

Catia

-Finish Tornalama-

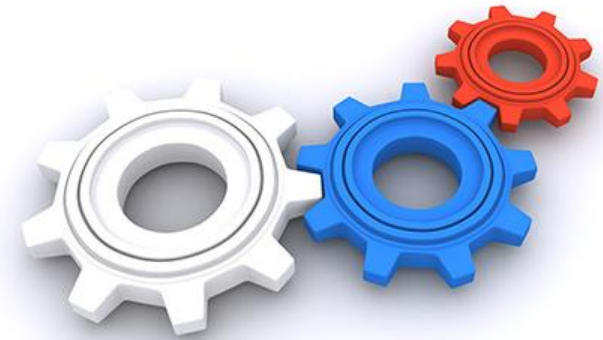
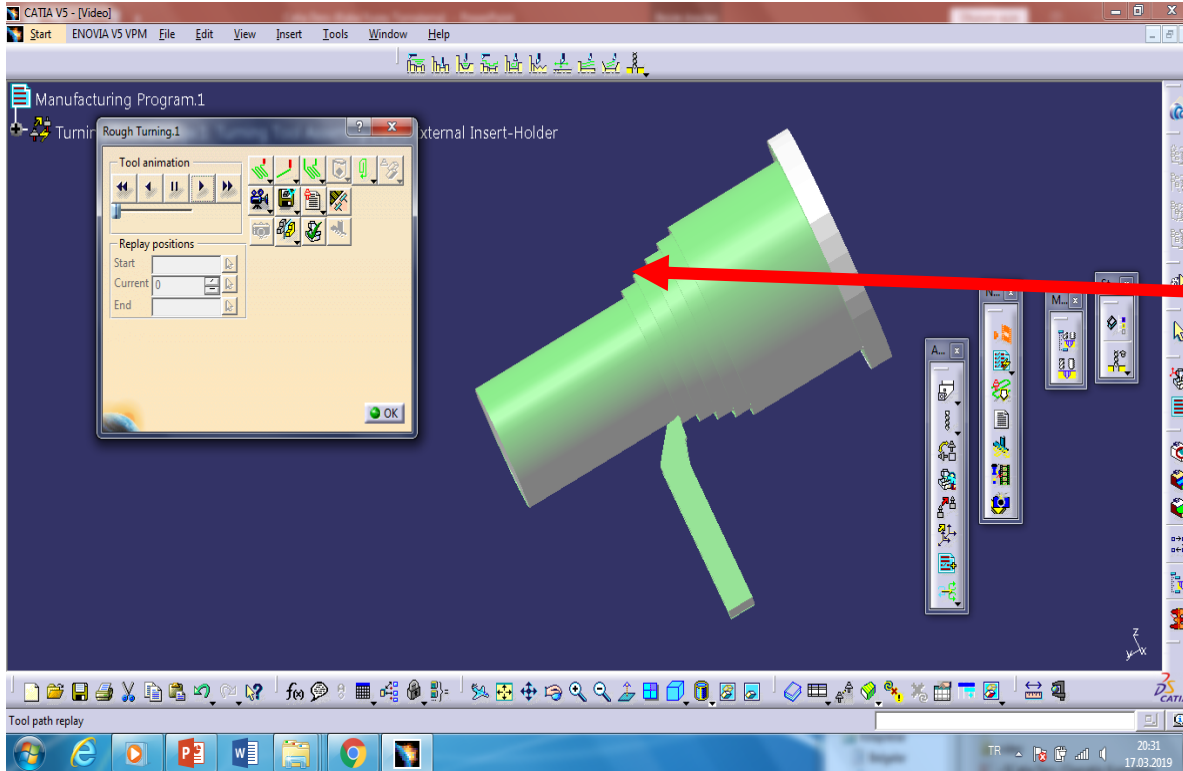


Ahmet SAN

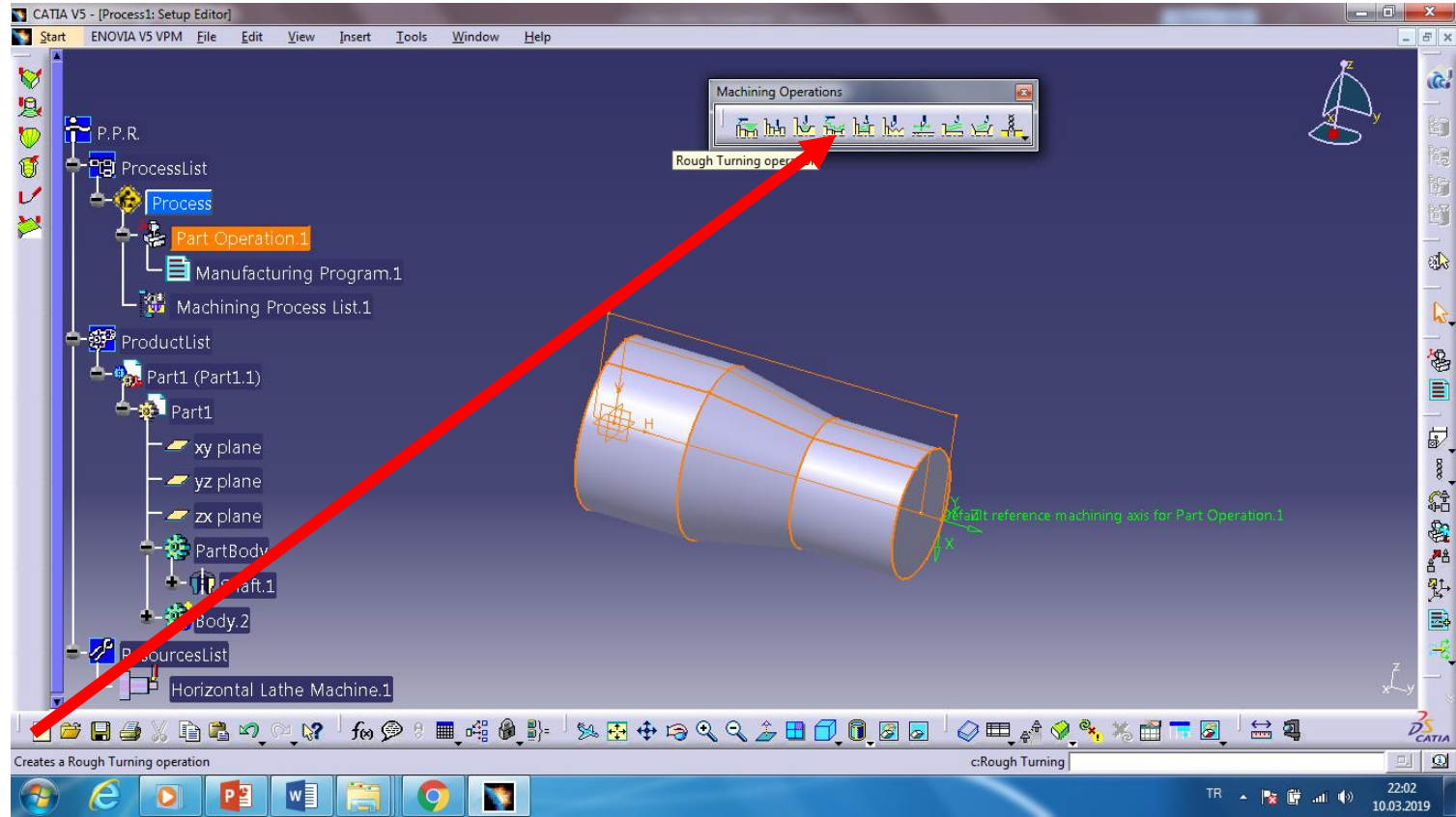
Karamürsel 2019

Finish Tornalama

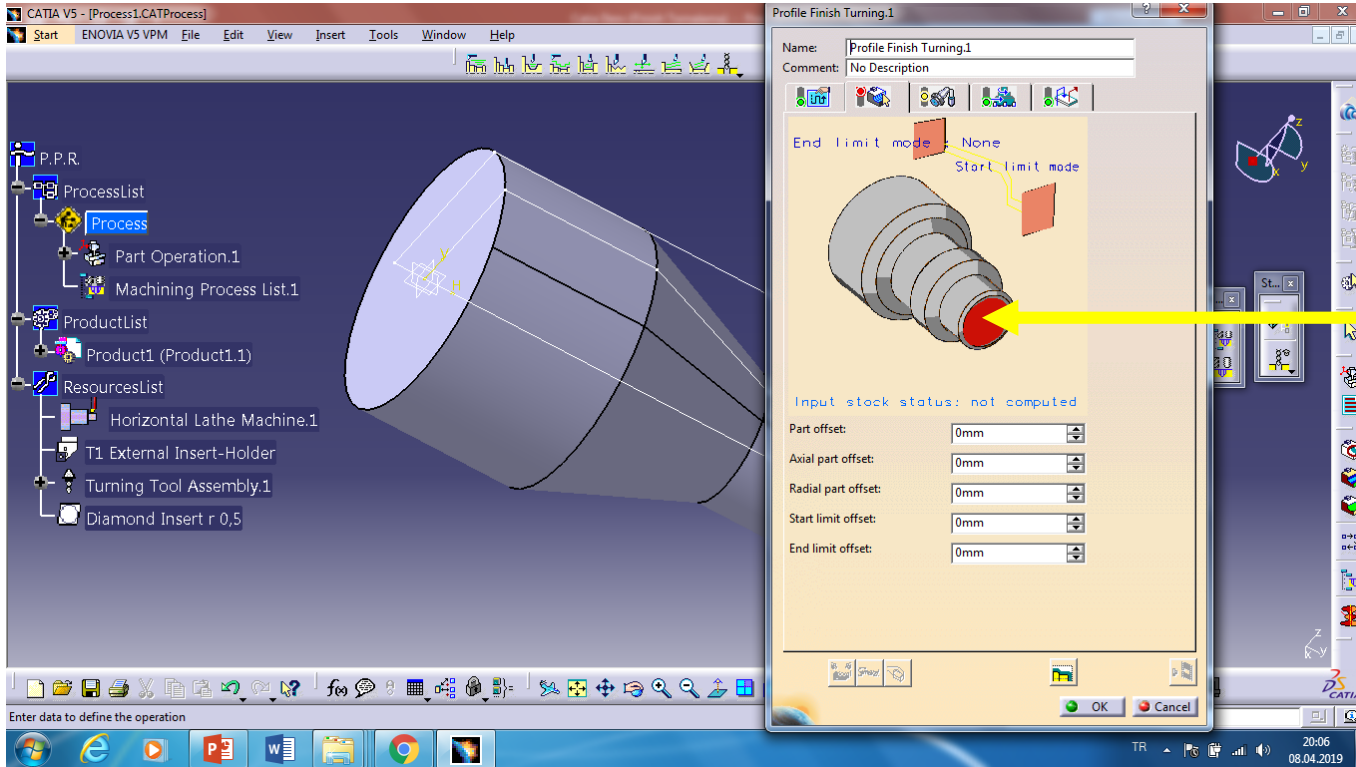
Kaba yüzey tornalama işlemine tabi tutulmuş parçaların özellikle kavis ve konik kısımları bir defada alınacak paso miktarına göre kademeli olmaktadır. Düzgün bir yüzey elde etmek için finish tornalama yapılmalıdır



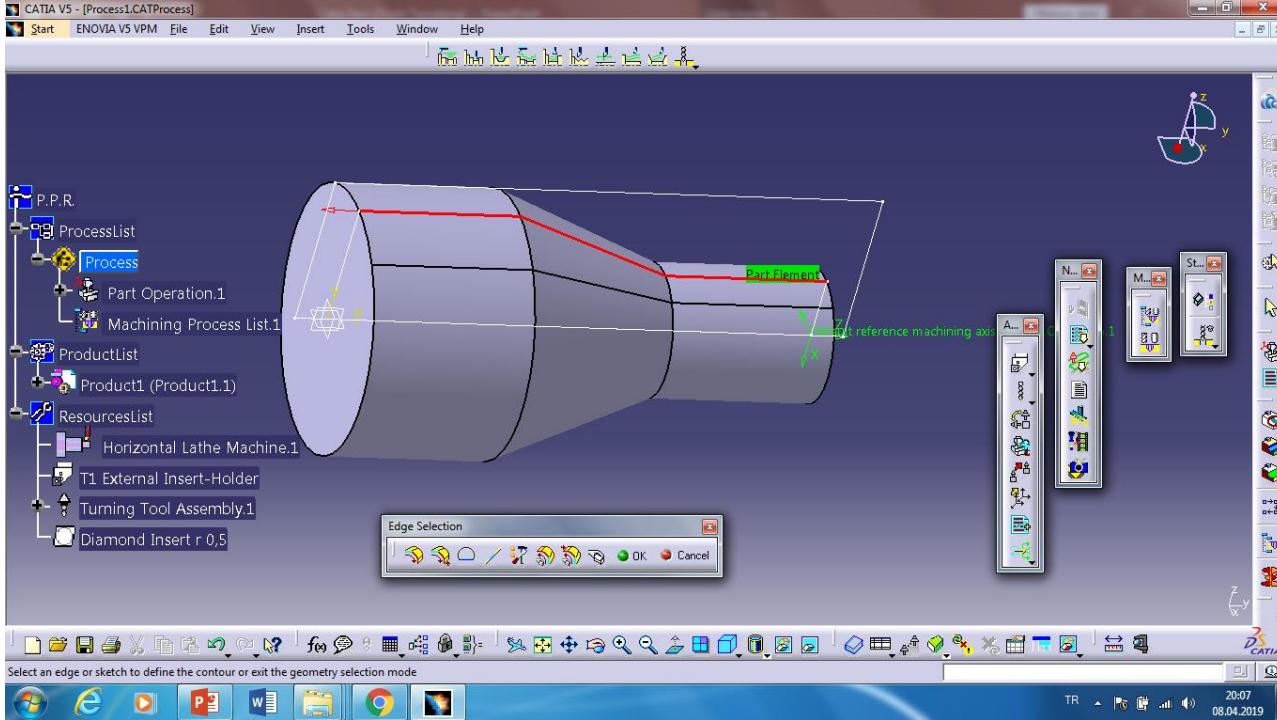
Kaba yüzey tornalanmış bir parçada Machining Operation araç çubuğundan / Profile Turning Finish Operation seçilir



h) - Açılan pencereden kütüğün anlı seçilip ekrandaki kütüğün dış çizgizi / ok (Penceredeki kırmızı yeşil olur)

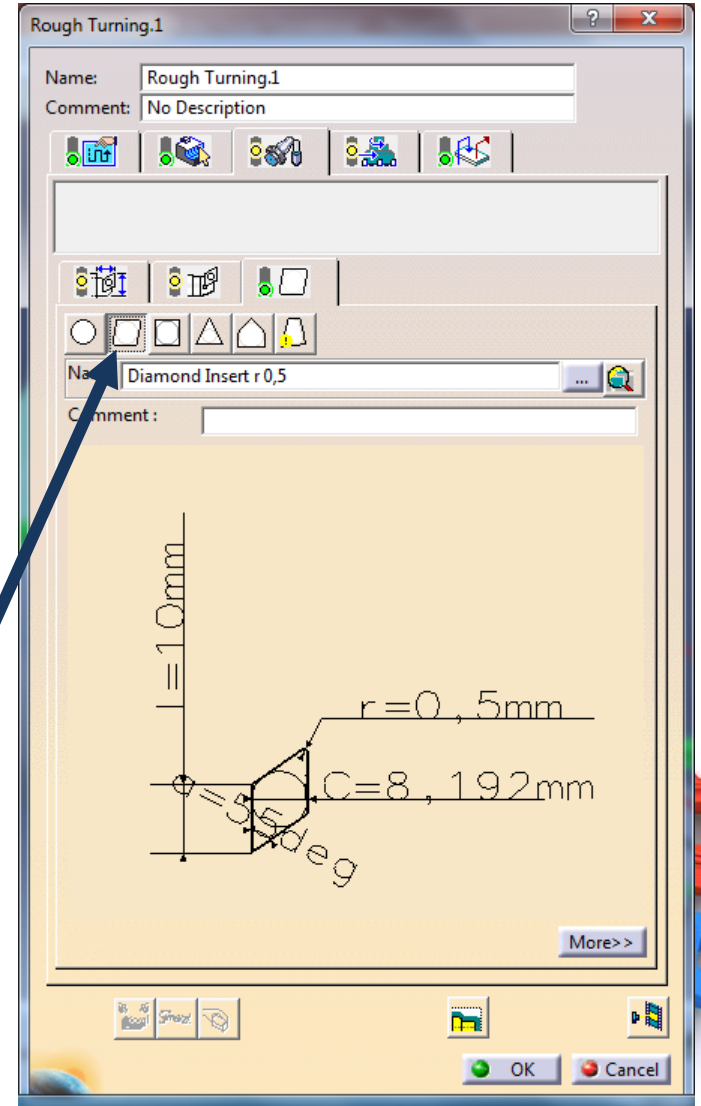
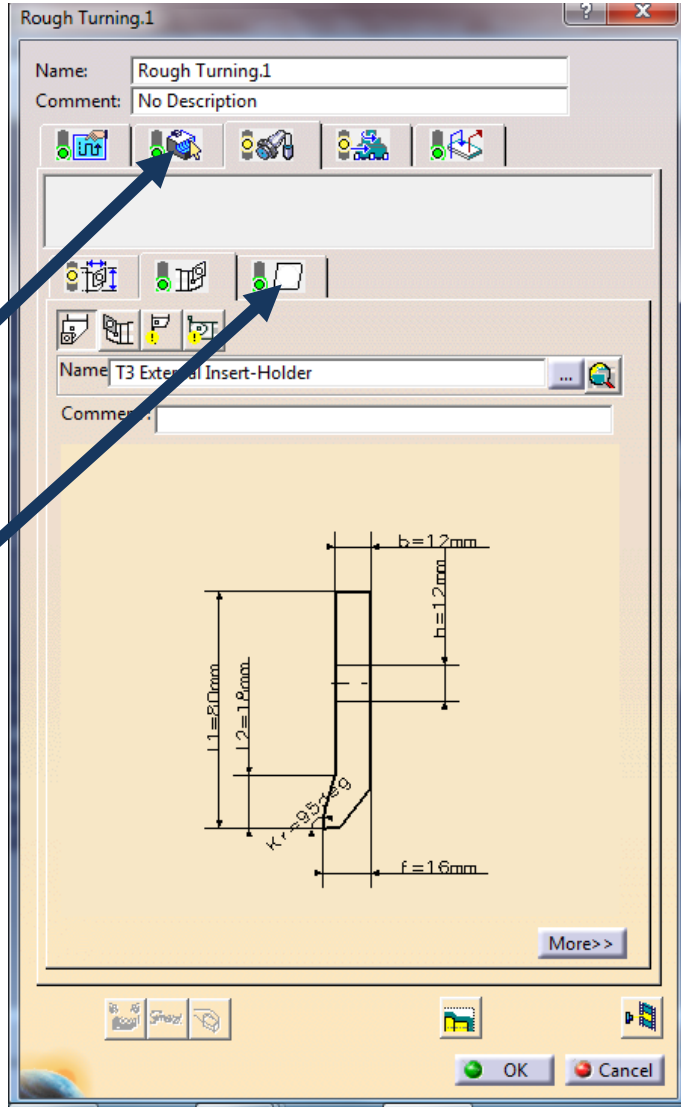


Seçimden sonra bu şekilde görünür



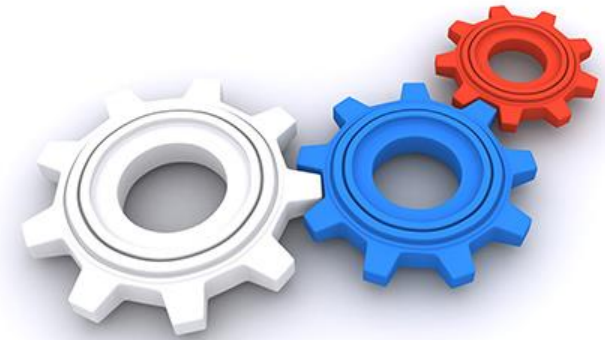
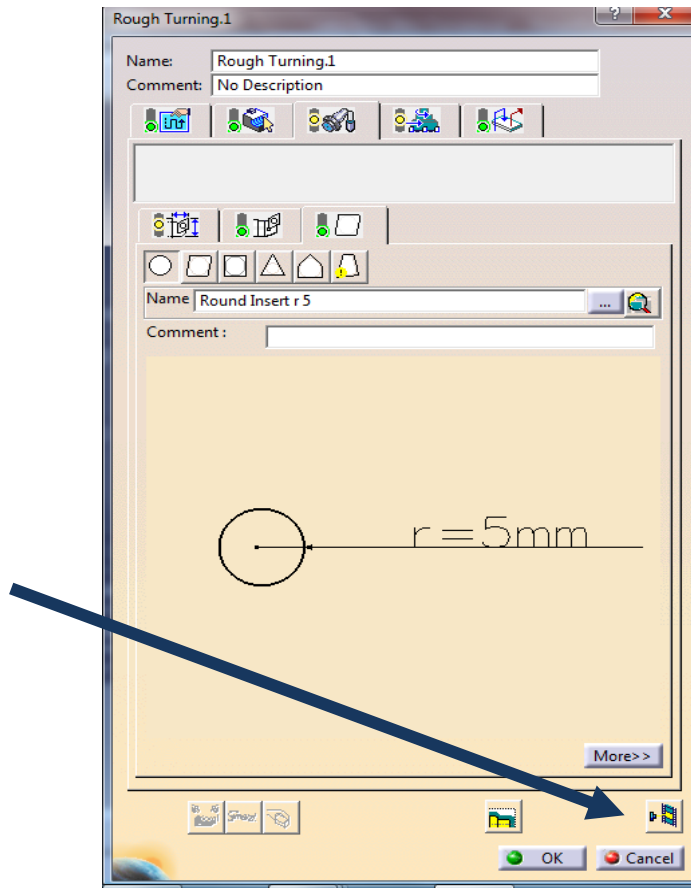
2 numaralı sekme tıklanıp torna kalem ucu seçilir (Baklava dilimi olan)

2

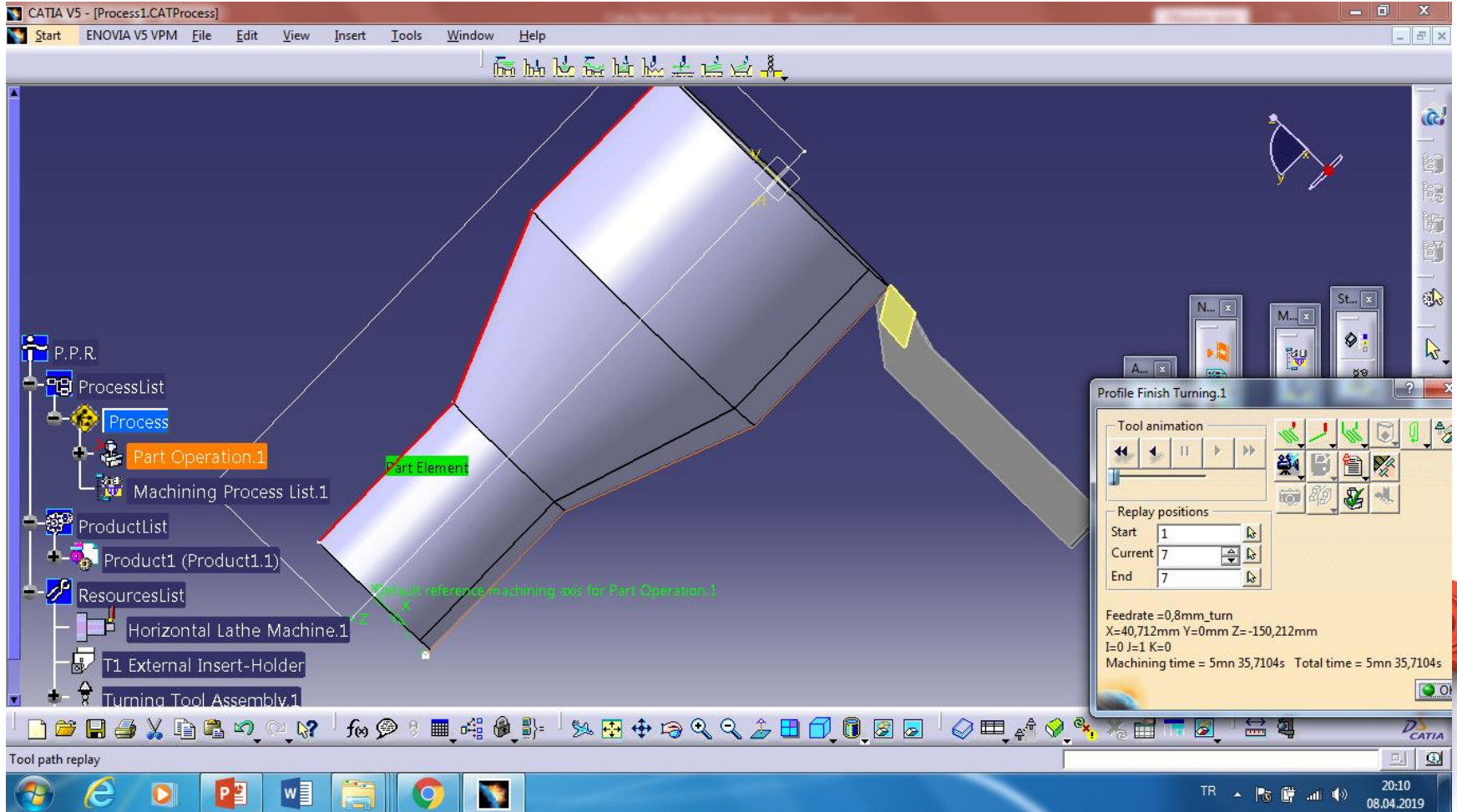


Simulasyon

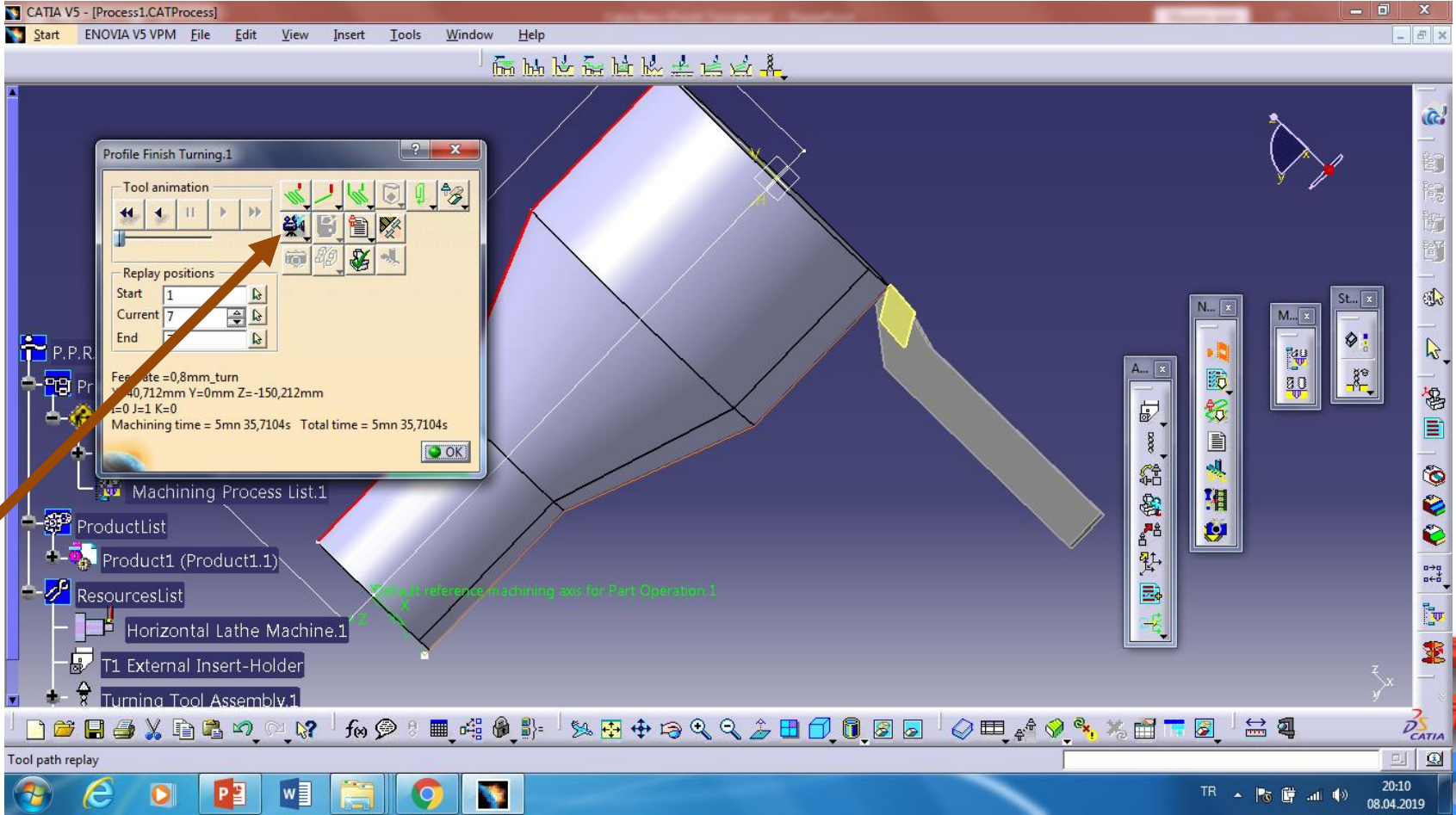
a) Rought turning penceresindeki **Tool Path Replay** butonuna tıklanır

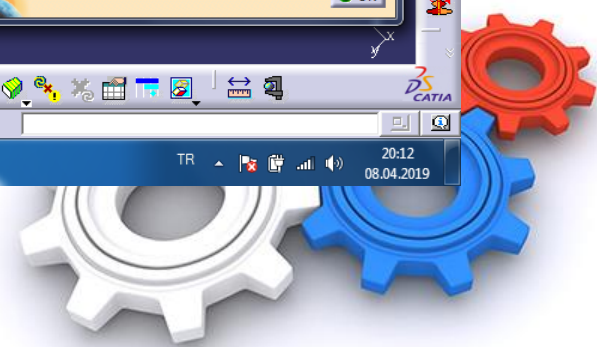
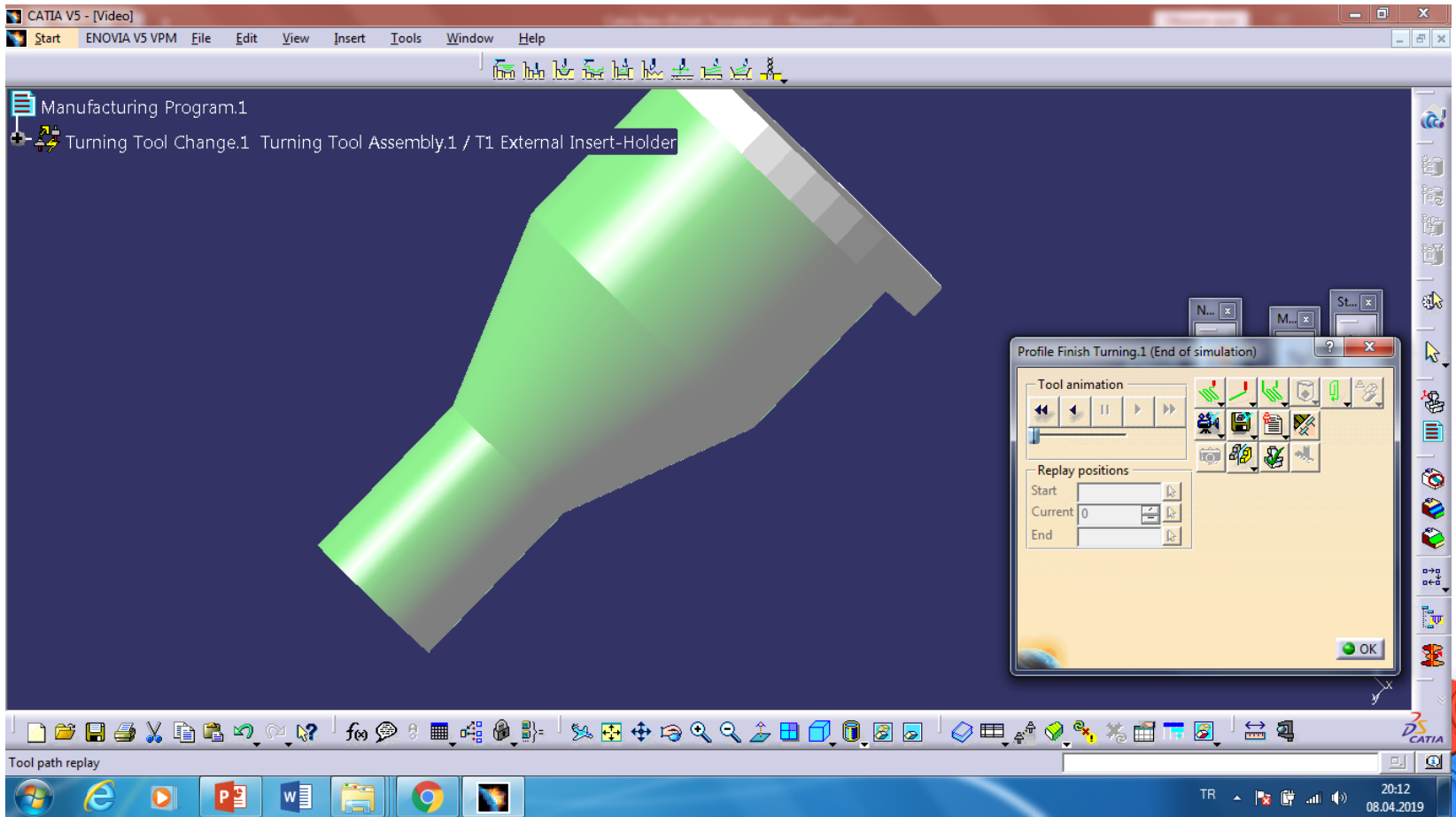


b) Açılan simulasyn penceresindeki **Backward Replay** ve **Forward Replay (F6-F7)** butonuna tıklanarak simülasyon izlenir



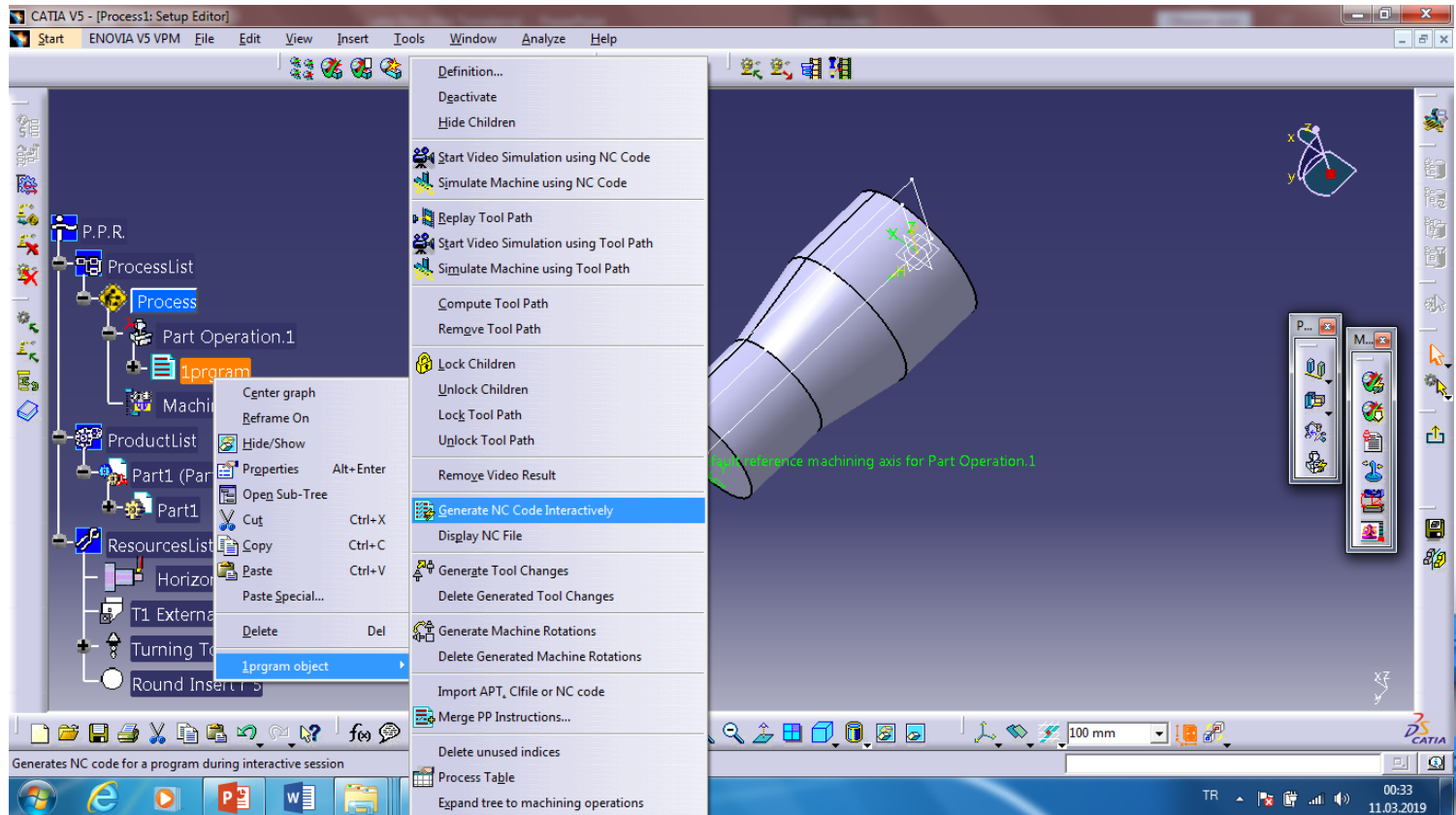
c) Kamera butonu tıklanarak tam simülasyon izlenebilir



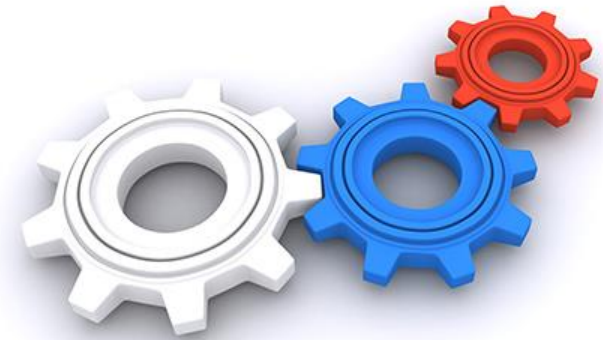
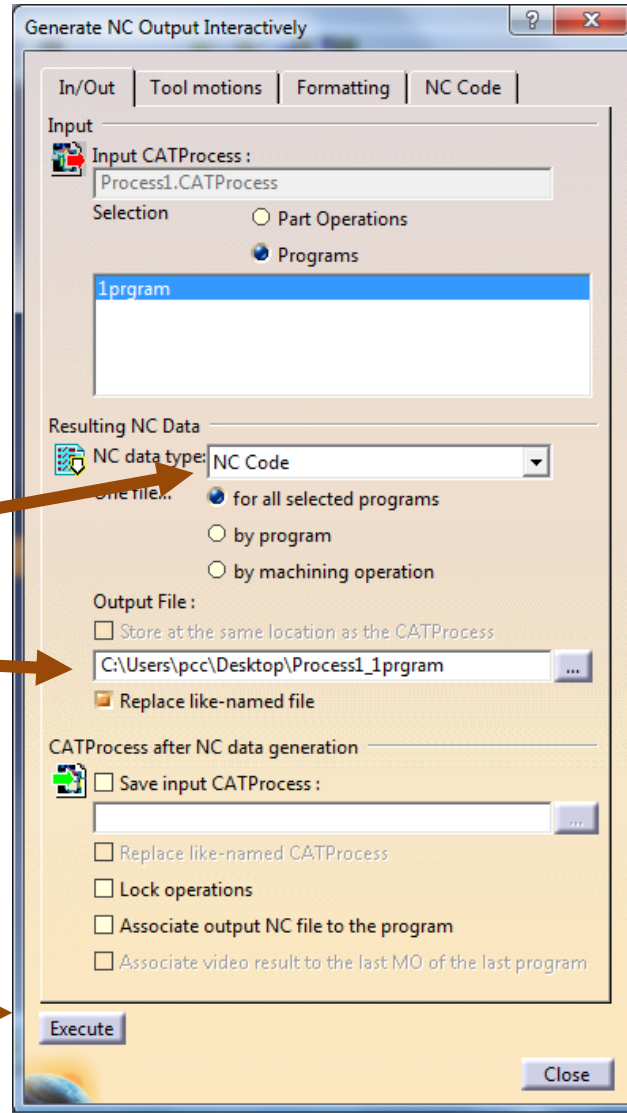


NC Kodu Üretme

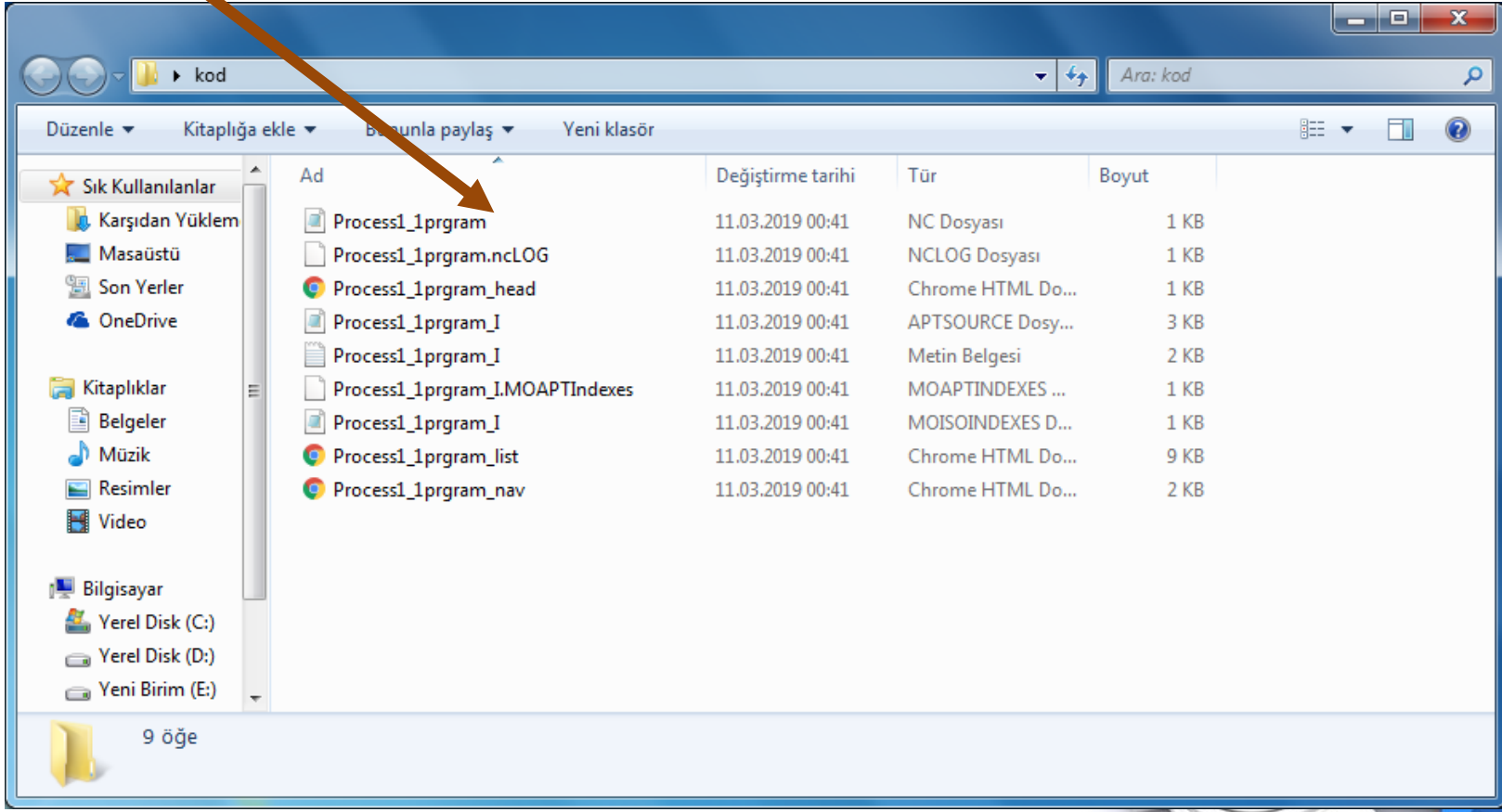
a) Unsur Ağacındaki part operation1 altında bulunan program'ı sağ tıklayıp Program object / generic Nc Code Intercitively tıklanır



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
%
O1000
N1 G49 G64 G17 G80 G0 G90 G40 G99
N2 T0001 M6
N3 X47.529 S70 M4
N4 G43 Z12.5 H9
N5 G1 G95 Z10.5 F.3
N6 Z-149.5 F.4
N7 X47.742 Z-149.288 F.8
N8 G0 Z12.5
N9 X44.559
N10 G1 Z10.5 F.3
N11 Z-149.5 F.4
N12 X44.771 Z-149.288 F.8
N13 G0 Z12.5
N14 X41.588
N15 G1 Z10.5 F.3
N16 Z-149.5 F.4
N17 X41.8 Z-149.288 F.8
N18 G0 Z12.5
N19 X38.618
N20 G1 Z10.5 F.3
N21 Z-95.198 F.4
N22 X38.83 Z-94.986 F.8
N23 G0 Z12.5
N24 X35.647
N25 G1 Z10.5 F.3
N26 Z-87.771 F.4
N27 X35.859 Z-87.559 F.8
N28 G0 Z12.5
N29 X32.676
N30 G1 Z10.5 F.3
N31 Z-80.345 F.4
N32 X32.889 Z-80.133 F.8
N33 G0 Z12.5
N34 X29.706
N35 G1 Z10.5 F.3
N36 Z-72.918 F.4
N37 X29.918 Z-72.706 F.8
N38 G0 Z12.5
N39 X26.735
```

