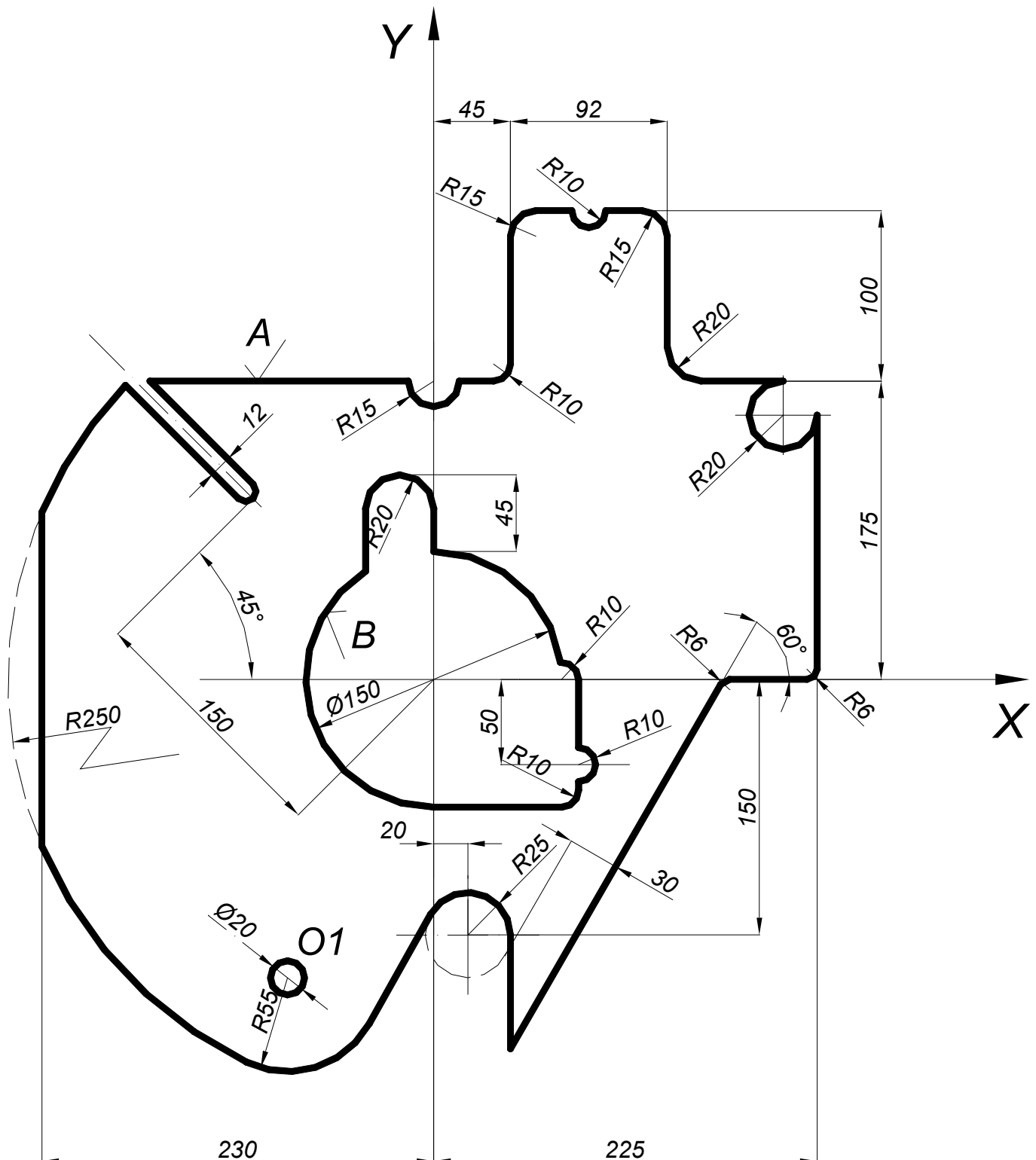


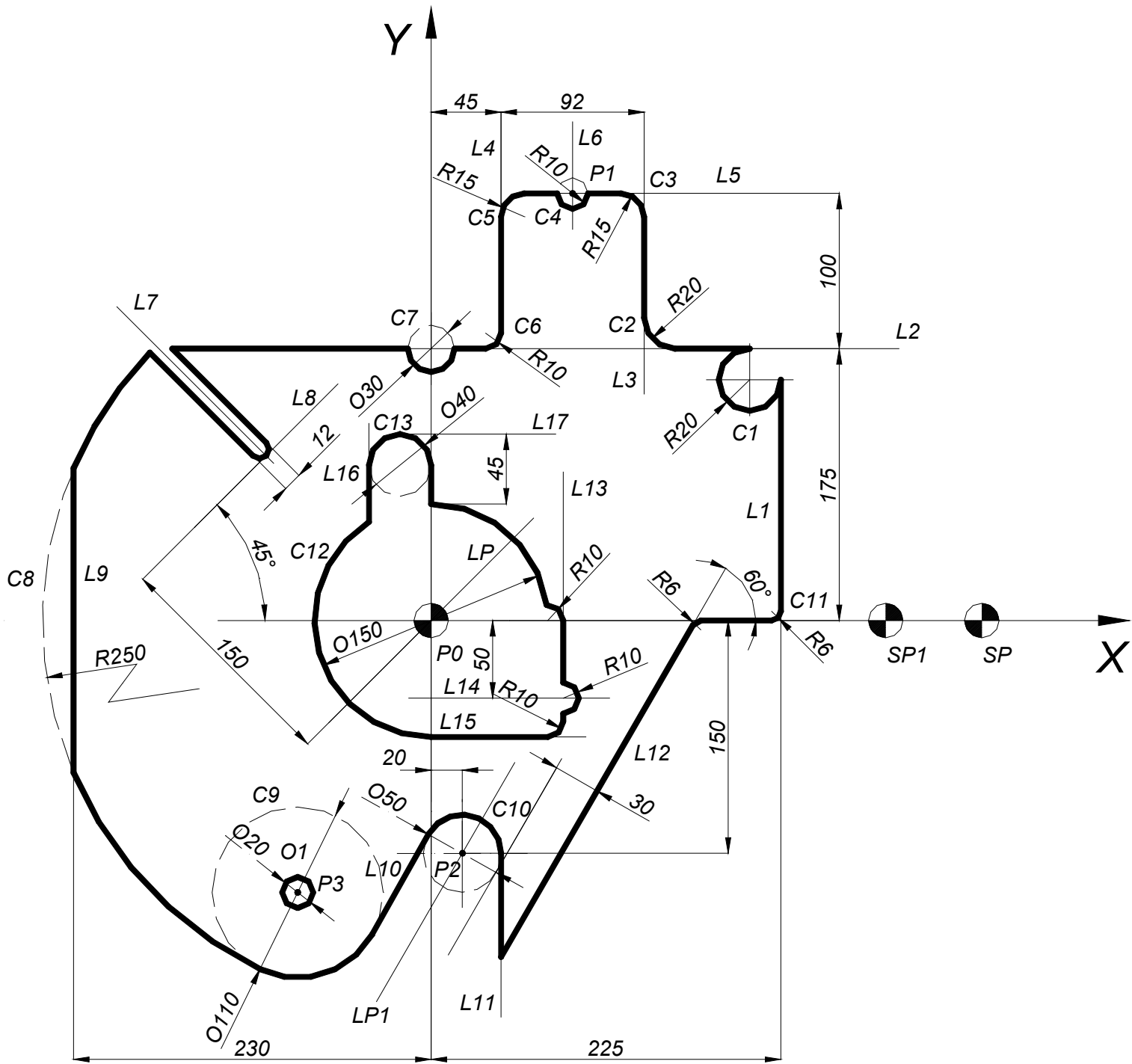
## Zadatak za auditornu vežbu iz proizvodnih sistema.

Za dati radni predmet napisati program za obradu u APT jeziku.

- Glodanje spoljašnje konture A: alat glodalo  $\phi 12$ ,  $n=400 \text{ min}^{-1}$ ,  $s_z=0.45 \text{ mm/z}$ ,  $z=5$ .
- Glodanje unutrašnje konture B : alat glodalo  $\phi 20$ ,  $n=500 \text{ min}^{-1}$ ,  $s_z=0.25 \text{ mm/z}$ ,  $z=8$ .
- Bušenje otvora  $O_1$ : alat burgija  $\phi 20$ ,  $n=500 \text{ min}^{-1}$ ,  $s_z=0.1 \text{ mm/o}$ .

Napomena: Na crtežu označiti početnu tačku SP i obeležiti potrebne elemente geometrije koji se definišu.





PARTNO/AUDITORNA  
MACHIN/MILL 1,1  
CLPRNT  
ZSURF/35  
\$\$OPIS GEOMETRIJE  
SP=POINT/400,0  
SP1=POINT/245,0  
P0=POINT/0,0  
LX=LINE/P0,SP  
LY=LINE/P0,PERPTO,LX  
L1=LINE/PARLEL,LY,XLARGE,225  
L2=LINE/PARLEL,LX,YLARGE,175  
C1=CIRCLE/XSMALL,L1,YSMALL,L2,RADIUS,20  
L4=LINE/PARLEL,LY,XLARGE,45  
L3=LINE/PARLEL,L4,XLARGE,92  
C2=CIRCLE/YLARGE,L2,XLARGE,L3,RADIUS,20  
L5=LINE/PARLEL,L2,YLARGE,100  
C3=CIRCLE/XSMALL,L3,YSMALL,L5,RADIUS,15  
L6=LINE/PARLEL,L3,XSMALL,46  
P1=POINT/INTOF,L6,L5  
C4=CIRCLE/CENTER,P1,RADIUS,10  
C5=CIRCLE/YSMALL,L5,XLARGE,L4,RADIUS,15  
C6=CIRCLE/XSMALL,L4,YLARGE,L2,RADIUS,10  
C7=CIRCLE/0,175,15  
L7=LINE/P0,ATANGL,135  
LP=LINE/P0,ATANGL,45  
L8=LINE/PARLEL,LP,XSMALL,150  
C8=CIRCLE/CENTER,P0,RADIUS,250  
L9=LINE/PARLEL,LY,XSMALL,230  
P2=POINT/20,-150  
LP1=LINE/P2,ATANGL,60  
L10=LINE/PARLEL,LP1,XSMALL,25  
C9=CIRCLE/XSMALL,L10,YSMALL,IN,C8,RADIUS,55  
P3=POINT/CENTER,C9  
C10=CIRCLE/20,-150,25  
L11=LINE/PARLEL,LY,XLARGE,45  
L12=LINE/PARLEL,LP1,XLARGE,55  
C11=CIRCLE/XSMALL,L1,YLARGE,LX,RADIUS,6  
C12=CIRCLE/0,0,75  
L13=LINE/PARLEL,LY,XLARGE,85  
L14=LINE/PARLEL,LX,YSMALL,50  
L15=LINE/PARLEL,LX,YSMALL,75  
L16=LINE/PARLEL,LY,,XSMALL,40  
L17=LINE/PARLEL,LX,YLARGE,120  
C13=CIRCLE/XSMALL,LY,YSMALL,L17,RADIUS,20  
\$\$KINEMATIKA KONTURE A  
CUTTER/12  
SPINDL/400,CLW  
FROM/SP  
RAPID  
GOTO/SP1  
FEDRAT/192  
GODLTA/-37  
GO/TO,L1  
GORGT/L1,TO,L2  
GOLFT/L2,TANTO,C1  
GOFWD/C1,TANTO,L1  
GOFWD/L1,PAST,L2  
GOLFT/L2,TANTO,C2  
GOFWD/C2,TANTO,L3  
GOFWD/L3,TANTO,C3  
GOFWD/C3,TANTO,L5  
GOFWD/L5,ON,L6  
GOLFT/L6,PAST,C4  
GORGT/C4,ON,2,INTOF,L6  
GORGT/L6,PAST,L5

GOLFT/L5,TANTO,C5  
GOFWD/C5,TANTO,L4  
GOFWD/L4,TANTO,C6  
GOFWD/C6,TANTO,L2  
GOFWD/L2,PAST,C7  
GOLFT/C7,PAST,2,INTOF,L2  
GOLFT/L2,ON,L7  
GOLFT/L7,TO,L8  
GOBACK/L7,PAST,C8  
GOLFT/C8,PAST,L9  
GOLFT/L9,PAST,2,INTOF,C8  
GOLFT/C8,TANTO,C9  
GOFWD/C9,TANTO,L10  
GOFWD/L10,TANTO,C10  
GOFWD/C10,TANTO,L11  
GOFWD/L11,PAST,L12  
GOLFT/L12,TO,LX  
GORGT/LX,TANTO,C11  
GOFWD/C11,TANTO,L1  
GODLTA/5,0  
RAPID  
GODLTA/37  
GOTO/SP  
SPINDL/OFF  
CUTTER/20  
SPINDL/500,CLW  
FROM/SP  
RAPID  
GOTO/P0  
GODLTA/-37  
FEDRAT/1000  
COOLNT/ON  
GO/TO,L13  
GORGT/L13,ON,L14  
GOLFT/L14,ON,L13  
GOBACK/L14,ON,L13  
GOLFT/L13,TO,L15  
GORGT/L15,TANTO,C12  
GOFWD/C12,PAST,2,INTOF,L16  
GOLFT/L16,TANTO,C13  
GOFWD/C13,TANTO,LY  
GOFWD/LY,PAST,C12  
GOLFT/C12,ON,LX  
GODLTA/-5,0  
RAPID  
COOLNT/OFF  
GODLTA/37  
GOTO/SP  
SPINDL/OFF  
CUTTER/20  
SPINDL/500,CLW  
RAPID  
GOTO/P3  
FEDRAT/0.1  
COOLNT/ON  
GODLTA/-37  
RAPID  
GODLTA/37  
COOLNT/OFF  
GOTO/SP  
SPINDL/OFF  
FINI