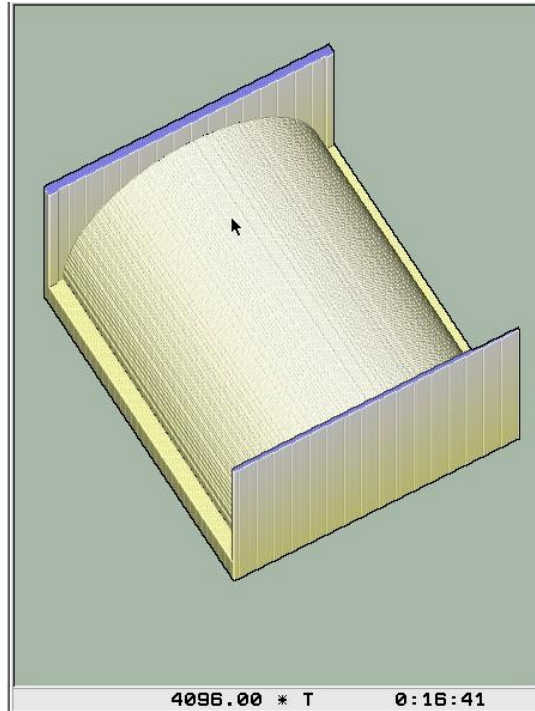


# 21. ŘÁDKOVÁNÍ VÁLCE

```
0 BEGIN PGM SKOLRACY MM
1 ; (RADKOVANI VALCE
2 BLK FORM 0.1 Z X-45 Y-2 Z-10
3 BLK FORM 0.2 X+45 Y+102 Z+50
4 ; (NULA Y JE NA PREDNIM CELE
5 ; (NULA X,Z JE NA OSE VALCE
6 STOP M0
7 ; *****FREZA PRAMET,D=40*****
8 TOOL CALL 1 Z S1200
9 L M13
10 Q1 = 40 ;POLOMER VALCE
11 Q2 = 100 ;DELKA VALCE
12 Q3 = Q1 + Q108
13 Q4 = 10 ;KROK V OSE Y
14 Q6 = 2 ;PRESAH
15 ; (HRUB TVARU
16 Q0 = 1000
17 CALL LBL 5
18 ; (CISTO
19 TOOL CALL 1 S2500
20 Q0 = 2500
21 Q4 = 2
22 CALL LBL 4
23 L Y+200 R0 FMAX M2
24 LBL 1
25 ; (JEDEN RADEK
26 L Z+100 R0 FMAX
27 L X-70 Y-Q6 R0 FMAX
28 L Z+0 R0 FMAX
29 L X-Q3 Y+0 R0 FQ0
30 CR X-Q108 Z+Q1 R+Q1 DR+
31 L IX+5
```



```
0 BEGIN PGM SKOLRACY MM
1 ; (RADKOVANI VALCE
2 BLK FORM 0.1 Z X-45 Y-2 Z-10
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17 CALL LBL 5
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19 TOOL CALL 1 S2500
20 Q0 = 2500
21 Q4 = 2
22 CALL LBL 4
23 L Y+200 R0 FMAX M2
24 LBL 1
25 ; (JEDEN RADEK
26 L Z+100 R0 FMAX
27 L X-70 Y-Q6 R0 FMAX
28 L Z+0 R0 FMAX
29 L X-Q3 Y+0 R0 FQ0
30 CR X-Q108 Z+Q1 R+Q1 DR+
31 L IX+5
```

```
31 L IX+5
32 L Z+100 R0 FMAX
33 LBL 0
34 LBL 2
35 ; (KOPIE LBL 1
36 Q5 = 0
37 Q7 = Q2 + Q6 + Q6
38 LBL 3
39 CALL LBL 1
40 Q5 = Q5 + Q4
41 CYCL DEF 7.0 NULOvy BOD
42 CYCL DEF 7.1 IY+Q4
43 FN 12: IF +Q5 LT +Q2 GOTO LBL 3
44 CYCL DEF 7.0 NULOvy BOD
45 CYCL DEF 7.1 Y+0
46 LBL 0
47 LBL 4
48 ; (KOPIE LBL 2
49 CALL LBL 2
50 CYCL DEF 8.0 ZRCADLENI
51 CYCL DEF 8.1 X
52 CALL LBL 2
53 CYCL DEF 8.0 ZRCADLENI
54 CYCL DEF 8.1
55 LBL 0
56 LBL 5
57 ; (KOPIE LBL 4
58 CYCL DEF 7.0 NULOvy BOD
59 CYCL DEF 7.1 Z+10
60 CALL LBL 4
61 CYCL DEF 7.0 NULOvy BOD
62 CYCL DEF 7.1 Z+5

63 CALL LBL 4
64 CYCL DEF 7.0 NULOvy BOD
65 CYCL DEF 7.1 Z+1
66 CALL LBL 4
67 CYCL DEF 7.0 NULOvy BOD
68 CYCL DEF 7.1 Z+0
69 LBL 0
70 END PGM SKOLRACY MM
```