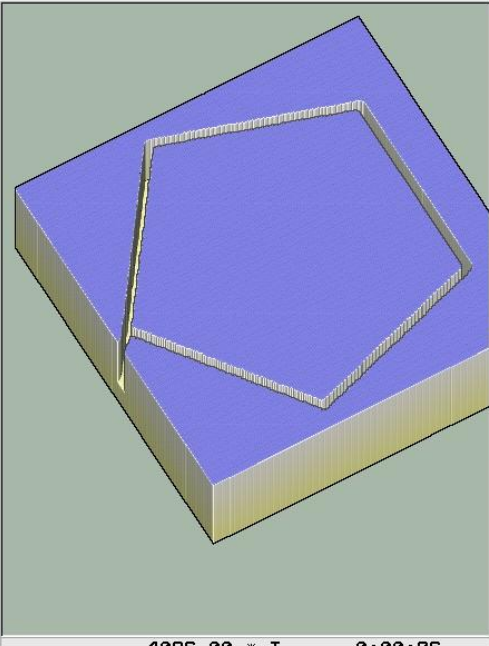
















19. VRTÁNÍ

Ruční provoz	Test programu		
<pre> 0 BEGIN PGM SKOL-NUH MM 1 ; (N-UH,OPRAVA DNE:22.07.2006 2 ; (NULA X,Y LEVY PREDNI ROH 3 ; (NULA Z NA HORNÍ PLOSE 4 ; (PGM NA OBECNY N-UHELNIK 5 ; (VSTUPNI PRM Q1=POCET STRAN 6 BLK FORM 0.1 Z X+0 Y+0 Z-30 7 BLK FORM 0.2 X+100 Y+100 Z+0 8 STOP M0 9 ; *****FREZA PRAMET ,D=40***** 10 TOOL CALL 1 Z S1400 11 L M13 12 FN 0: Q0 =+1000 13 FN 0: Q1 =+5 ; POCET STRAN 14 CALL LBL 1 15 L Y+200 R0 FMAX M30 16 LBL 1 17 ; (OBJETI TVARU 18 L Z+150 R0 FMAX 19 CC X+50 Y+50 20 L X-50 Y+50 R0 FMAX 21 L Z-20 R0 FMAX 22 APPR PCT PR+45 PA+180 CCA180 R+20 RL FQ0 23 CALL LBL 2 24 DEP CT CCA30 R+1 25 L Z+150 R0 FMAX 26 LBL 0 27 LBL 2 28 ; (N-UHELNIK 29 FN 4: Q2 =+360 DIV +Q1 30 FN 0: Q3 =+1 </pre>			<div style="display: flex; flex-direction: column; align-items: center;"> <div style="margin-bottom: 5px;">M </div> <div style="margin-bottom: 5px;">S </div> <div style="margin-bottom: 5px;">T </div> <div style="margin-bottom: 5px;">S </div> <div style="margin-bottom: 5px;">S100% </div> <div style="margin-bottom: 5px;">VVP ZAP </div> <div style="margin-bottom: 5px;">S </div> </div>
<div style="display: flex; justify-content: space-around;"> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>			

```

0 BEGIN PGM SKOL-NUH MM
1 ; (N-UH,OPRAVA DNE:22.07.2006
2 ; (NULA X,Y LEVY PREDNI ROH
3 ; (NULA Z NA HORNÍ PLOSE
4 ; (PGM NA OBECNY N-UHELNIK
5 ; (VSTUPNI PRM Q1=POCET STRAN
6 BLK FORM 0.1 Z X+0 Y+0 Z-30
7 BLK FORM 0.2 X+100 Y+100 Z+0
8 STOP M0
9 ; *****FREZA PRAMET ,D=40*****
10 TOOL CALL 1 Z S1400
11 L M13
12 FN 0: Q0 =+1000
13 FN 0: Q1 =+5 ; POCET STRAN
14 CALL LBL 1
15 L Y+200 R0 FMAX M30
16 LBL 1
17 ; (OBJETI TVARU
18 L Z+150 R0 FMAX
19 CC X+50 Y+50
20 L X-50 Y+50 R0 FMAX
21 L Z-20 R0 FMAX
22 APPR PCT PR+45 PA+180 CCA180
R+20 RL FQ0
23 CALL LBL 2
24 DEP CT CCA30 R+1
25 L Z+150 R0 FMAX
26 LBL 0
27 LBL 2
28 ; (N-UHELNIK
29 FN 4: Q2 =+360 DIV +Q1
30 FN 0: Q3 =+1
    
```

```
31 FN 0: Q4 =+0
32 LBL 3
33 LP IPA-Q2
34 FN 1: Q4 =+Q4 + +Q3
35 FN 12: IF +Q4 LT +Q1 GOTO LBL 3
36 LBL 0
37 END PGM SKOL-NUH MM
```