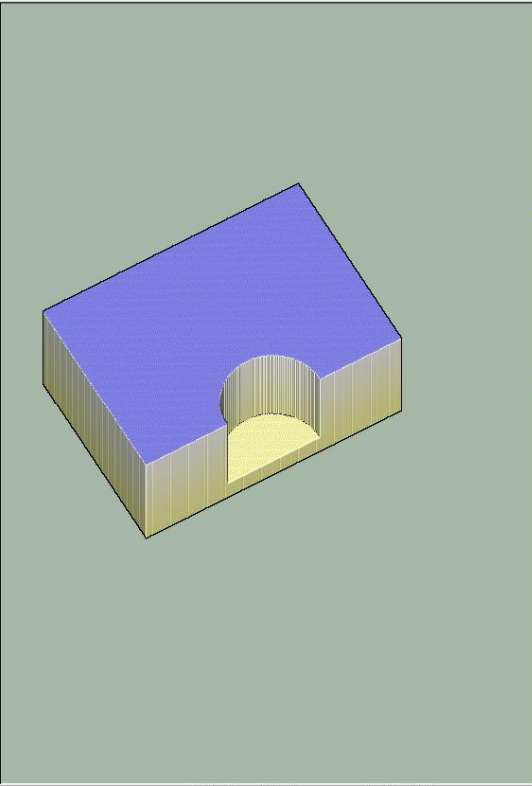


# 1. VRTÁNÍ

Ruční provoz      Test programu      iTNC 530

```
0 BEGIN PGM CYKLUS200 MM
1 BLK FORM 0.1 Z X-55 Y-45 Z-25
2 BLK FORM 0.2 X-5 Y-10 Z+0
3 STOP M0
4 ; *****VRTAK NOVEX,D=25*****
5 TOOL CALL 9 Z S2000
6 L M13
7 CYCL DEF 200 VRTANI
  Q200=+2 ;BEZPECNOSTNI VZDAL.
  Q201=-20 ;HLOUBKA
  Q206=+100 ;POSUV NA HLOUBKU
  Q202=+5 ;HLOUBKA PRISUVU
  Q210=+0 ;CAS.PRODLEVA NAHORE
  Q203=+0 ;SOURADNICE POUVRCHU
  Q204=+50 ;2. BEZPEC.VZDALENOST
  Q211=+0 ;CAS. PRODLEVA DOLE
8 CALL LBL 1
9 L Y+200 R0 FMAX M30
10 ; ** P O D P R O G R A M Y **
11 LBL 1
12 ; (DIRA,D=25,HL=20
13 L Z+100 R0 FMAX
14 L X-30 Y-45 R0 FMAX M99
15 L Z+100 R0 FMAX
16 LBL 0
17 END PGM CYKLUS200 MM
```



30 H +60 U z 0:00:23

M S T S S10% UVP ZAP S diagnostk INFO UVP MODE

STOP na START Start Po bloku RESET + START