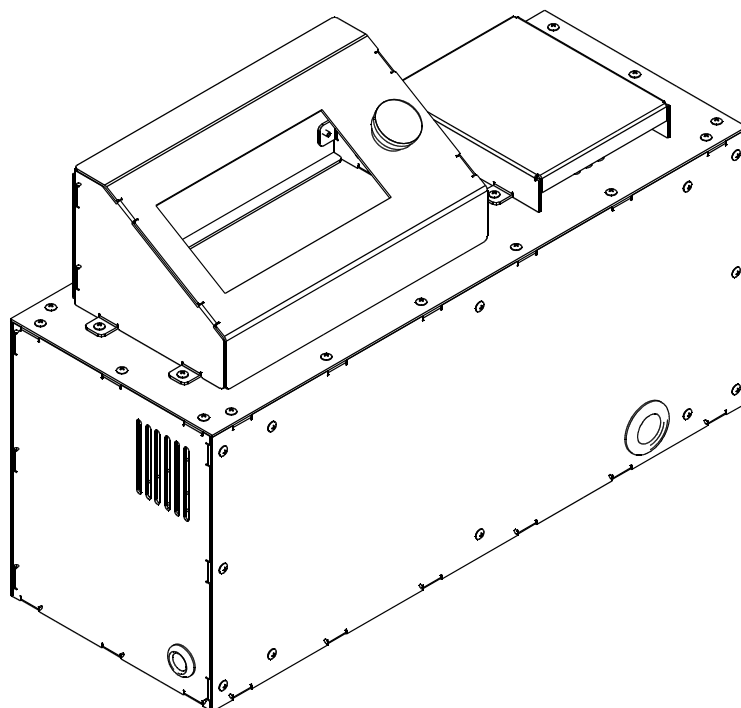


## 作業手順書－２

### 制御ボックス NCプログラム



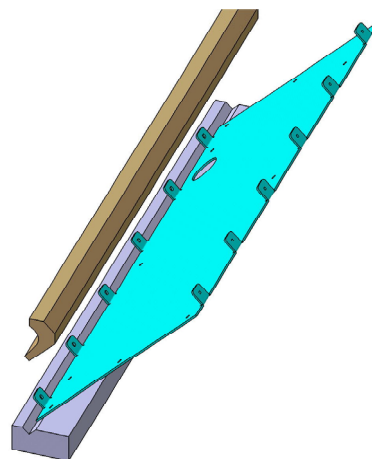
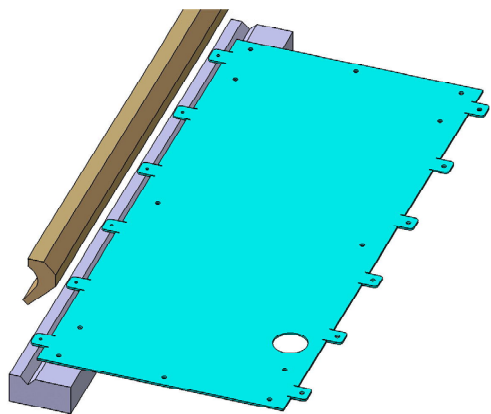
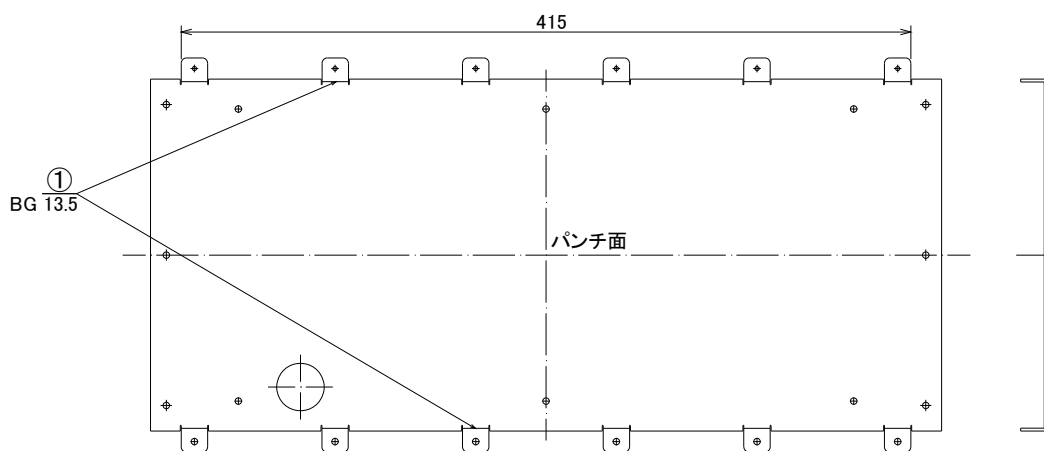


## 作業手順書

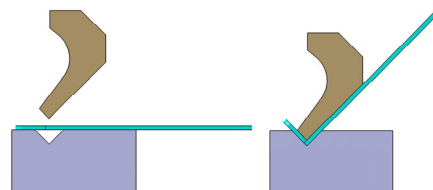
図面番号	C-1140-1	部品名称	前板
工作機械名	プレスブレーキ (RG-M2)		
素 材	SPCC t=1.6 (914 × 1829 からレーザ加工機で部品取り)		

使用する工具	ダイ : ダイ長さ > 415mm パンチ : パンチ長さ > 415mm
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## 作 業 手 順



【メモ】

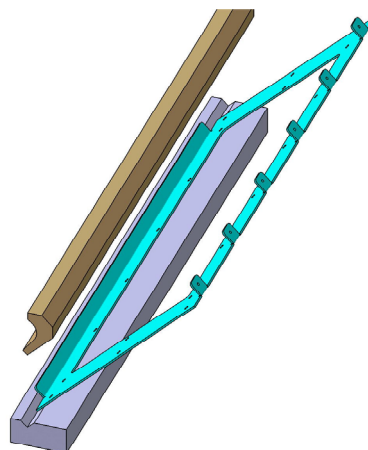
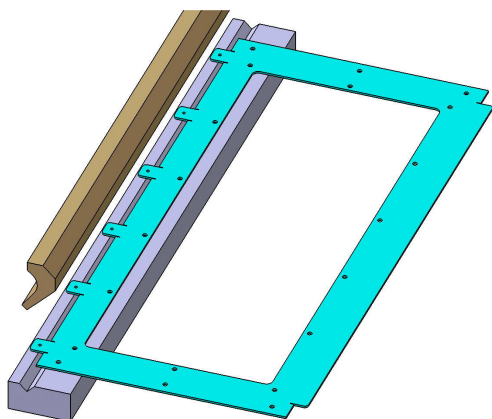
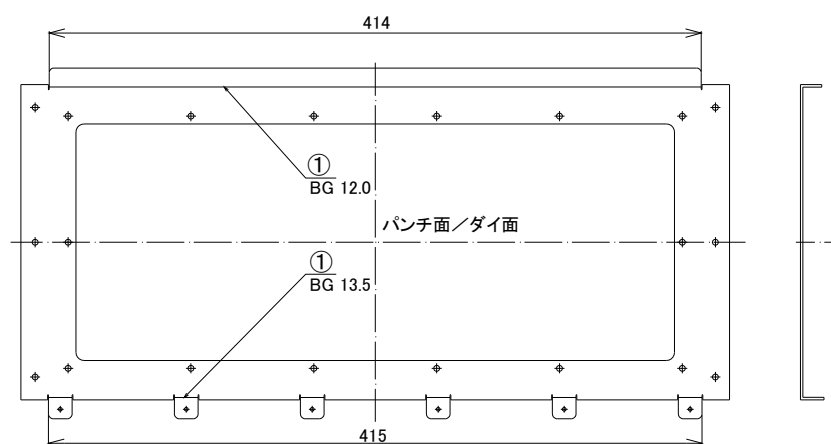


## 作業手順書

図面番号	C-1140-2	部品名称	後板
工作機械名	プレスブレーキ (RG-M2)		
素 材	SPCC t=1.6 (914 × 1829 からレーザ加工機で部品取り)		

使用する工具	ダイ : ダイ長さ > 415mm パンチ : パンチ長さ > 415mm
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## 作 業 手 順



【メモ】

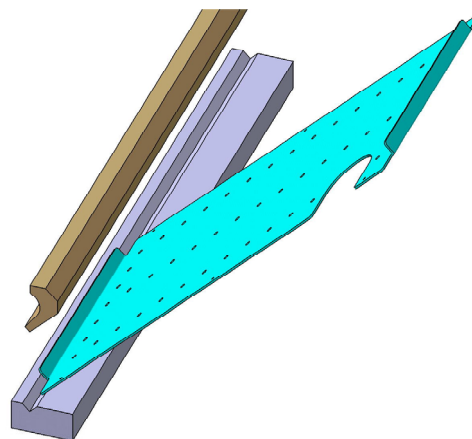
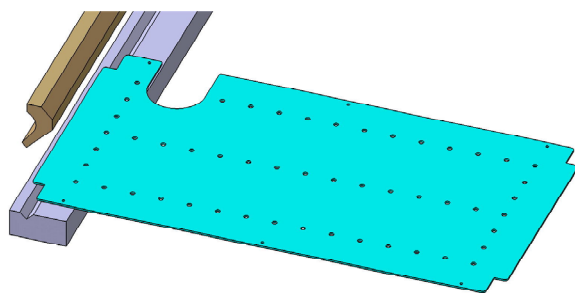
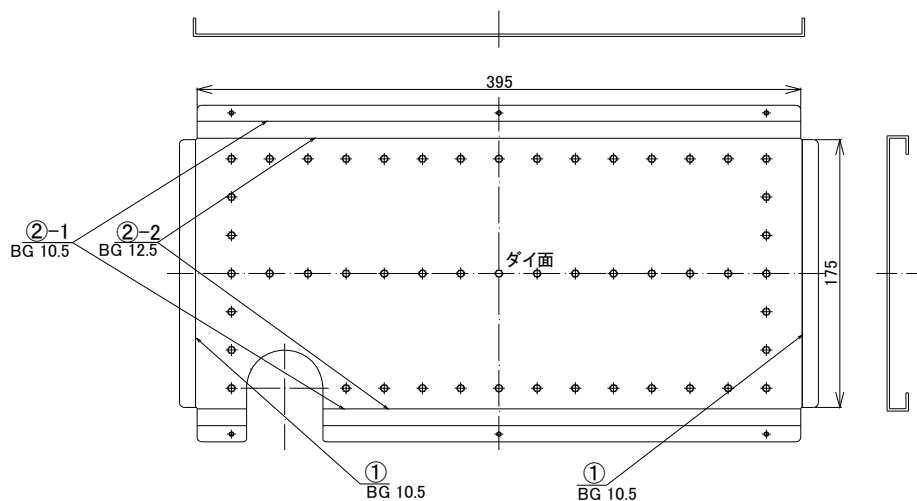


## 作業手順書

図面番号	C-1140-3	部品名称	取付板
工作機械名	プレスブレーキ (RG-M2)		
素 材	SPCC t=1.6 (914 × 1829 からレーザ加工機で部品取り)		

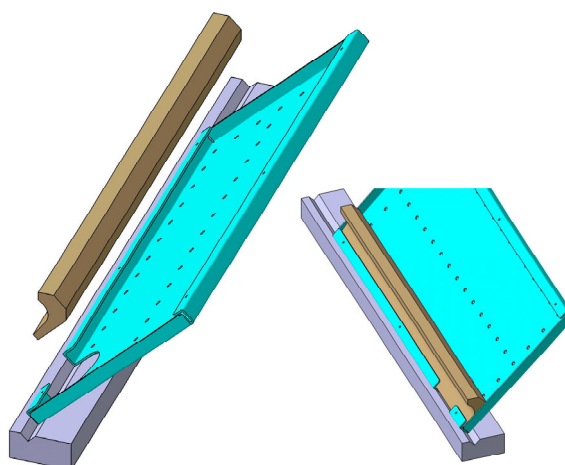
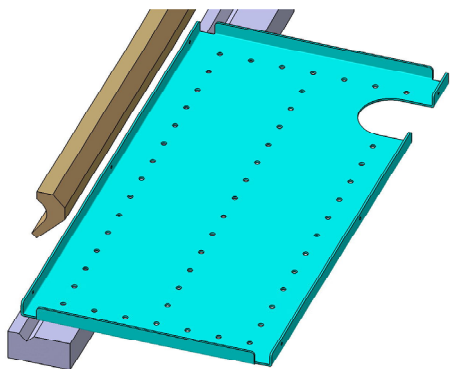
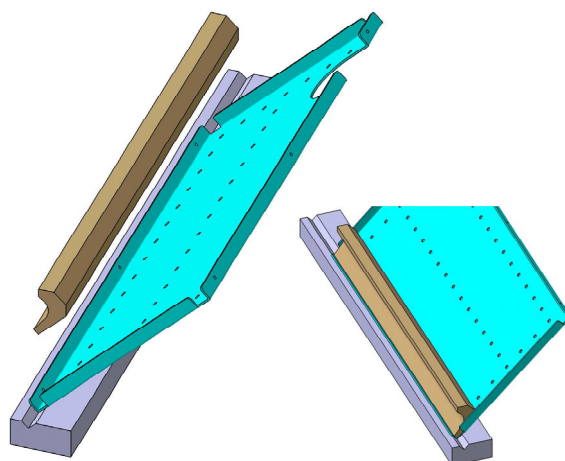
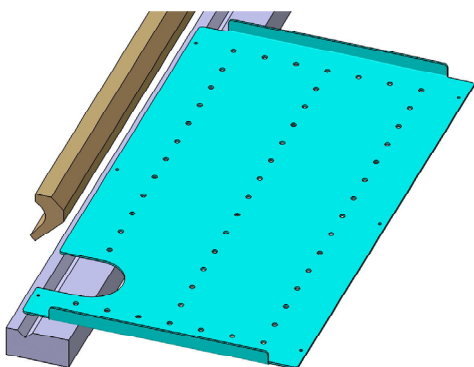
使用する工具	ダイ : ダイ長さ > 415mm パンチ : パンチ長さ > 415mm、パンチ長さ = 395mm
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## 作 業 手 順



【メモ】

## 作業手順



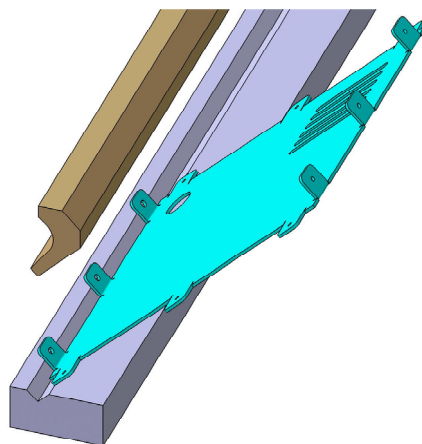
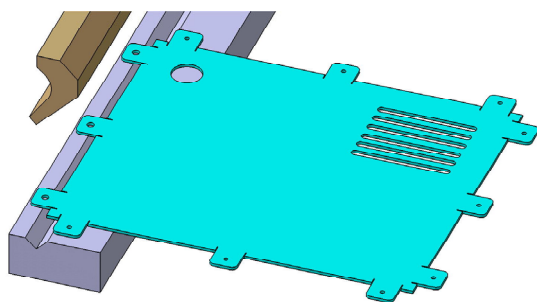
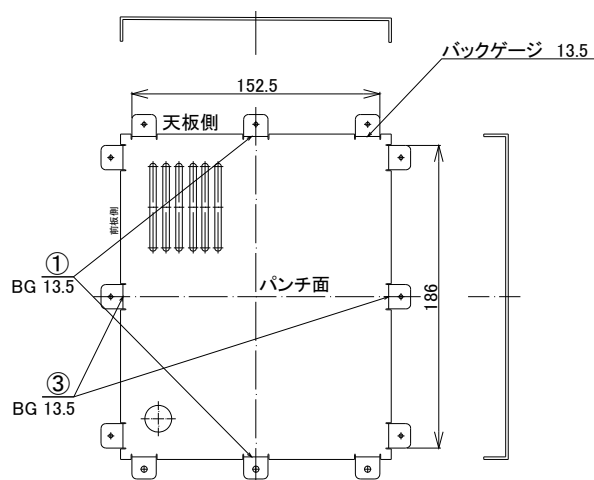
【メモ】

## 作業手順書

図面番号	C-1140-4	部品名称	側板－A
工作機械名	プレスブレーキ（RG-M2）		
素 材	SPCC t=1.6（914 × 1829 からレーザ加工機で部品取り）		

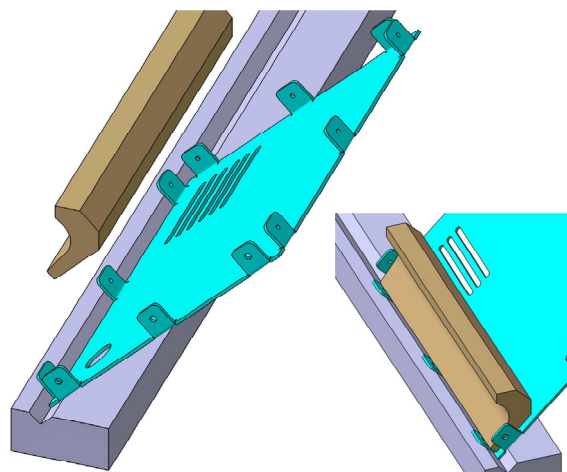
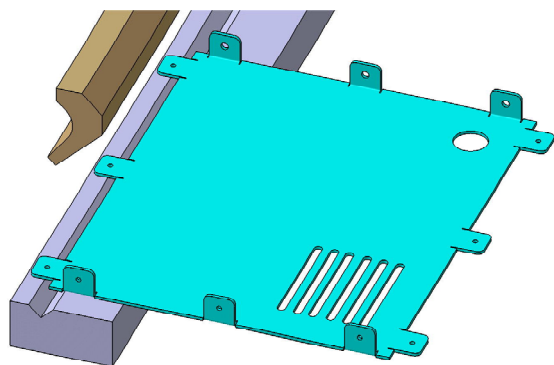
使用する工具	ダイ：ダイ長さ＞415mm パンチ：パンチ長さ＞415mm、パンチ長さ＝190mm
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## 作 業 手 順



【メモ】

## 作業手順



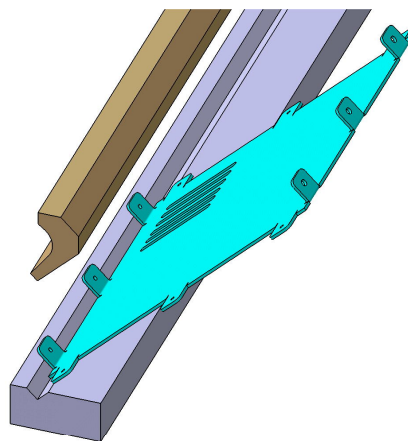
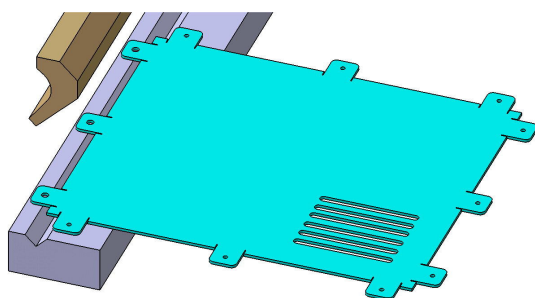
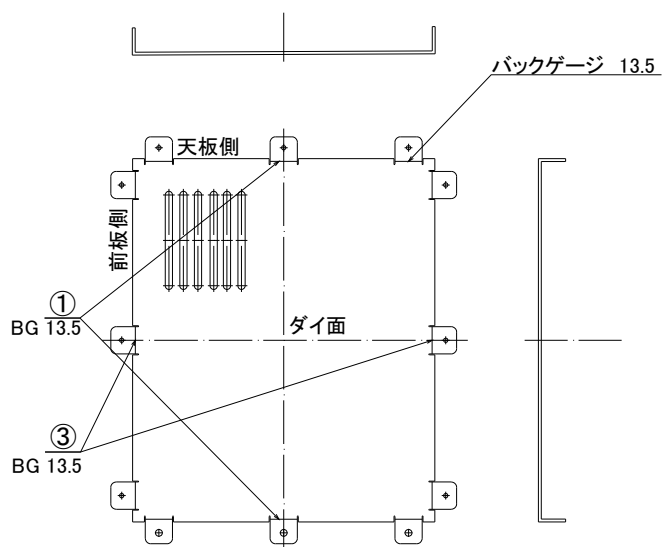
【メモ】

## 作業手順書

図面番号	C-1140-5	部品名称	側板－B
工作機械名	プレスブレーキ（RG-M2）		
素 材	SPCC t=1.6（914 × 1829 からレーザ加工機で部品取り）		

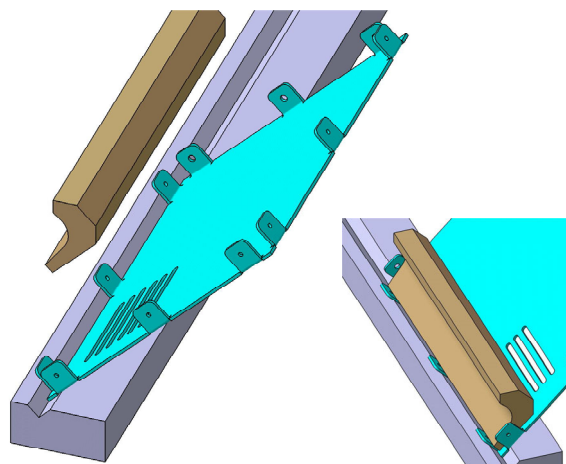
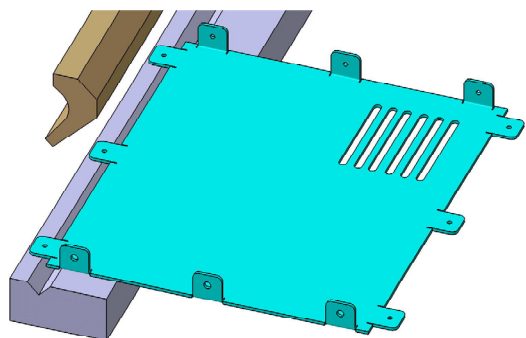
使用する工具	ダイ：ダイ長さ＞415mm パンチ：パンチ長さ＞415mm、パンチ長さ＝190mm
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## 作 業 手 順



【メモ】

## 作業手順



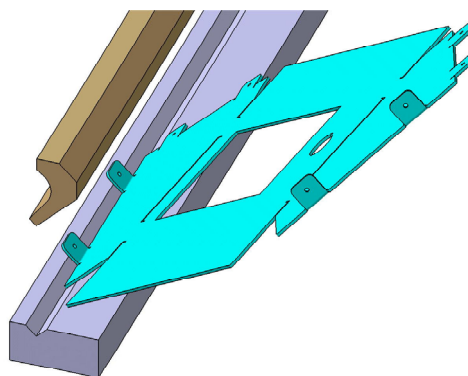
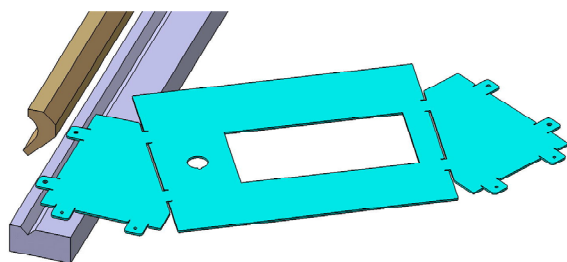
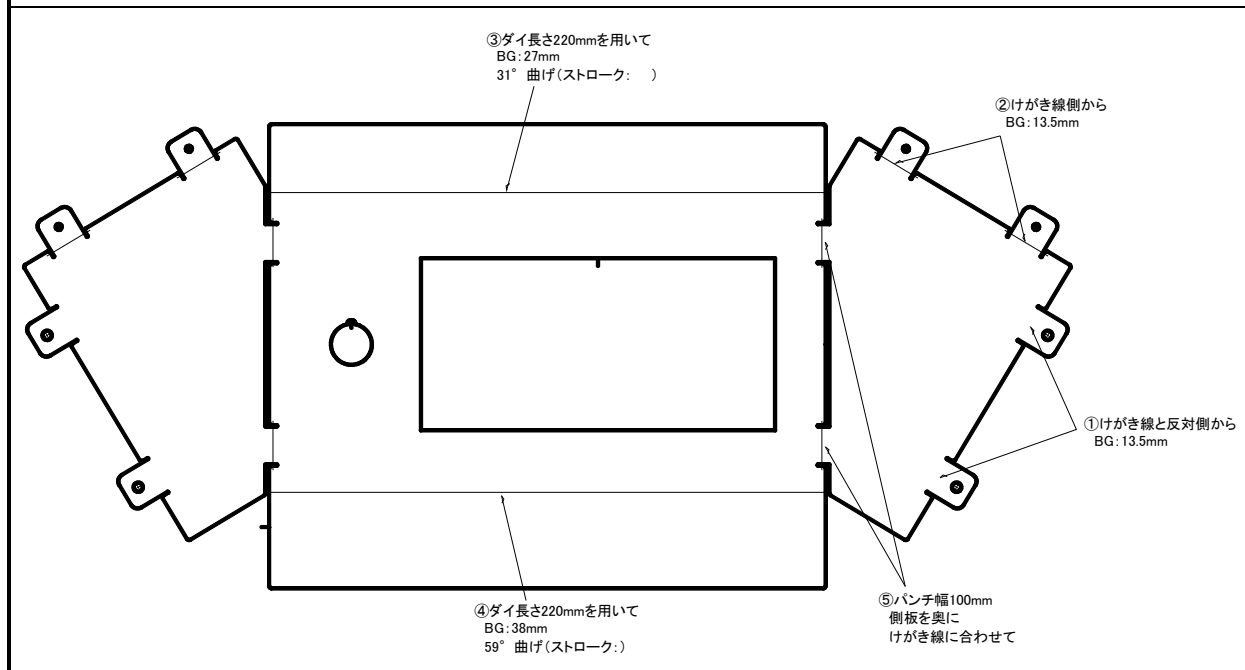
【メモ】

## 作業手順書

図面番号	C-2140	部品名称	操作盤－A
工作機械名	プレスブレーキ（RG-M2）		
素 材	SPCC t=1.6（914 × 1829 からレーザ加工機で部品取り）		

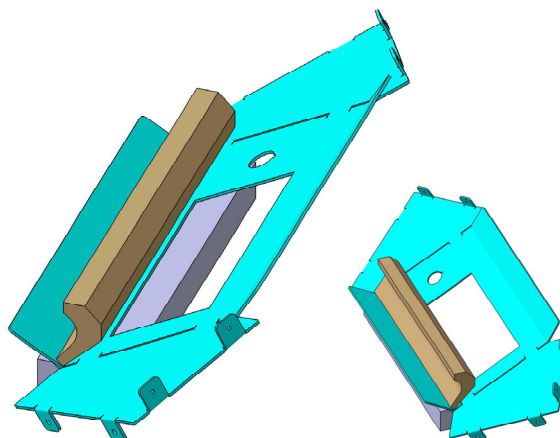
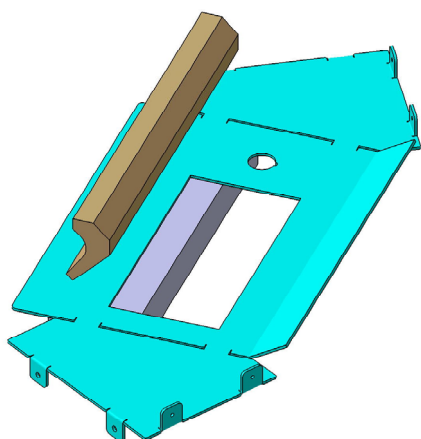
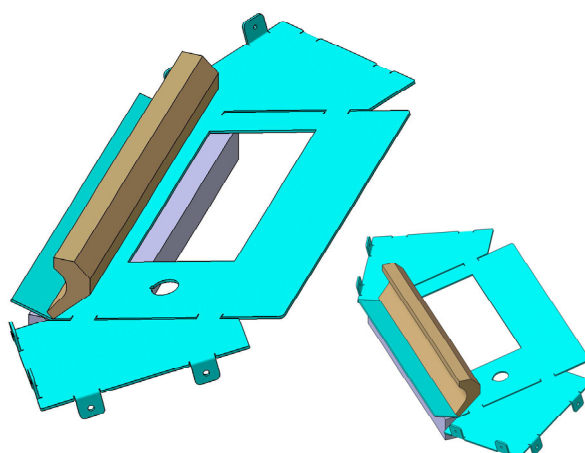
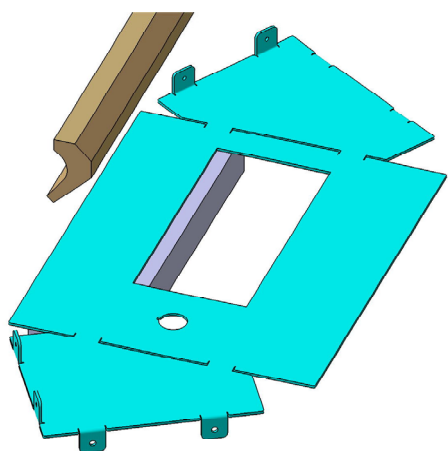
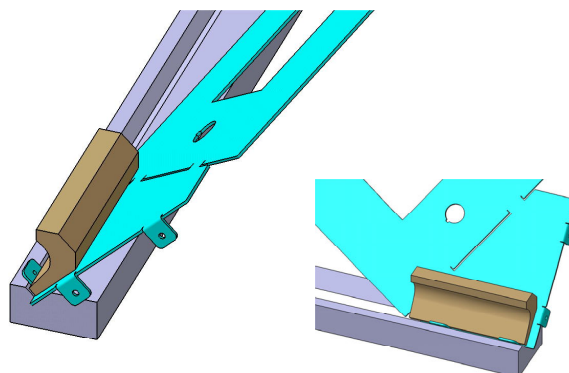
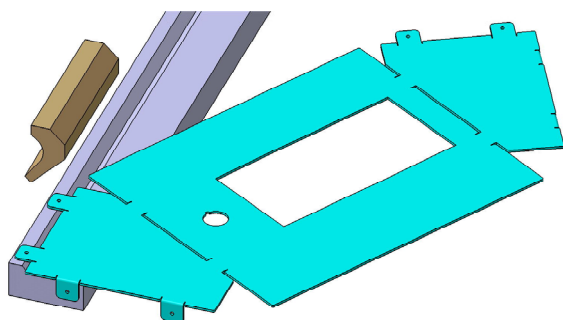
使用する工具	ダイ：ダイ長さ＞415mm、ダイ長さ＝220mm パンチ：パンチ長さ＞415mm、パンチ長さ＝100mm
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## 作 業 手 順



【メモ】

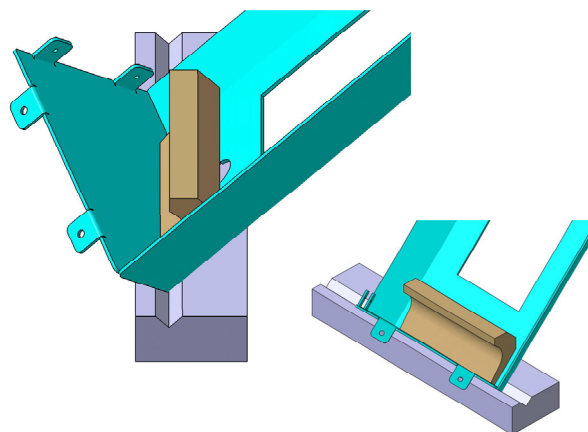
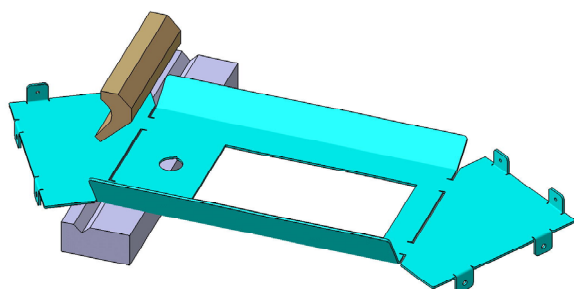
## 作業手順



【メモ】



## 作 業 手 順



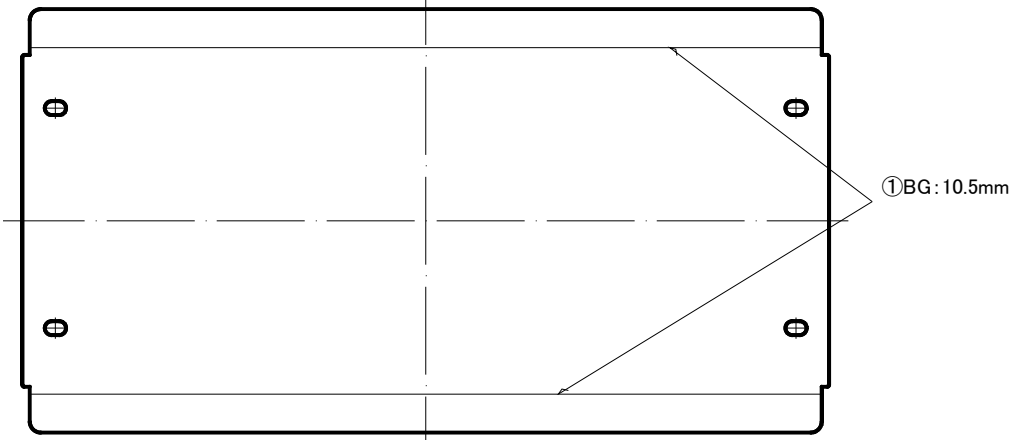
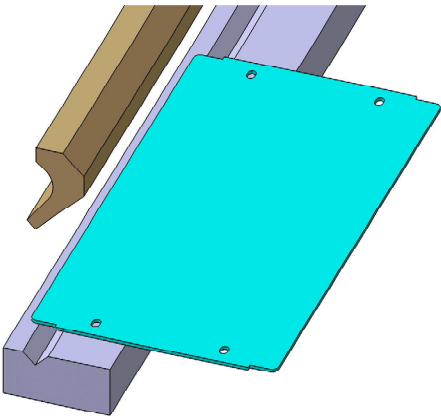
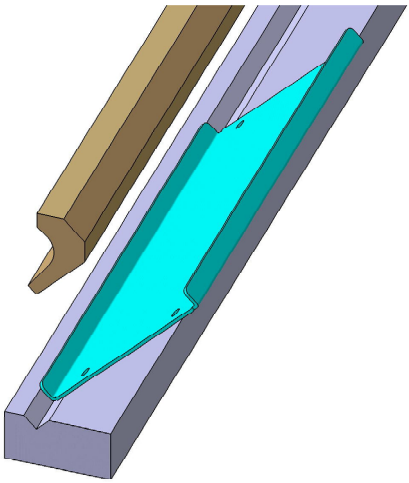
【メモ】

作業手順書

No. 1 / 1

図面番号	C-2240	部品名称	操作盤－B
工作機械名	プレスブレーキ（RG-M2）		
素 材	SPCC    t=1.6（914 × 1829 からレーザ加工機で部品取り）		

使用する工具	ダ イ：ダイ長さ＞ 415mm パンチ：パンチ長さ＞ 415mm
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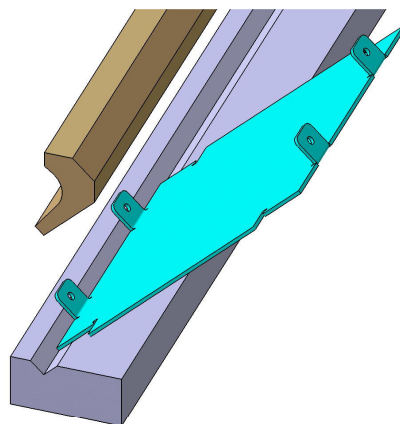
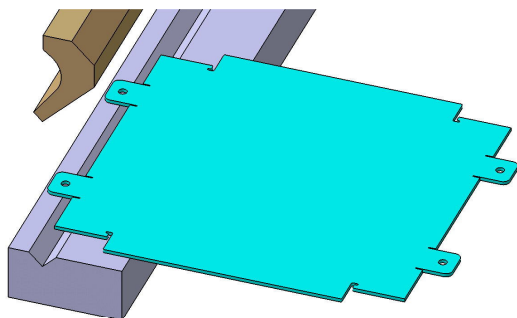
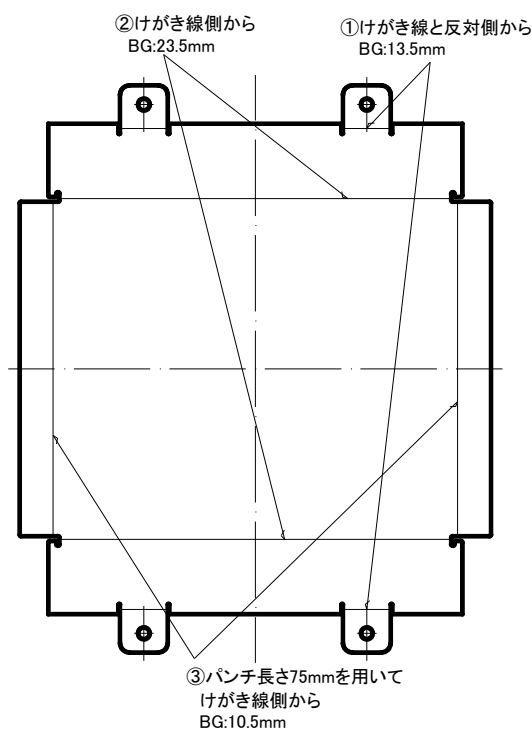
作 業 手 順	
	
	
【メモ】	

## 作業手順書

図面番号	C-3140	部品名称	電磁弁取付板
工作機械名	プレスブレーキ (RG-M2)		
素 材	SPCC t=1.6 (914 × 1829 からレーザ加工機で部品取り)		

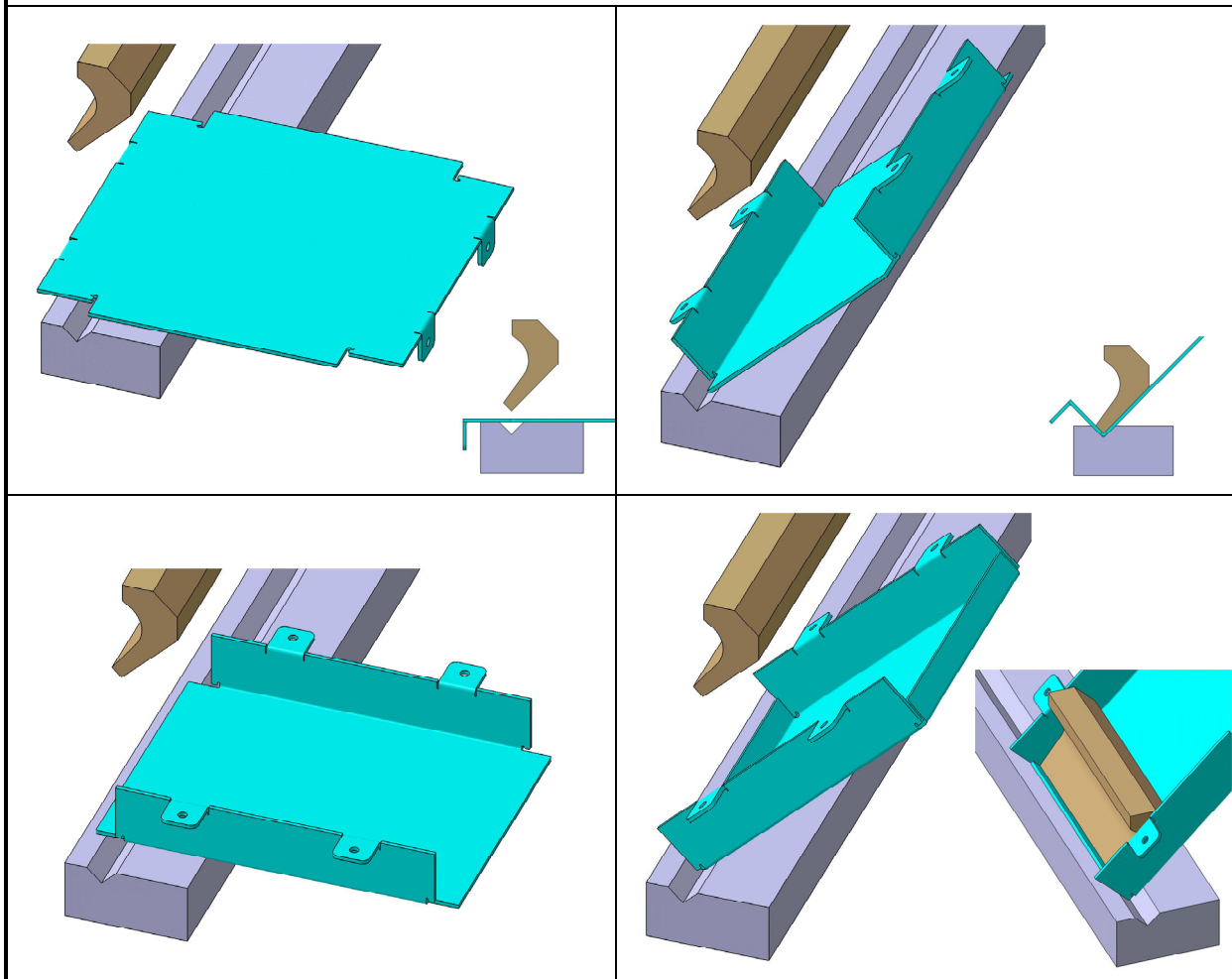
使用する工具	ダイ : ダイ長さ > 415mm パンチ : パンチ長さ > 415mm、パンチ長さ = 105mm
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## 作 業 手 順



【メモ】

## 作業手順



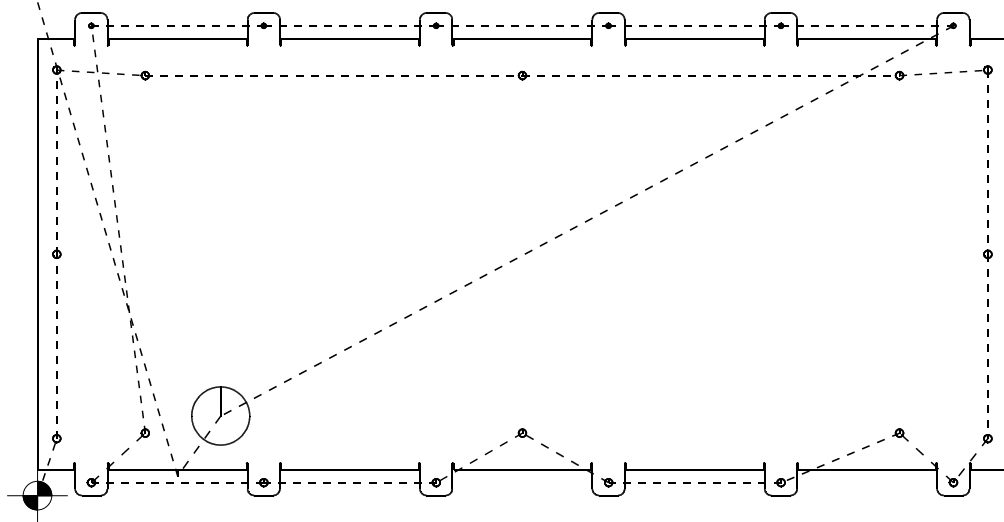
【メモ】

# 作業手順書

No. 1 / 2

図面番号	C-1110-1	部品名称	前板
工作機械名	レーザ加工機（WTS4112/SOL13H）		
素 材	SPCC 914 × 1829 × 1.6		

## 部品取りとプログラム



O7510 G90G54  N1 (D3.7) T01 D01F250 G00X9.Y26.5 M98P7595 G00Y112. M98P7595 G00Y197.5 M98P7595 G00X50.Y195. M98P7595 G00X225. M98P7595 G00X400. M98P7595 G00X441.Y197.5 M98P7595 G00Y112. M98P7595 G00Y26.5 M98P7595 G00X425.Y6. M98P7595 G00X400.Y29. M98P7595 G00X345.Y6. M98P7595	G00X265. M98P7595 G00X225.Y29. M98P7595 G00X185.Y6. M98P7595 G00X105. M98P7595 G00X25. M98P7595 G00X50.Y29. M98P7595  N2 (D2.4) G00X25.Y218. M98P7596 G00X105. M98P7596 G00X185. M98P7596 G00X265. M98P7596 G00X345. M98P7596 G00X425. M98P7596  N3 (D27) T02 D01F1000 G00X85.Y37.	M98P7597  N4 (GAIKEI) T02 D01F1000 G00X65.Y9. M03 G41G01Y12. X33. Y15. G03X32.5I-0.25 G01Y3. G02X29.5Y0.I-3. G01X20.5 G02X17.5Y3.J3. G01Y15. G03X17.I-0.25 G01Y12. X0. Y212. X17. Y209. G03X17.5I0.25 G01Y221. G02X20.5Y224.I3. G01X29.5 G02X32.5Y221.J-3. G01Y209. G03X33.I0.25 G01Y212. X97.121	Y209. G03X273.I0.25 G01Y212. X337. Y209. G03X337.5I0.25 G01Y221. G02X340.5Y224.I3. G01X349.5 G02X352.5Y221.J-3. G01Y209. G03X353.I0.25 G01Y212. X417. Y209. G03X417.5I0.25 G01Y221. G02X420.5Y224.I3. G01X429.5 G02X432.5Y221.J-3. G01Y209. G03X433.I0.25 G01Y212. X450. Y12. X433. Y15. G03X432.5I-0.25 G01Y3. G02X429.5Y0.I-3. G01X420.5
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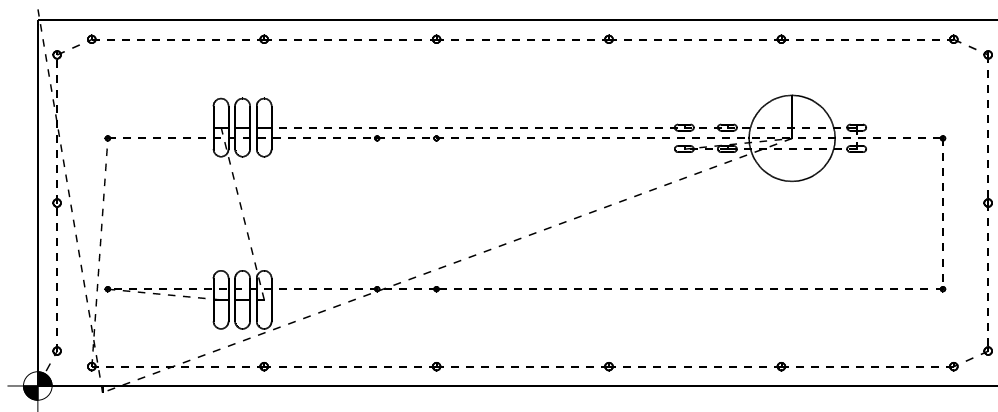
G02X417.5Y3.J3. G01Y15. G03X417.I-0.25 G01Y12. X353. Y15. G03X352.5I-0.25 G01Y3. G02X349.5Y0.I-3. G01X340.5 G02X337.5Y3.J3. G01Y15. G03X337.I-0.25 G01Y12. X273. Y15. G03X272.5I-0.25 G01Y3. G02X269.5Y0.I-3. G01X260.5 G02X257.5Y3.J3. G01Y15. G03X257.I-0.25 G01Y12. X193. Y15. G03X192.5I-0.25 G01Y3. G02X189.5Y0.I-3. G01X180.5 G02X177.5Y3.J3. G01Y15. G03X177.I-0.25 G01Y12. X113. Y15. G03X112.5I-0.25 G01Y3. G02X109.5Y0.I-3. G01X100.5 G02X97.5Y3.J3. G01Y15. G03X97.I-0.25 G01Y12. X65.2 M05 G40G00X65.Y9. G00X0Y229. M30		O7595 (D3.7) G91 M03 G42G01Y1.85 G02J-1.85 M05 G40G00Y-1.85 G90 M99  O7596 (D2.4) G91 M03 G42G01Y1.2 G02J-1.2 M05 G40G00Y-1.2 G90 M99  O7597 (D27) G91 M03 G42G01Y13.5 G02J-13.5 M05 G40G00Y-13.5 G90 M99	
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# 作業手順書

No. 1 / 2

図面番号	C-1110-2	部品名称	天板
工作機械名	レーザ加工機 (WTS4112/SOL13H)		
素 材	SPCC 914 × 1829 × 1.6		

## 部品取りとプログラム



O7520 G90G54  N1 (D3.7) T01 D01F250 G00X9.Y16.25 M98P7595 G00Y85. M98P7595 G00Y153.75 M98P7595 G00X25.Y161. M98P7595 G00X105. M98P7595 G00X185. M98P7595 G00X265. M98P7595 G00X345. M98P7595 G00X425. M98P7595 G00X441.Y153.75 M98P7595 G00Y85. M98P7595 G00Y16.25 M98P7595 G00X425.Y9.	M98P7595 G00X345. M98P7595 G00X265. M98P7595 G00X185. M98P7595 G00X105. M98P7595 G00X25. M98P7595  N2 (D2.4) G00X32.5Y115. M98P7596 G00X157.5 M98P7596 G00X185. M98P7596 G00X420. M98P7596 G00Y45. M98P7596 G00X185. M98P7596 G00X157.5 M98P7596 G00X32.5 M98P7596  N3 (27-7 NAGA ANA)	T02 D01F1000 G00X85.Y40. M98P7586 G00X95. M98P7586 G00X105. M98P7586 G00X85.Y120. M98P7586 G00X95. M98P7586 G00X105. M98P7586  N4 (9-3 NAGA ANA) G00X300.Y120. M98P7585 G00X320. M98P7585 G00X380. M98P7585 G00Y110. M98P7585 G00X320. M98P7585 G00X300. M98P7585  N5 (D40) G00X350.Y115.	M98P7598  N6 (GAIKEI) G00X30.Y-3. M03 G41G01Y0. X0. Y170. X450. Y0. X30.2 M05 G40G00X30.Y-3. G00X0Y175. M30
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O7595 (D3.7) G91 M03 G42G01Y1.85 G02J-1.85 M05 G40G00Y-1.85 G90 M99  O7596 (D2.4) G91 M03 G42G01Y1.2 G02J-1.2 M05 G40G00Y-1.2 G90 M99  O7598 (D40) G91 M03 G42G01Y20. G02J-20. M05 G40G00Y-20. G90 M99  O7585 G91 M03 G42G01Y1.5 X3. G02Y-3.J-1.5 G01X-6. G02Y3.J1.5 G01X3. M05 G40G00Y-1.5 G90 M99	O7586 G91 M03 G42G01X-3.5 Y10. G02X7.I3.5 G01Y-20. G02X-7.I-3.5 G01Y10. M05 G40G00X3.5 G90 M99		
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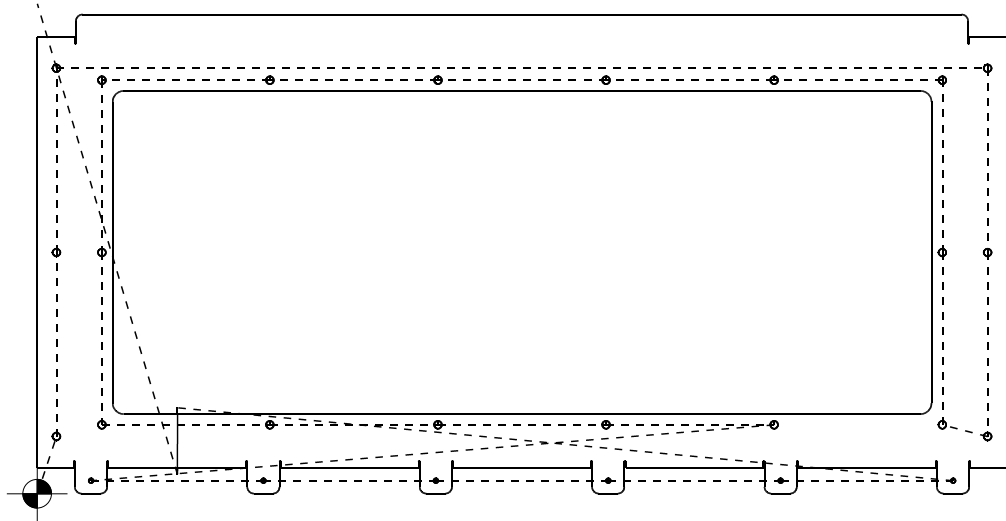


# 作業手順書

No. 1 / 2

図面番号	C-1110-3	部品名称	後板
工作機械名	レーザ加工機 (WTS4112/SOL13H)		
素 材	SPCC 914 × 1829 × 1.6		

## 部品取りとプログラム



O7530 G90G54  N1 (D3.7) T01 D01F250 G00X9.Y26.5 M98P7595 G00Y112. M98P7595 G00Y197.5 M98P7595 G00X441. M98P7595 G00Y112. M98P7595 G00Y26.5 M98P7595 G00X420.Y32. M98P7595 G00Y112. M98P7595 G00Y192. M98P7595 G00X342. M98P7595 G00X264. M98P7595 G00X186. M98P7595 G00X108.	M98P7595 G00X30. M98P7595 G00Y112. M98P7595 G00Y32. M98P7595 G00X108. M98P7595 G00X186. M98P7595 G00X264. M98P7595 G00X342. M98P7595  N2 (D2.4) G00X25.Y6. M98P7596 G00X105. M98P7596 G00X185. M98P7596 G00X265. M98P7596 G00X345. M98P7596 G00X425. M98P7596  N3 (UTIGAWA)	T02 D01F1000 G00X65.Y40. M03 G42G01Y37. X40. G02X35.Y42.J5. G01Y182. G02X40.Y187.I5. G01X410. G02X415.Y182.J-5. G01Y42. G02X410.Y37.I-5. G01X65.2 M05 G40G00X65.Y9.  N4 (GAIKEI) T02 D01F1000 G00X65.Y9. M03 G41G01Y12. X33. Y15. G03X32.5I-0.25 G01Y3. G02X29.5Y0.I-3. G01X20.5 G02X17.5Y3.J3. G01Y15.	G03X17.I-0.25 G01Y12. X0. Y212. X17.5 Y209. G03X18.I0.25 G01Y219.5 G02X21.Y222.5I3. G01X429. G02X432.Y219.5J-3. G01Y209. G03X432.5I0.25 G01Y212. X450. Y12. X433. Y15. G03X432.5I-0.25 G01Y3. G02X429.5Y0.I-3. G01X420.5 G02X417.5Y3.J3. G01Y15. G03X417.I-0.25 G01Y12. X353. Y15. G03X352.5I-0.25 G01Y3. G02X349.5Y0.I-3.
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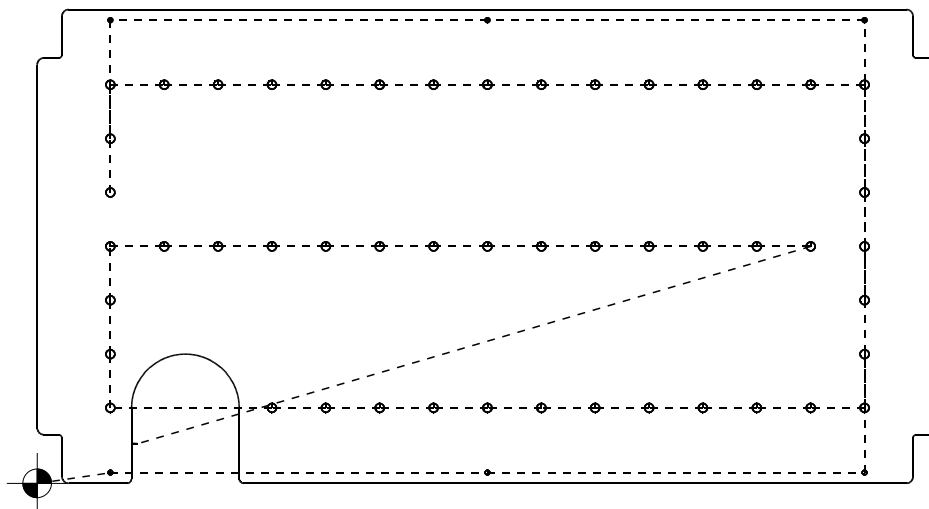
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# 作業手順書

No. 1 / 2

図面番号	C-1110-4	部品名称	取付板
工作機械名	レーザ加工機（WTS4112/SOL13H）		
素 材	SPCC 914 × 1829 × 1.6		

## 部品取りとプログラム



O7540 G90G54  N1 (D2.4) T01 D01F250 G00X34.Y5. M98P7596 G00X209. M98P7596 G00X384. M98P7596 G00X384.Y215. M98P7596 G00X209. M98P7596 G00X34. M98P7596  N2 (D4.2) T01 D01F250 G00X34.Y135. M98P7599 G00Y160. M98P7599 G00Y185. M98P7599 G00X59. M98P7599 G00X84.	M98P7599 G00X109. M98P7599 G00X134. M98P7599 G00X159. M98P7599 G00X184. M98P7599 G00X209. M98P7599 G00X234. M98P7599 G00X259. M98P7599 G00X284. M98P7599 G00X309. M98P7599 G00X334. M98P7599 G00X359. M98P7599 G00Y160. M98P7599 G00Y135. M98P7599 G00Y110. M98P7599	G00Y85. M98P7599 G00Y60. M98P7599 G00Y35. M98P7599 G00X359. M98P7599 G00X334. M98P7599 G00X309. M98P7599 G00X284. M98P7599 G00X259. M98P7599 G00X234. M98P7599 G00X209. M98P7599 G00X184. M98P7599 G00X159. M98P7599 G00X134. M98P7599 G00X109. M98P7599 G00X34. M98P7599 G00Y60.	M98P7599 G00Y85. M98P7599 G00Y110. M98P7599 G00X59. M98P7599 G00X84. M98P7599 G00X109. M98P7599 G00X134. M98P7599 G00X159. M98P7599 G00X184. M98P7599 G00X209. M98P7599 G00X234. M98P7599 G00X259. M98P7599 G00X284. M98P7599 G00X309. M98P7599 G00X334. M98P7599 G00X359. M98P7599
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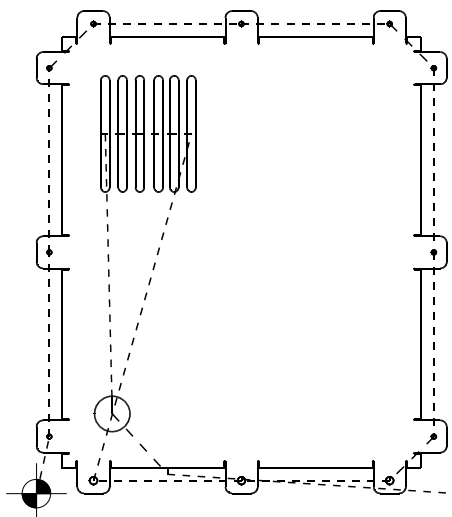
N3 (GAIKEI) T02 D01F1000 G00X46.868Y18.5 M03 G41G01X43.868 Y2. G02X41.868Y0.I-2. G01X14.5 G02X11.5Y3.J3. G01Y21.5 G03X10.5Y22.5I-1. G01X3. G02X0.Y25.5J3. G01Y194.5 G02X3.Y197.5I3. G01X10.5 G03X11.5Y198.5J1. G01Y217. G02X14.5Y220.I3. G01X403.5 G02X406.5Y217.J-3. G01Y198.5 G03X407.5Y197.5I1. G01X415. G02X418.Y194.5J-3. G01Y25.5 G02X415.Y22.5I-3. G01X407.5 G03X406.5Y21.5J-1. G01Y3. G02X403.5Y0.I-3. G01X95.868 G02X93.868Y2.J2. G01Y35. G03X43.868I-25. G01Y18.7 M05 G40G00X46.868Y18.5 M30		O7596 (D2.4) G91 M03 G42G01Y1.2 G02J-1.2 M05 G40G00Y-1.2 G90 M99  O7599 (D4.2) G91 M03 G42G01Y2.1 G02J-2.1 M05 G40G00Y-2.1 G90 M99	
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# 作業手順書

No. 1 / 2

図面番号	C-1110-5	部品名称	側板－A
工作機械名	レーザ加工機（WTS4112/SOL13H）		
素 材	SPCC 914 × 1829 × 1.6		

## 部品取りとプログラム



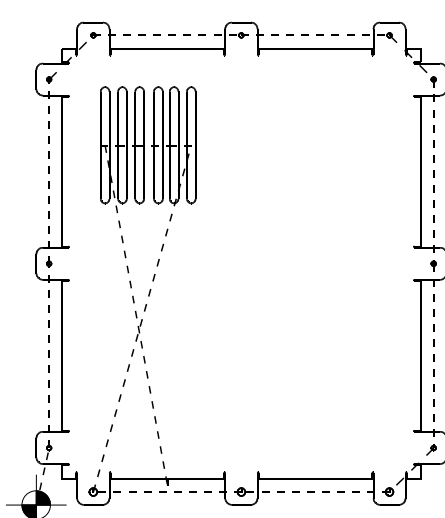
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G01Y221. G02X159.5Y224.I3. G01X168.5 G02X171.5Y221.J-3. G01Y209. G03X172.I0.25 G01Y212. X178.5 Y205.5 X175.5 G03Y205.J-0.25 G01X187.5 G02X190.5Y202.J-3. G01Y193. G02X187.5Y190.I-3. G01X175.5 G03Y189.5J-0.25 G01X178.5 Y120. X175.5 G03Y119.5J-0.25 G01X187.5 G02X190.5Y116.5J-3. G01Y107.5 G02X187.5Y104.5I-3. G01X175.5 G03Y104.J-0.25 G01X178.5 Y34.5 X175.5 G03Y34.J-0.25 G01X187.5 G02X190.5Y31.J-3. G01Y22. G02X187.5Y19.I-3. G01X175.5 G03Y18.5J-0.25 G01X178.5 Y12. X172. Y15. G03X171.5I-0.25 G01Y3. G02X168.5Y0.I-3. G01X159.5 G02X156.5Y3.J3. G01Y15. G03X156.I-0.25 G01Y12. X103.25 Y15. G03X102.75I-0.25 G01Y3. G02X99.75Y0.I-3. G01X90.75 G02X87.75Y3.J3.	G01Y15. G03X87.25I-0.25 G01Y12. X61.075 M05 G40G00X60.875Y9. G00X195.5Y0 M30	O7594 (D16.5) G91 M03 G42G01Y8.25 G02J-8.25 M05 G40G00Y-8.25 G90 M99  O7595 (D3.7) G91 M03 G42G01Y1.85 G02J-1.85 M05 G40G00Y-1.85 G90 M99  O7596 (D2.4) G91 M03 G42G01Y1.2 G02J-1.2 M05 G40G00Y-1.2 G90 M99  O7587 (54-4 NAGAANA) G91 M03 G42G01X-2. Y25. G02X4.I2. G01Y-50. G02X-4.I-2. G01Y25. M05 G40G00X2. G90 M99	
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# 作業手順書

No. 1 / 2

図面番号	C-1110-6	部品名称	側板－B
工作機械名	レーザ加工機（WTS4112/SOL13H）		
素 材	SPCC 914 × 1829 × 1.6		

部品取りとプログラム			
			
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G01X168.5 G02X171.5Y221.J-3. G01Y209. G03X172.I0.25 G01Y212. X178.5 Y205.5 X175.5 G03Y205.J-0.25 G01X187.5 G02X190.5Y202.J-3. G01Y193. G02X187.5Y190.I-3. G01X175.5 G03Y189.5J-0.25 G01X178.5 Y120. X175.5 G03Y119.5J-0.25 G01X187.5 G02X190.5Y116.5J-3. G01Y107.5 G02X187.5Y104.5I-3. G01X175.5 G03Y104.J-0.25 G01X178.5 Y34.5 X175.5 G03Y34.J-0.25 G01X187.5 G02X190.5Y31.J-3. G01Y22. G02X187.5Y19.I-3. G01X175.5 G03Y18.5J-0.25 G01X178.5 Y12. X172. Y15. G03X171.5I-0.25 G01Y3. G02X168.5Y0.I-3. G01X159.5 G02X156.5Y3.J3. G01Y15. G03X156.I-0.25 G01Y12. X103.25 Y15. G03X102.75I-0.25 G01Y3. G02X99.75Y0.I-3. G01X90.75 G02X87.75Y3.J3. G01Y15. G03X87.25I-0.25	G01Y12. X61.075 M05 G40G00X60.875Y9. M30	O7595 (D3.7) G91 M03 G42G01Y1.85 G02J-1.85 M05 G40G00Y-1.85 G90 M99  O7596 (D2.4) G91 M03 G42G01Y1.2 G02J-1.2 M05 G40G00Y-1.2 G90 M99  O7587 (54-4 NAGAANA) G91 M03 G42G01X-2. Y25. G02X4.I2. G01Y-50. G02X-4.I-2. G01Y25. M05 G40G00X2. G90 M99	
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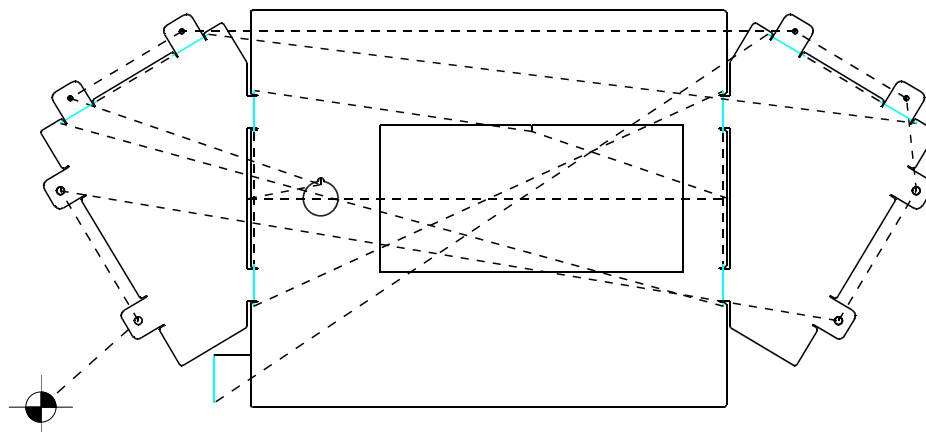


# 作業手順書

No. 1 / 3

図面番号	C-2110	部品名称	操作盤 - A
工作機械名	レーザ加工機 (WTS4112/SOL13H)		
素 材	SPCC 914 × 1829 × 1.6		

## 部品取りとプログラム



O7710  
G90G54  
  
N1 (D3.7)  
T01  
D01F250  
G00X45.Y40.  
M98P7595  
G00X8.985Y100.025  
M98P7595  
G00X368.559Y40.  
M98P7595  
G00X404.574Y100.025  
M98P7595

N2 (D2.4)  
T01  
D01F250  
G00X399.978Y142.899  
M98P7596  
G00X348.528Y173.769  
M98P7596  
G00X65.031  
M98P7596  
G00X13.581Y142.899  
M98P7596

N3 (HIJOU ANA)  
T02  
D01F1000

G00X129.28Y102.983  
M03  
G42G01Y105.983  
X129.78  
G02X130.78Y104.983J-1.  
G01Y104.443  
G02X127.78I-1.5J-7.96  
G01Y104.983  
G02X128.78Y105.983I1.  
G01X129.08  
M05  
G40G00X129.28Y102.983

N4 (SURITTO HIDARI)  
T02  
D01F1000  
G00X96.03Y96.483  
M03  
G42G01X95.28  
Y128.983  
X99.78  
G02Y128.483J-0.25  
G01X97.78  
G03X96.78Y127.483J-1.  
G01Y65.483  
G03X97.78Y64.483I1.  
G01X99.78  
G02Y63.983J-0.25  
G01X95.28  
Y96.283  
M05

G40G00X96.03Y96.483	M04
N5 (SURITTO MIGI)	G01X26.015Y141.613
T02	M05
D01F1000	G00X60.315Y162.193
G00X317.53Y96.483	M04
M03	G01X77.465Y172.483
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Y127.483	G00X404.694Y131.323
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G01X318.28	G00X353.244Y162.193
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X313.78	G01X336.094Y172.483
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G01X315.78	N8 (GAIKEI)
G03X316.78Y65.483J1.	T02
G01Y96.283	D01F1000
M05	G00X80.Y2.
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T02	G41G01X96.78
D01F1000	Y47.483
G00X226.78Y127.483	G02X97.78Y48.483I1.
M03	G01X99.78
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X296.78	G01X95.28
Y62.483	Y37.614
X156.78	G02X94.794Y36.757I-1.
Y130.483	G01X65.614Y19.249
X226.58	G02X64.242Y19.592I-0.514J0.857
M05	G01X54.775Y35.37
G40G00X226.78Y127.483	G02X55.118Y36.742I0.857J0.514
N7 (KEGAKI)	G01X56.833Y37.771
T07	G03X56.576Y38.199I-0.129J0.214
F2500	G01X46.286Y32.025
G00X98.28Y146.483	G02X42.17Y33.054I-1.543J2.572
M04	G01X37.54Y40.772
G01Y126.983	G02X38.569Y44.888I2.572J1.543
M05	G01X48.859Y51.062
G00X98.28Y66.233	G03X48.601Y51.49I-0.129J0.214
M04	G01X46.886Y50.461
G01Y46.733	G02X45.515Y50.804I-0.514J0.857
M05	G01X18.761Y95.394
G00X315.28Y146.233	G02X19.104Y96.766I0.857J0.514
M04	G01X20.819Y97.795
G01Y126.733	G03X20.561Y98.224I-0.129J0.214
M05	G01X10.272Y92.05
G00X315.28Y66.233	G02X6.156Y93.079I-1.543J2.572
M04	G01X1.525Y100.796
G01Y46.733	G02X2.554Y104.912I2.572J1.543
M05	G01X12.844Y111.086
G00X8.865Y131.323	G03X12.587Y111.515I-0.129J0.214
	G01X10.872Y110.486
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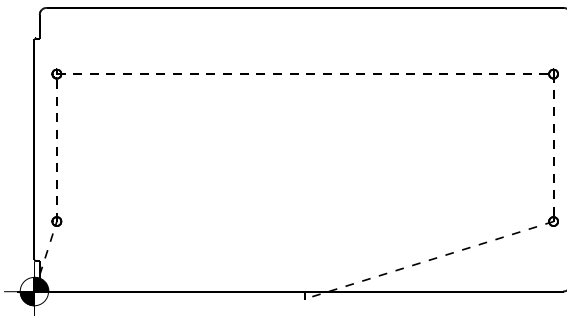
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# 作業手順書

No. 1 / 1

図面番号	C-2210	部品名称	操作盤－B
工作機械名	レーザ加工機（WTS4112/SOL13H）		
素 材	SPCC 914 × 1829 × 1.6		

## 部品取りとプログラム



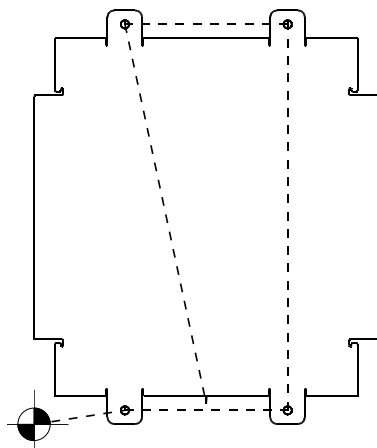
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# 作業手順書

No. 1 / 1

図面番号	C-3100	部品名称	電磁弁取付板
工作機械名	レーザ加工機（WTS4112/SOL13H）		
素 材	SPCC 914 × 1829 × 1.6		

## 部品取りとプログラム



O7810 G90G54  N1 (D3.7) T01 D01F250 G00X39.Y6. M98P7595 G00X109. M98P7595 G00Y172. M98P7595 G00X39. M98P7595  N2 (GAIKEI) T02 D01F1000 G00X74.Y9. M03 G41G01Y12. X47. Y15. G03X46.5I-0.25 G01Y3. G02X43.5Y0.I-3. G01X34.5 G02X31.5Y3.J3. G01Y15. G03X31.I-0.25 G01Y12.	X9. Y34.5 G02X9.5Y35.I0.5 G01X11. G02X11.5Y34.5J-0.5 G01Y34. G03X12.5I0.5 G01Y36. G03X12.Y36.5I-0.5 G01X0.5 G02X0.Y37.J0.5 G01Y141. G02X0.5Y141.5I0.5 G01X12. G03X12.5Y142.J0.5 G01Y144. G03X11.5I-0.5 G01Y143.5 G02X11.Y143.I-0.5 G01X9.5 G02X9.Y143.5J0.5 G01Y166. X31. Y163. G03X31.5I0.25 G01Y175. G02X34.5Y178.I3. G01X43.5 G02X46.5Y175.J-3. G01Y163. G03X47.I0.25	G01Y166. X101. Y163. G03X101.5I0.25 G01Y175. G02X104.5Y178.I3. G01X113.5 G02X116.5Y175.J-3. G01Y163. G03X117.I0.25 G01Y166. X139. Y143.5 G02X138.5Y143.I-0.5 G01X137. G02X136.5Y143.5J0.5 G01Y144. G03X135.5I-0.5 G01Y142. G03X136.Y141.5I0.5 G01X147.5 G02X148.Y141.J-0.5 G01Y37. G02X147.5Y36.5I-0.5 G01X136. G03X135.5Y36.J-0.5 G01Y34. G03X136.5I0.5 G01Y34.5 G02X137.Y35.I0.5 G01X138.5	G02X139.Y34.5J-0.5 G01Y12. X117. Y15. G03X116.5I-0.25 G01Y3. G02X113.5Y0.I-3. G01X104.5 G02X101.5Y3.J3. G01Y15. G03X101.I-0.25 G01Y12. X74.2 M05 G40G00X74.Y9. M30  O7595 (D3.7) G91 M03 G42G01Y1.85 G02J-1.85 M05 G40G00Y-1.85 G90 M99
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