

G71 y G75 en torno

<https://www.programacioncnc.es/g71-y-g75-en-torno/>

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$G54
:2222
N10 G40 G00
N20 G99
N30 M5
N40 M9
N50 T0101
N60 G97 S1000
N80 G50 S3500
N90 G96 S0240
N100 G00 X92. Z140.1 M4
N110 G01 X-2. F0.15 M7
N120 G00 Z142.
N130 G00 X90.
N135 (---INICIO CICLO DE DESBASTADO LONGITUDINAL---)
N140 G71 U3. R1
N150 G71 P160 Q250 U0.6 W0.2 F0.15
N160 G42 G00 X38.
N170 G01 X40. Z140.
N180 G01 Z106.
N190 G02 X52. Z100. I6. K0.
N200 G01 X60.
N210 G03 X80. Z90. I0. K-10.
N220 G01 Z55.
N230 G02 X90. Z50. I5. K0.
N240 G01 X92.
N250 G40
N260 G00 X150. Z250.
N270 M9
N275 (---PASADA DE ACABADO---)
N280 T0202
N290 G50 S4500
N300 G96 S0380 M4
N310 G00 X-1.6 Z142.
N320 G42 G01 X-1.6 Z140. F0.1
N330 G01 X40.
N340 G01 Z106.
N350 G02 X52. Z100. I6. K0.
N360 G01 X60.
N370 G03 X80. Z90. I0. K-10.
N380 G01 Z55.
N390 G02 X90. Z50. I5. K0.
N400 G01 X92.
N410 G40
N420 G00 X150. Z100.
N430 M5
N440 T0808 M7
N445 (---INICIO DE CICLOS DE RANURADO---)
N450 G50 S1500
N460 G96 S0100 M4
N470 G00 X82. Z60.
N480 G75 R1.0
N490 G75 X60.0 Z82.0 P10000 Q2200 R0 F0.2
N500 G00 Z110.
N510 G00 X42.
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N520 G75 R1.0  
N530 G75 X20.0 Z121.0 P10000 Q2200 R0 F0.2  
N540 G00 X150. Z240.  
N550 M5  
N560 M9  
N570 M30
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