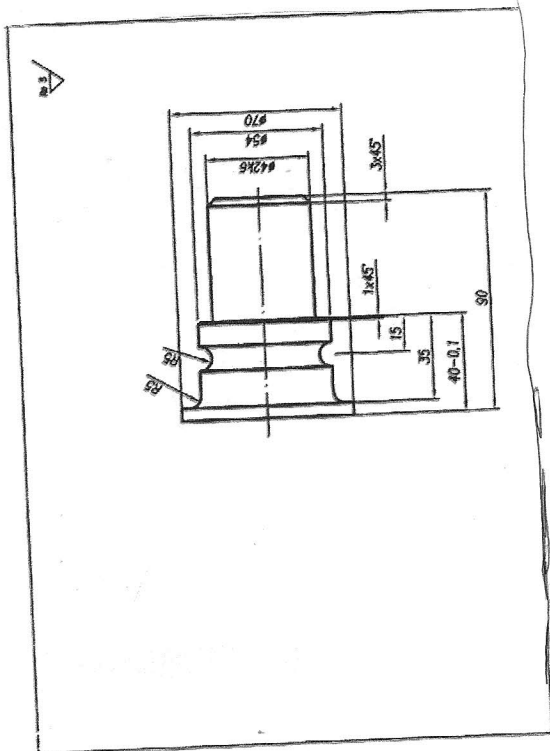


Warpak - nie mogl sie spierac
Materiał - aluminium

$v_t = 300 \text{ m/min}$

$a_p = 2 \text{ mm}$



Obrotów
 $n = \frac{1000 \cdot v}{\pi d} = 1400 \text{ obr/min}$

Posuw

$f_{max} = f_a - 5 = 5.5 = 25$

$f = \sqrt{\frac{f_{max} \cdot 8 \cdot \pi}{1000}} = \sqrt{\frac{25 \cdot 8 \cdot 8}{1000}} = 0.9 \text{ mm/obr}$

% walek

N10 G55 G90 G71

N20 T0110 M451400 G95

N30 G0 x44 z94

N40 x42

N50 G1 z-2

N60 x44 z94

N70 x68

N80 G1 z-2

N90 G0 x40 z94

N100 x64

N110 G1 z5

N120 G0 x66 z94

N130 x62

N140 G1 z5

N150 G0 x64 z94

N160 x58

N170 G1 z5

N180 G0 x60 z94

N190 x56

N200 G1 z5

N210 G0 x58 z94

N220 x52

N230 G1 z42

N240 G0 x54 z94

N250 x50

N260 G1 z42

N270 G0 x52 z94

N280 x46

N290 G1 z44

N300 G0 x48 z94

N310 x42

N320 G1 x44

N330 G0 x44 z94

N340 x38

N350 G1 z91

N360 G0 x39 z90

N370 G1 x42 z87

N380 x40

N390 x53

N400 x54 z39

N410 z30

N420 G2 x49 z25954 K25

N430 G2 x54 z20954 K25

N440 G1 z7,5

N450 G2 x54 z5954,5 K7,5

N460 G1 x40

N470 z0

N480 G28 x z

N490 M2