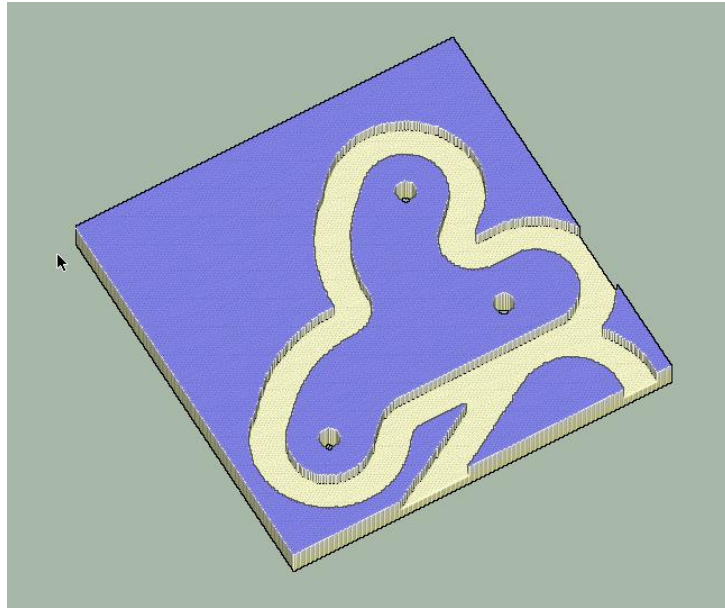


## PROGRAMOVÁNÍ SLOŽITÉHO OBRYSU



```
0 BEGIN PGM 01 MM
1 BLK FORM 0.1 Z X-40 Y-40 Z-10
2 BLK FORM 0.2 X+80 Y+80 Z+0
3 TOOL CALL 5 Z S1500 F500
4 L X+70 Y-60 Z+2 R0 FMAX M3
5 L Z-5
6 APPR LCT X+50 Y-12 R20 RL F AUTO
7 FL Y-12 AN+180 CLSD+
8 FCT DR+ R10
9 FLT AN+225
10 FCT DR- R12 CCX-13 CCY-13
11 FLT AN+45
12 FCT DR- R34 CCY-22
13 FCT DR+ R10
14 FCT DR- R34 CCY+22
15 FLT AN+45
16 FCT DR- R12 CCX+44 CCY+44
17 FSELECT2
18 FLT AN+225
19 FCT DR+ R10 CCY+22
20 FLT AN+0
21 FCT DR- CCX+60 R12 CCY+0
22 FLT X+50 Y-12 AN+180 CLSD-
23 DEP LCT X-30 Y-60 R20 F AUTO
24 L Z+100
25 TOOL CALL 3 Z S900 F500
26 L X-13 Y-13 R0 FMAX M3
27 CYCL DEF 200 VRTANI ~
    Q200=+2 ;BEZPECNOSTNI VZDAL. ~
    Q201=-12 ;HLOUBKA ~
    Q206=+150 ;POSUV NA HLOUBKU ~
    Q202=+5 ;HLOUBKA PRISUVU ~
    Q210=+0 ;CAS.PRODLEVA NAHORE ~
```

```
      Q203=+0      ;SOURADNICE POVRCHU ~
      Q204=+50      ;2. BEZPEC.VZDALENOST ~
      Q211=+0      ;CAS. PRODLEVA DOLE
28 CYCL CALL M3
29 L  X+44  Y+44  Z+5 R0 FMAX M3
30 CYCL DEF 200 VRTANI ~
      Q200=+2      ;BEZPECNOSTNI VZDAL. ~
      Q201=-12     ;HLOUBKA ~
      Q206=+150    ;POSUV NA HLOUBKU ~
      Q202=+5      ;HLOUBKA PRISUVU ~
      Q210=+0      ;CAS.PRODLEVA NAHORE ~
      Q203=+0      ;SOURADNICE POVRCHU ~
      Q204=+50      ;2. BEZPEC.VZDALENOST ~
      Q211=+0      ;CAS. PRODLEVA DOLE
31 CYCL CALL M3
32 L  X+50  Y+0   Z+5 R0 FMAX M3
33 CYCL DEF 200 VRTANI ~
      Q200=+2      ;BEZPECNOSTNI VZDAL. ~
      Q201=-12     ;HLOUBKA ~
      Q206=+150    ;POSUV NA HLOUBKU ~
      Q202=+5      ;HLOUBKA PRISUVU ~
      Q210=+0      ;CAS.PRODLEVA NAHORE ~
      Q203=+0      ;SOURADNICE POVRCHU ~
      Q204=+50      ;2. BEZPEC.VZDALENOST ~
      Q211=+0      ;CAS. PRODLEVA DOLE
34 CYCL CALL M3
35 END PGM 01 MM
```