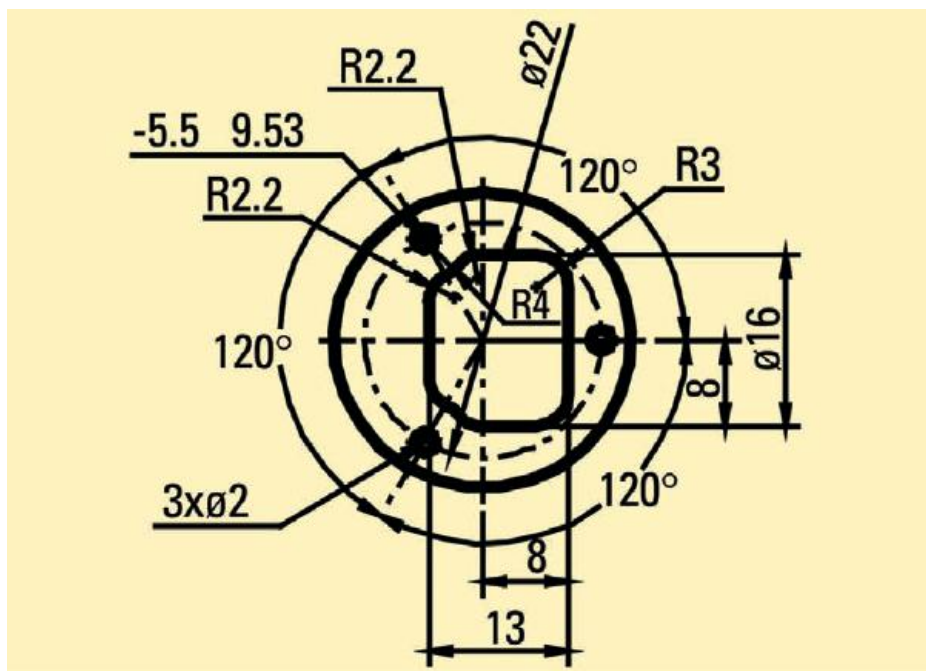
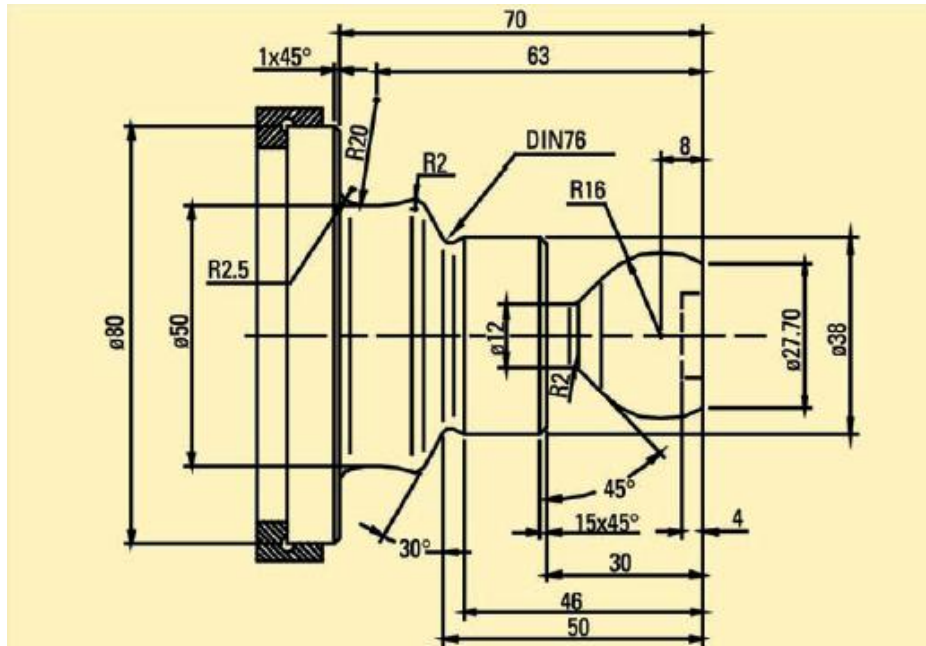


SOUSTRUŽENÍ PŘÍKLAD



MANUAL GUIDE *i* EDIT 13:45:12

OKAMZ. POL. (ABS. >)	D. K. UJETI	VRETENO S1	0 1234
X 300.000		S 0	N 0000000
Z 200.000		0%	T 0
C 100.000		POSUV MM/MIN.	S 0 H 0
Y 0.000 A 0.000		F 0	F 0
		0%	G00 10 40 54 00
			G97 95 69.1 13.1

01234 PROG ←→

- 1 01234 (NO. 1234.5678) ;
- 2 G1900 D40. L42. K0.1 ;
- 3 G0 X100 Z100 ;
- 4 T0101 ;
- 5 G95 G96 S200 M3 ;
- 6 X41 Z1 ;
- 7 G1120 P1. Q2. H100. C0.2 D0.1
F0.2 E0.1 V0.1 K100. W2. U1.5
L2. M2. Z10. ;
- 8 M98 P900 (PROFIL) ;
- 9 G0 X42 Z1 ;
- 10 G1126 P1. F0.05 L2. M2. Z10. ;

D: CÍSLO PROGRAMU

NOVYPR
SEZN
ILED ↑
ILED ↓
ILED

KOPIE
VYJMI
SMAZAT
VLOZKL
VLOZIT

MANUAL GUIDE *i* EDIT 13:46:01

OKAMZ. POL. (ABS. >)	D. K. UJETI	VRETENO S1	0 1234
X 300.000		S 0	N 0000000
Z 200.000		0%	T 0
C 100.000		POSUV MM/MIN.	S 0 H 0
Y 0.000 A 0.000		F 0	F 0
		0%	G00 10 40 54 00
			G97 95 69.1 13.1

01234 PROG ←→

- 1 01234 (NO. 1234.5678) ;
- 2 G1900 D40. L42. K0.1 ;
- 3 G0 X100 Z100 ;
- 4 T0101 ;
- 5 G95 G96 S200 M3 ;
- 6 X41 Z1 ;
- 7 G1120 P1. Q2. H100. C0.2 D0.1
F0.2 E0.1 V0.1 K100. W2. U1.5
L2. M2. Z10. ;
- 8 M98 P900 (PROFIL) ;
- 9 G0 X42 Z1 ;
- 10 G1126 P1. F0.05 L2. M2. Z10. ;

UVTORIT NOVY PROG.

CIS. NOVEHO PROG. : 1236

ZADEJTE NOVE CÍSLO PROGRAMU.

NOVYPR
SEZN
ILED ↑
ILED ↓
ILED

KOPIE
VYJMI
SMAZAT
VLOZKL
VLOZIT

MANUAL GUIDE *i* EDIT 13:46:26

OKAMZ. POL. (ABS. >)	D. K. UJETI	VRETENO S1	0 1236
X 300.000		S 0	N 0000000
Z 200.000		0%	T 0
C 100.000		POSUV MM/MIN.	S 0 H 0
Y 0.000 A 0.000		F 0	F 0
		0%	G00 10 40 54 00
			G97 95 69.1 13.1

01236 PROG ←→

- 1 01236 ;
- 2 %

D: CÍSLO PROGRAMU

NOVYPR
SEZN
ILED ↑
ILED ↓
ILED

KOPIE
VYJMI
SMAZAT
VLOZKL
VLOZIT

MANUAL GUIDE *i* -D1 13:47:18

OKAMZ. POL. (ABS.) D. K. UJETI VRETEND S1 0 1236
 X 300.000 S 0 N 0000000
 Z T 0
 C
 Y 0.

OTEVŘIT PROGRAM

CIS. PROG.	POUZ. /VOLNI	6 / 489	
PANET. OBL.	POUZ. /VOLNI	4500 / 270500	
CIS. :	KOMENTAR	DATUM UPRAVY	VELIK. CZN. >
0900:	PROFIL	2004-12-17 12:02	500
1000:	<DADASDADAS	2004-12-14 16:56	3000
1234:	NO. 1234.5678	2004-12-17 12:57	500
1236:		2004-12-17 13:40	500

0 54 00
9.1 13.1

PROG ←→

VBĚŘTE ČÍSLO PROGRAMU A STISKNETE SOFTWAREVÉ TLACÍTKO.

NOVE KOPIE SMAZAT EDTKNT HLEDAT PAMKRT VSESMZ PORTRD OTEVR ZAVRIT

MANUAL GUIDE *i* -D1 13:47:58

OKAMZ. POL. (ABS.) D. K. UJETI VRETEND S1 0 1236
 X 300.000 S 0 N 0000000
 Z T 0
 C
 Y 0.

OTEVŘIT PROGRAM

CIS. PROG.	POUZ. /VOLNI	6 / 489	
PANET. OBL.	POUZ. /VOLNI	4500 / 270500	
CIS. :	KOMENTAR	DATUM UPRAVY	VELIK. CZN. >
0900:	PROFIL	2004-12-17 12:02	500
1000:	<DADASDADAS	2004-12-14 16:56	3000
1234:	NO. 1234.5678	2004-12-17 12:57	500
1236:		2004-12-17 13:40	500

0 54 00
9.1 13.1

PROG ←→

UPRAVIT KOMENTAR

KOMENTAR: 234.987

ZADEJTE KOMENTAR.

ZMENIT STORNO

MANUAL GUIDE *i* -D1 13:48:27

OKAMZ. POL. (ABS.) D. K. UJETI VRETEND S1 0 1236
 X 300.000 S 0 N 0000000
 Z T 0
 C
 Y 0.

OTEVŘIT PROGRAM

CIS. PROG.	POUZ. /VOLNI	6 / 489	
PANET. OBL.	POUZ. /VOLNI	4500 / 270500	
CIS. :	KOMENTAR	DATUM UPRAVY	VELIK. CZN. >
0900:	PROFIL	2004-12-17 12:02	500
1000:	<DADASDADAS	2004-12-14 16:56	3000
1234:	NO. 1234.5678	2004-12-17 12:57	500
1236:	234.987	2004-12-17 13:48	500

0 54 00
9.1 13.1

PROG ←→

VBĚŘTE ČÍSLO PROGRAMU A STISKNETE SOFTWAREVÉ TLACÍTKO.

NOVE KOPIE SMAZAT EDTKNT HLEDAT PAMKRT VSESMZ PORTRD OTEVR ZAVRIT

MANUAL GUIDE *i* -DI 13:49:09

OKAMZ. POL. (ABS.)	D. K. UJETI	VRETENO S1	U 1236
X 300.000		S 0	N 0000000
Z 200.000		0%	T 0
C 100.000		POSUV MM/MIN.	S 0 H 0
Y 0.000 n 0.000		F 0	F 0
		0%	G00 18 40 54 00
			G97 95 69.1 13.1

01236 PROG ←→

1 01236 (234.987) ;

2 %

0: CÍSLO PROGRAMU

NOVYPR
SEZN
HLED ↑
HLED ↓
O HLED

KOPIE
VYJMI
GNAZAT
VLOZKL
VLOZIT

MANUAL GUIDE *i* -DI 13:49:36

OKAMZ. POL. (ABS.)	D. K. UJETI	VRETENO S1	U 1236
X 300.000		S 0	N 0000000
Z 200.000		0%	T 0
C 100.000		POSUV MM/MIN.	S 0 H 0
Y 0.000 n 0.000		F 0	F 0
		0%	G00 18 40 54 00
			G97 95 69.1 13.1

01236 PROG ←→

1 01236 (234.987) ;

2 %

0: CÍSLO PROGRAMU

START
CYKLUS
KONEC

ZMENIT
TVAR
M KOD
PEVFOR

MANUAL GUIDE *i* -DI 13:50:31

OKAMZ. POL. (ABS.)	D. K. UJETI	VRETENO S1	U 1236
X 300.000		S 0	N 0000000
Z 200.000		0%	T 0
C		POSUV MM/MIN.	S 0 H 0
Y			F 0
			G00 18 40 54 00
			G97 95 69.1 13.1

VLOZIT POCATECNI PUVEL SOUSTRUZENI

START POLOTOVAR [VOL. VRET.]

1. POLOTOVAR TVARU PRAVOUHLEHO ROVNOBEZHNESTENU
2. VALCOVY POLOTOVAR
3. DUTY VALCOVY POLOTOVAR
4. VALCOVY POLOTOVAR VOLNEHO OBRYSU
5. POLOTOVAR-HRANOL

VYBERTE CYKLUS, KTERY CHCETE VLOZIT A STISKNETE [VYBER]

[]
[]
[]
[]

VYBER
STORNO

MANUAL GUIDE *i* EDIT 13:51:17

OKAMZ. POL. (ABS.) D. K. UJETI VRETEND S1 0 1236
 X 300.000 S 0 N 0000000
 Z T 0
 C
 Y

VALCOVY POLOTOVAR- VLOZIT

OBROBEK
 PRUMER D=80.
 DELKA L=75.
 POC. OBROBKU Z K=0.
 POC. OBROB. Z(SPN 2) W=

00
13.1

ZADEJTE CÍSLICE (MM, INCH)

VLOZIT STORNO

MANUAL GUIDE *i* EDIT 13:51:43

OKAMZ. POL. (ABS.) D. K. UJETI VRETEND S1 0 1236
 X 300.000 S 0 N 0000000
 Z 200.000 POSUV MM/MIN. F 0
 C 100.000 F 0 S 0 H 0
 Y 0.000 0 0.000 000 10 40 54 00
 G97 95 69.1 13.1

01236 PROG ←

- 01236 (234.987) ;
- G1900 D80. L75. K0. ;
- %

G1900: VALCOVY POLOTOVAR

START CYKLUS KONEC ZMENIT TVAR N KOD PEVFOR

MANUAL GUIDE *i* EDIT 13:52:13

OKAMZ. POL. (ABS.) D. K. UJETI VRETEND S1 0 1236
 X 300.000 S 0 N 0000000
 Z 200.000 POSUV MM/MIN. F 0
 C Y 0.000 0 0.000 S 0 H 0
 000 10 40 54 00
 G97 95 69.1 13.1

VLOZIT POCATECNI PUVEL SOUSTRUZENI

START POLOTOVAR VDL. VRET.

1. START G0 X100 Z100 ;
 T7 ;
 G95 G96 S200 M3 ;
 Y41 Z1 ;

UYBERTE CYKLUS, KTERY CHCETE VLOZIT A STISKNETE [UYBER]

VLOZIT STORNO

MANUAL GUIDE *z* EPI 13:53:42

OKAMZ. POL. (ABS.)	D. K. UJETI	VRETEND S1	U 1236
X 300.000		S 0	N 0000000
Z 200.000		0%	T 0
C 100.000		POSIV MM/MIN.	S 0 H 0
Y 0.000 A 0.000		F 0	F 0
		0%	G00 10 40 54 00
			G97 95 69.1 13.1

01236 PROG ←→

- 1 O1236 (234.987) ;
- 2 G1900 D80. L75. K0. ;
- 3 G0 X100 Z100 ;
- 4 T0101 ;
- 5 G95 G97 G00 M3 ;
- 6 X02 Z1
- 7 %

X: ABSOLUTNI POLDHA OSY X

START
CYKLUS
KONEC

ZHENIT
TVAR
M KOD
PEVFOR

MANUAL GUIDE *z* EPI 13:54:18

OKAMZ. POL. (ABS.)	D. K. UJETI	VRETEND S1	U 1236
X 300.000		S 0	N 0000000
Z 200.000		0%	T 0
C		POSIV MM/MIN.	S 0 H 0
Y			F 0
			G00 10 40 54 00
			G97 95 69.1 13.1

VLOZIT CYKLUS SOUSTR.

DBR. DTRY SOUSTRUZ. S-DRAZKOU ZAVITOVANI

1. SOUSTRUZENI (VNEJSI HRUBOVANI)
2. SOUSTRUZENI (VNITRNI HRUBOVANI)
3. SOUSTRUZENI (HRUBOVANI CELA)
4. SOUSTRUZENI (POLODOK. VNEJSIHO POURCHU)
5. SOUSTRUZENI (POLODOK. VNITRNIHO POURCHU)

UYBERTE CYKLUS, KTERY CHCETE VLOZIT A STISKNETE [UYBER]

UYBER
STORNO

MANUAL GUIDE *z* EPI 13:55:12

OKAMZ. POL. (ABS.)	D. K. UJETI	VRETEND S1	U 1236
X 300.000		S 0	N 0000000
Z			T 0
C			S 0 H 0
Y			F 0
			G00 10 40 54 00
			G97 95 69.1 13.1

SOUSTRUZENI (VNEJSI HRUBOVANI) - VLOZIT TAB ←→

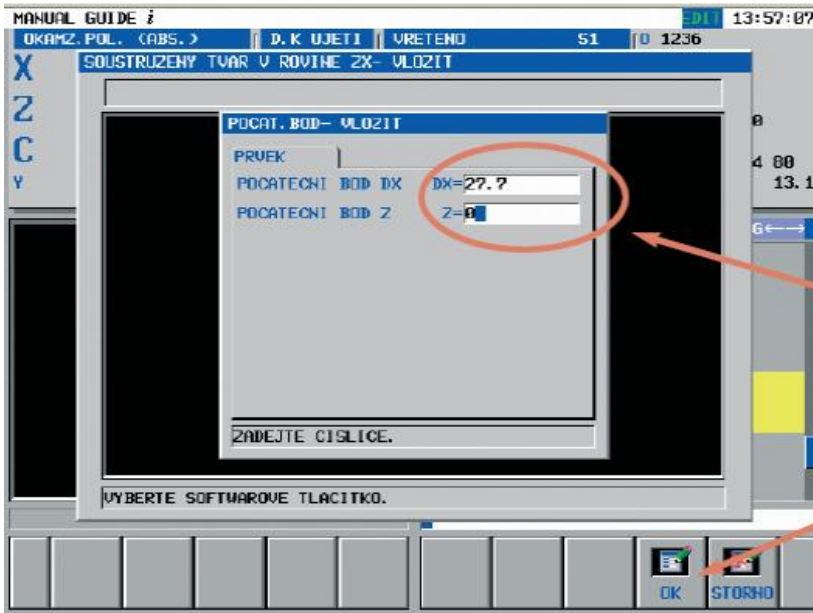
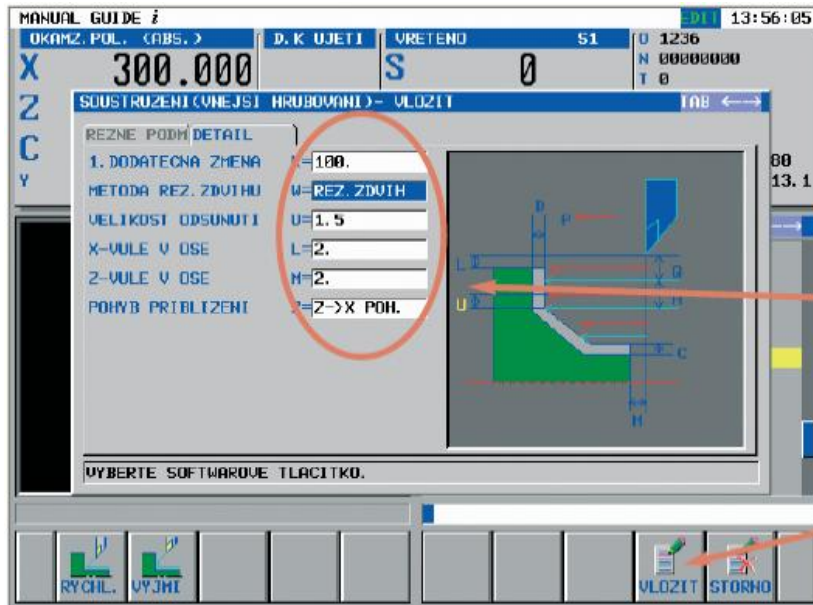
REZNE PODH DETAIL

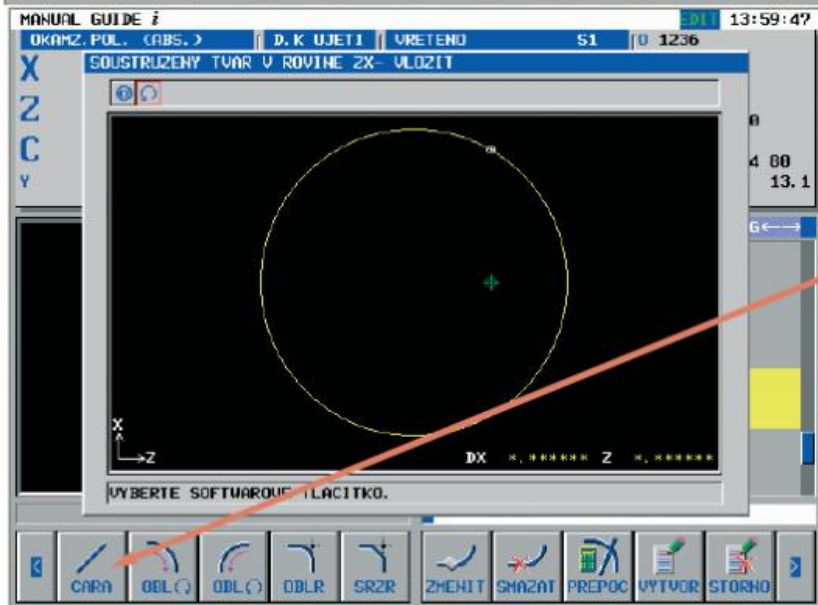
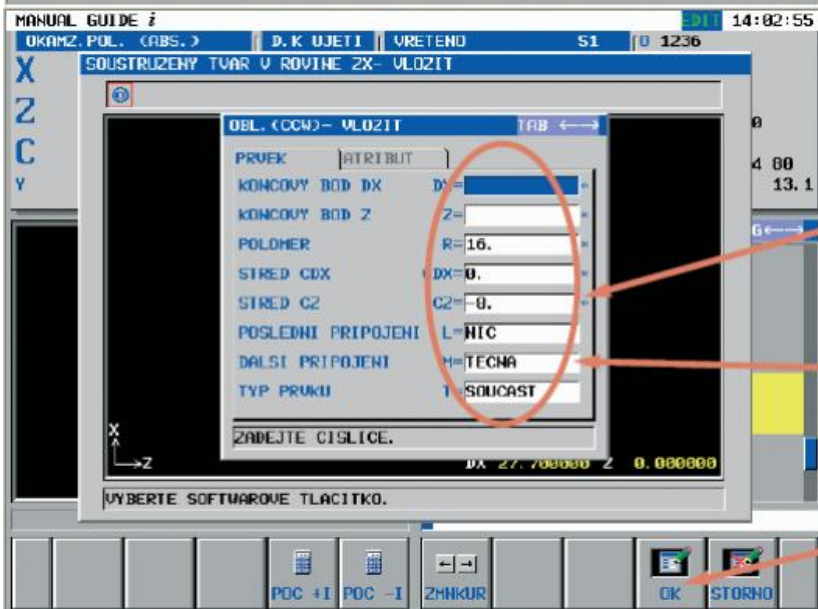
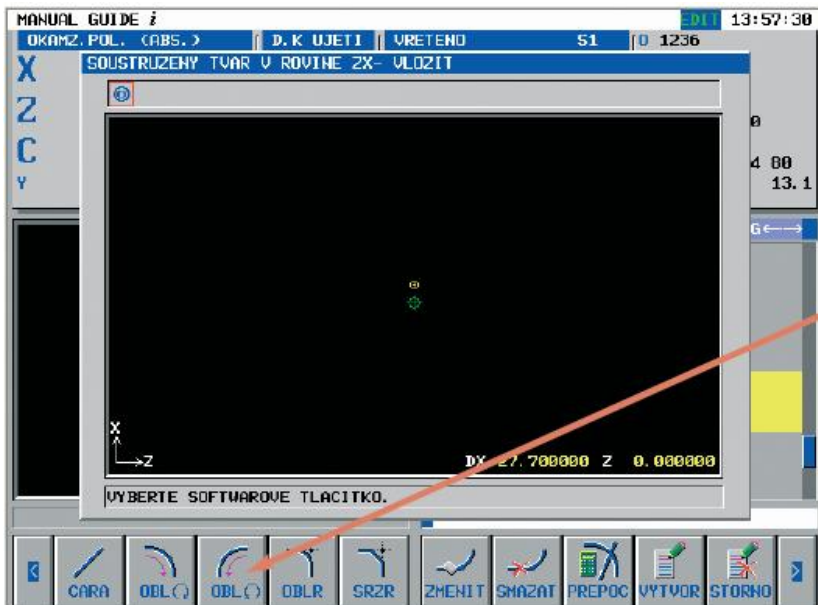
SHER OBRABENI	P = 2
HLOUBKA REZU	Q = 2
POMER HLOUBKY REZU	H = 100
X-PRID. NA DOK. V OSE	C = 0.2
Z-PRID. NA DOK. V OSE	D = 0.1
RYCH. POS. VE SM. OB.	F = 0.2
RYCH. POS. DO HL. REZU	E = 0.1
RYCH. POS. REZ. ZDVITHU	V = 0.1

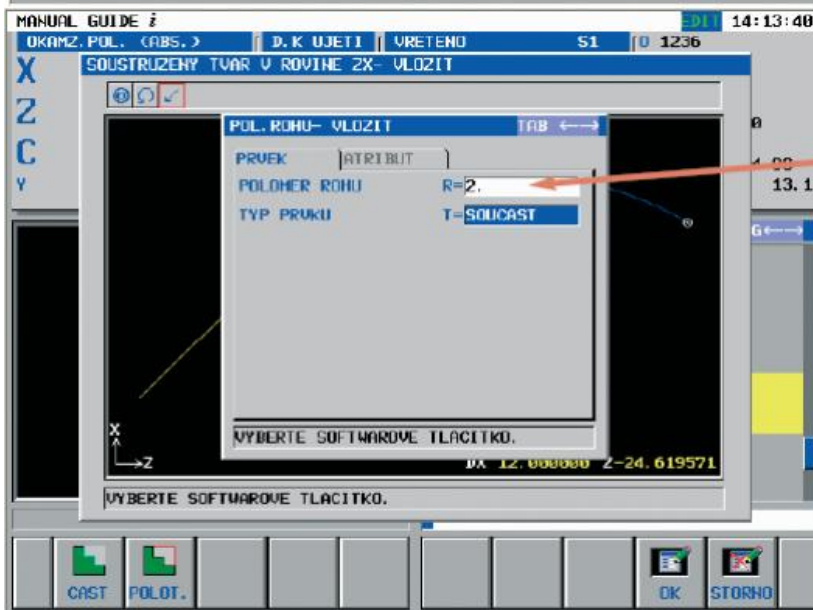
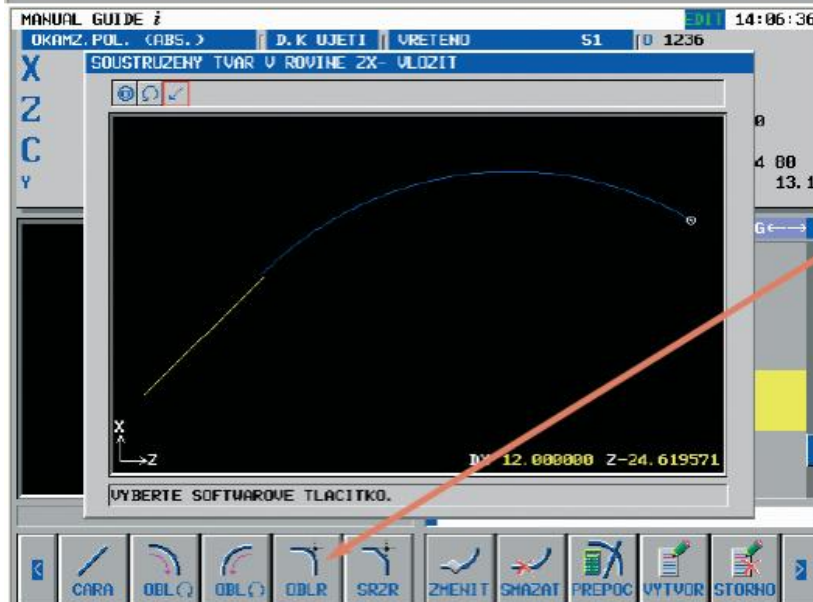
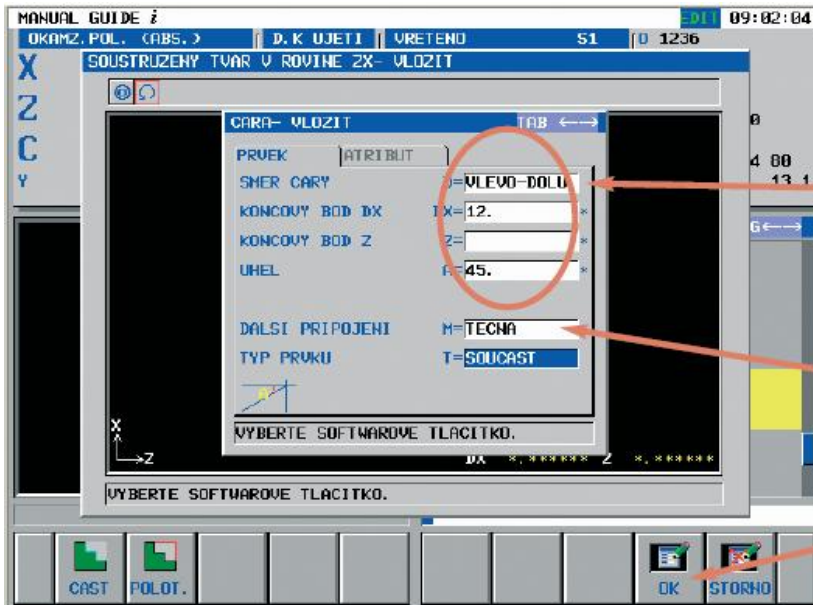
UYBERTE SOFTWAREVE TLACITKO.

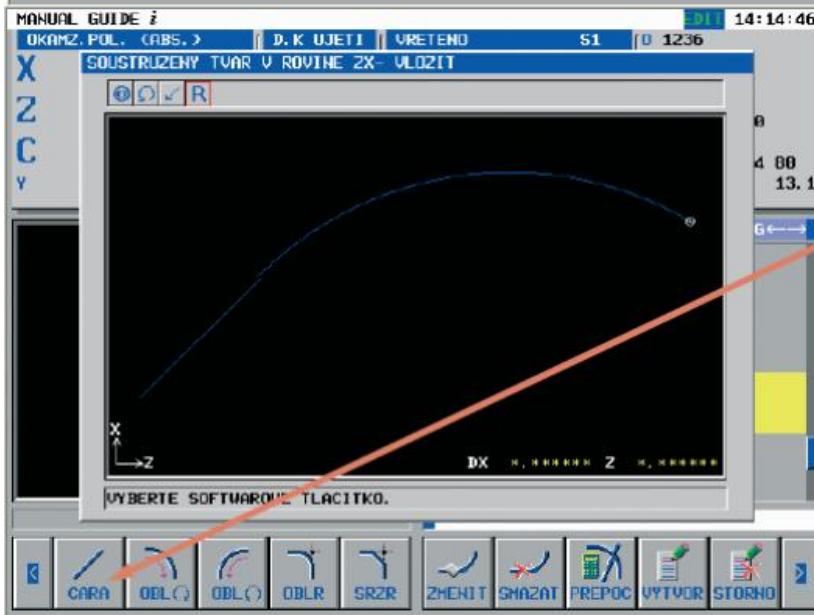
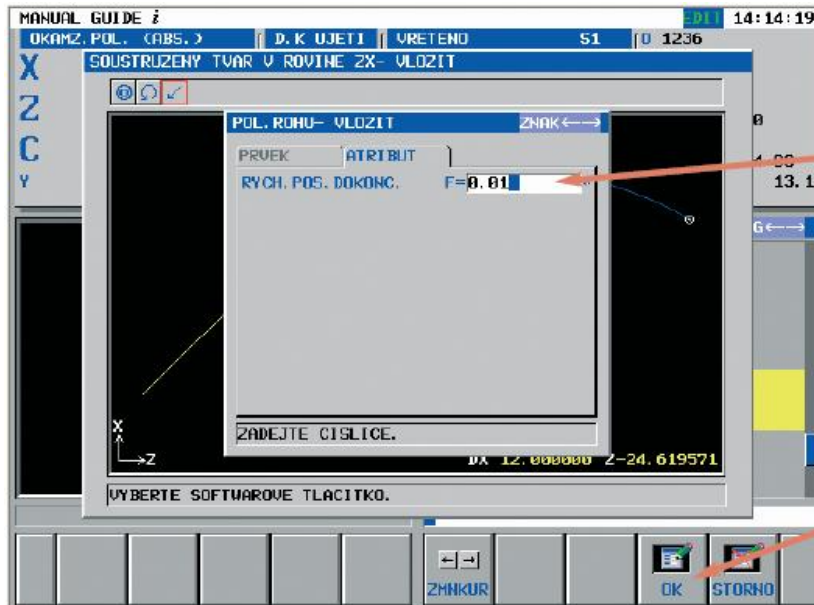
-2
+2

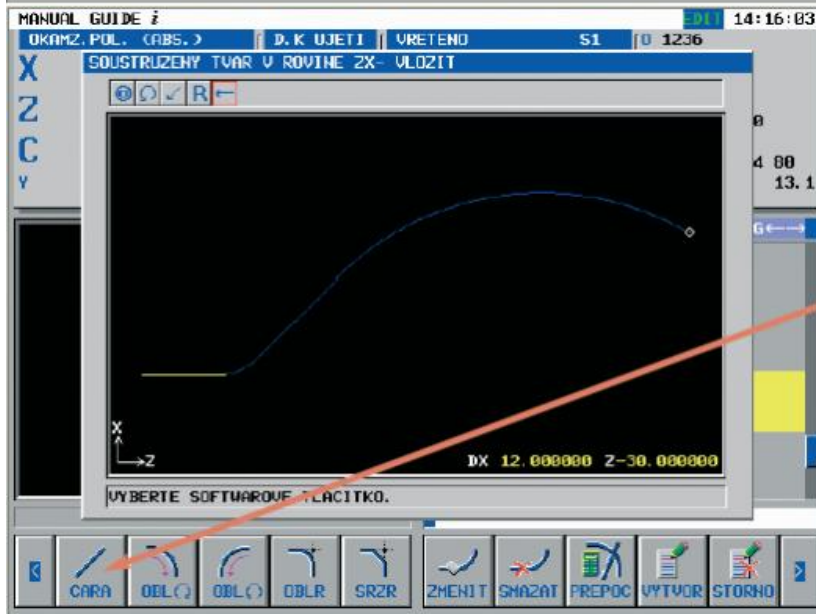
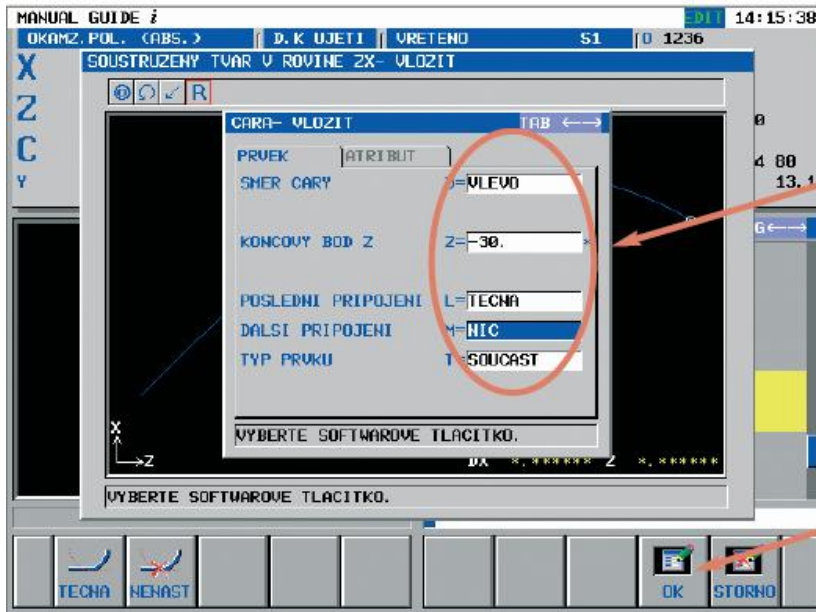
VLOZIT
STORNO

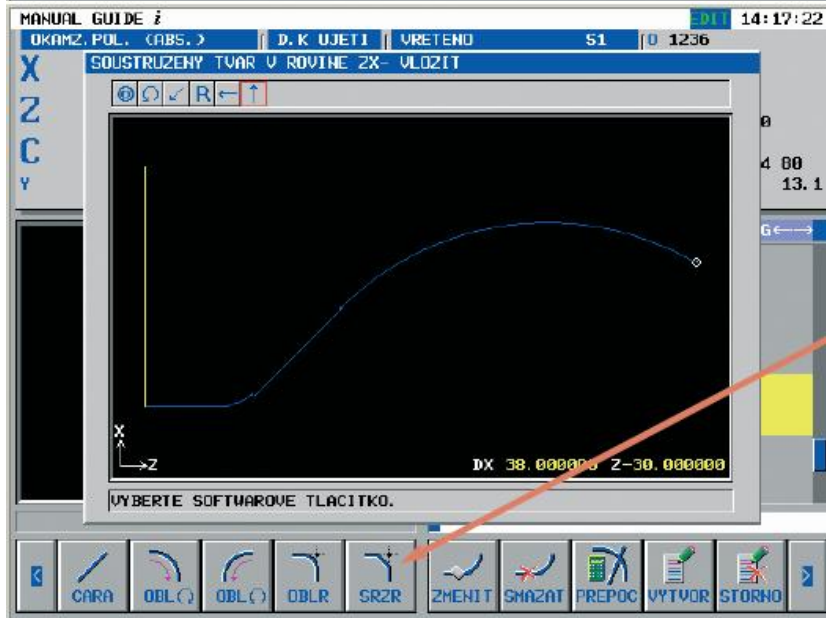
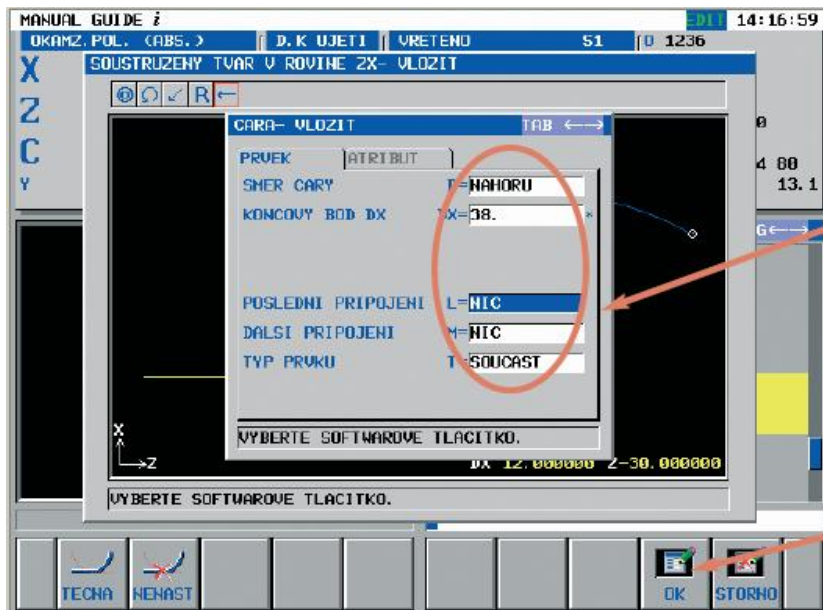


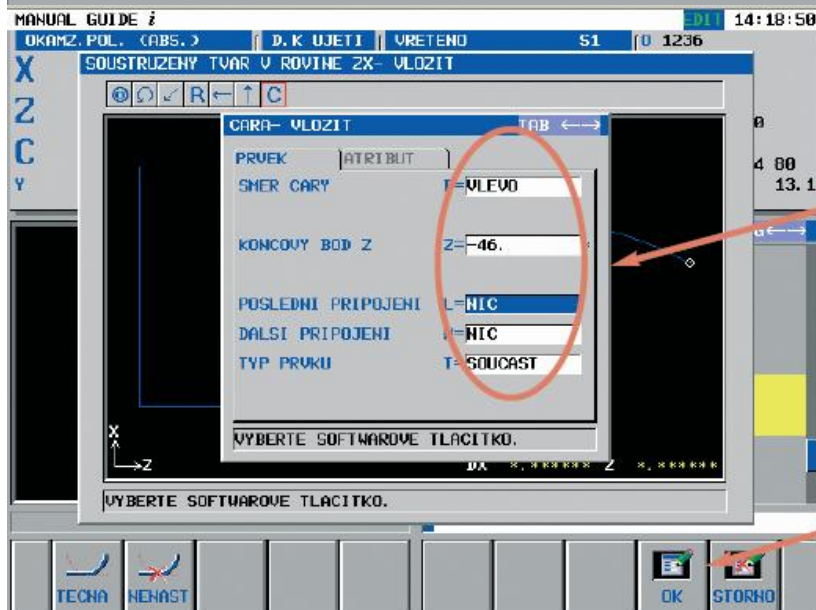
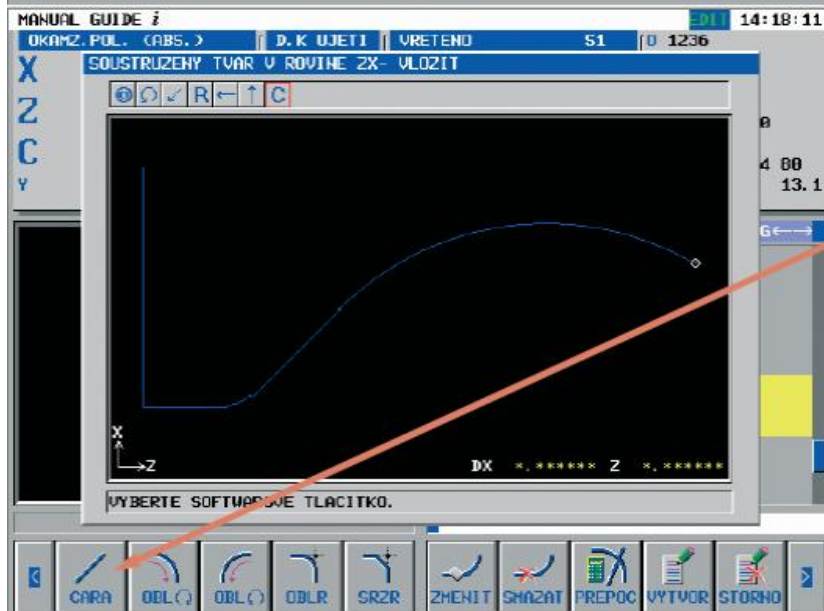
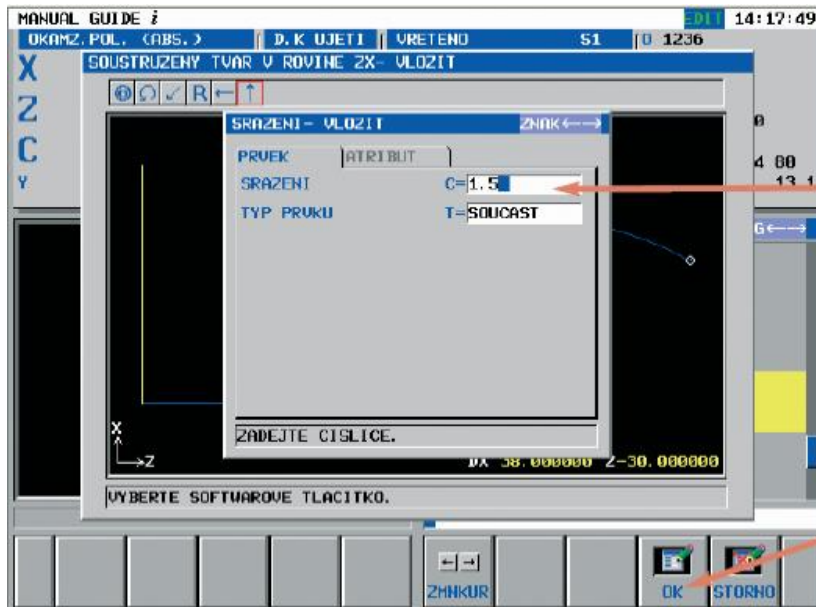


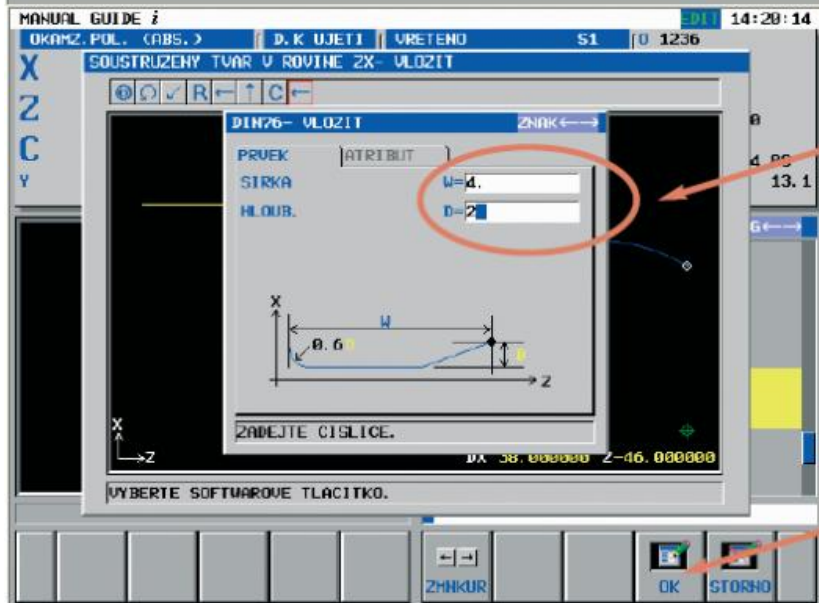
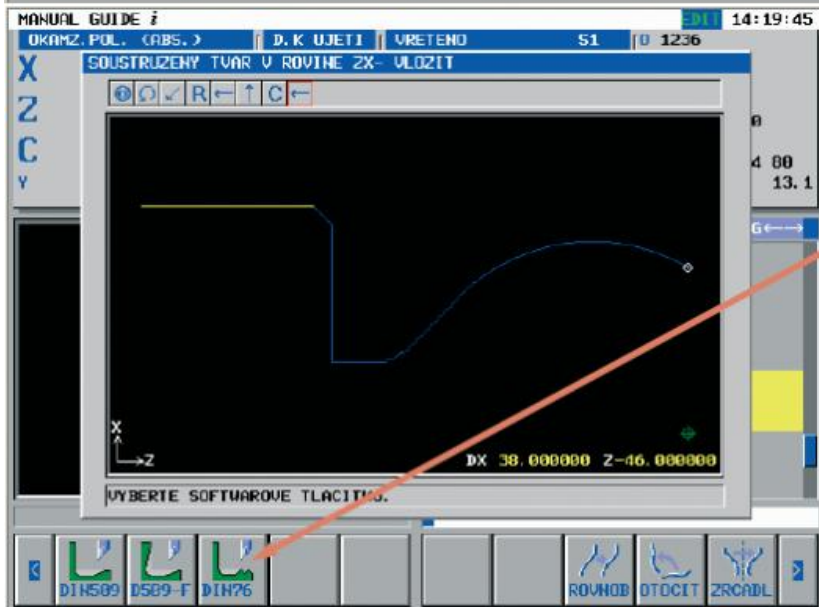
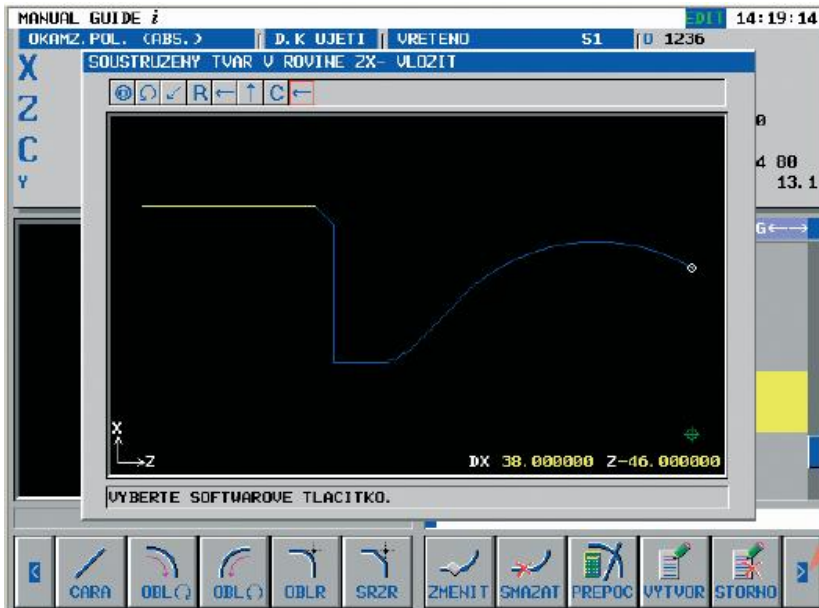


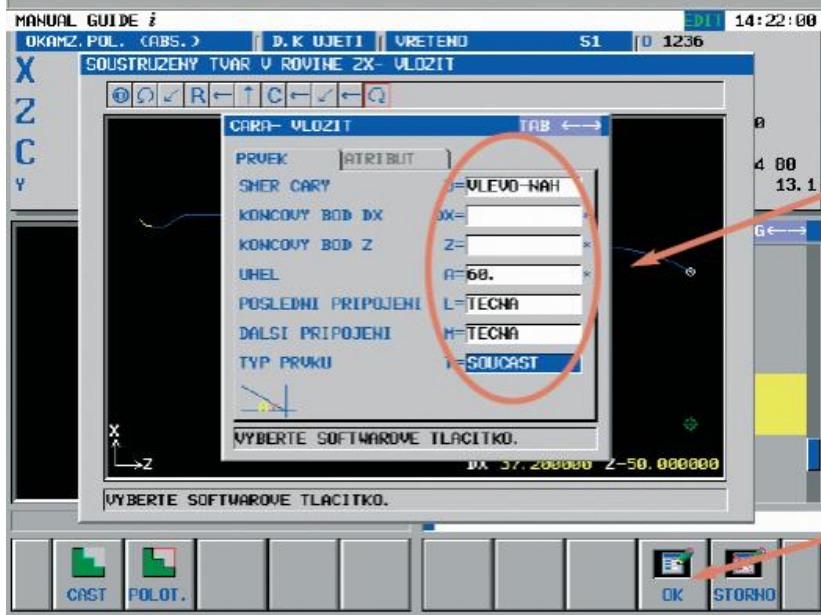
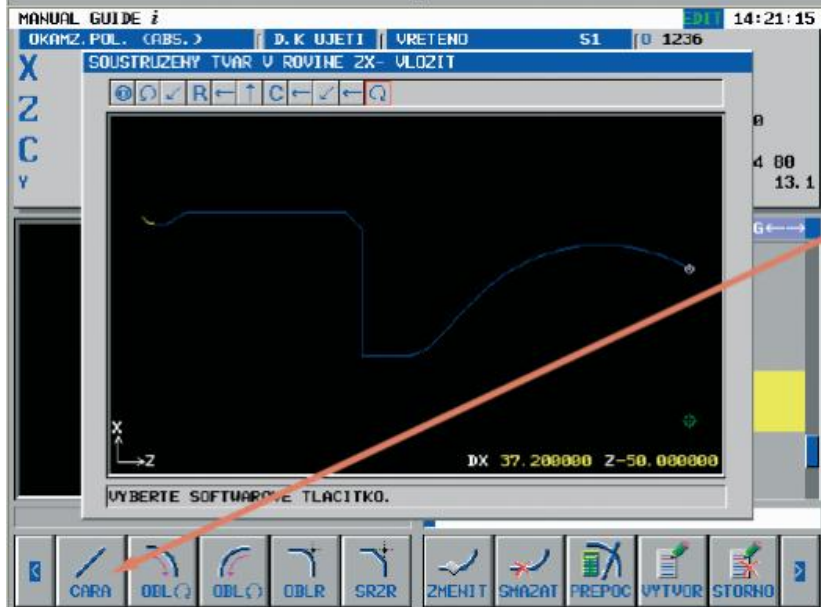
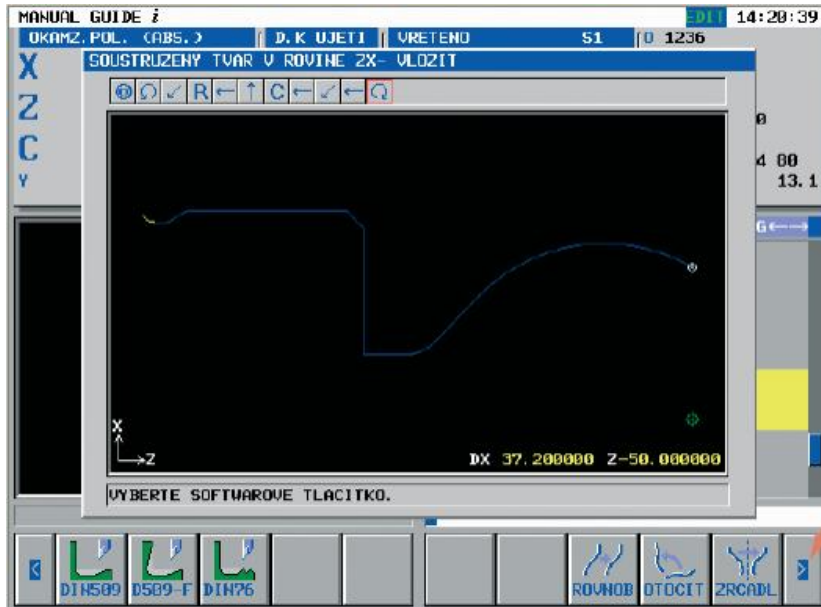


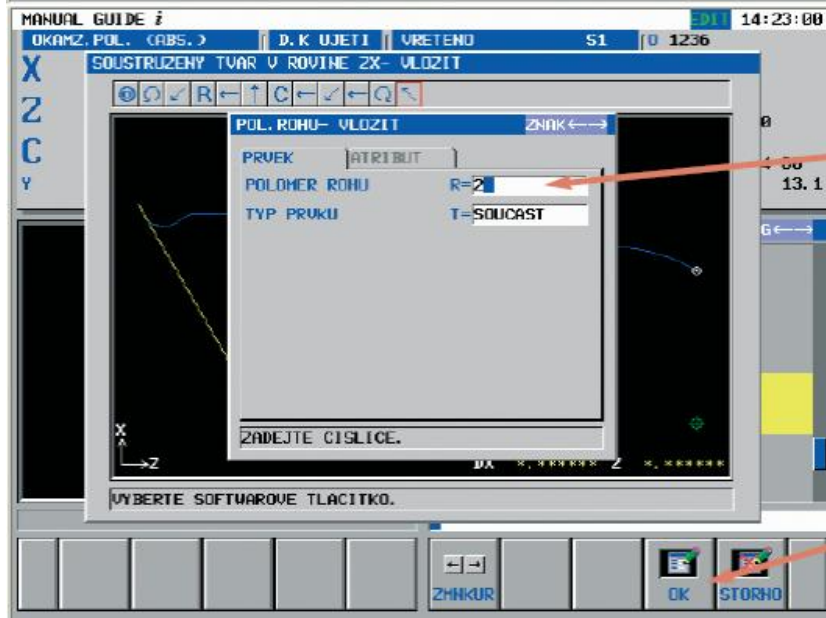
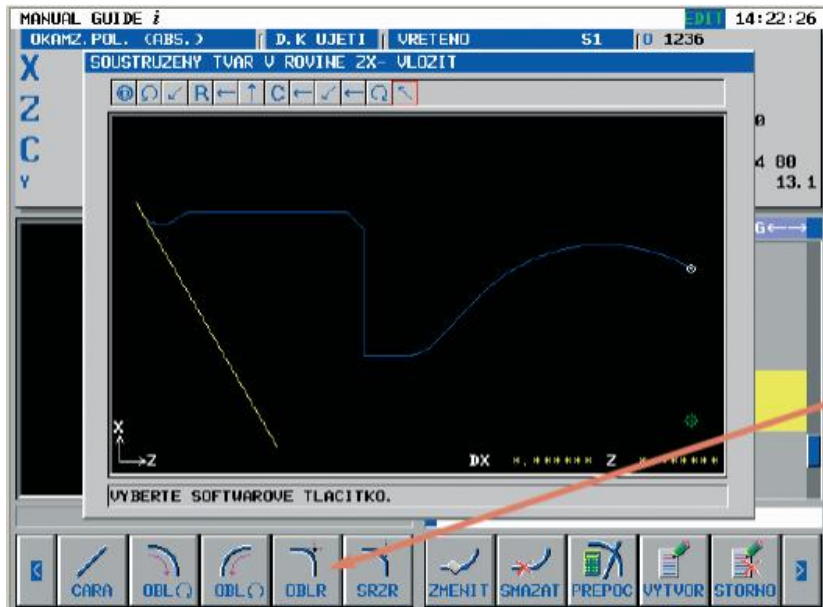


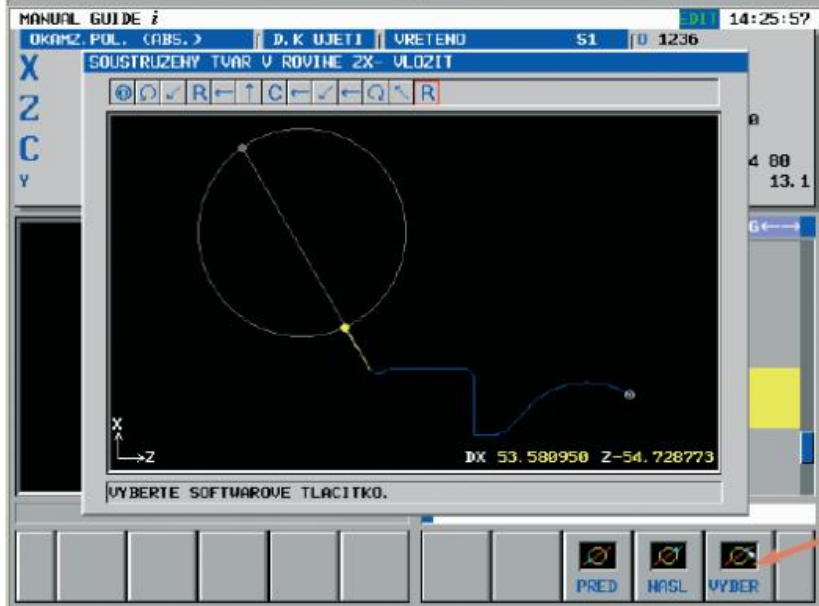
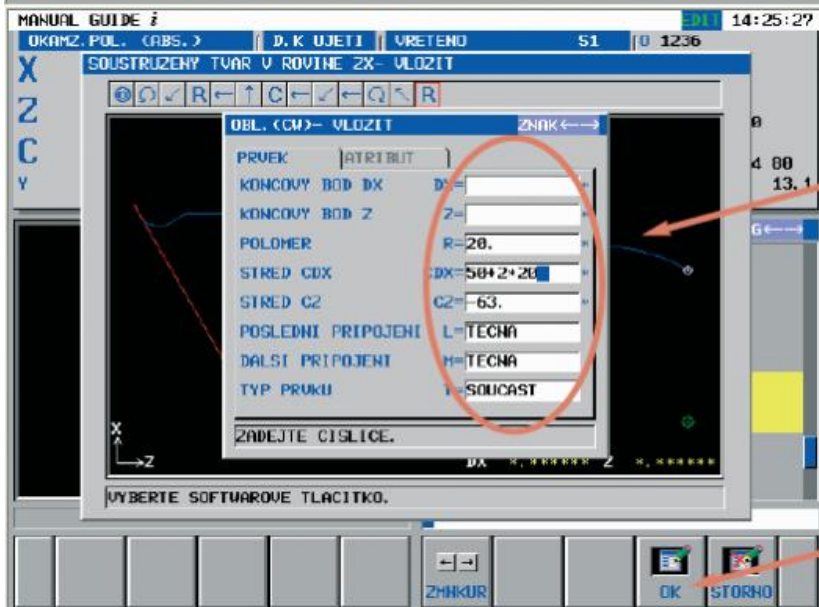
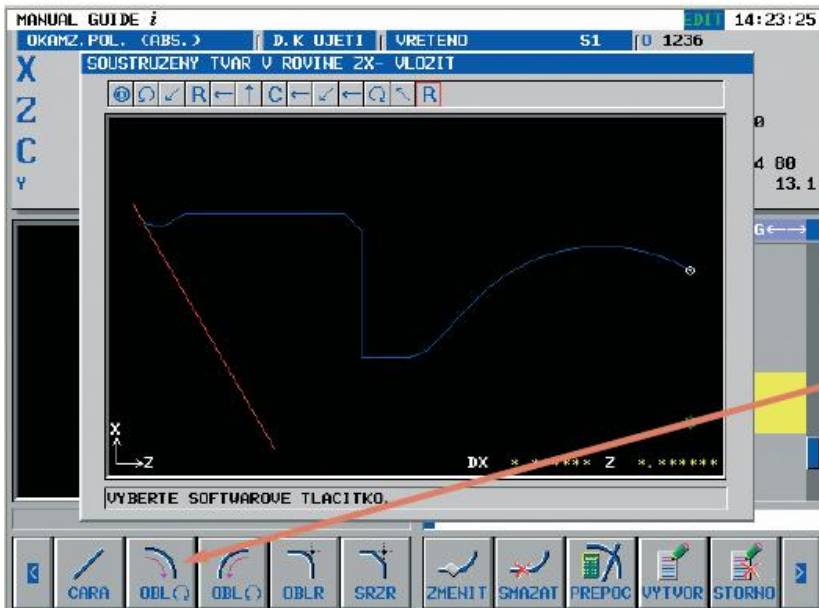


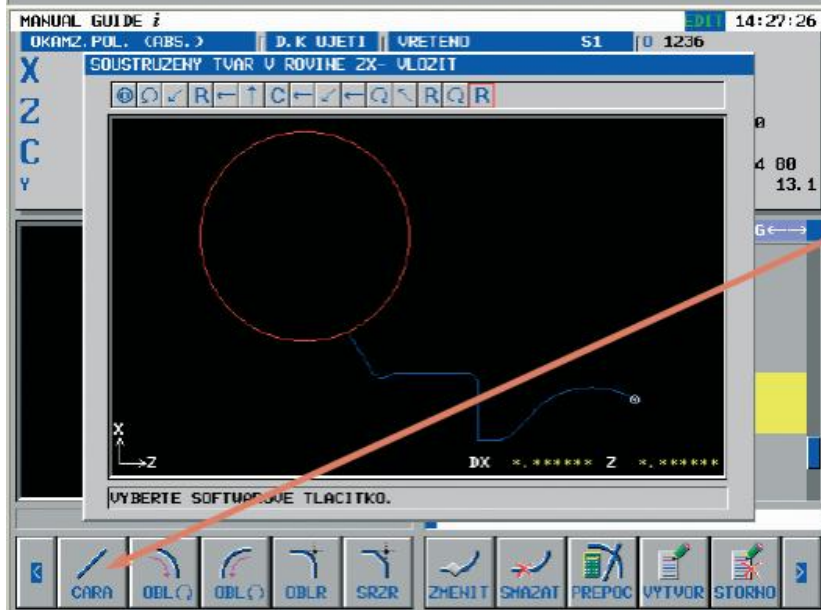
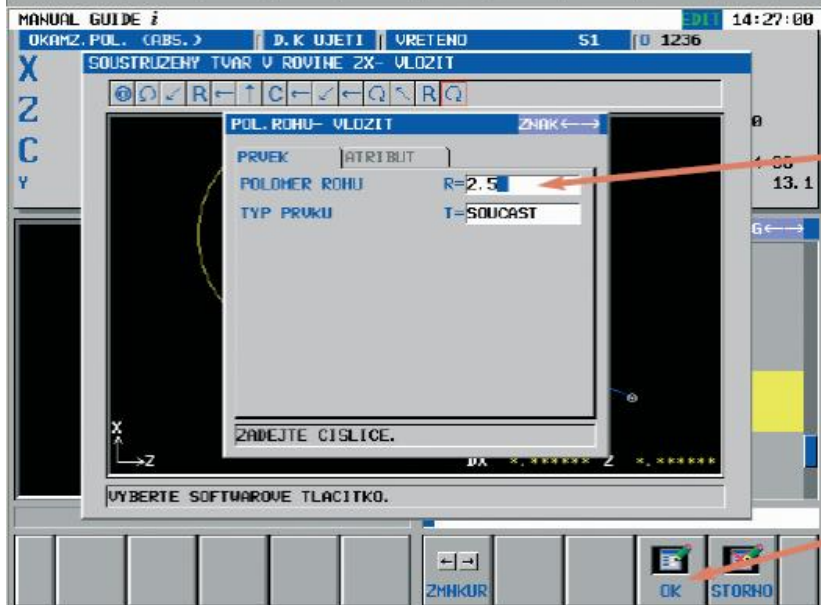
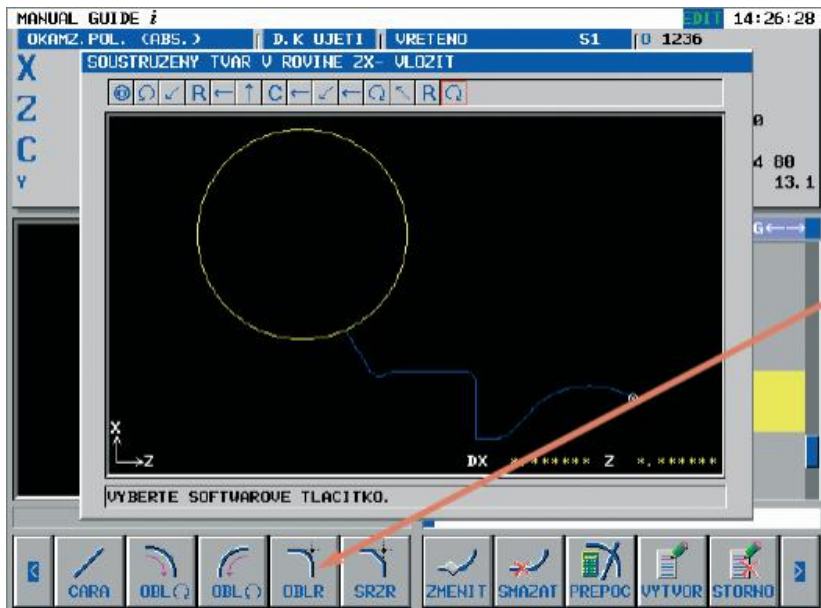


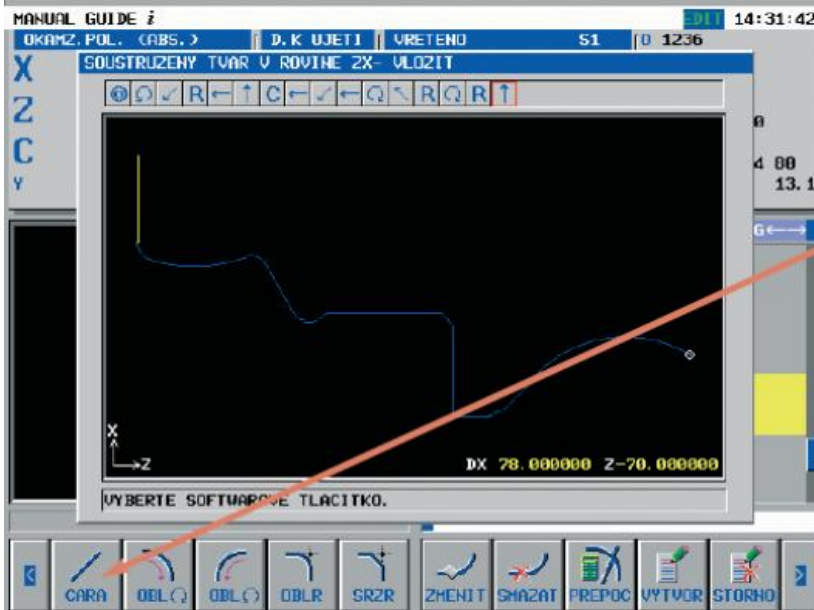
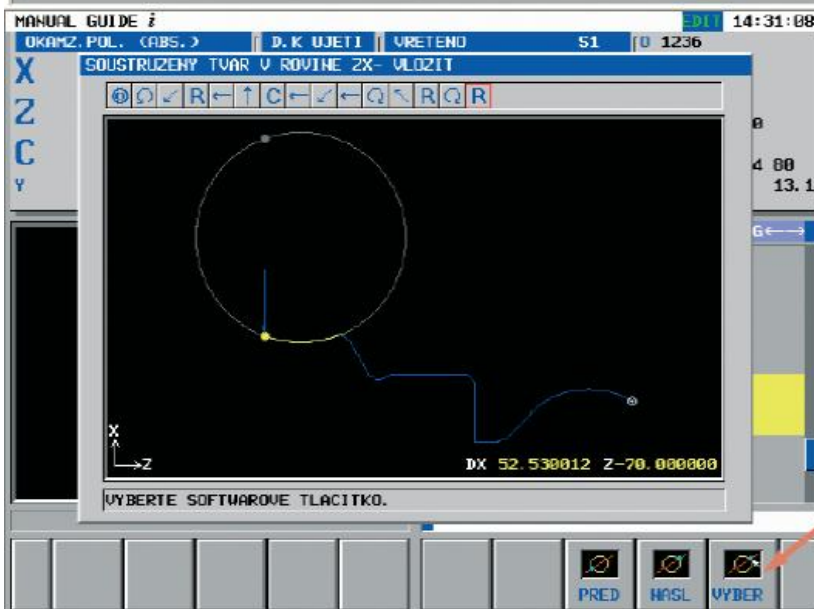
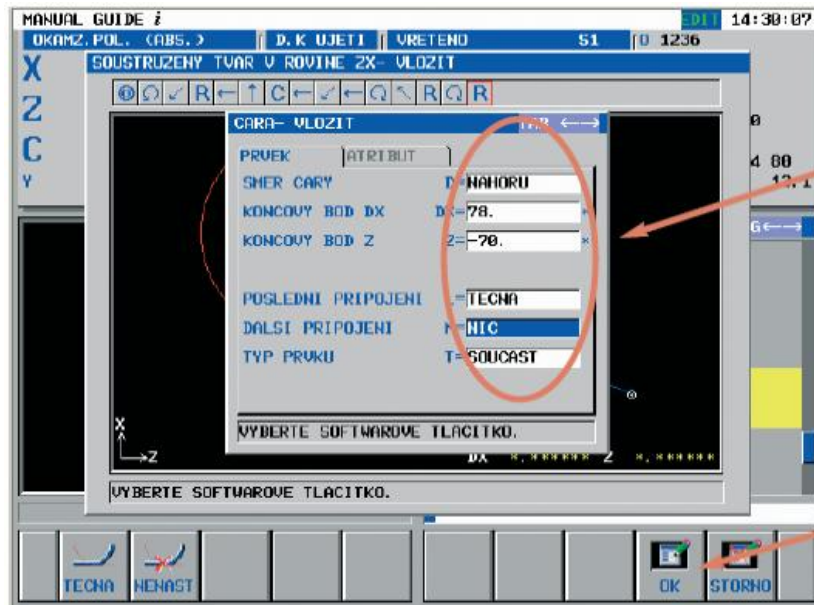












MANUAL GUIDE *i* EDIT 14:32:19

OKAMZ. POL. (ABS.) | D. K. UJETI | VRETENO | S1 | 0 1236

SOUSTRUZENY TVAR V ROVINE ZX- VLOZIT

CARA- VLOZIT TAB ←→

PRUEK	ATRIBUT
SHER CARY	D=VLEVD-NAH
KONCOUY BOD DX	DX=80.
KONCOUY BOD Z	Z=
UHEL	A=45.
POSLEDNI PRIPOJENI	L=NIC
DALSI PRIPOJENI	H=NIC
TYP PRUKU	T=SOUCAST

X
Z
C
Y

0
4 00
13.1

G ←→

VYBERTE SOFTWARE TLAČITKO.
 DX 78.000000 Z-70.000000

MANUAL GUIDE *i* EDIT 14:32:44

OKAMZ. POL. (ABS.) | D. K. UJETI | VRETENO | S1 | 0 1236

SOUSTRUZENY TVAR V ROVINE ZX- VLOZIT

X
Z
C
Y

0
4 00
13.1

G ←→

VYBERTE SOFTWARE TLAČITKO.
 DX 80.000000 Z-71.000000

MANUAL GUIDE *i* EDIT 14:40:05

OKAMZ. POL. (ABS.) | D. K. UJETI | VRETENO | S1 | 0 0901

SOUSTRUZENY TVAR V ROVINE ZX- ZMENA

CARA- VLOZIT TAB ←→

SHER CARY	D=UPRAVO
KONCOUY BOD Z	Z=0.
POSLEDNI PRIPOJENI	L=NIC
DALSI PRIPOJENI	H=NIC
TYP PRUKU	T=POLOTOVAR

X
Z
C
Y

0
4 00
13.1

G ←→

VYBERTE SOFTWARE TLAČITKO.
 DX 80.000000 Z-71.000000

MANUAL GUIDE *i* EDIT 14:33:55

OKAMZ. POL. (ABS.) | D. K. UJETI | VRETENO | S1 | 0 1236

SOUSTRUZENY TVAR V ROVINE ZX- VLOZIT

X
Z
C
Y

0
4.00
13.1

G ← →

DX 80.000000 Z 0.000000

UYBERTE SOFTWAREOVE TLACITKO.

CARA OBL() OBL() OBLR SRZR ZHENIT SMAZAT PREPOC VYTVOR STORNO

MANUAL GUIDE *i* EDIT 14:34:32

OKAMZ. POL. (ABS.) | D. K. UJETI | VRETENO | S1 | 0 1236

SOUSTRUZENY TVAR V ROVINE ZX- VLOZIT

X
Z
C
Y

CARA- VLOZIT

PRUEK
SHER CAR
KONCOVY BOD DX
POSLEDNI PRIPOJENI
DALSI PRIPOJENI
TYP PRUKU

D= DOLU
DX=27.7
L=NIC
M=NIC
=POLOTOVAR

UYBERTE SOFTWAREOVE TLACITKO.

DX 80.000000 Z 0.000000

TECNA NEHAST OK STORNO

MANUAL GUIDE *i* EDIT 14:34:57

OKAMZ. POL. (ABS.) | D. K. UJETI | VRETENO | S1 | 0 1236

SOUSTRUZENY TVAR V ROVINE ZX- VLOZIT

X
Z
C
Y

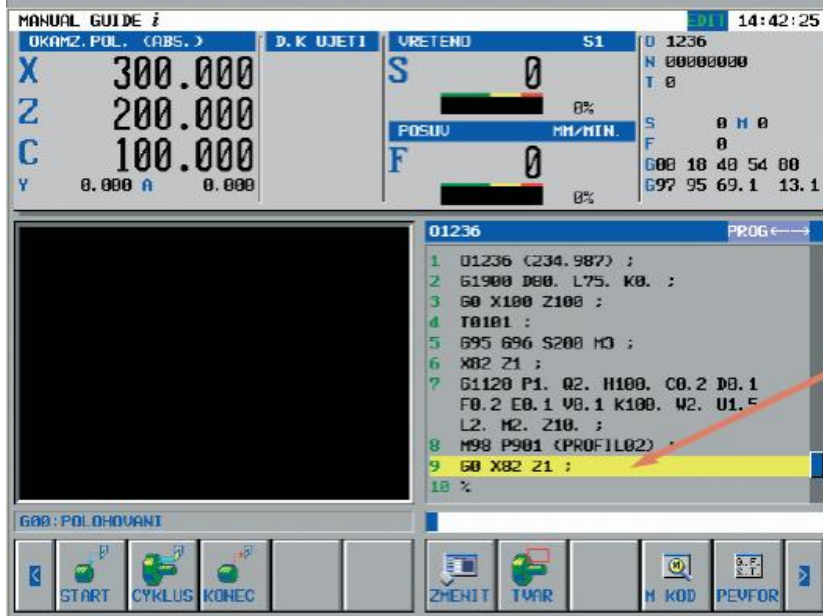
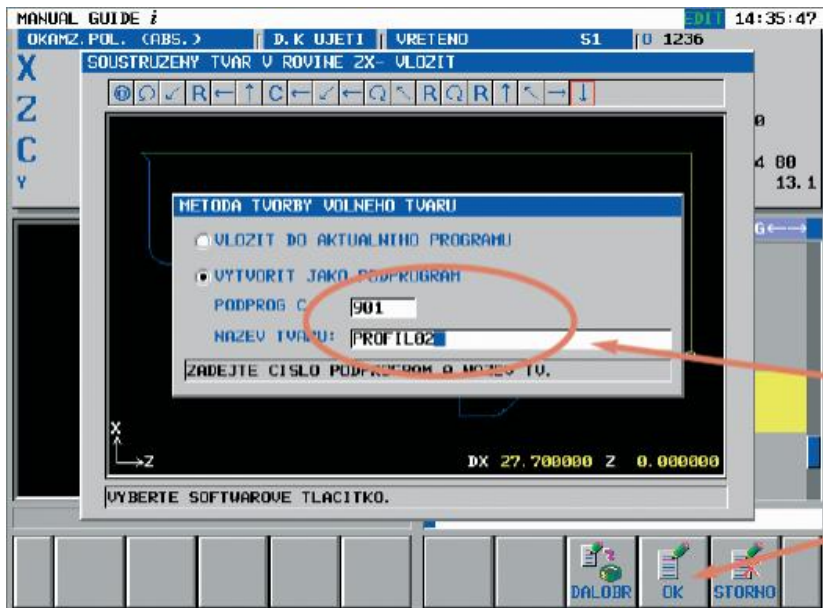
0
4.00
13.1

G ← →

DX 27.700000 Z 0.000000

UYBERTE SOFTWAREOVE TLACITKO.

CARA OBL() OBL() OBLR SRZR ZHENIT SMAZAT PREPOC VYTVOR STORNO



MANUAL GUIDE *i* -D11 09:15:56

OKAMZ. POL. (ABS.)	D. K. UJETI	VRETEND S1	0 1236
X 300.000		S 0	N 00000000
Z 200.000		POSUV MM/MIN.	T 0
C 100.000		F 0	S 0 H 0
Y 0.000 A 0.000			F 0
			G00 10 40 54 00
			G97 95 69.1 13.1

01236 PROG ←

```

5 G95 G96 S200 M3 ;
6 X82 Z1 ;
7 G1120 P1. Q2. H100. C0.2 D0.1
F0.2 E0.1 U0.1 K100. U2. U1.5
L2. M2. Z10. ;
8 M90 P901 (PROFIL02) ;
9 G0 X82 Z1 ;
10 G1126 P1. F0.05 L2. M2. Z10. ;
11 M90 P901 (PROFIL02) ;
12 G0 X38 Z0 ;
13 G1 X0 F0.22 ;
14 G0 Z2 ;

```

G00: POLOHUVANI

START CYKLUS KONEC ZMENIT TVAR H KOD PEVFOR

MANUAL GUIDE *i* -D11 15:11:26

OKAMZ. POL. (ABS.)	D. K. UJETI	VRETEND S1	0 1236
X 300.000		S 0	N 00000000
Z 200.000		POSUV MM/MIN.	T 0
C 100.000		F 0	S 0 H 0
Y 0.000 A 0.000			F 0
			G00 10 40 54 00
			G97 95 69.1 13.1

01236 PROG ←

```

5 G95 G96 S200 M3 ;
6 X82 Z1 ;
7 G1120 P1. Q2. H100. C0.2 D0.1
F0.2 E0.1 U0.1 K100. U2. U1.5
L2. M2. Z10. ;
8 M90 P901 (PROFIL02) ;
9 G0 X82 Z1 ;
10 G1126 P1. F0.05 L2. M2. Z10. ;
11 M90 P901 (PROFIL02) ;
12 G0 X38 Z0 ;
13 G1 X0 F0.02 ;
14 G0 Z2 ;

```

G00: POLOHUVANI

START CYKLUS KONEC ZMENIT TVAR H KOD PEVFOR

MANUAL GUIDE *i* -D11 15:16:56

OKAMZ. POL. (ABS.)	D. K. UJETI	VRETEND S1	0 1236
X 300.000		S 0	N 00000000
Z 200.000		POSUV MM/MIN.	T 0
C 100.000		F 0	S 0 H 0
Y 0.000 A 0.000			F 0
			G00 10 40 54 00
			G97 95 69.1 13.1

ULOZIT POCATECNI PUVEL FREZOVANI

START KONV. SOUR. POLOTOVAR UOL. URET.

1. START + REF

```

G0 X100 Z100 ;
T7 ;
M48 ;
G0 C0 ;
X42 Z2 S2300 M103 ;

```

UYBERTE CYKLUS, KTERY CHCETE ULOZIT A STISKNETE LUYBERI

ULOZIT STORNO

MANUAL GUIDE EDIT 15:18:48

OKAMZ. POL. (ABS.)	D. K UJETI	VRETEND S1	O 1236
X 300.000		S 0	N 0000000
Z 200.000		0%	T 0
C 100.000		POSUV MM/MIN.	S 0 H 0
Y 0.000 A 0.000		F 0	F 0
		0%	G00 10 40 54 00
			G97 95 69.1 13.1

01236 PROG ←

```

8 M98 P901 (PROFIL02) ;
9 G0 X82 Z1 ;
10 G1126 P1. F0.05 L2. M2. Z10. ;
11 M98 P901 (PROFIL02) ;
12 G0 X38 Z0 ;
13 G1 X0 F0.02 ;
14 G0 Z2 ;
15 G0 X100 Z100 ;
16 T0404 ;
17 M48 ;
18 G0 C0 ;
19 X82 Z2 G94 S4200 M103 ;

```

X: ABSOLUTNI POLoha OSY X

START CYKLUS KONEC ZHENIT TVAR N KOD PEVFOR

MANUAL GUIDE EDIT 15:19:32

OKAMZ. POL. (ABS.)	D. K UJETI	VRETEND S1	O 1236
X 300.000		S 0	N 0000000
Z 200.000		0%	T 0
C		POSUV MM/MIN.	S 0 H 0
Y			F 0

ULOZIT CYKLUS FREZOVANI

OBR. DTRY | OBR. CELA | KOPIROVANI | FREZ. KAPSY | DRAZKOVANI

1. FREZOVANI KAPSY<HRUBOVANI>
2. FREZOVANI KAPSY<DOK. DNA>
3. FREZOVANI KAPSY<DOK. STRAN>
4. FREZOVANI KAPSY<SRAZENI>

80 13.1

UYBERTE CYKLUS, KTERY CHCETE ULOZIT A STISKNETE [UYBER]

UYDER STORNO

MANUAL GUIDE EDIT 15:20:41

OKAMZ. POL. (ABS.)	D. K UJETI	VRETEND S1	O 1236
X 300.000		S 0	N 0000000
Z			T 0
C			
Y			

FREZOVANI KAPSY<HRUBOVANI> - ULOZIT ZNAK ←

REZNE PODM|DETAIL

TLOUSTKA DNA T=

BOCNI TLOUSTKA S=

HL. REZU NA POLOMERU L=2.

HLOUBKA REZU V OSE J=4.

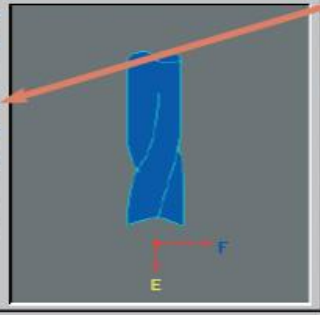
STRAN. PRID. NA DOK. K=0.

PRIDAVEK NA DOK. DNA H=0.

RYCH. POS. - JEDEN REZ F=120.

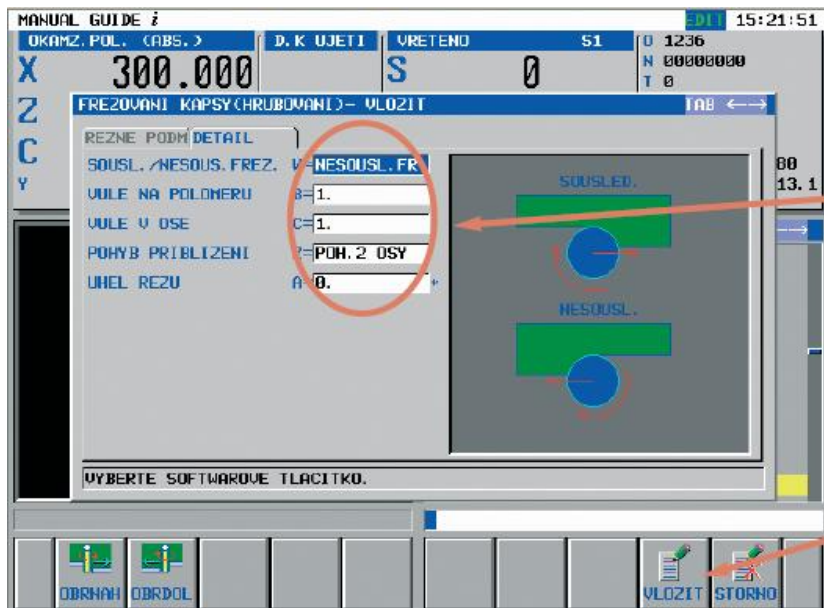
RYCH. POS. - OBA ZPUS. V=100.

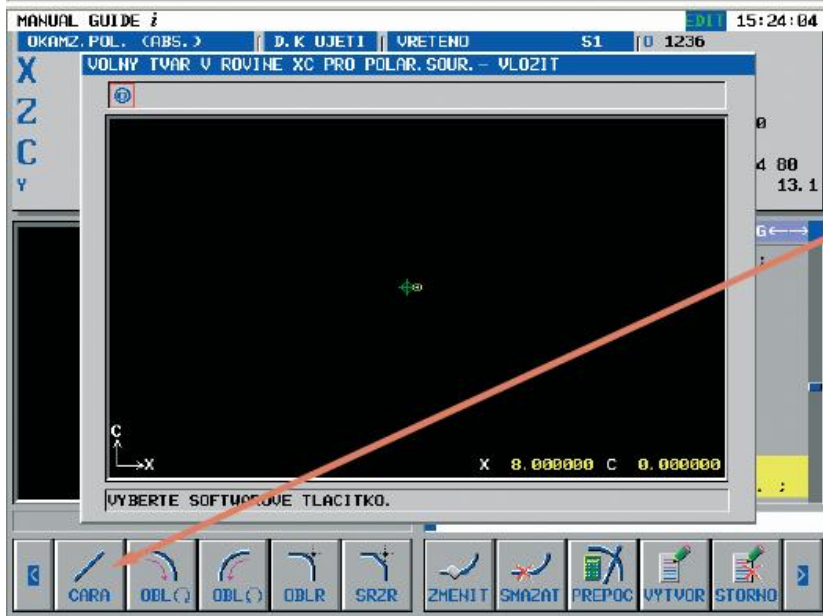
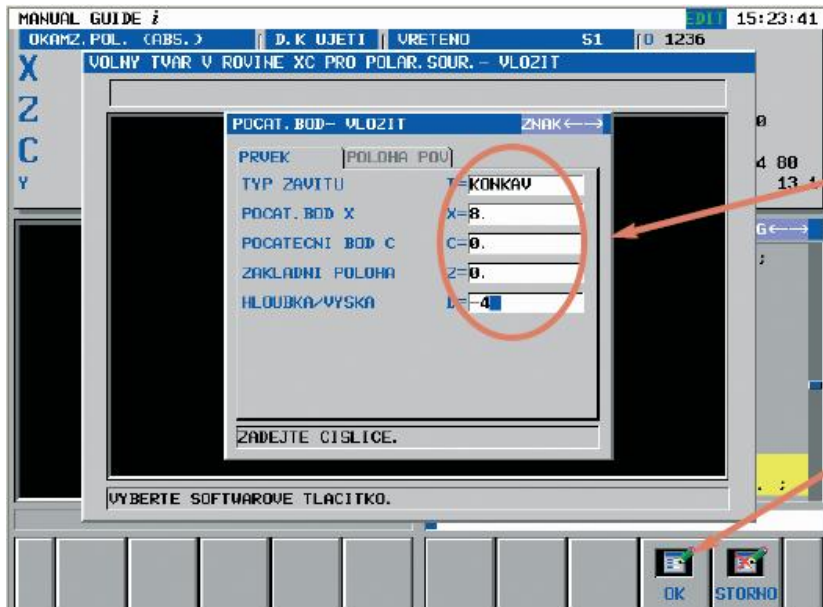
RYCHLOST POSUVU-OSA S=80

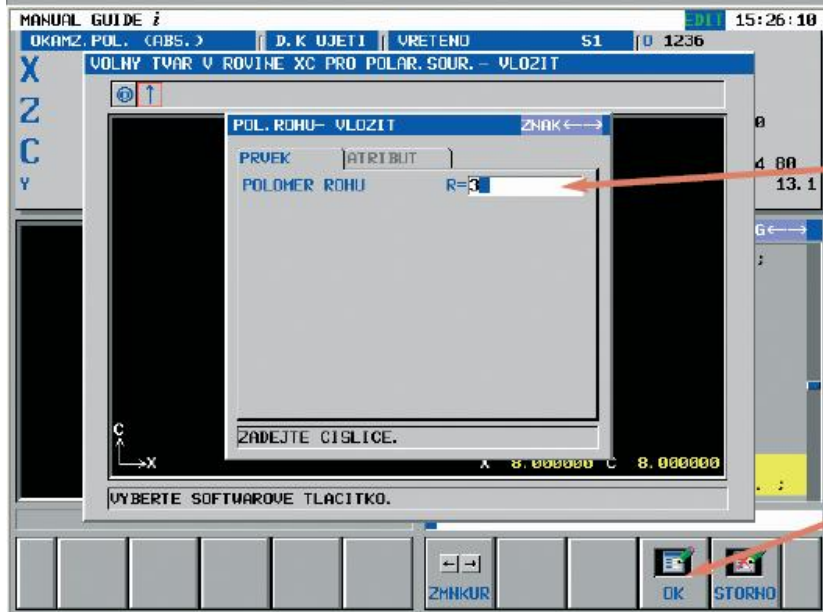
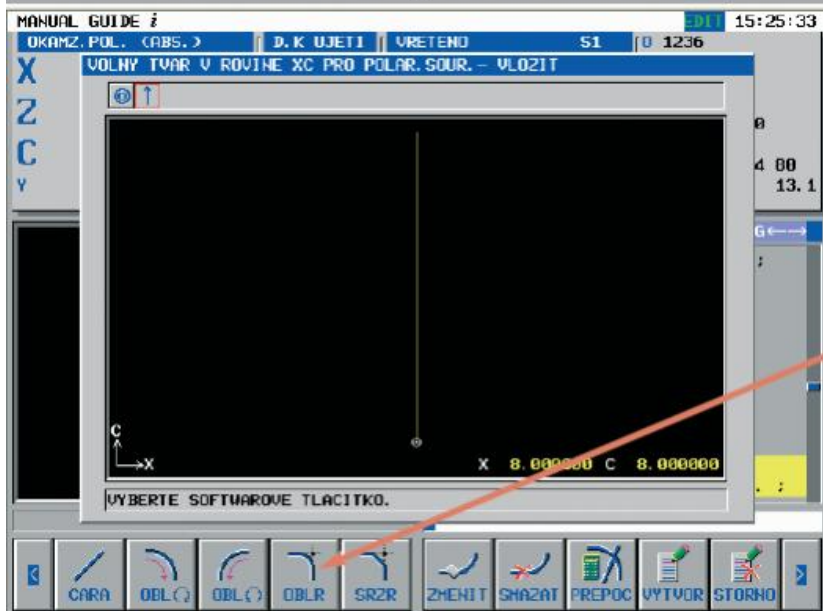
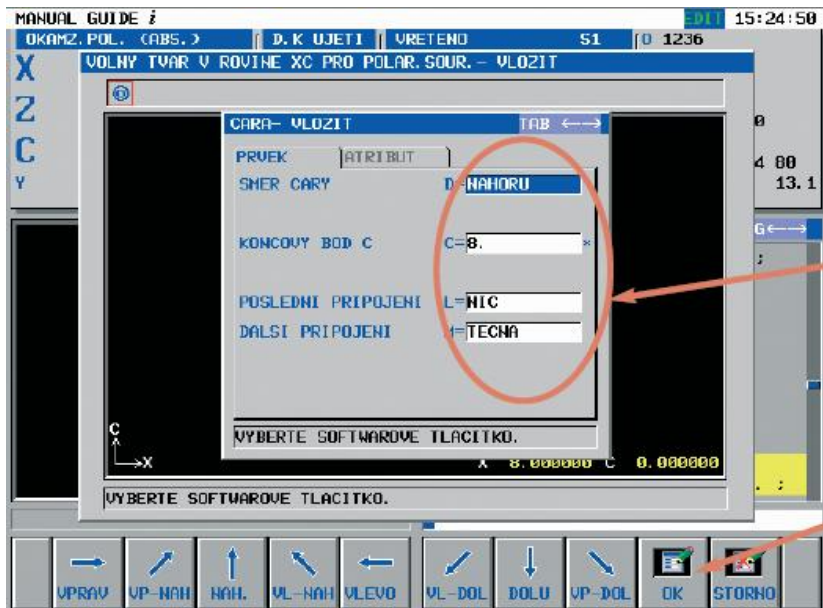


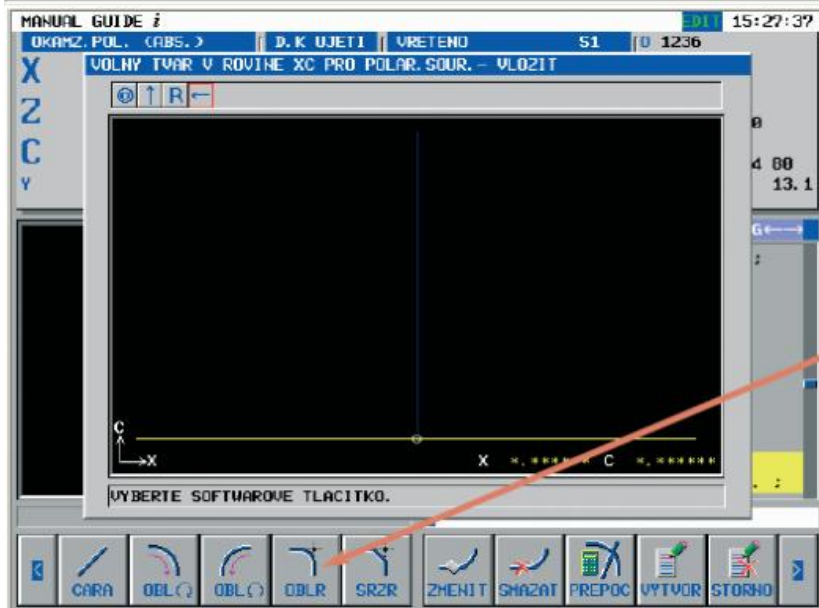
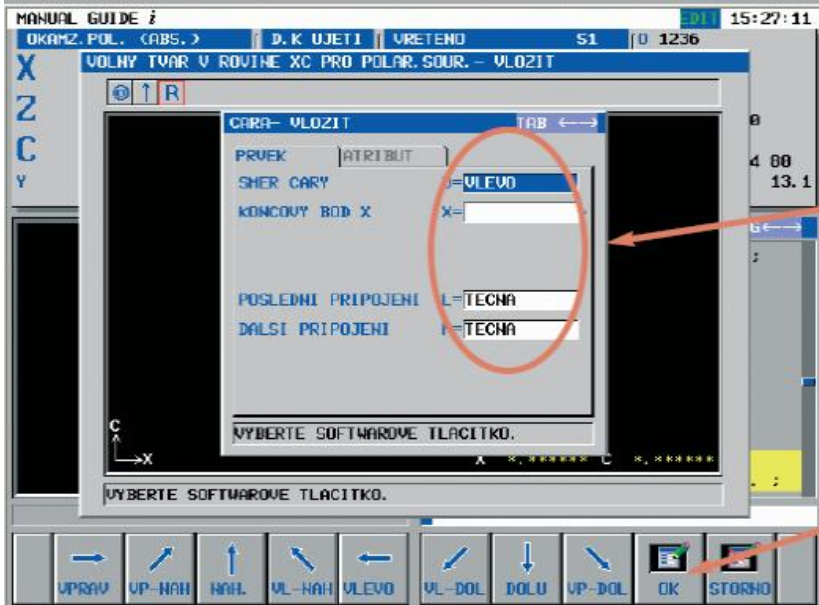
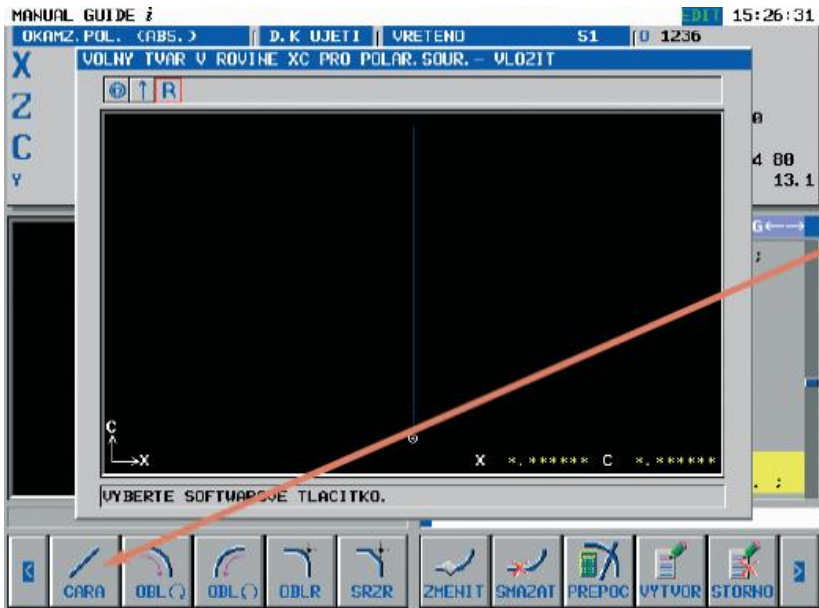
ZADEJTE CISLICE. CNM/MIN, MM/REV, INCH/MIN, INCH/REV

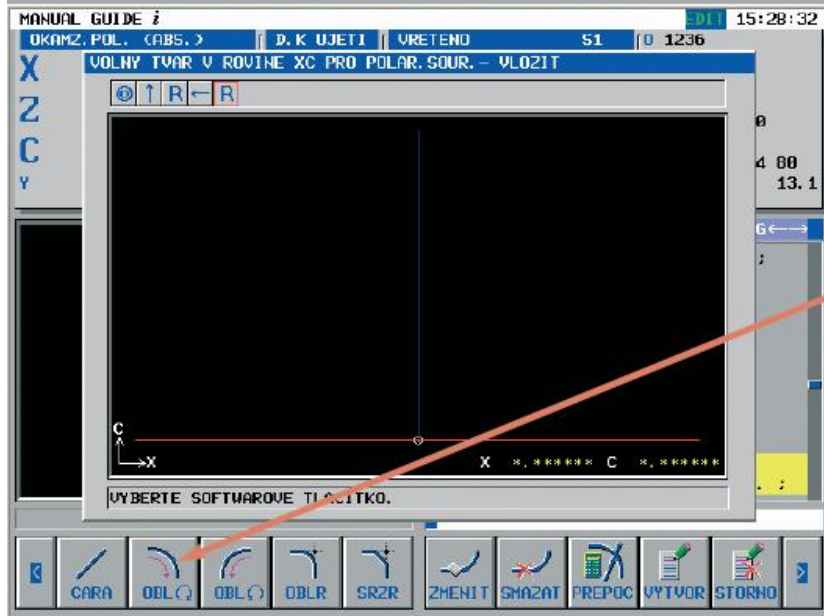
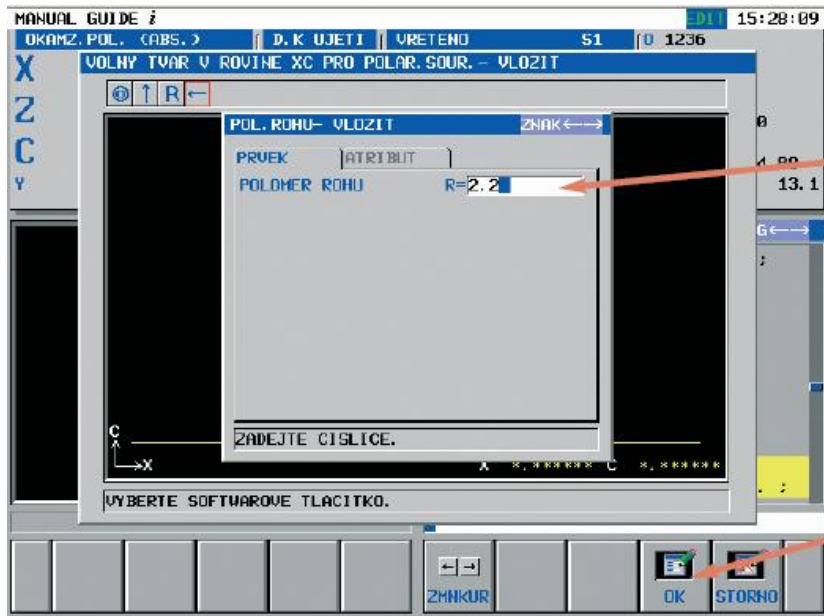
ZHNKUR ULOZIT STORNO











MANUAL GUIDE *i* EDIT 15:30:06

OKAMZ. POL. (ABS.) | D. K. UJETI | VRETENO | S1 | 0 1236

VOLNY TVAR V ROVINE XC PRO POLAR. SOUR. - VLOZIT

⊕ ↑ R ← R

PRUEK	ATRIBUT
KONCOVY BOD X	X=
KONCOVY BOD C	C=
POLOHER	R=4.
STRED CX	CX=-5.5
STRED CC	CC=9.53
POSLEDNI PRIPOJENI	L=TECNA
DALSI PRIPOJENI	M=TECNA
TYP DRAHY	U=KRATKA

UYBERTE SOFTWARETVE TLACITKO.

TECNA NENAST OK STORNO

MANUAL GUIDE *i* EDIT 15:30:32

OKAMZ. POL. (ABS.) | D. K. UJETI | VRETENO | S1 | 0 1236

VOLNY TVAR V ROVINE XC PRO POLAR. SOUR. - VLOZIT

⊕ ↑ R ← R

UYBERTE SOFTWARETVE TLACITKO.

PRED NASL VYBER

MANUAL GUIDE *i* EDIT 15:31:05

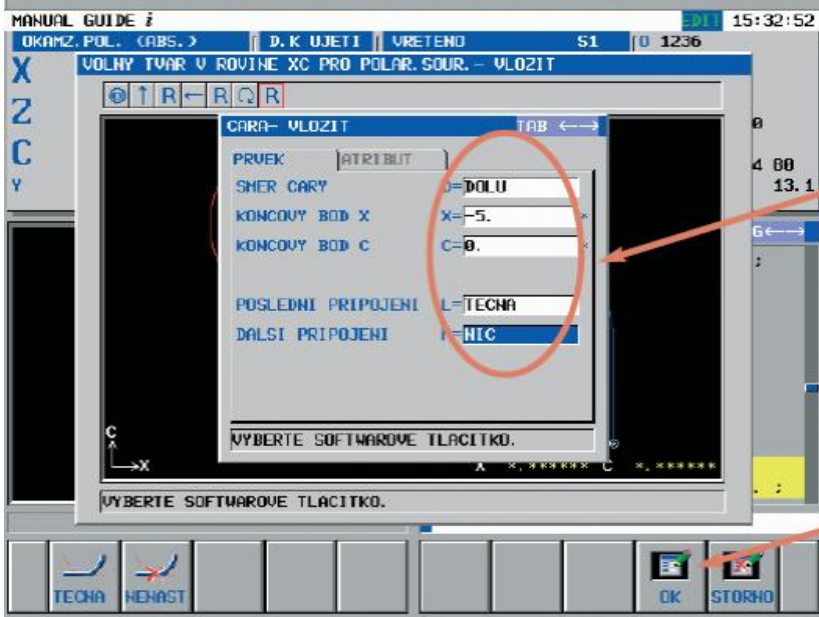
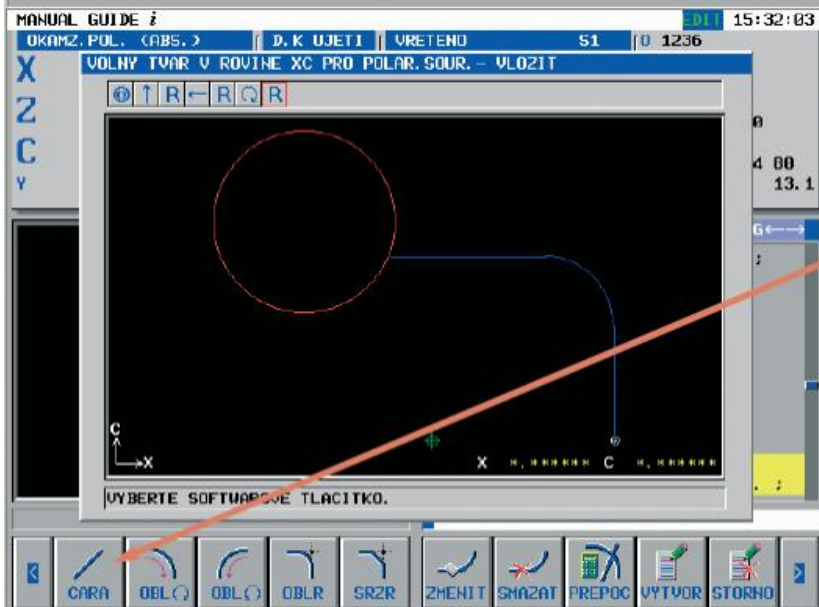
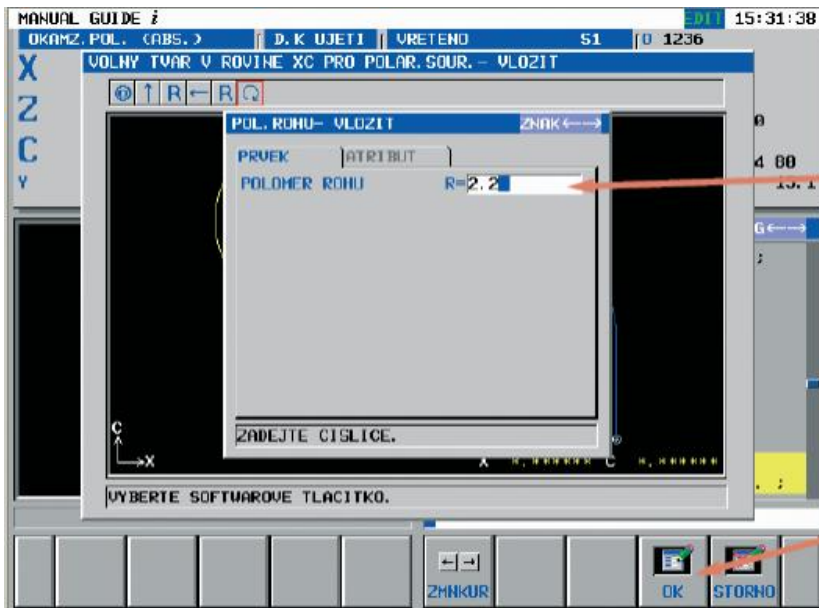
OKAMZ. POL. (ABS.) | D. K. UJETI | VRETENO | S1 | 0 1236

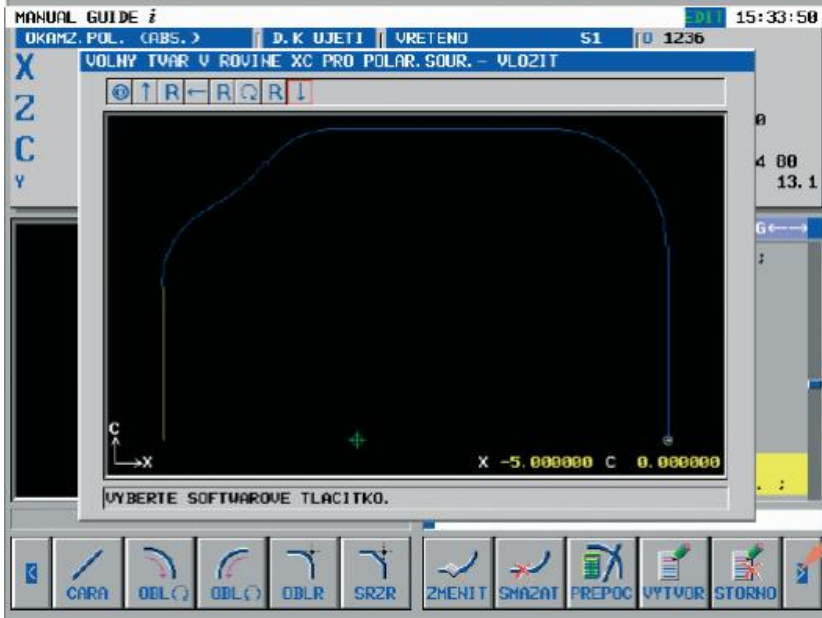
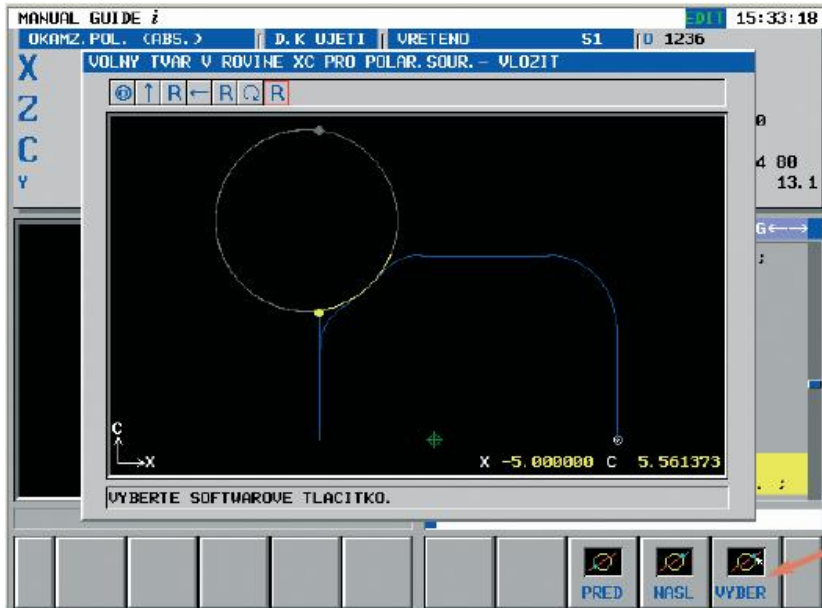
VOLNY TVAR V ROVINE XC PRO POLAR. SOUR. - VLOZIT

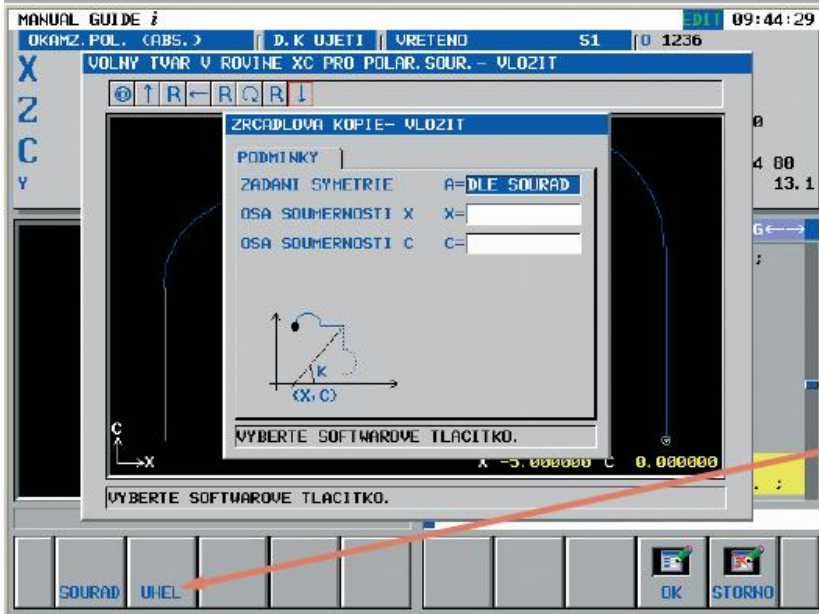
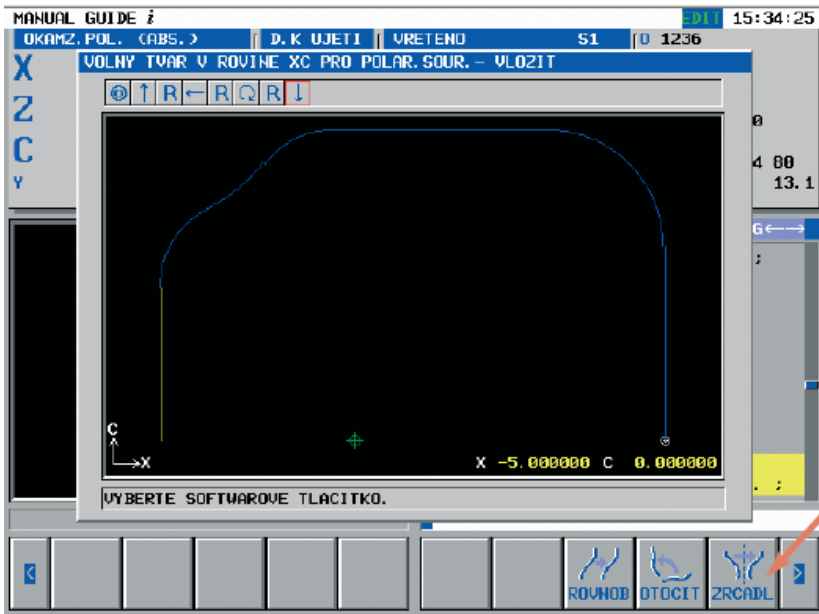
⊕ ↑ R ← R ⊙

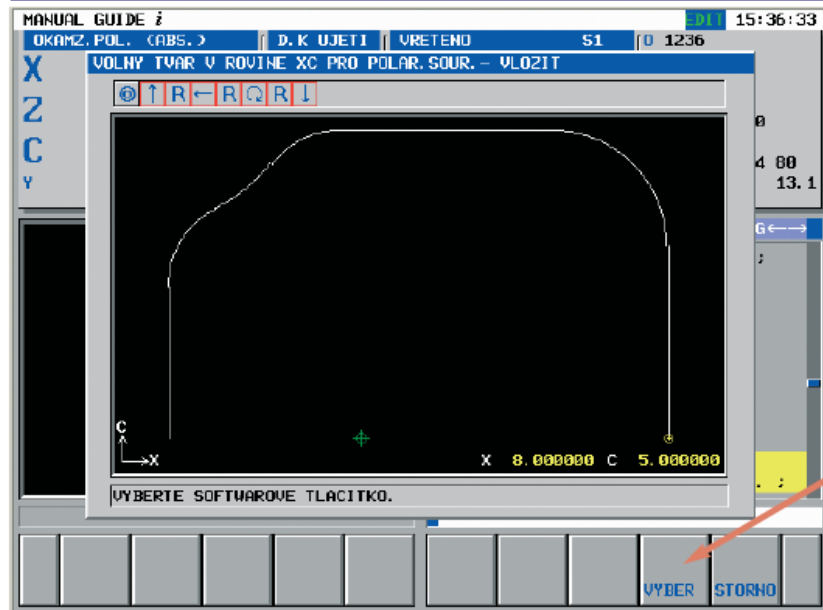
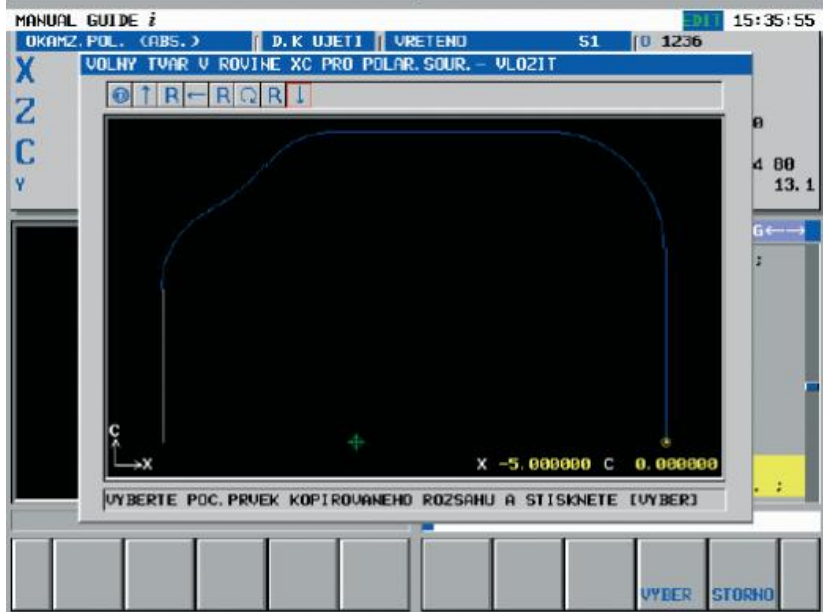
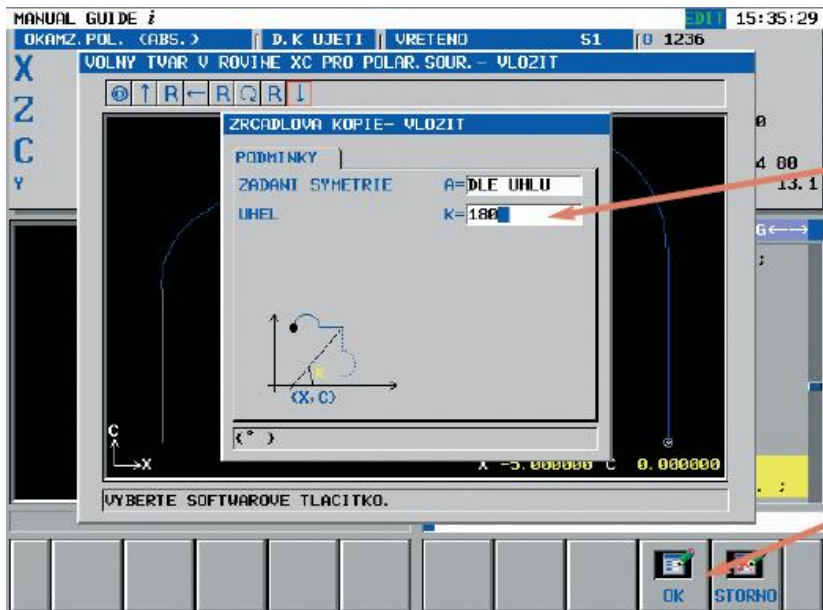
UYBERTE SOFTWARETVE TLACITKO.

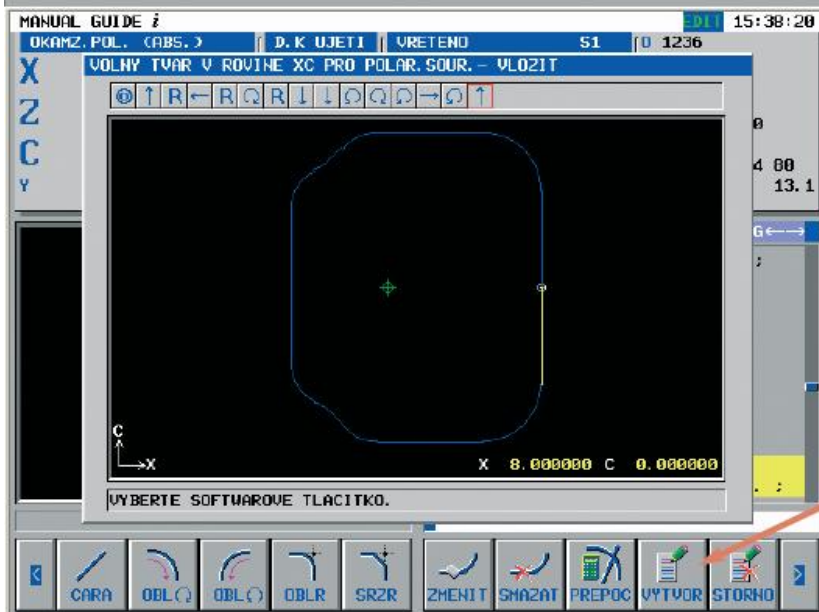
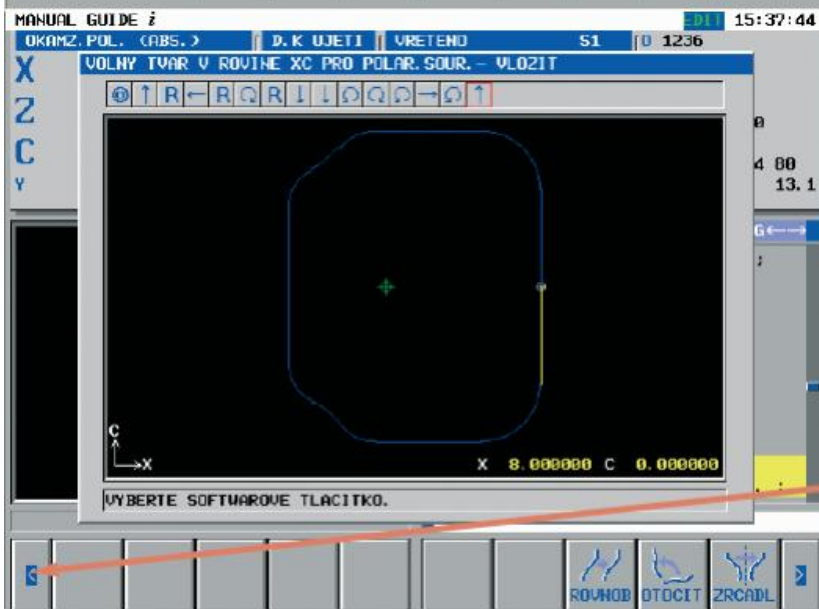
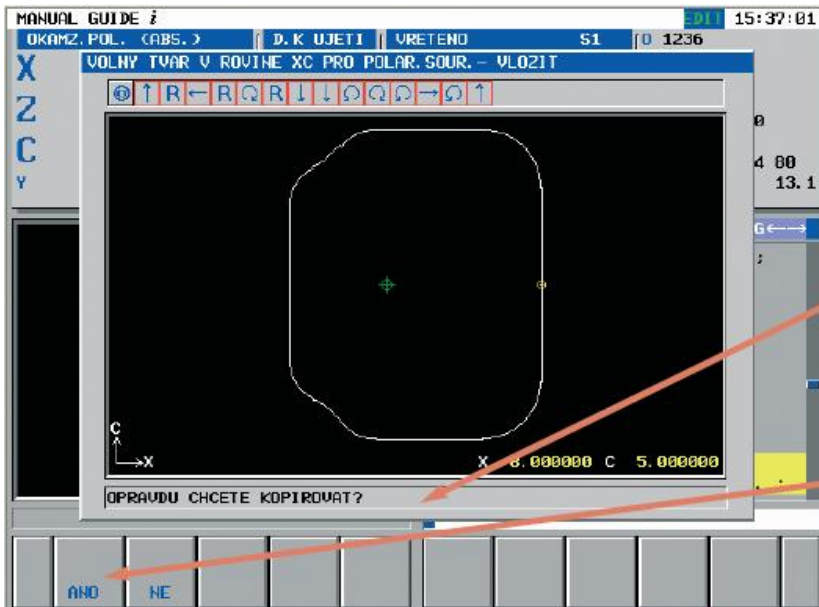
CARA OBL() OBL() OBLR SRZR ZHENIT SMAZAT PREPOC VYTVOR STORNO











MANUAL GUIDE *ž* E-DI 15:39:26

OKAMZ. POL. (ABS.) D. K. UJETI VRETENO S1 0 1236

VOLNY TVAR V ROVINE XC PRO POLAR. SOUR. - VLOZIT

X
Z
C
Y

METODA TVORBY VOLNEHO TVARU

VLOZIT DO AKTUALNHU PROGRAMU

VYTvorIT JAKO PODPROGRAM

PODPROG...: 902

NAZEV TVARU: POCKETING FACE

ZADEJTE CÍSLO PODPROGRAM A NAZEV TV

X 8.000000 C 0.000000

UYBERTE SOFTWAREVE TLACITKO.

OSTROV DALOBR OK STORNO

MANUAL GUIDE *ž* E-DI 15:39:57

OKAMZ. POL. (ABS.) D. K. UJETI VRETENO S1 0 1236

X 300.000
Z 200.000
C 100.000
Y 0.000 A 0.000

S 0
POSUV MM/NTN
F 0

N 00000000
T 0
S 0 H 0
F 0
G00 10 40 54 00
G97 95 69.1 13.1

01236 PROG ←

```

11 M98 P901 (PROFIL02) ;
12 G0 X38 Z0 ;
13 G1 X0 F0.02 ;
14 G0 Z2 ;
15 G0 X100 Z100 ;
16 T0404 ;
17 M48 ;
18 G0 C0 ;
19 X02 Z2 G94 S4200 M103 ;
20 G1040 L2. J4. K0. H0. F120.
V100. E00. W2. B1. C1. Z2. A0. ;
21 M98 P902 (POCKETING FACE) ;

```

M98: VOLANT PODPROGRAMU.

START CYKLUS KONEC ZHENIT TVAR H KOD PEVFOR

MANUAL GUIDE *i* EDIT 15:40:41

OKAMZ. POL. (ABS.)	D. K. UJETI	VRETEND S1	U 1236
X 300.000		S 0	N 00000000
Z 200.000		0%	T 0
C 100.000		POSUV MM/MIN	S 0 M 0
Y 0.000 A 0.000			F 0
			G00 10 40 54 00
			G97 95 63.1 13.1

ULOZIT POCATECNI POVEL FREZOVANI

START [KONV. SOUR.] [POLOTOVAR] [VOL. VRET.]

1. START + REF

```

G0 X100 Z100 ;
T? ;
M48 ;
G0 C0 ;
X42 Z2 S2300 M103 ;

```

60 13.1

UYBERTE CYKLUS, KTERY CHCETE ULOZIT A STISKNETE [UYBER]

VLOZIT STORNO

MANUAL GUIDE *i* EDIT 15:41:59

OKAMZ. POL. (ABS.)	D. K. UJETI	VRETEND S1	U 1236
X 300.000		S 0	N 00000000
Z 200.000		0%	T 0
C 100.000		POSUV MM/MIN	S 0 M 0
Y 0.000 A 0.000			F 0
			G00 10 40 54 00
			G97 95 63.1 13.1

01236 PROG ←→

```

15 G0 X100 Z100 ;
16 T0404 ;
17 M48 ;
18 G0 C0 ;
19 X82 Z2 694 S4200 M103 ;
20 G1040 L2. J4. K0. H0. F120.
V100. E00. W2. B1. C1. Z2. A0. ;
21 M98 P902 (POCKETING FACE) ;
22 G0 X100 Z100 ;
23 T0505 ;
24 X82 Z2 S2300 M103 ;

```

X: ABSOLUTNI POLOHA OSY X

START CYKLUS KONEC ZMENIT TVAR H KOD PEVFOR

MANUAL GUIDE *i* 15:42:22

OKAMZ. POL. (ABS.) D. K UJETI VRETEND S1 0 1236
 X 300.000 S 0 N 0000000
 Z 200.000 T 0
 C POSIU MM/MIN S 0 H 0

ULOZIT CYKLUS FREZOVANI

OBR. DIRY | OBR. CELA | KOPIROVANI | FREZ. KAPSY | DRAZKOVANI

1. NAVRTAVANI
2. VRTANI
3. ZAVITOVANI
4. VYSTRUZOVANI
5. UVYRTAVANI

00 13.1

UYBERTE CYKLUS, KTERY CHCETE ULOZIT A STISKNETE [UYBER]

UYBER STORNO

MANUAL GUIDE *i* 15:43:40

OKAMZ. POL. (ABS.) D. K UJETI VRETEND S1 0 1236
 X 300.000 S 0 N 0000000
 Z T 0
 C POSIU MM/MIN S 0 H 0

VRTANI - ULOZIT

REZNE PODMDETAIL

HL. ODLEHCENI REZU 0

REZ. NAVR. DO RF. BODU REF. POL.

HLOUBKA REZU L=-1.2

VELIKOST PROJETI K=1.

VALE C=1.

RYCHLOST POSIUU F=120.

DOBA PRODLEUY V=0.

POHYB PŘIBLIZENI Z-X->Z POH.

00 13.1

UYBERTE SOFTWAREOVE TLACITKO.

Z → X X → Z Z OSY

VLOZIT STORNO

MANUAL GUIDE *i* 15:44:21

OKAMZ. POL. (ABS.) D. K UJETI VRETEND S1 0 1236
 X 300.000 S 0 N 0000000
 Z 200.000 T 0
 C POSIU MM/MIN S 0 H 0

ULOZIT FREZOVANY TVAR

POLOH. DIRY | PODPROGRAM

13. BODY ODELNIKA YZ
14. BODY KRUZHICE YZ
15. BODY OBLOKU YZ (STEJNA ROSTEC)
16. BODY OBLOKU YZ (RUZNA ROSTEC)
17. DIRA NA CELE V OSE C (BODY OBLOKU)

00 13.1

UYBERTE TVAR, KTERY CHCETE ULOZIT A STISKNETE [UYBER]

UYBER STORNO

MANUAL GUIDE *i* EDIT 15:45:06

OKAMZ. POL. (ABS.) D. K. UJETI VRETEND S1 0 1236
 X 300.000 S 0 N 0000000
 Z T 0

XC-C DIRA V OSE(BODY OBLOUKU)- VLOZIT TAB ←

POLOHA/VEL. OPAKOVAT (POLOHA POU)
 ZAKLADNI POLOHA B=0.
 X-OSA X=11.
 POCATECNI UHEL A=0.

ZADEJTE CISLICE. (MM, INCH)

ZMKUR DALOBR VLOZIT STORNO

MANUAL GUIDE *i* EDIT 15:48:15

OKAMZ. POL. (ABS.) D. K. UJETI VRETEND S1 0 1236
 X 300.000 S 0 N 0000000
 Z T 0

XC-C DIRA V OSE(BODY OBLOUKU)- VLOZIT ZNAK ←

POLOHA/VEL. OPAKOVAT (POLOHA POU)
 UHEL STOUPIANT C=120.
 CISLO DIRY H=3

ZADEJTE CISLICE.

ZMKUR DALOBR VLOZIT STORNO

MANUAL GUIDE *i* EDIT 15:48:54

OKAMZ. POL. (ABS.) D. K. UJETI VRETEND S1 0 1236
 X 300.000 S 0 N 0000000
 Z 200.000 F POSIU MM/MIN. 0
 C 100.000 F 0
 Y 0.000 A 0.000

01236 PROG ←

```

18 G0 C0 ;
19 X82 Z2 G94 S4200 M103 ;
20 G1040 L2. J4. K0. H0. F120.
   U100. F80. W2. B1. C1. Z2. A0. ;
21 H98 P902 (POCKETING FACE) ;
22 G0 X100 Z100 ;
23 T0505 ;
24 X02 Z2 S2300 M103 ;
25 G1111 I3. L-1.2 K1. C1. F120.
   P0. Z11. ;
26 G1572 B0. X11. A0. C120. H3. Z1.
   ;

```

G1572: DIRA V OSE-C(KRIZNICE)

START CYKLUS KONEC ZHERIT TVAR H KOD PEVFOR

MANUAL GUIDE *i* EDIT 15:50:08

OKAMZ. POL. (ABS. >)	D. K. UJETI	VRETEND S1	O 1236
X 300.000		S 0	N 00000000
Z 200.000		0%	T 0
C 100.000		POSUV MM/MIN.	S 0 H 0
Y 0.000 A 0.000		F 0	F 0
		0%	G00 10 40 54 00
			G97 95 69.1 13.1

01236 PROG ←

```

18 G0 C0 ;
19 X82 Z2 G94 S4200 M103 ;
20 G1040 L2. J4. K0. H0. F120.
U100. E80. W2. B1. C1. Z2. A0. ;
21 M98 P902 (POCKETING FACE) ;
22 G0 X100 Z100 ;
23 T0505 ;
24 X02 Z2 S2300 M103 ;
25 G1111 I3. L-1.2 K1. C1. F120.
P0. Z11. ;
26 G1572 B0. X11. A0. C120. M3. Z1.
;

```

G1572:DIRA U OSE-C(KRUZNICE)

START CYKLUS KONEC

ZHENIT TVAR M KOD PEVFOR

MANUAL GUIDE *i* EDIT 15:50:34

OKAMZ. POL. (ABS. >)	D. K. UJETI	VRETEND S1	O 1236
X 300.000		S 0	N 00000000
Z 200.000		0%	T 0
C 100.000		POSUV MM/MIN.	S 0 H 0
Y 0.000 A 0.000		F 0	F 0
		0%	G00 10 40 54 00
			G97 95 69.1 13.1

VLOZIT UKONCOVACI Povel SOUSTRUZENI

<p>KONEC</p> <p>1. END</p>	<pre> G0 X100 Z100 ; M30 ; </pre>
----------------------------	-----------------------------------

(VYBERTE CYKLUS, KTERY CHCETE VLOZIT A STISKNETE (VYBER)

VLOZIT STORNO

MANUAL GUIDE *i* EDIT 15:51:08

OKAMZ. POL. (ABS. >)	D. K. UJETI	VRETEND S1	O 1236
X 300.000		S 0	N 00000000
Z 200.000		0%	T 0
C 100.000		POSUV MM/MIN.	S 0 H 0
Y 0.000 A 0.000		F 0	F 0
		0%	G00 10 40 54 00
			G97 95 69.1 13.1

01236 PROG ←

```

20 G1040 L2. J4. K0. H0. F120.
U100. E80. W2. B1. C1. Z2. A0. ;
21 M98 P902 (POCKETING FACE) ;
22 G0 X100 Z100 ;
23 T0505 ;
24 X02 Z2 S2300 M103 ;
25 G1111 I3. L-1.2 K1. C1. F120.
P0. Z11. ;
26 G1572 B0. X11. A0. C120. M3. Z1.
;
27 G0 X100 Z100 ;
28 M30 ;

```

M30: KONEC PROGRAMU

START CYKLUS KONEC

ZHENIT TVAR M KOD PEVFOR

MANUAL GUIDE *ž* MEM 15:51:38

OKAMZ. POL. (ABS.)		D. K. UJETI		VRETEND S1		O 1236	
X	300.000	G00	X 0.000	S	0	N 00000000	T 0
Z	200.000	X	Z 0.000	0%		S	0 H 0
C	100.000	Z	C 0.000	POSUV MM/MIN.		F	0
Y	0.000	Y	Y 0.000	F	0	G00 18 40 54 00	G97 95 69.1 13.1
A	0.000	A	A 0.000	0%			

NASL. UZDAL		01236 ZNAK ←	
G00	X 0.000	P0. Z11. ;	
X	Z 0.000	26 G1572 B0. X11. A0. C120. M3. Z1.	
Z	C 0.000	;	
C	Y 0.000	27 G0 X100 Z100 ;	
Y	A 0.000	28 M30 ;	
A		29 %	

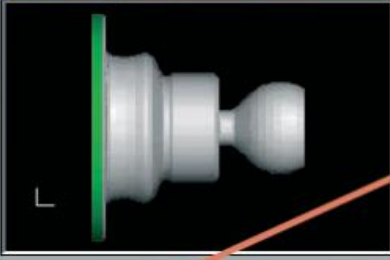
AKTUALNI OBRABENI

PREVNI SEZN EDTPDZ HLED C HLED SKUTPL PREDVD STRVYK SIMUL

MANUAL GUIDE *ž* MEM 15:52:26

OKAMZ. POL. (ABS.)		D. K. UJETI		VRETEND S1		O 1236	
X	-408.000	G00	X 0.000	S	2300	N 00000099	T 505
Z	100.000	X	Z 0.000	0%		S	2300 H 103
C	-200.000	Z	C 0.000	POSUV MM/MIN.		F	0.02000000
Y	0.000	Y	Y 0.000	F	0	G00 18 40 54 00	G96 94 69.1 13.1
A	0.000	A	A 0.000	0%			

SIMULACE-ANIMACE




01236 ZNAK ←	
1 01236 (234.987) ;	
2 G1900 D80. L75. K0. ;	
3 G0 X100 Z100 ;	
4 T0101 ;	
5 G95 G96 S200 M3 ;	
6 X02 Z1 ;	
7 G1120 P1. Q2. H100. C0.2 D0.1	
F0.2 E0.1 V0.1 K100. W2. U1.5	
L2. M2. Z10. ;	
8 M98 P901 (PROFIL02) ;	
9 G0 X02 Z1 ;	
10 G1126 P1. F0.05 L2. M2. Z10. ;	

PREVNI START PAUZA JEDNTL STOP POC. HLREZU KOLIZE BRNAST VYPSKP

MANUAL GUIDE *ž* MEM 15:53:31

OKAMZ. POL. (ABS.)		D. K. UJETI		VRETEND S1		O 1236	
X	-408.000	G00	X 0.000	S	2300	N 00000099	T 505
Z	100.000	X	Z 0.000	0%		S	2300 H 103
C	-200.000	Z	C 0.000	POSUV MM/MIN.		F	0.02000000
Y	0.000	Y	Y 0.000	F	0	G00 18 40 54 00	G96 94 69.1 13.1
A	0.000	A	A 0.000	0%			

SIMULACE-ANIMACE



01236 ZNAK ←	
1 01236 (234.987) ;	
2 G1900 D80. L75. K0. ;	
3 G0 X100 Z100 ;	
4 T0101 ;	
5 G95 G96 S200 M3 ;	
6 X02 Z1 ;	
7 G1120 P1. Q2. H100. C0.2 D0.1	
F0.2 E0.1 V0.1 K100. W2. U1.5	
L2. M2. Z10. ;	
8 M98 P901 (PROFIL02) ;	
9 G0 X02 Z1 ;	
10 G1126 P1. F0.05 L2. M2. Z10. ;	

PREVNI START PAUZA JEDNTL STOP POC. HLREZU KOLIZE BRNAST VYPSKP

NA TVORBU VÝUKOVÉHO MATERIÁLU BYL POUŽIT
VÝUKOVÝ PROGRAM FANUC MANUAL GUIDE I A
VÝKRESOVÁ DOKUMENTACE.