

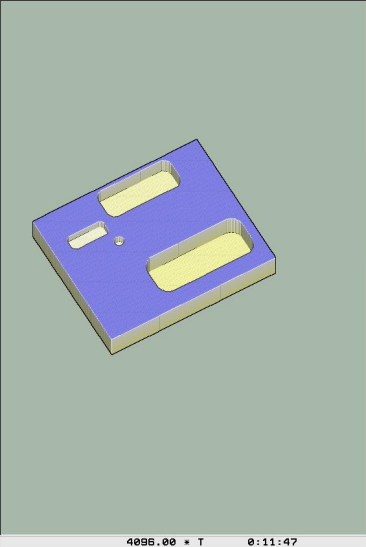
6. ZRCADLENÍ A ZMĚNA MĚŘÍTKA

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0 BEGIN PGM CYKLUS011 MM
1 ; (NULA X,Y JE OSA KUSU
2 ; (NULA Z NA HORNÍ PLOSE
3 BLK FORM 0.1 Z X-60 Y-90 Z-30
4 BLK FORM 0.2 X+120 Y+60 Z+0
5 STOP M0
6 ; *****MONOKARBID,D=8,L=20*****
7 TOOL CALL 5 Z S3000
8 L M13
9 CYCL DEF 4.0 KAPSOVE FREZOVANI
10 CYCL DEF 4.1 VZDALZ
11 CYCL DEF 4.2 HLOUBK-20
12 CYCL DEF 4.3 PRISUV3 F50
13 CYCL DEF 4.4 X+80
14 CYCL DEF 4.5 Y+33
15 CYCL DEF 4.6 F1200 DR+ POLOM10
16 CALL LBL 1
17 CALL LBL 2
18 CALL LBL 3
19 CALL LBL 4
20 L Y+250 R0 FMAX M30
21 LBL 1
22 ; (KAPSA
23 L Z+150 R0 FMAX
24 L X+45 Y+40 R0 FMAX
25 L Z+2 R0 FMAX M99
26 L Z+150 R0 FMAX
27 LBL 0
28 LBL 2
29 ; (KOPIE LBL 1
30 CYCL DEF 11.0 ZMENA MERITKA
31 CYCL DEF 11.1 SCL 0.5
32 CYCL DEF 8.0 ZRCADLENI
33 CYCL DEF 8.1 X
34 CALL LBL 1
35 CYCL DEF 8.0 ZRCADLENI
36 CYCL DEF 8.1
37 CYCL DEF 11.0 ZMENA MERITKA
38 CYCL DEF 11.1 SCL 1
39 LBL 0
40 LBL 3
41 ; (KOPIE LBL 1
42 CYCL DEF 11.0 ZMENA MERITKA
43 CYCL DEF 11.1 SCL 1.3
44 CYCL DEF 8.0 ZRCADLENI
45 CYCL DEF 8.1 Y
46 CALL LBL 1

47 CYCL DEF 8.0 ZRCADLENI
48 CYCL DEF 8.1
49 CYCL DEF 11.0 ZMENA MERITKA
50 CYCL DEF 11.1 SCL 1
51 LBL 0
52 LBL 4
53 ; (POCATEK
54 L Z+100 R0 FMAX
55 L X+0 Y+0 R0 FMAX
56 L Z+2 R0 FMAX
57 L Z-10 R0 F50
58 L Z+100 R0 FMAX
59 LBL 0
60 END PGM CYKLUS011 MM
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Ruční provoz Test programu ITNC 530

0 BEGIN PGM CYKLUS011 MM
1 ; (NULA X,Y JE OSA KUSU
2 ; (NULA Z NA HORNÍ PLOSE
3 BLK FORM 0.1 Z X-60 Y-90 Z-30
4 BLK FORM 0.2 X+120 Y+60 Z+0
5 STOP M0
6 ; *****MONOKARBID,D=8,L=20*****
7 TOOL CALL 5 Z S3000
8 L M13
9 CYCL DEF 4.0 KAPSOVE FREZOVANI
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11 CYCL DEF 4.2 HLOUBK-20
12 CYCL DEF 4.3 PRISUV3 F50
13 CYCL DEF 4.4 X+80
14 CYCL DEF 4.5 Y+33
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16 CALL LBL 1
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18 CALL LBL 3
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20 L Y+250 R0 FMAX M30
21 LBL 1
22 ; (KAPSA
23 L Z+150 R0 FMAX
24 L X+45 Y+40 R0 FMAX
25 L Z+2 R0 FMAX M99
26 L Z+150 R0 FMAX
27 LBL 0
28 LBL 2
29 ; (KOPIE LBL 1
30 CYCL DEF 11.0 ZMENA MERITKA
31 CYCL DEF 11.1 SCL 0.5
32 CYCL DEF 8.0 ZRCADLENI
33 CYCL DEF 8.1 X
34 CALL LBL 1
35 CYCL DEF 8.0 ZRCADLENI
36 CYCL DEF 8.1
37 CYCL DEF 11.0 ZMENA MERITKA
38 CYCL DEF 11.1 SCL 1
39 LBL 0
40 LBL 3
41 ; (KOPIE LBL 1
42 CYCL DEF 11.0 ZMENA MERITKA
43 CYCL DEF 11.1 SCL 1.3
44 CYCL DEF 8.0 ZRCADLENI
45 CYCL DEF 8.1 Y
46 CALL LBL 1



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STOP na START Start Po bloku RESET + START

ITNC 530 controls: M, S, T, S, S100%, UVP, ZAP, S, diagnostik, INFO UVP, MODE