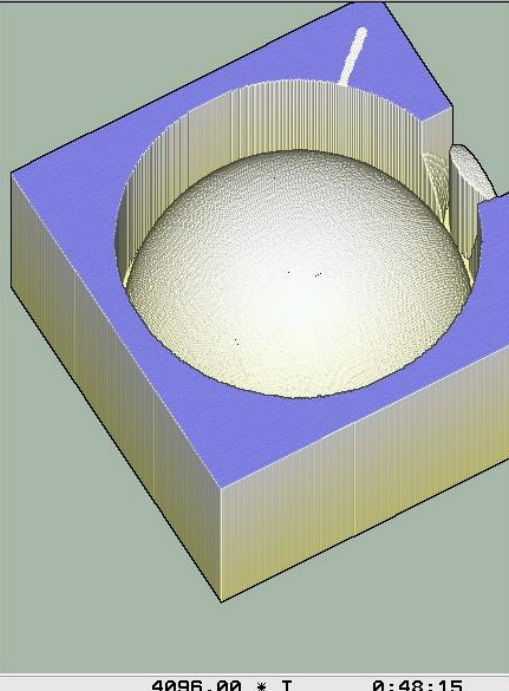







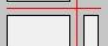


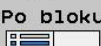


20. POLOKOULE

Ruční provoz	Test programu						
<pre>0 BEGIN PGM SK-KOULE MM 1 ;(RADKOVANI KOULE 2 ;(PROGRAM PRO FREZU CR=0 3 BLK FORM 0.1 Z X-60 Y-60 Z-65 4 BLK FORM 0.2 X+60 Y+60 Z+0 5 ;***** 6 ; DEFINICNI PARAMETRY 7 Q1 = 50 ;POLOMER KOULE 8 Q2 = 89.9 ;POCATECNI UHEL XZ 9 Q3 = 0 ;KONCOVY UHEL XZ 10 Q4 = 0.1 ;KROK UHLU V XZ 11 ;***** 12 STOP M0 13 ;*****FREZA,D=40,R=0,L=60***** 14 TOOL CALL 1 Z S2000 15 L M13 16 FN 0: Q0 =+10000 ;POSUV 17 CALL LBL 1 18 L Y+200 R0 FMAX M2 19 LBL 1 20 ;(RADKOVANI TVARU 21 L Z+50 R0 FMAX 22 L X+50 Y+50 R0 FMAX 23 L Z+2 R0 FMAX 24 L Z+0 R0 FQ0 25 CALL LBL 2 26 L Z+100 R0 FMAX 27 LBL 0 28 LBL 2 29 Q10 = Q2 30 ;(VLASTNI DRAHA 31 LBL 3</pre>	 <p>4096.00 * T 0:48:15</p>	<p>M </p> <p>S </p> <p>T </p> <p>S  +</p> <p>S100%  VVP ZAP</p> <p>S  -</p>					
				STOP na 	START	Start Po bloku 	RESET + START

```

0 BEGIN PGM SK-KOULE MM
1 ;(RADKOVANI KOULE
2 ;(PROGRAM PRO FREZU CR=0
3 BLK FORM 0.1 Z X-60 Y-60 Z-65
4 BLK FORM 0.2 X+60 Y+60 Z+0
5 ;*****
6 ; DEFINICNI PARAMETRY
7 Q1 = 50 ;POLOMER KOULE
8 Q2 = 89.9 ;POCATECNI UHEL XZ
9 Q3 = 0 ;KONCOVY UHEL XZ
10 Q4 = 0.1 ;KROK UHLU V XZ
11 ;*****
12 STOP M0
13 ;*****FREZA,D=40,R=0,L=60*****
14 TOOL CALL 1 Z S2000
15 L M13
16 FN 0: Q0 =+10000 ;POSUV
17 CALL LBL 1
18 L Y+200 R0 FMAX M2
19 LBL 1
20 ;(RADKOVANI TVARU
21 L Z+50 R0 FMAX
22 L X+50 Y+50 R0 FMAX
23 L Z+2 R0 FMAX
24 L Z+0 R0 FQ0
25 CALL LBL 2
26 L Z+100 R0 FMAX
27 LBL 0
28 LBL 2
29 Q10 = Q2
30 ;(VLASTNI DRAHA
31 LBL 3

32 CALL LBL 5
33 APPR LCT X+Q11 Y+0 Z+Q12 R15 RL
FQ0
34 CC X+0 Y+0
35 CP PA+0 DR-
36 DEP CT CCA90 R+15
37 Q10 = Q10 - Q4
38 FN 12: IF +Q10 LT +Q3 GOTO LBL 4
39 FN 9: IF +0 EQU +0 GOTO LBL 3
40 LBL 4
41 L Z+10 R0 FMAX
42 LBL 0
43 LBL 5
44 ;(VYPOCET OSY X,Z
45 Q11 = Q1 * COS Q10
46 Q12 = Q1 * ( SIN Q10 ) - Q1
47 LBL 0
48 END PGM SK-KOULE MM

```