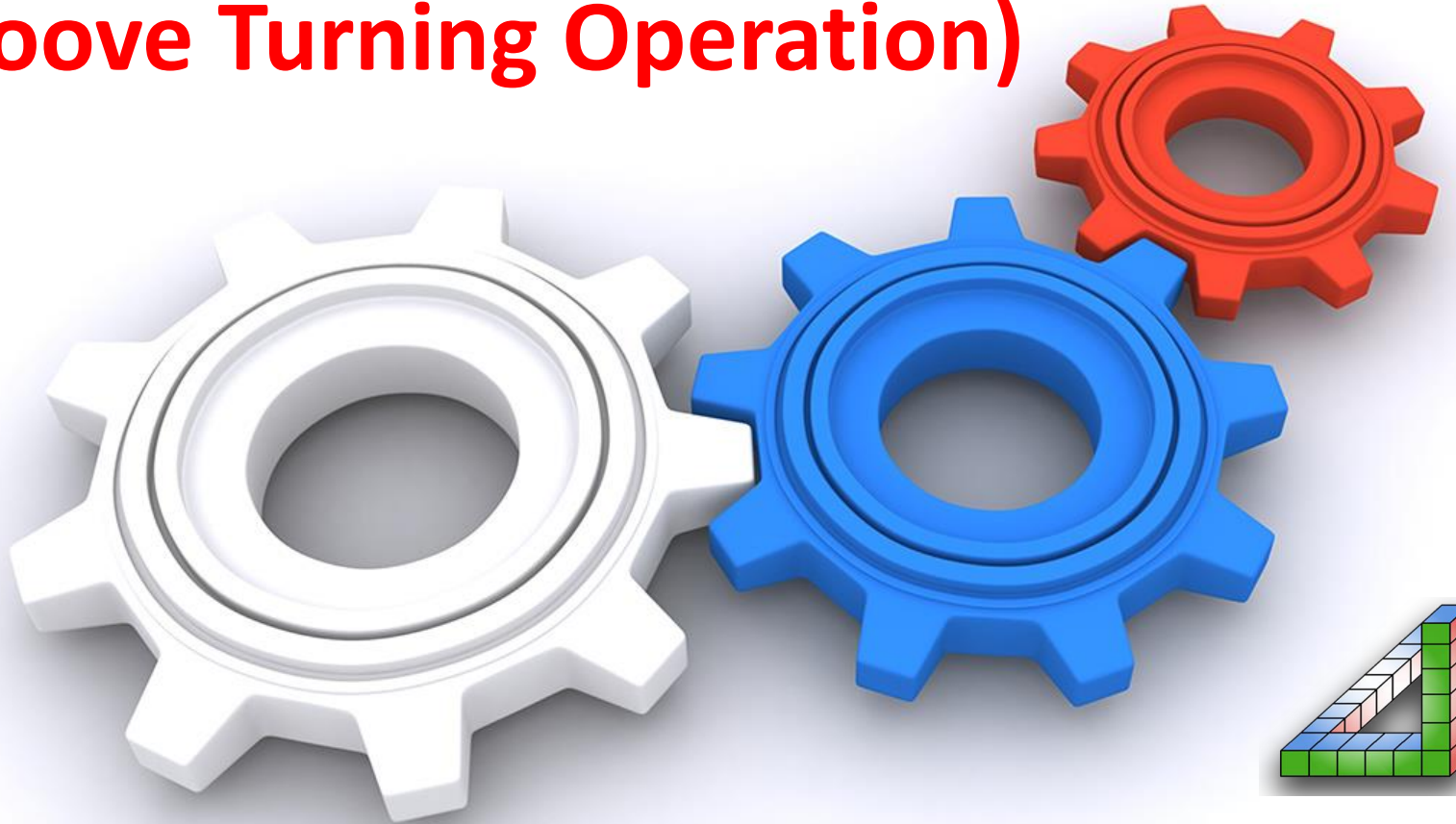


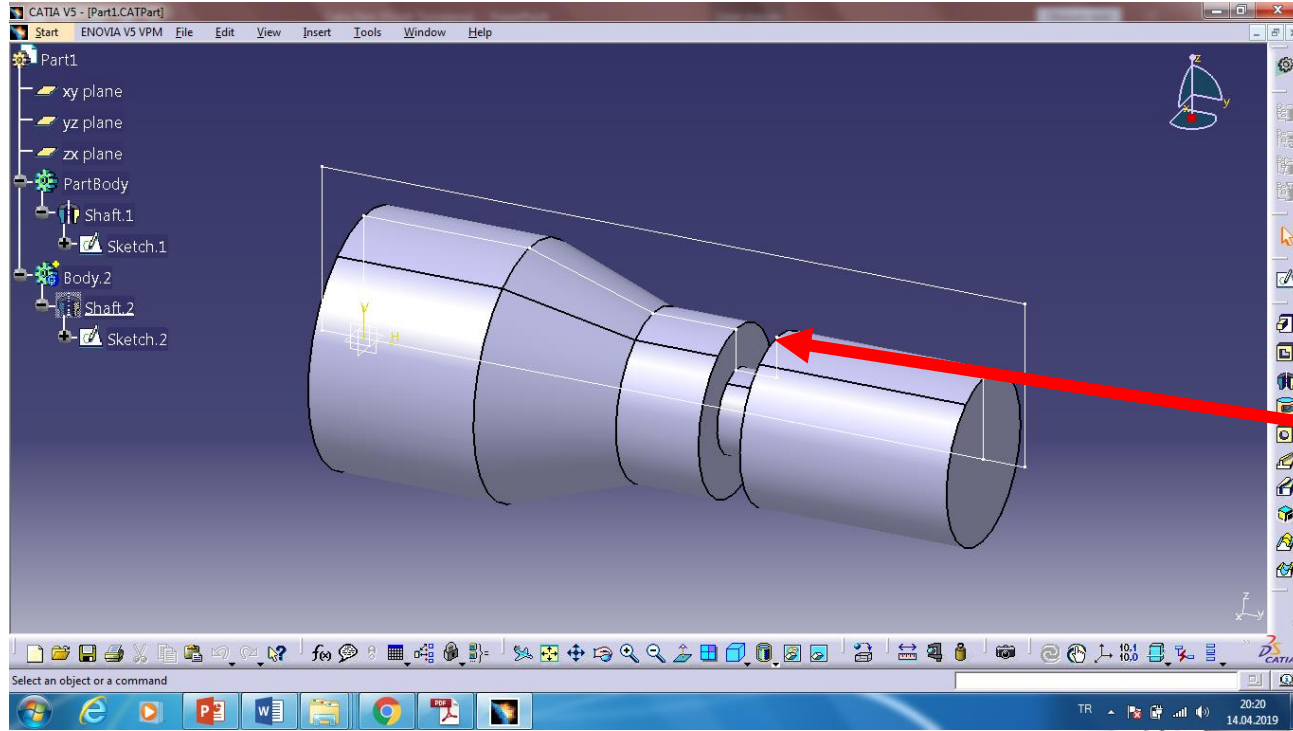
Catia

-Dalma Yöntemiyle Kanal Açma (Groove Turning Operation)

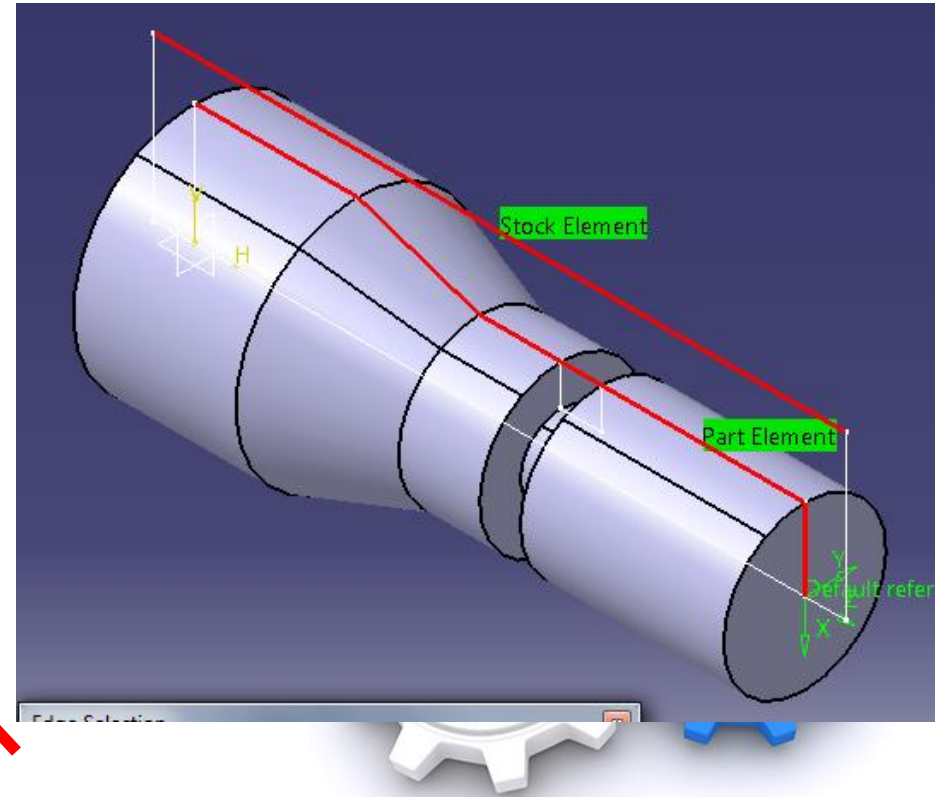
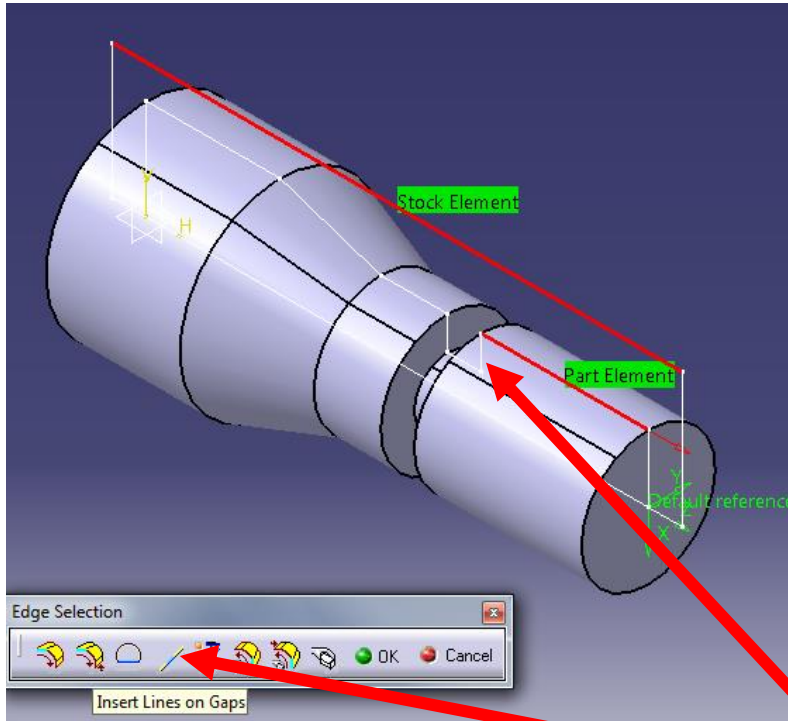


Kanal Açma Tornalama (Groove Turning Operation)

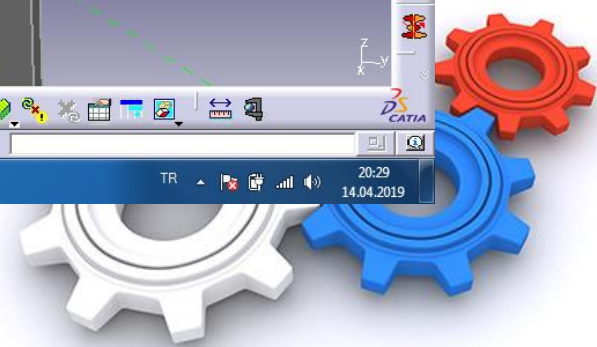
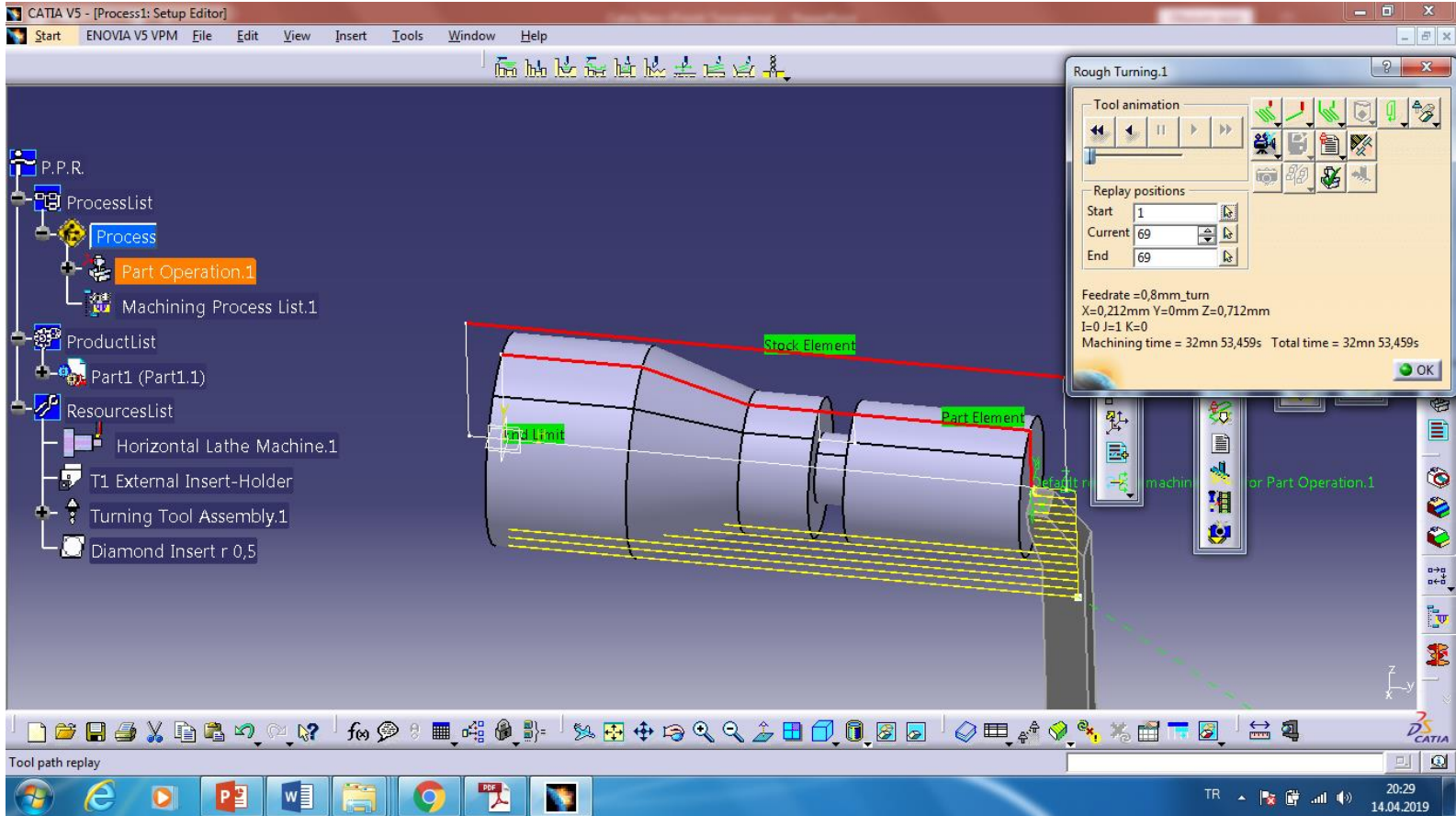
Kaba yüzey tornalama işlemine tabi tutulmuş parçaların üzerinde kanla varsa kaba ve ince tornalama yaparken tornalama çizgisinde kanal düz çizgiyle geçildikten sonra kanal kanal açılmalı (kaba ve ince olarak)



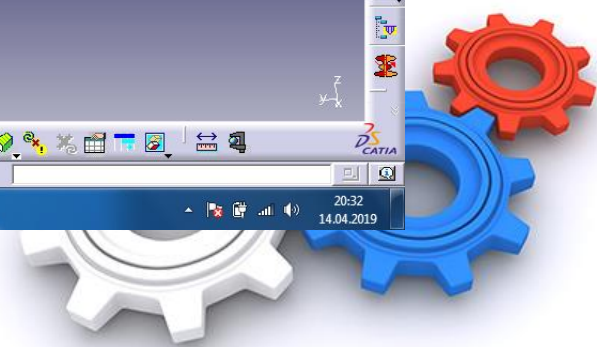
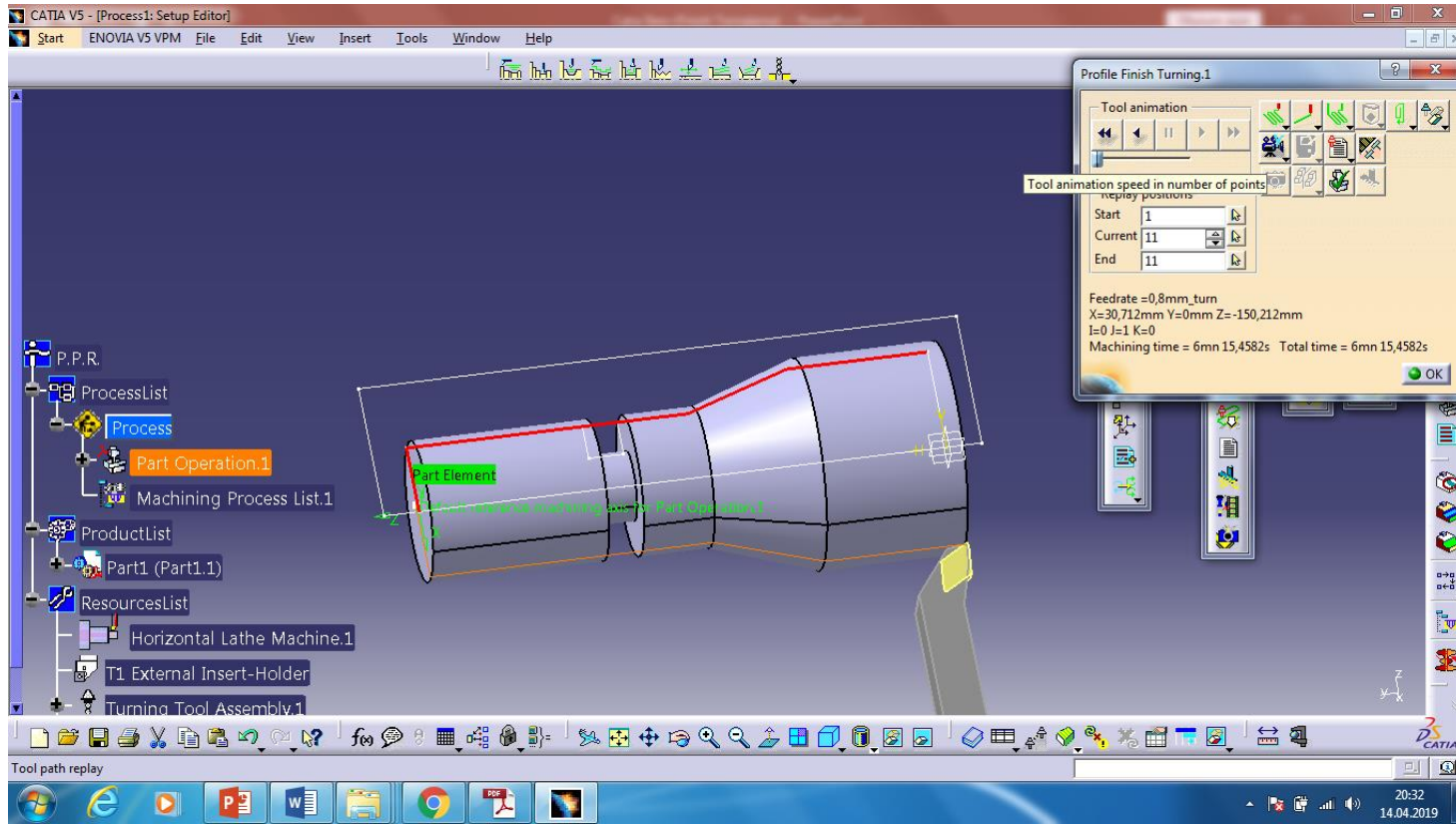
Kaba ve ince tornalama yaparken ana parça seçilirken insert line on gaps seçilip kanal pas geçilir



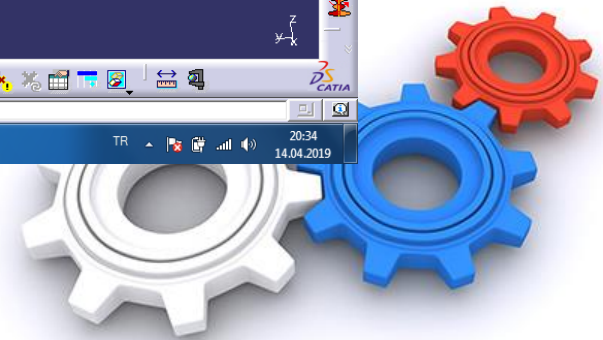
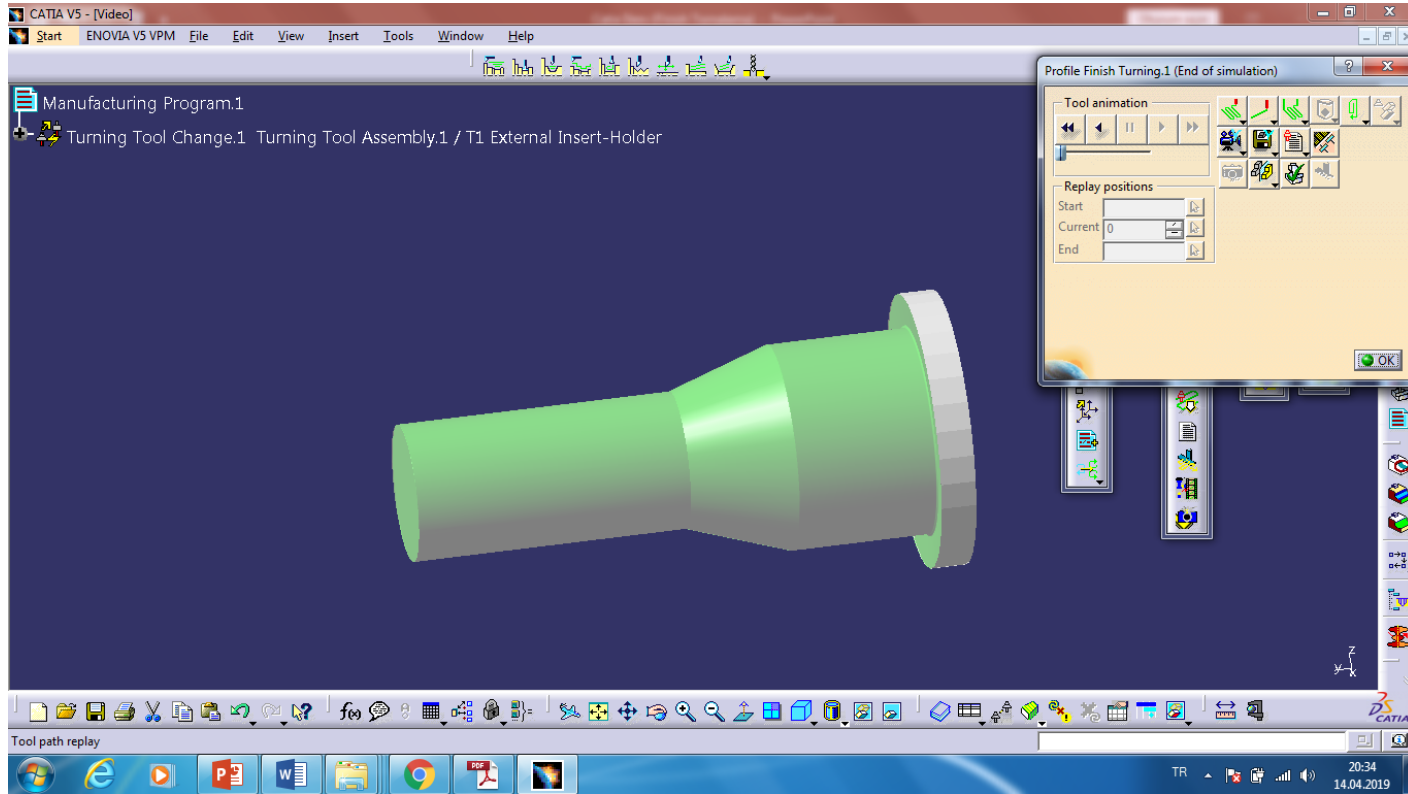
Kaba yüzey tornalama takım yolu



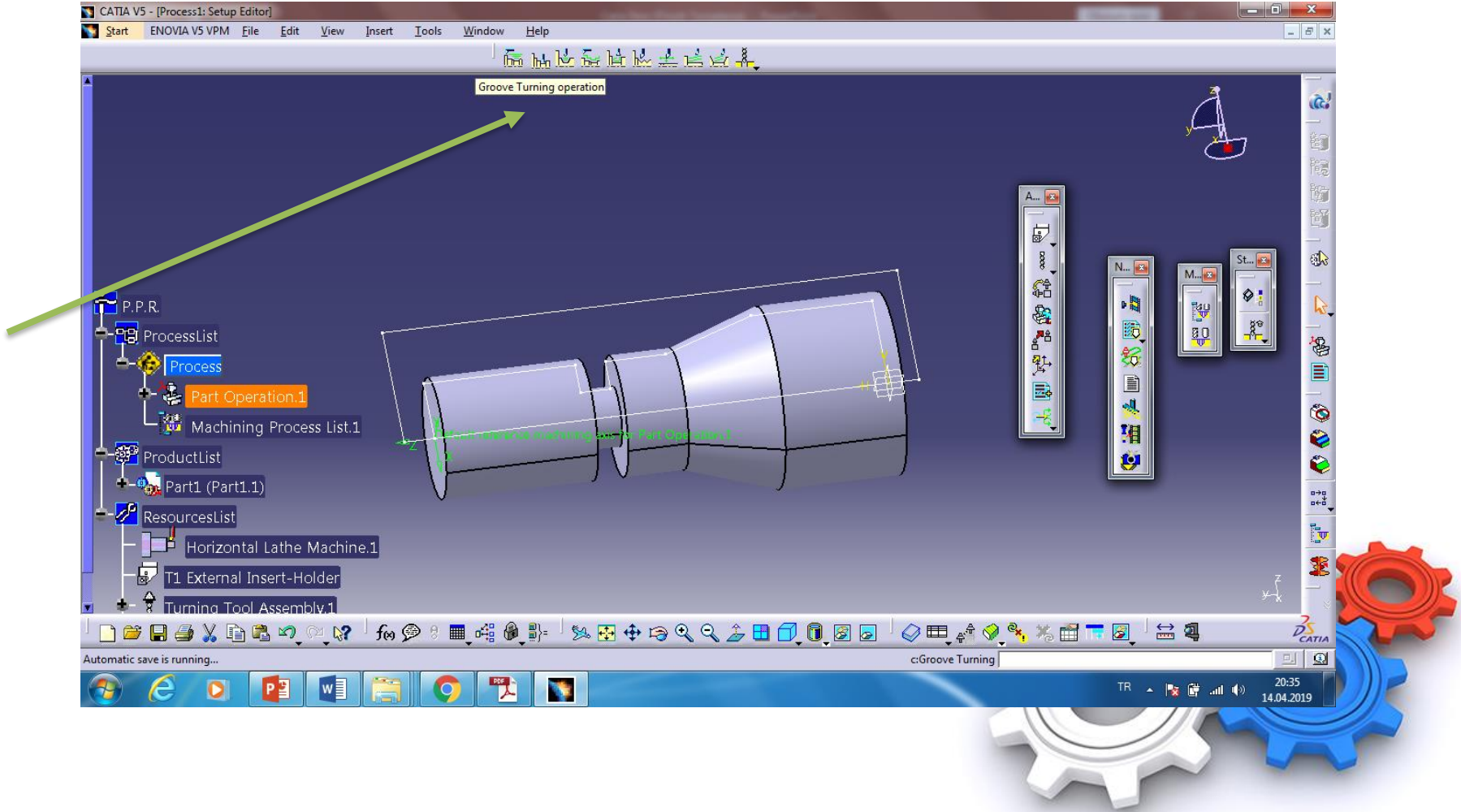
Finish yüzey tornalama takım yolu



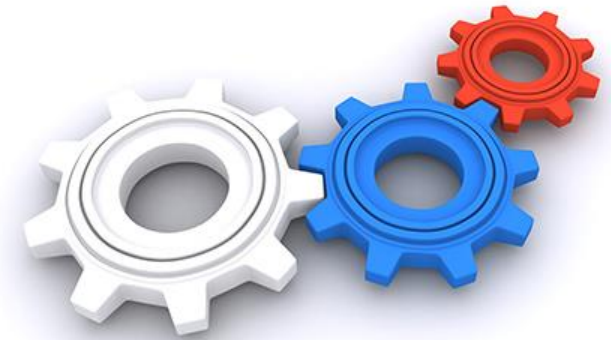
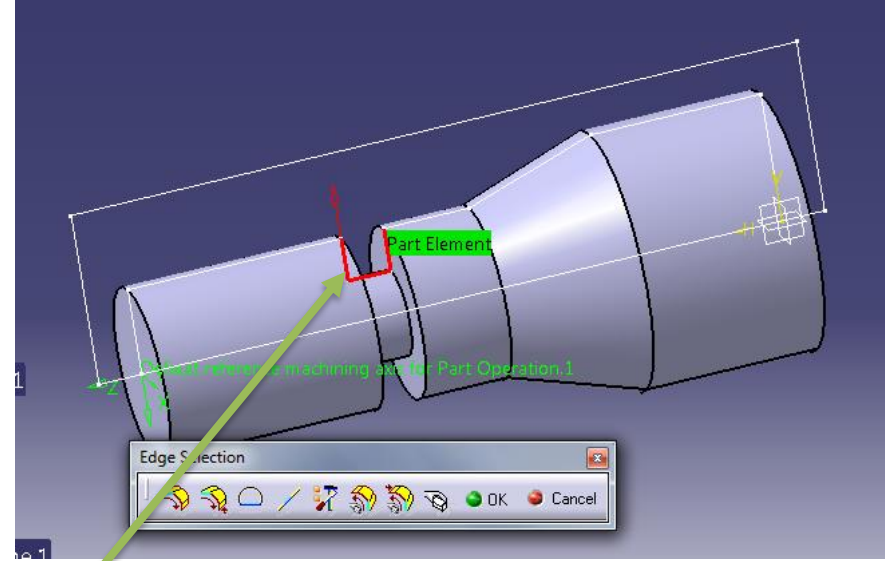
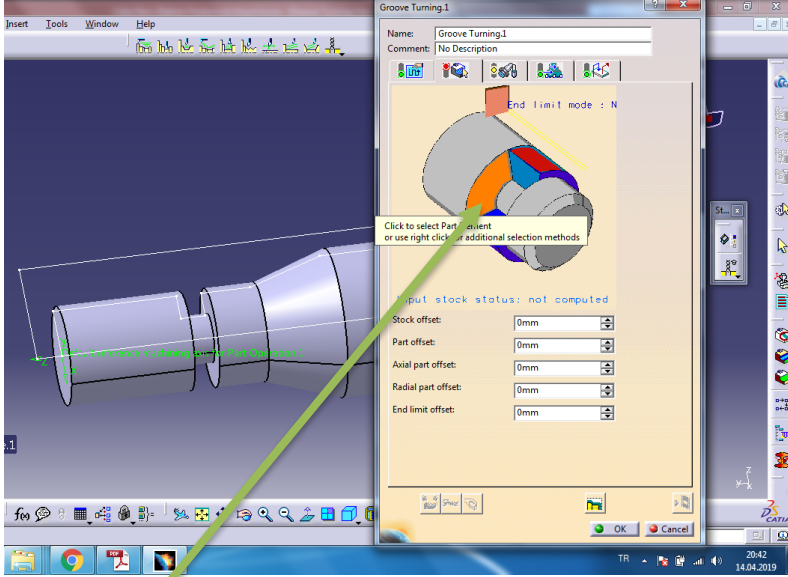
Kaba ve Finish tornalaması yapılmış parçamız



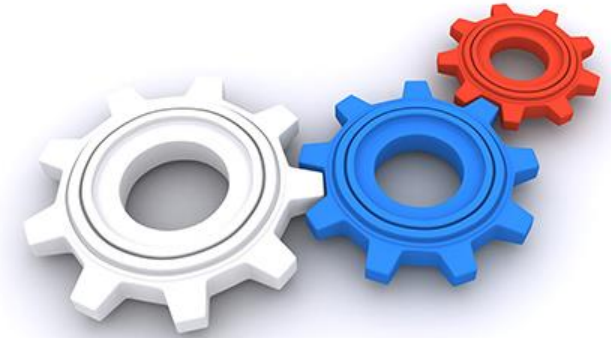
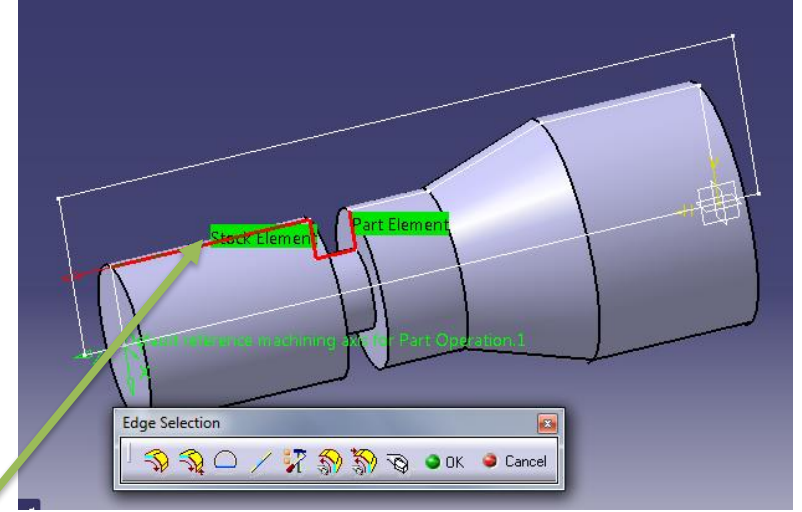
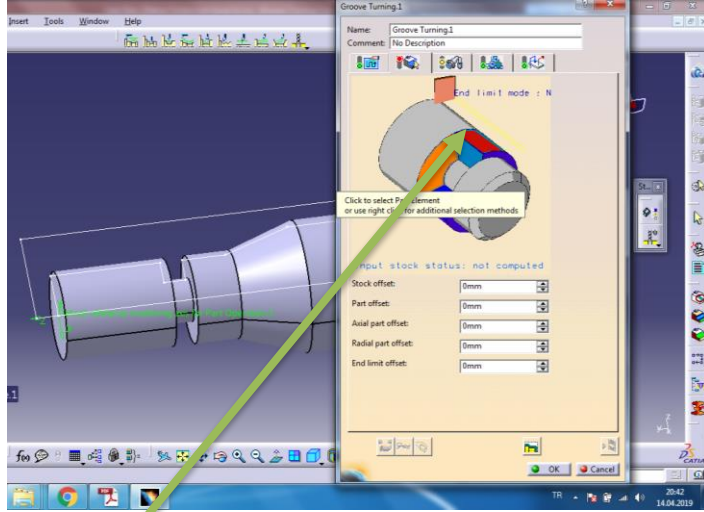
Dalma yöntemiyle kaba kanal açmak için Machining Operation araç çubuğundan **Groove Turning Operation** seçilir



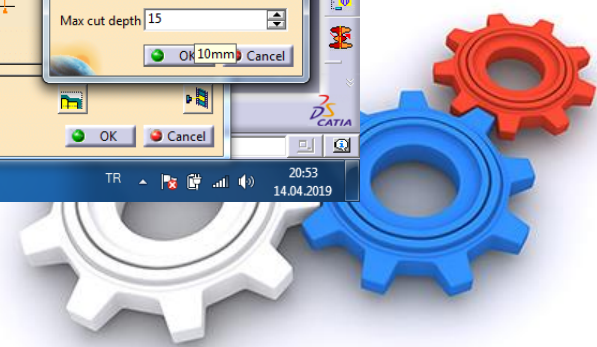
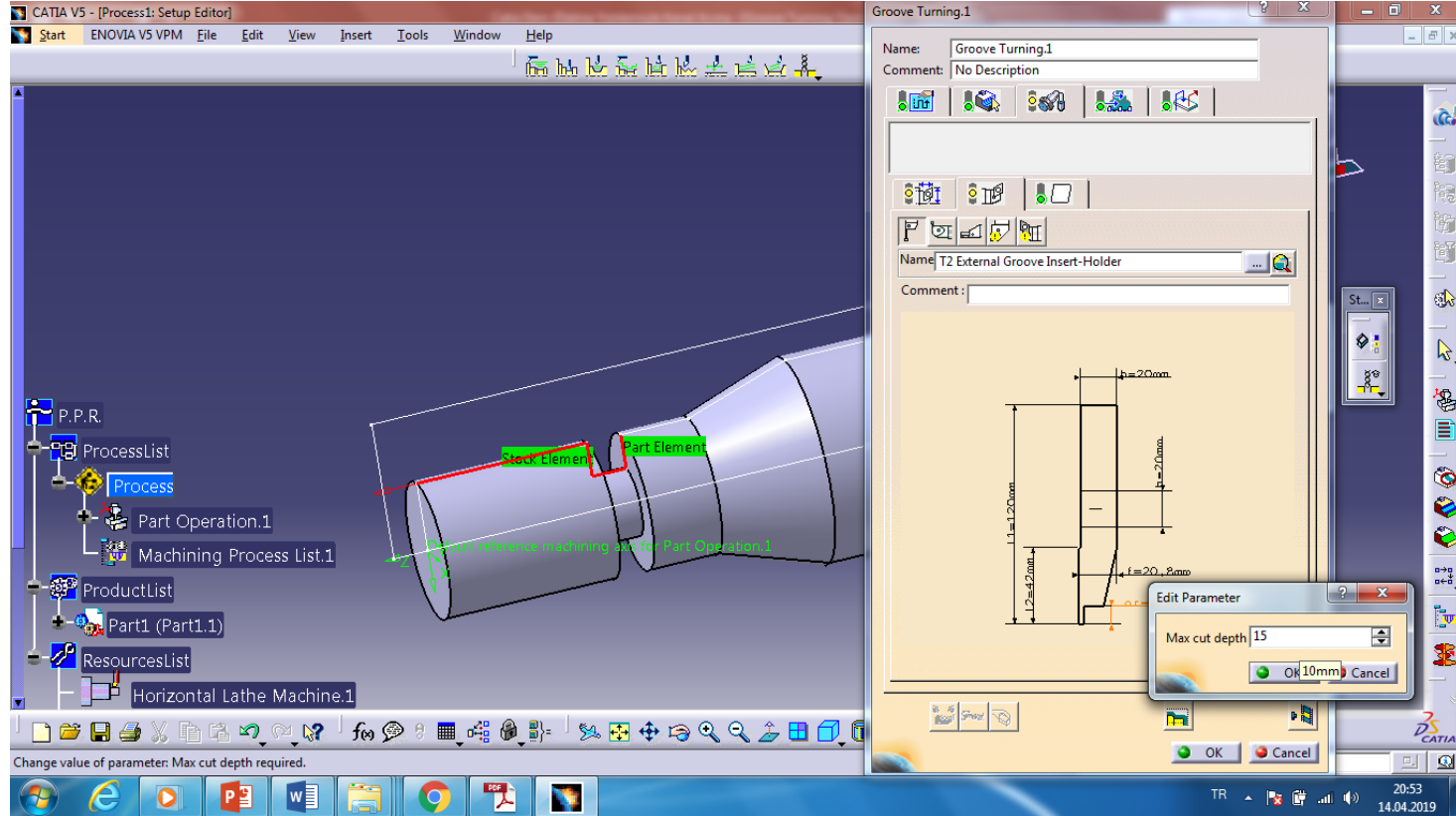
Karşımıza çıkan kanal tornalama penceresinde sarı yüzeye tıklanır ve kanalın çizgisi işaretlenir



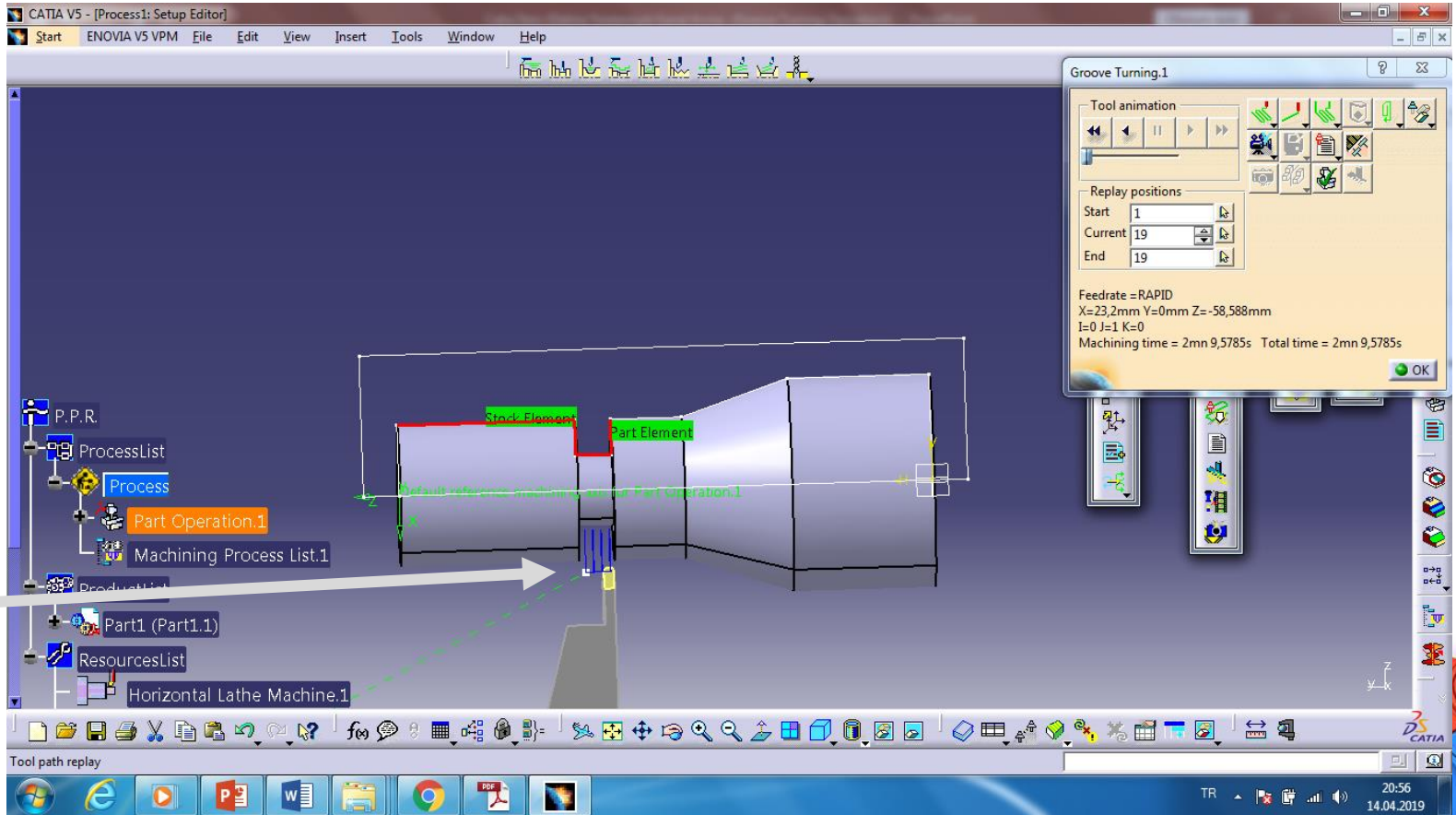
Karşımıza çıkan kanal tornalama penceresinde sarı yüzeye tıklanır ve kanalın Üst çizgisi işaretlenir



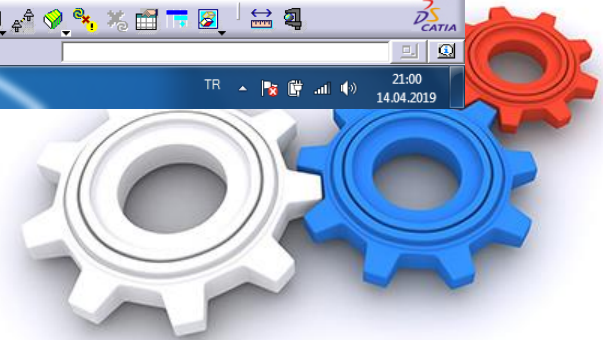
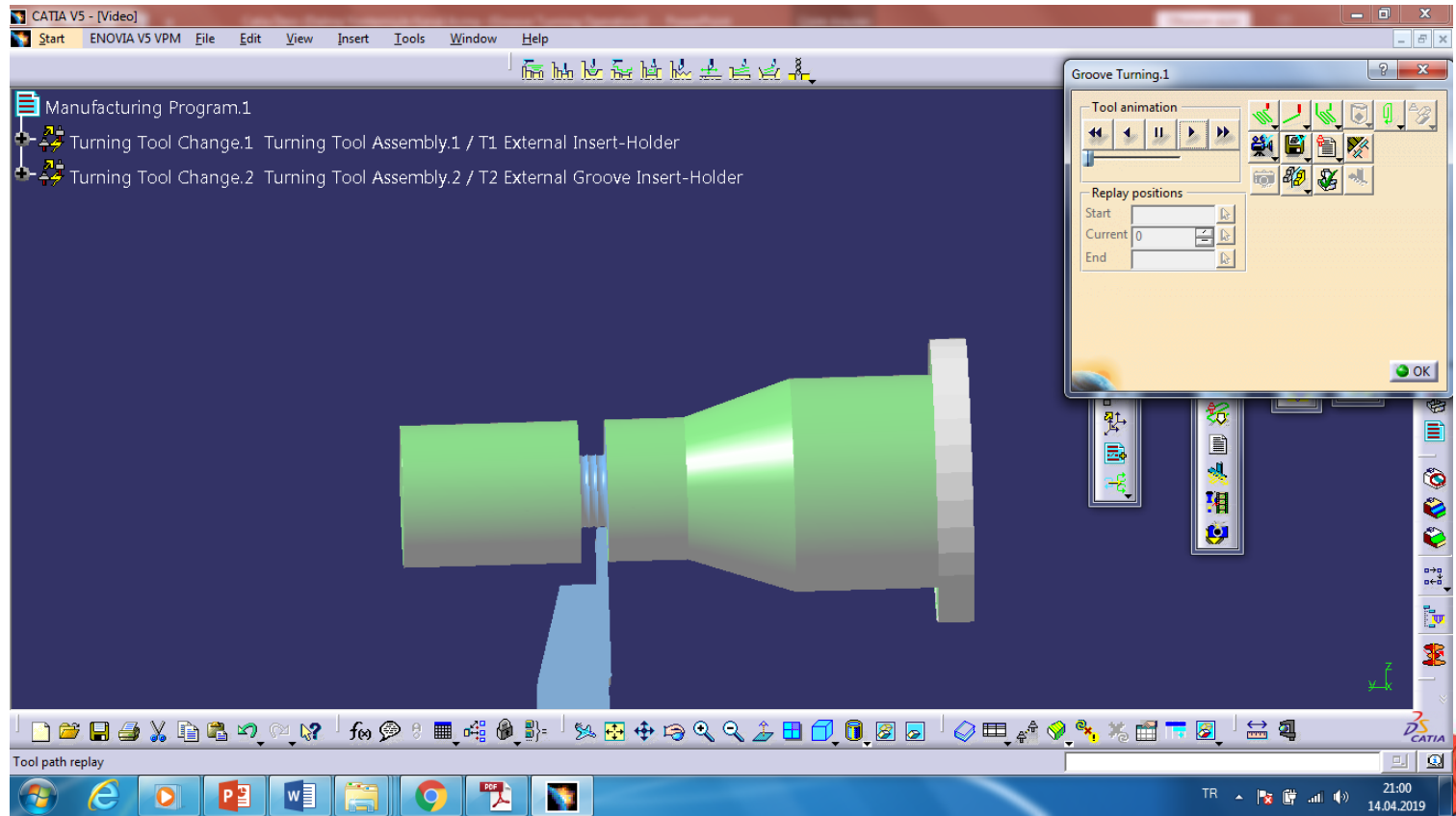
Kanal genişliği ve derinliğine göre kater ve uç ölçüleri girilir



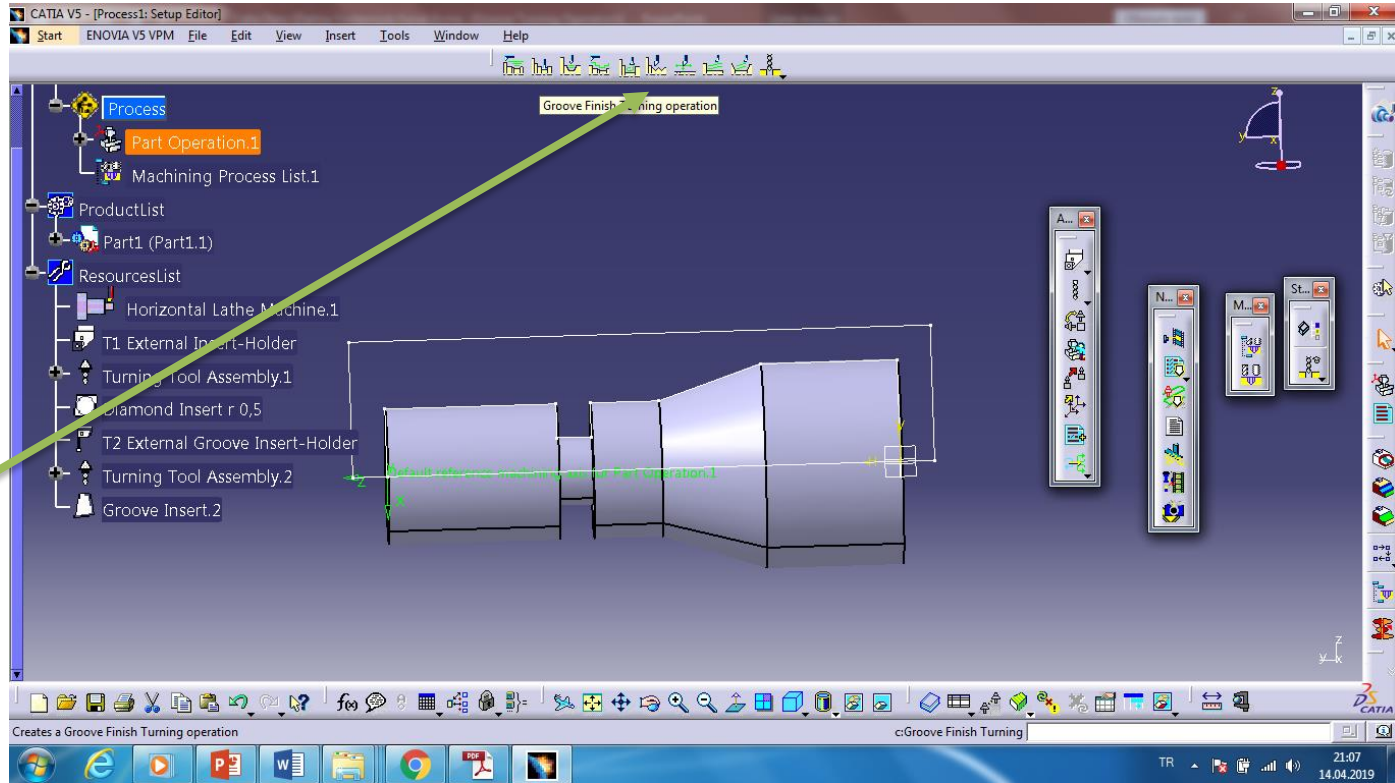
Takım yolları



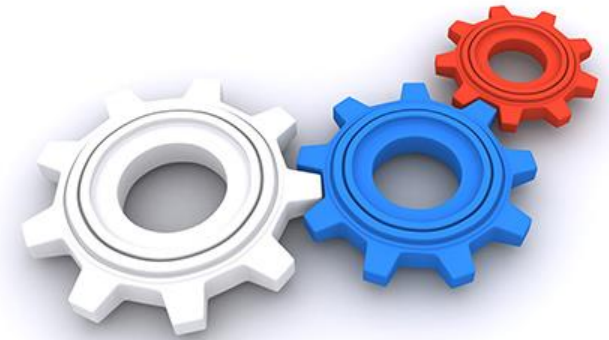
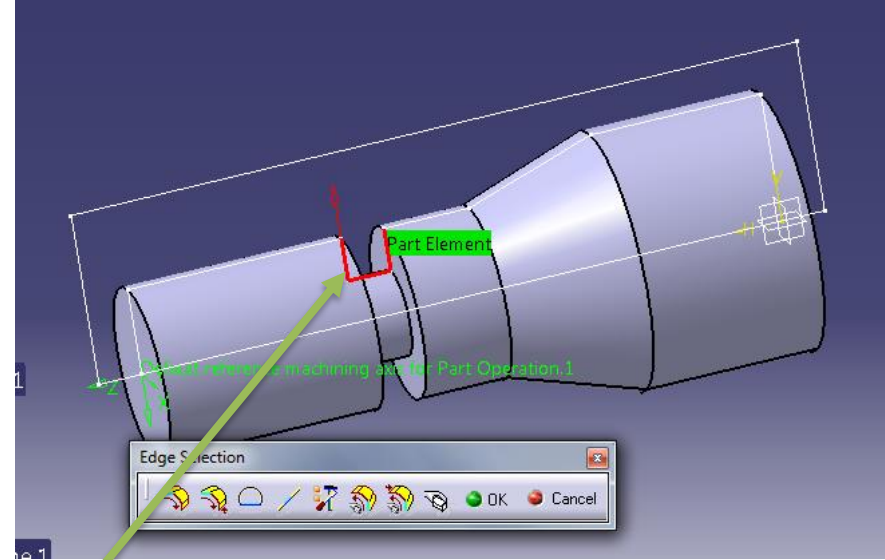
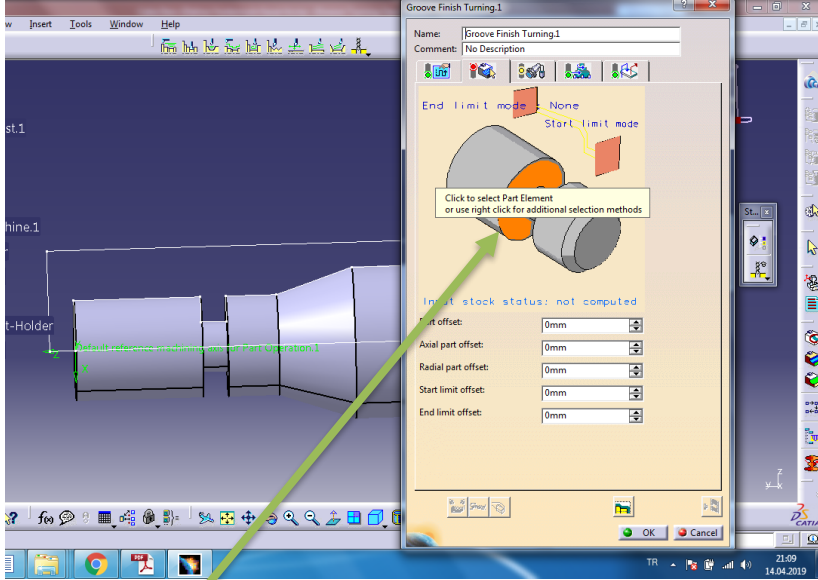
Simulasyon



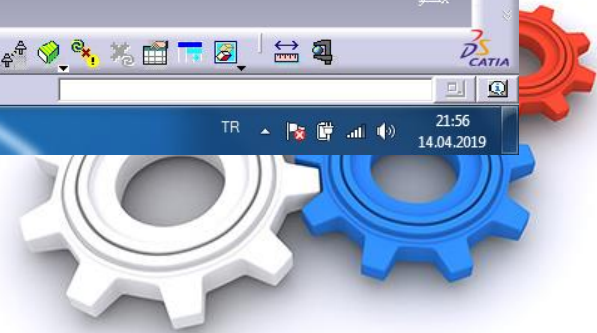
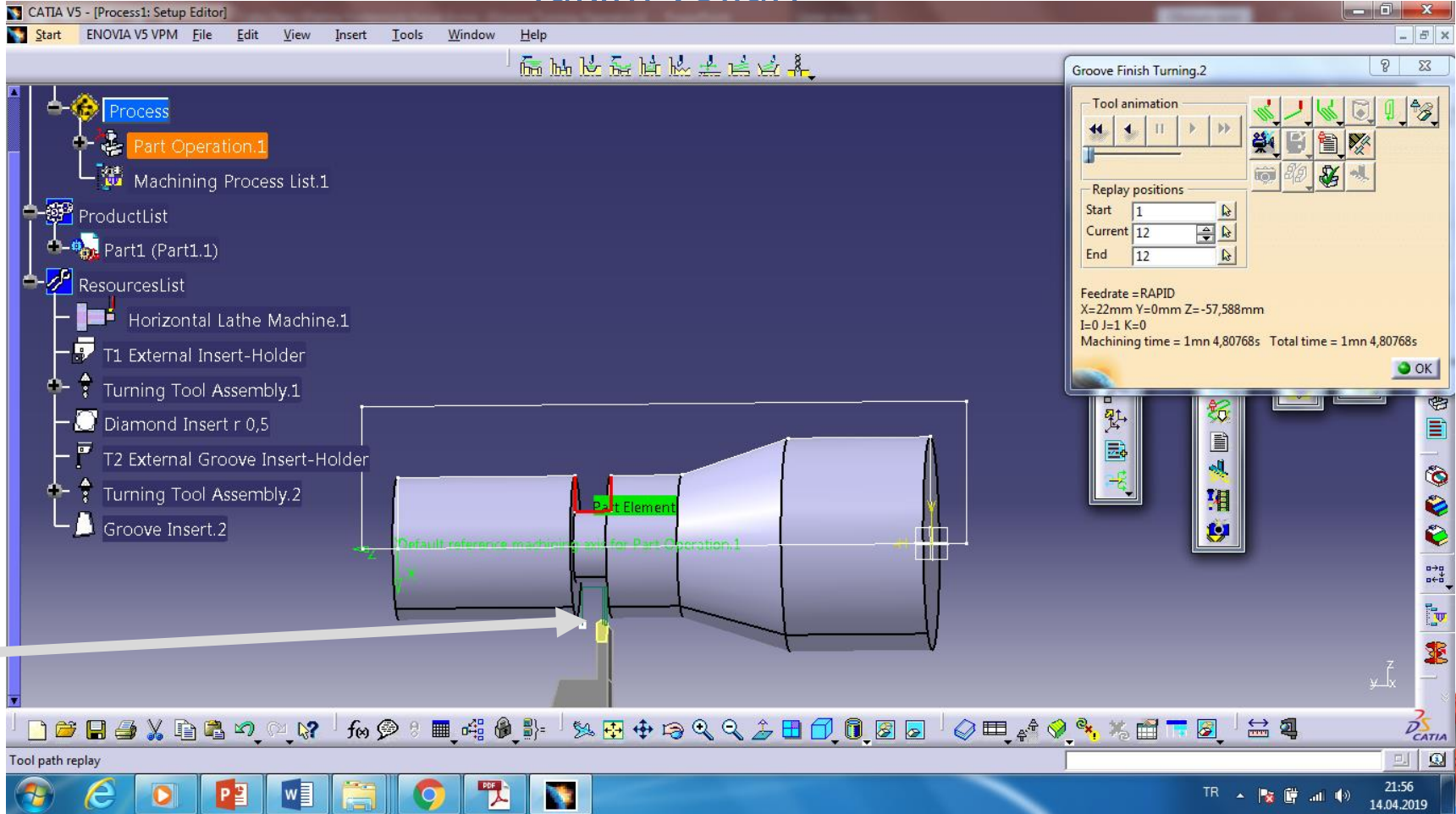
Dalma yöntemiyle Finish kanal açmak için Machining Operation araç çubuğundan **Groove Finish Turning Operation** seçilir



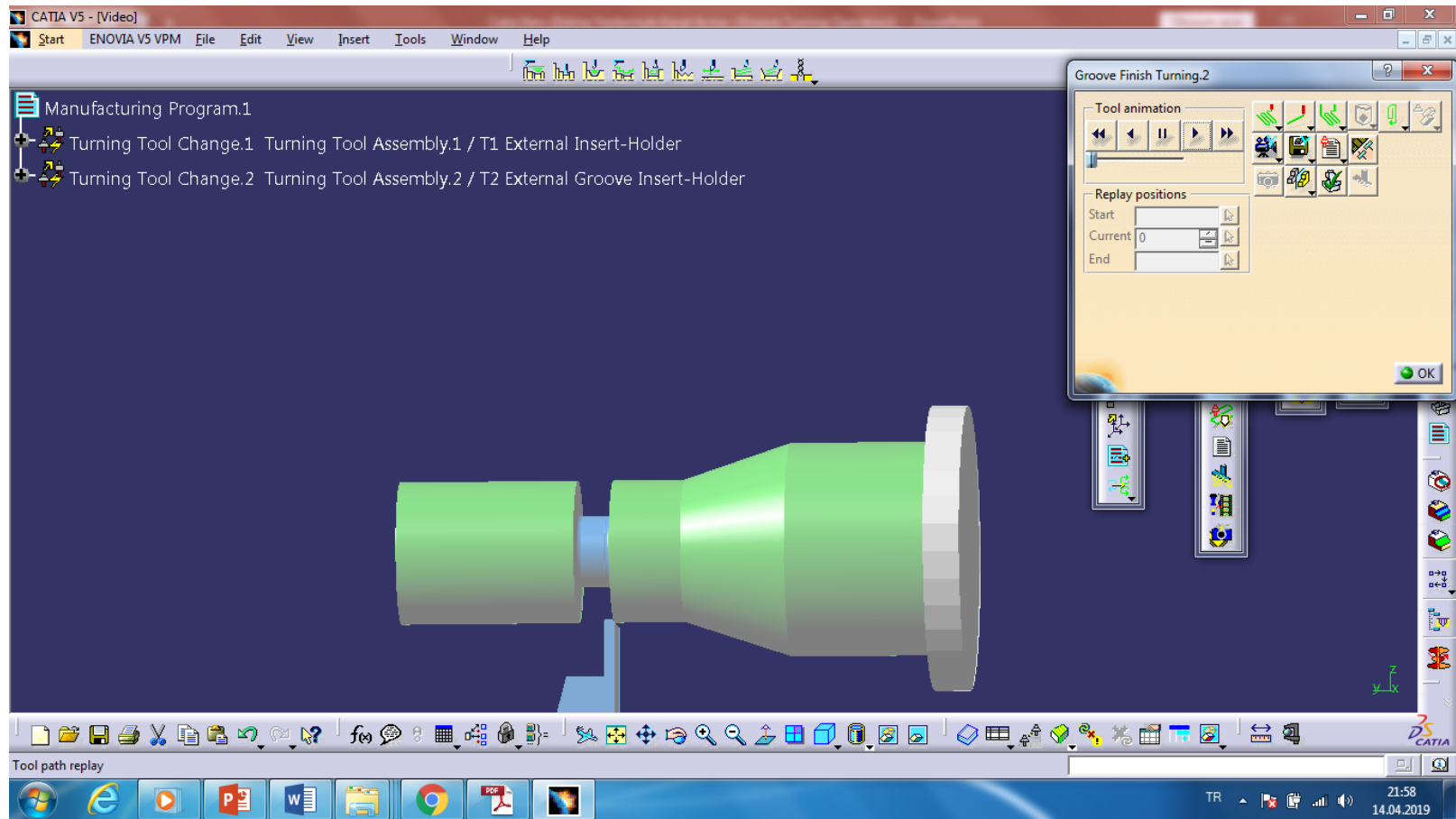
Karşımıza çıkan Finish kanal tornalama penceresinde sarı yüzeye tıklanır ve kanalın çizgisi işaretlenir



Takım volları

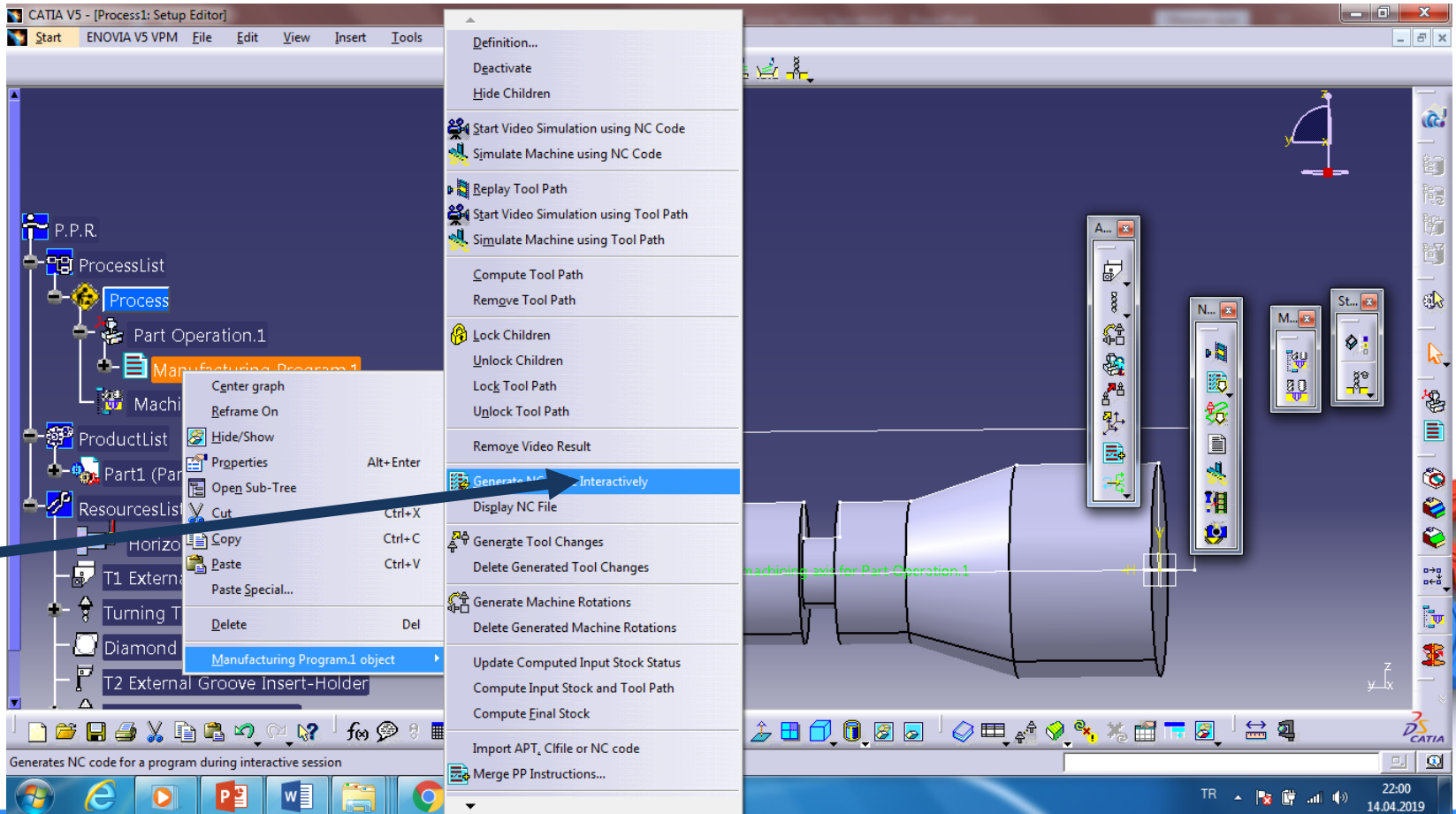


Simulasiyon

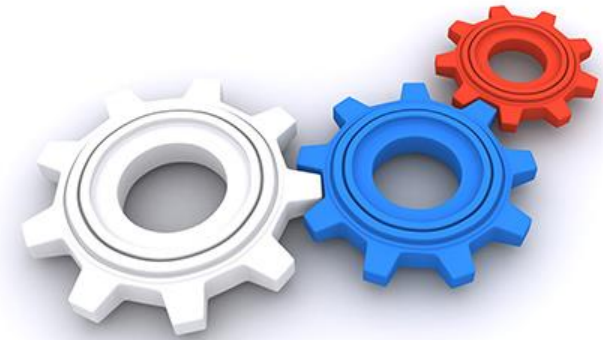
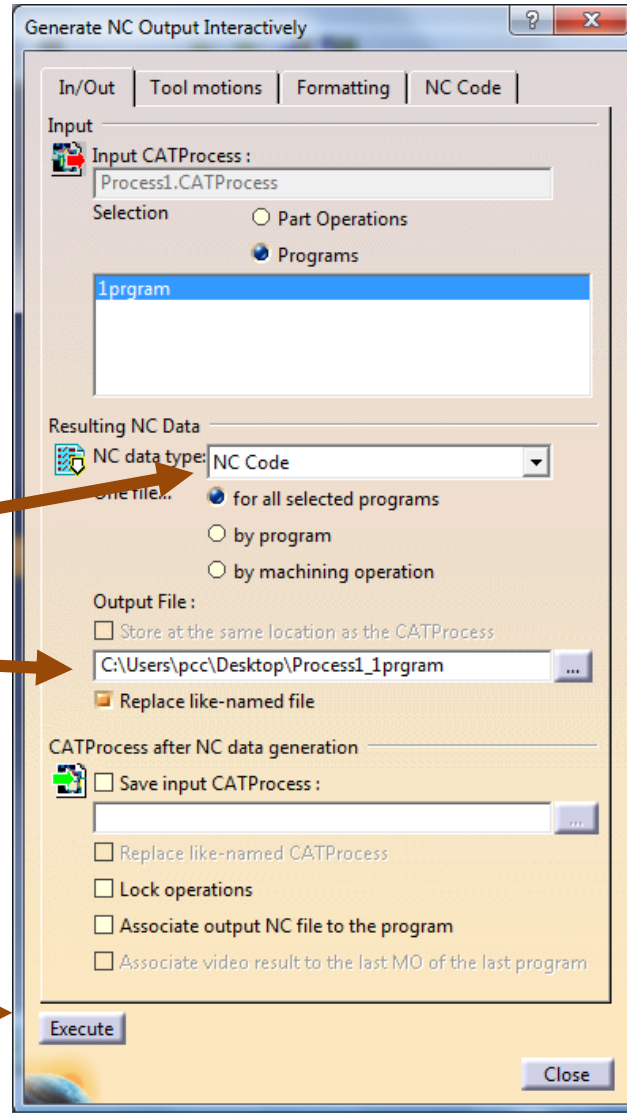


NC Kodu Üretme

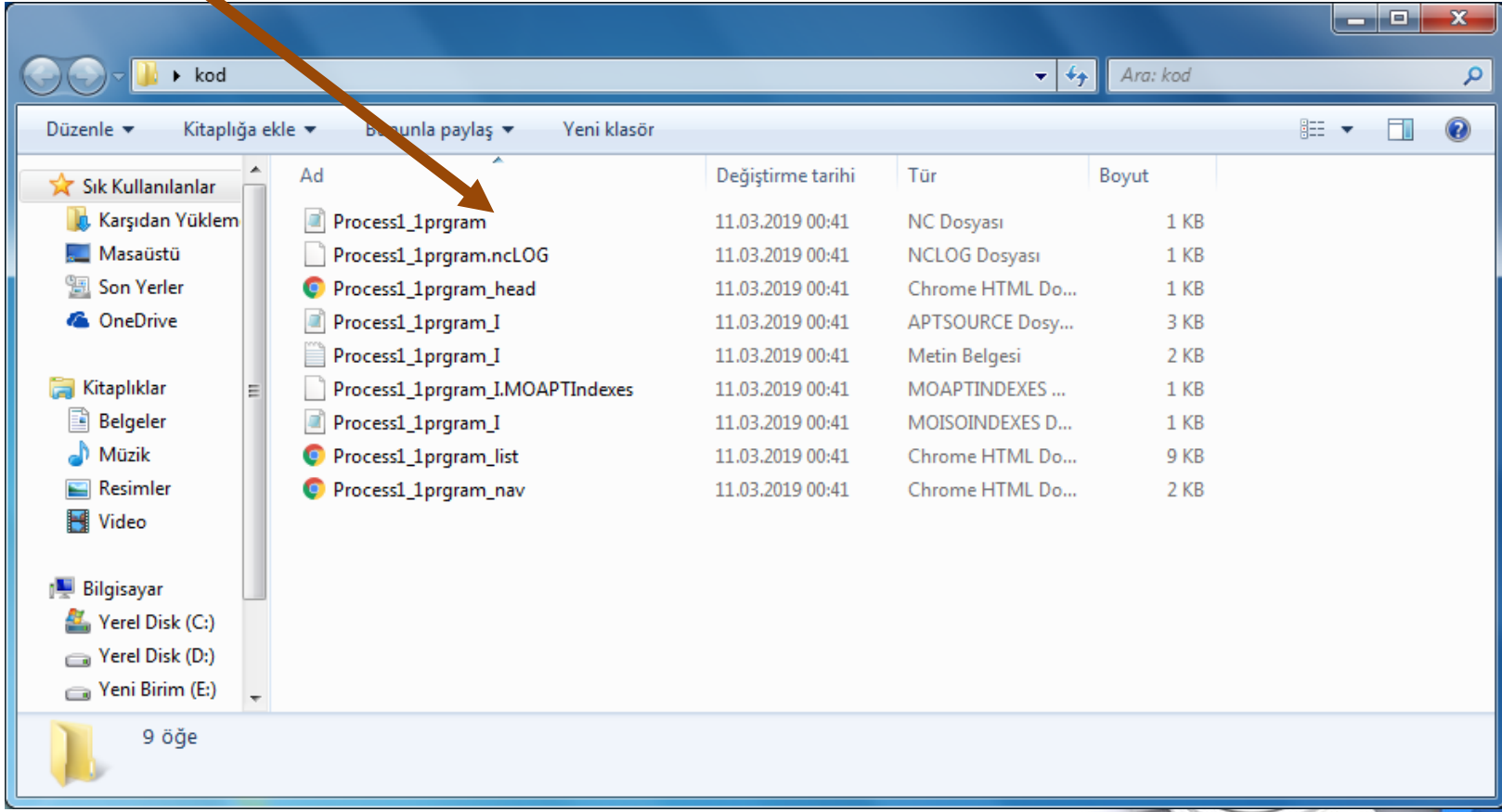
a) Unsur Ağacındaki part operation1 altında bulunan program'ı sağ tıklayıp Program object / generic Nc Code Intercitively tıklanır



b) Nc Code seçilir, nc kodunun kaydedileceği klasör belirleriniz execute butonuna basılır



d) En üstteki Process1_1program dosyası not defteri ile açılır



e) Nc Kod dosyasının içeriği (Post Dosyası)

```
Process1_Part_Operation_1 - Not Defteri
Dosya Düzen Biçim Görünüm Yardım
N77 X30.5 Z-110.
N78 Z-150.
N79 X30.712 Z-150.212 F.8
( TOOL: T2 EXTERNAL GROOVE INSERT-HOLDER )
( OPERATION: GROOVE TURNING.1 )
N80 X23.2 Z-51.8 F.3
N81 X21.2
N82 X11.2
N83 X23.2 F.8
N84 G0 Z-54.133
N85 G1 X21.2 F.3
N86 X11.2 F.4
N87 X11.412 Z-53.921 F.8
N88 G0 X23.2
N89 Z-56.467
N90 G1 X21.2 F.3
N91 X11.2 F.4
N92 X11.412 Z-56.255 F.8
N93 G0 X23.2
N94 Z-58.8
N95 G1 X21.2 F.3
N96 X11.2 F.4
N97 X11.412 Z-58.588 F.8
N98 G0 X23.2
( OPERATION: GROOVE FINISH TURNING.2 )
N99 G1 X22. Z-51.8 F.3
N100 X20.
N101 X11.2 F.4
N102 Z-57.8
N103 X11.412 Z-58.012 F.8
N104 G0 X22.
N105 Z-58.8
N106 G1 X20. F.3
N107 X11.2 F.4
N108 Z-57.8
N109 X11.412 Z-57.588 F.8
N110 G0 X22.
N111 M30
%
```

