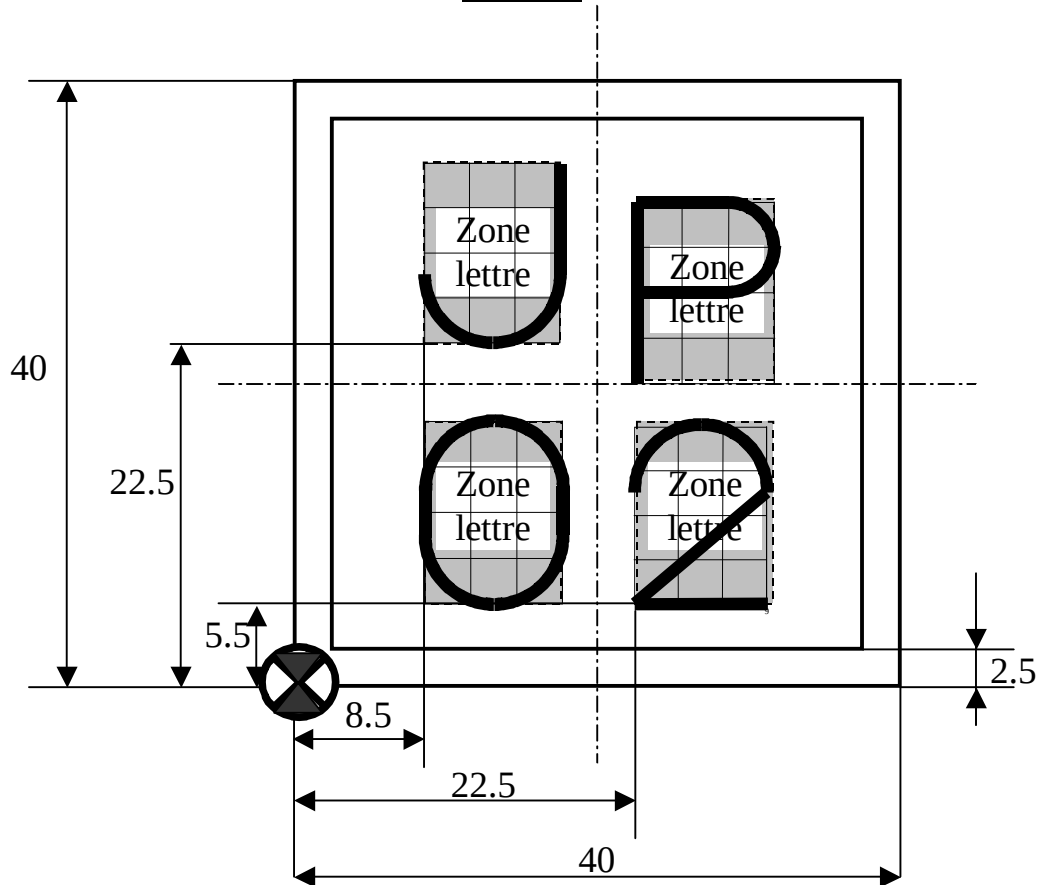
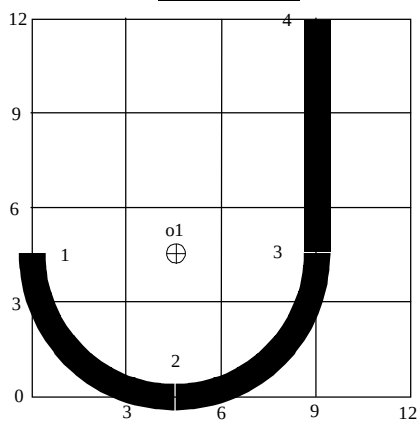
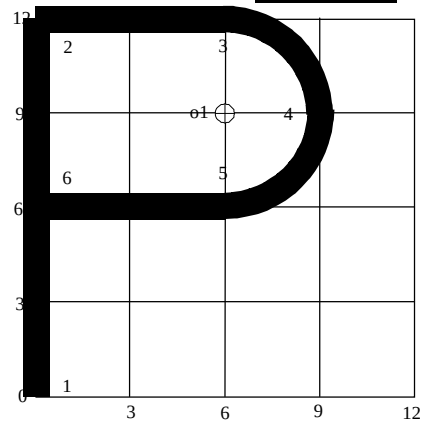
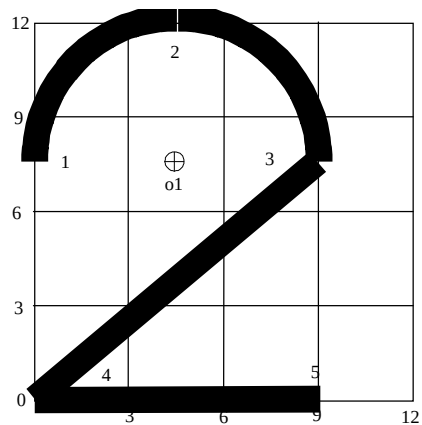
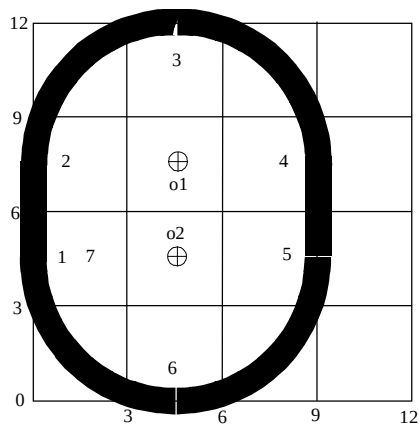
Dessin

Les initiales seront creusées de 3mm.

Initiale 1Initiale 2



**Lettre J** : coord. Pt 0 : X 8.5 Y 22.5

| Pts | X    | Y    | Pts | X | Y | Pts | X | Y |
|-----|------|------|-----|---|---|-----|---|---|
| 1   | 8.5  | 27   |     |   |   |     |   |   |
| 2   | 13   | 22.5 |     |   |   |     |   |   |
| 3   | 17.5 | 27   |     |   |   |     |   |   |
| 4   | 17.5 | 34.5 |     |   |   |     |   |   |
| O1  | 13   | 27   |     |   |   |     |   |   |

**Lettre P** : coord. Pt 0 : X 22.5 Y 20

| Pts | X    | Y  | Pts | X    | Y  | Pts | X | Y |
|-----|------|----|-----|------|----|-----|---|---|
| 1   | 22.5 | 20 | 6   | 22.5 | 26 |     |   |   |
| 2   | 22.5 | 32 | O1  | 28.5 | 29 |     |   |   |
| 3   | 28.5 | 32 |     |      |    |     |   |   |
| 4   | 31.5 | 29 |     |      |    |     |   |   |
| 5   | 28.5 | 26 |     |      |    |     |   |   |

**Lettre 0** : coord. Pt 0 : X 8.5 Y 5.5

| Pts | X    | Y    | Pts | X   | Y   | Pts | X | Y |
|-----|------|------|-----|-----|-----|-----|---|---|
| 1   | 8.5  | 10   | 6   | 13  | 5.5 |     |   |   |
| 2   | 8.5  | 13   | 7   | 8.5 | 10  |     |   |   |
| 3   | 13   | 17.5 | O1  | 13  | 13  |     |   |   |
| 4   | 17.5 | 13   | O2  | 13  | 10  |     |   |   |
| 5   | 17.5 | 10   |     |     |     |     |   |   |

**Lettre 2** : coord. Pt 0 : X 22.5 Y 5.5

| Pts | X    | Y    | Pts | X  | Y  | Pts | X | Y |
|-----|------|------|-----|----|----|-----|---|---|
| 1   | 22.5 | 13   | O1  | 27 | 13 |     |   |   |
| 2   | 27   | 17.5 |     |    |    |     |   |   |
| 3   | 31.5 | 13   |     |    |    |     |   |   |
| 4   | 22.5 | 5.5  |     |    |    |     |   |   |
| 5   | 31.5 | 5.5  |     |    |    |     |   |   |

## Programme

|                                   |                            |
|-----------------------------------|----------------------------|
| %801 ( porte clé face JP : Ph20 ) | (LETTRE 0)                 |
| N10 G17 G40 G80 M5 M9             | N190 G0 X8.5 Y10           |
| N20 G0 G52 Z0                     | N200 G1 Z-3                |
| N30 G0 G52 X0 Y0                  | N210 G1 X8.5 Y13           |
|                                   | N220 G2 X13 Y17.5 I13 J13  |
|                                   | N230 G2 X17.5 Y13 I13 J13  |
|                                   | N240 G1 X17.5 Y10          |
| N40 T12 D12 ( FRAISE 2T X 3 )     | N250 G2 X13 Y5.5 I10 J13   |
| N45 S3000 F500 M3 M8              | N260 G2 X8.5 Y10 I10 J13   |
| (LETTRE J)                        | N270 G1 Z2                 |
| N50 G0 X8.5 Y27 Z2                | (LETTRE 2)                 |
| N60 G1 Z-3                        | N280 G0 X22.5 Y13          |
| N70 G3 X13 Y22.5 I13 J27          | N290 G1 Z-3                |
| N80 G3 X17.5 Y27 I13 J27          | N300 G2 X27 Y17.5 I27 J13  |
| N90 G1 X17.5 Y34.5                | N310 G2 X31.5 Y13 I27 J13  |
| N100 G1 Z2                        | N320 G1 X22.5 Y5.5         |
| (LETTRE P)                        | N330 G1 X31.5 Y5.5         |
| N110 G0 X22.5 Y20                 | N340 G1 Z2                 |
| N120 G1 Z-3                       |                            |
| N130 G1 X22.5 Y32                 | N350 G0 G52 X0 Y0 Z0 M5 M9 |
| N140 G1 X28.5 Y32                 | N360 M2                    |
| N150 G2 X31.5 Y29 I28.5 J29       |                            |
| N160 G2 X28.5 Y26 I28.5 J29       |                            |
| N170 G1 X22.5 Y26                 |                            |
| N180 G1 Z2                        |                            |

## Mettre en œuvre la MOCN

|               |    |    |    |
|---------------|----|----|----|
| <b>PREF</b>   | X= | Y= | Z= |
| <b>DEC</b>    | X= | Y= | Z= |
| <b>Jauges</b> | R= |    | L= |