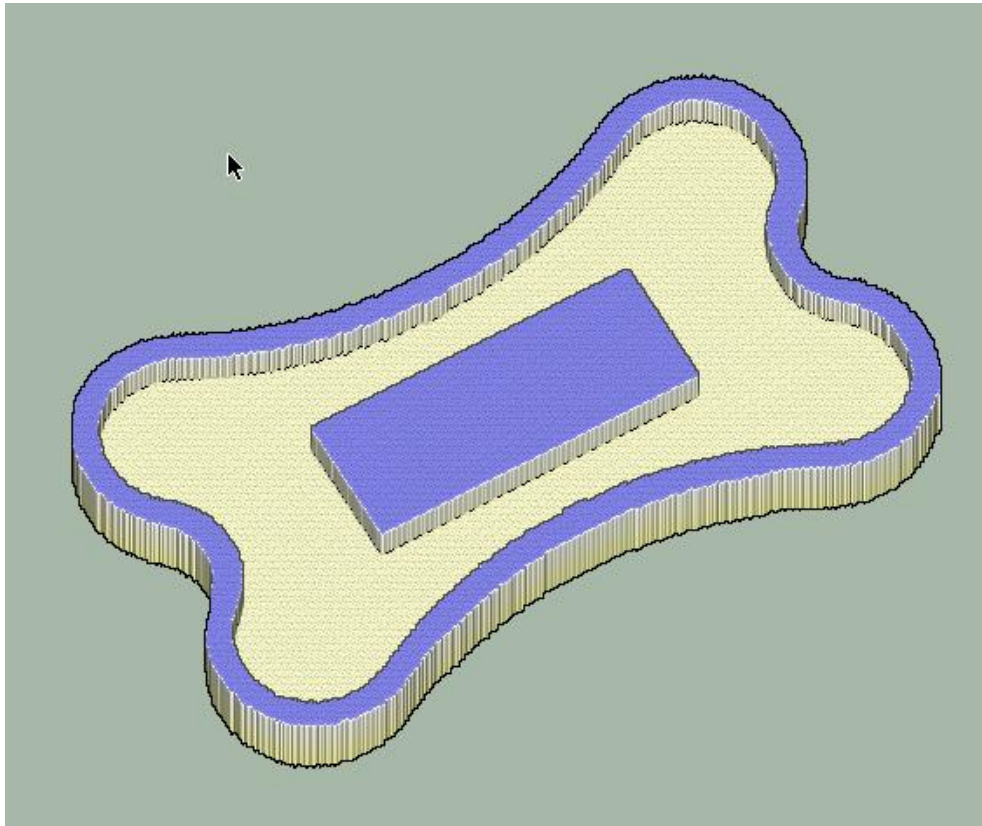


# FUNKCE VOLNÁ KONTURA A OBRYS S VÝSTUPKEM



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0 BEGIN PGM 06 MM
1 BLK FORM 0.1 Z X-100 Y-60 Z-20
2 BLK FORM 0.2 X+100 Y+60 Z+0
3 TOOL CALL 10 Z S1500 F500
4 L X-140 Y-80 R0 FMAX M3
5 L Z-5
6 LBL 1
7 L IZ-5 R0 FMAX
8 APPR LCT X-100 Y-32.5 R20 RL F500 M3
9 FC DR- R27.5 CCX-72.5 CCY-32.5 CLSD+
10 FCT DR+ R15 CCY+0
11 FSELECT2
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12 FCT DR- R27.5  CCX-72.5  CCY+32.5
13 FCT DR+ R125  CCX+0
14 FSELECT1
15 FCT DR- R27.5  CCX+72.5  CCY+32.5
16 FCT DR+ R15  CCY+0
17 FSELECT1
18 FCT DR- R27.5  CCX+72.5  CCY-32.5
19 FCT DR+ R125  CCX+0
20 FSELECT2
21 FCT DR- R27.5  CCX-72.5  CCY-32.5  X-100  Y-32.5  CLSD-
22 DEP LCT  X-140  Y+0  R20  F  AUTO
23 LBL 0
24 CALL LBL 1 REP4
25 L  Z+150  R0  FMAX
26 TOOL CALL 1  Z  S500  F200
27 CYCL DEF 14.0  OBRYS
28 CYCL DEF 14.1  LBL  OBRYSU2  /3
29 CYCL DEF 20  DATA  OBRYSU  ~
    Q1=-10  ;HLOUBKA  FREZOVANI  ~
    Q2=+1  ;PREKRYTI  DRAHY  NAST.  ~
    Q3=+1  ;PRIDAVEK  PRO  STRANU  ~
    Q4=+1  ;PRIDAVEK  PRO  DNO  ~
    Q5=+0  ;SOURADNICE  POVRCHU  ~
    Q6=+2  ;BEZPECNOSTNI  VZDAL.  ~
    Q7=+50  ;BEZPECNA  VYSKA  ~
    Q8=+0  ;RADIUS  ZAOBLENI  ~
    Q9=+1  ;SMYSL  OTACENI
30 CYCL DEF 21  PREDVRTANI  ~
    Q10=-5  ;HLOUBKA  PRISUVU  ~
    Q11=+150  ;POSUV  NA  HLOUBKU  ~
    Q13=+0  ;PROTAHOVACI  NASTROJ
31 CYCL CALL
32 CYCL DEF 22  VYHRUBOVANI  ~
    Q10=-5  ;HLOUBKA  PRISUVU  ~
    Q11=+150  ;POSUV  NA  HLOUBKU  ~
    Q12=+500  ;POSUV  PRO  FREZOVANI  ~
    Q18=+0  ;PREDHRUBOVACI  NASTR.  ~
    Q19=+0  ;POSUV  PENDLOVANI  ~
    Q208=+99999  ;POSUV  NAVRATU  ~
    Q401=+100  ;FAKTOR  POSUVU  ~
    Q404=+0  ;ZPUSOB  ZACISTENI
33 CYCL CALL
34 CYCL DEF 23  DOKONCOVAT  DNO  ~
    Q11=+150  ;POSUV  NA  HLOUBKU  ~
    Q12=+500  ;POSUV  PRO  FREZOVANI  ~
    Q208=+99999  ;POSUV  NAVRATU
35 CYCL CALL
36 CYCL DEF 24  DOKONCOVANI  STEN  ~
    Q9=+1  ;SMYSL  OTACENI  ~
    Q10=-5  ;HLOUBKA  PRISUVU  ~
    Q11=+150  ;POSUV  NA  HLOUBKU  ~
    Q12=+500  ;POSUV  PRO  FREZOVANI  ~
    Q14=+0  ;PRIDAVEK  PRO  STRANU
37 CYCL CALL
38 LBL 2
39 L  X-92  Y-32.5  RR
40 FC DR- R19.5  CCX-72.5  CCY-32.5
41 FCT DR+ R23  CCY+0

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42 FSELECT2  
43 FCT DR- R19.5 CCX-72.5 CCY+32.5  
44 FCT DR+ R133 CCX+0  
45 FSELECT1  
46 FCT DR- R19.5 CCX+72.5 CCY+32.5  
47 FCT DR+ R23 CCY+0  
48 FSELECT1  
49 FCT DR- R19.5 CCX+72.5 CCY-32.5  
50 FCT DR+ R133 CCX+0  
51 FSELECT2  
52 FCT DR- R19.5 CCX-72.5 CCY-32.5 X-92 Y-32.5  
53 LBL 0  
54 LBL 3  
55 L X-45 Y+17.5 RL  
56 L X+45  
57 L X+45 Y-17.5  
58 L X-45  
59 L Y+17.5  
60 LBL 0  
61 END PGM 06 MM