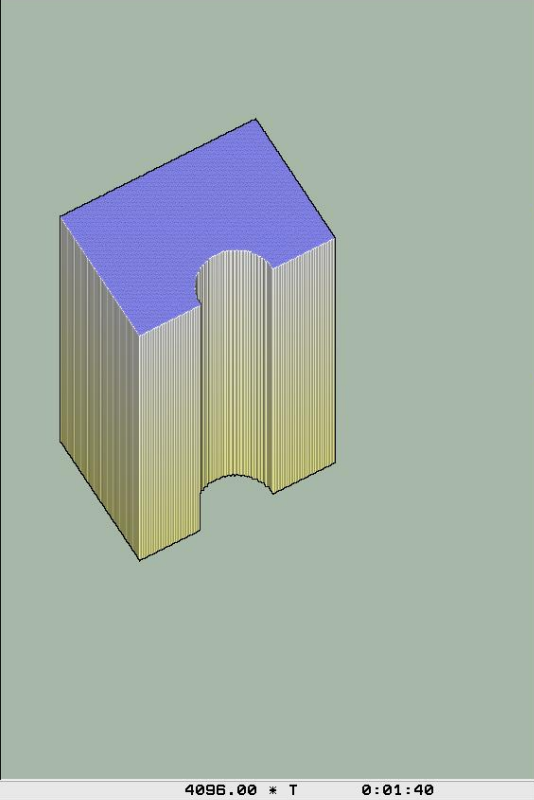











2. VRTÁNÍ S ODSKOKEM

Ruční provoz	Test programu	iTNC 530
<pre>0 BEGIN PGM CYKLUS203 MM 1 BLK FORM 0.1 Z X-55 Y-45 Z-100 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 203 UNIVERSAL-VRTANI Q200=+2 ;BEZPECNOSTNI VZDAL. Q201=-102 ;HLOUBKA Q206=+100 ;POSUV NA HLOUBKU Q202=+1 ;HLOUBKA PRISUVU Q210=+0 ;CAS.PRODLEVA NAHORE Q203=+0 ;SOURADNICE POUVRCHU Q204=+50 ;2. BEZPEC.VZDALENOST Q212=+0 ;HODNOTA ODBERU Q213=+10 ;POCET TRISEK Q205=+0 ;MIN. HLOUBKA PRISUVU Q211=+0 ;CAS. PRODLEVA DOLE Q208=+4444 ;POSUV NAVRATU Q256=+0.2 ;ODSKOK ZLOM.TRISKY 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=102 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 CYKLUS203 MM</pre>		<p>M </p> <p>S </p> <p>T </p> <p>S </p> <p>S100%  UVP ZAP</p> <p>S </p> <p>diagnostk </p> <p>INFO UVP </p> <p>MODE </p>
<p>4096.00 * T 0:01:40</p> <p>STOP na START Start Po bloku RESET + START</p>		