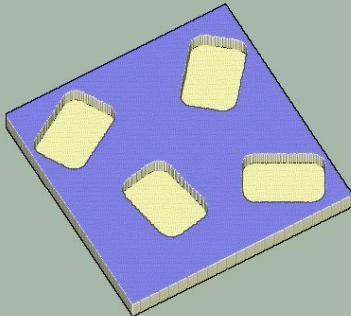


















7. KOPÍROVÁNÍ KAPSY S ROTACÍ A POSUNUTÍM

```
0 BEGIN PGM CYKLUSTRA MM
1 ; (UKAZKA NA POUZITI CYKLU
2 ; (4,7,8,10 A JEJICH KOMBINACE
3 BLK FORM 0.1 Z X-100 Y-100 Z-20
4 BLK FORM 0.2 X+100 Y+100 Z+0
5 STOP M0
6 ; *****FREZA,D=20,L=45*****
7 TOOL CALL 2 Z S250
8 L M13
9 CYCL DEF 4.0 KAPSOVE FREZOVANI
10 CYCL DEF 4.1 VZDALZ
11 CYCL DEF 4.2 HLOUBK-15
12 CYCL DEF 4.3 PRISUVS F30
13 CYCL DEF 4.4 X+65
14 CYCL DEF 4.5 Y+45
15 CYCL DEF 4.6 F200 DR+ POLOM11
16 CALL LBL 2
17 CALL LBL 3
18 CALL LBL 4
19 CALL LBL 5
20 L Y+250 R0 FMAX M30
21 LBL 1
22 ; (CENTRALNI KAPSA
23 L X+0 Y+0 Z+100 R0 FMAX
24 L Z+2 R0 FMAX M99
25 L Z+100 R0 FMAX
26 LBL 0
27 LBL 2
28 ; (1.KOPIE PRAVA HORNI
29 CYCL DEF 7.0 NULOVY BOD
30 CYCL DEF 7.1 X+60
31 CYCL DEF 7.2 Y+50
32 CYCL DEF 10.0 OTACENI
33 CYCL DEF 10.1 ROT+50
34 CALL LBL 1
35 CALL LBL 6
36 LBL 0
37 LBL 3
38 ; (2.KOPIE LEVA HORNI
39 CYCL DEF 7.0 NULOVY BOD
40 CYCL DEF 7.1 X-60
41 CYCL DEF 7.2 Y+60
42 CYCL DEF 10.0 OTACENI
43 CYCL DEF 10.1 ROT+30
44 CALL LBL 1
45 CALL LBL 6
46 LBL 0
47 LBL 4
48 ; (3.KOPIE PRAVA DOLNI
49 CYCL DEF 8.0 ZRCADLENI
50 CYCL DEF 8.1 Y
51 CYCL DEF 7.0 NULOVY BOD
52 CYCL DEF 7.1 X+60
53 CYCL DEF 7.2 Y+60
54 CYCL DEF 10.0 OTACENI
55 CYCL DEF 10.1 ROT+30
56 CALL LBL 1
57 CALL LBL 6
58 LBL 0
59 LBL 5
60 ; (4.KOPIE LEVA DOLNI
61 CYCL DEF 8.0 ZRCADLENI
62 CYCL DEF 8.1 Y
63 CYCL DEF 7.0 NULOVY BOD
64 CYCL DEF 7.1 X-30
65 CYCL DEF 7.2 Y+30
66 CYCL DEF 10.0 OTACENI
67 CYCL DEF 10.1 ROT+30
68 CALL LBL 1
69 CALL LBL 6
70 LBL 0
71 LBL 6
72 ;RUSENI TRANSFORMACI
73 CYCL DEF 7.0 NULOVY BOD
74 CYCL DEF 7.1 X+0
75 CYCL DEF 7.2 Y+0
76 CYCL DEF 10.0 OTACENI
77 CYCL DEF 10.1 ROT+0
78 CYCL DEF 8.0 ZRCADLENI
79 CYCL DEF 8.1
80 LBL 0
81 END PGM CYKLUSTRA MM
```

Ruční provoz	Test programu	iTNC 530							
<pre> 0 BEGIN PGM CYKLUSTRA MM 1 ; (UKAZKA NA POUZITI CYKLU 2 ; (4,7,8,10 A JEJICH KOMBINACE 3 BLK FORM 0.1 Z X-100 Y-100 Z-20 4 BLK FORM 0.2 X+100 Y+100 Z+0 5 STOP M0 6 ; *****FREZA,D=20,L=45***** 7 TOOL CALL 2 Z S250 8 L M13 9 CYCL DEF 4.0 KAPSOVE FREZOVANI 10 CYCL DEF 4.1 VZDAL2 11 CYCL DEF 4.2 HLOUBK-15 12 CYCL DEF 4.3 PRISUVS F30 13 CYCL DEF 4.4 X+65 14 CYCL DEF 4.5 Y+45 15 CYCL DEF 4.6 F200 DR+ POLOM11 16 CALL LBL 2 17 CALL LBL 3 18 CALL LBL 4 19 CALL LBL 5 20 L Y+250 R0 FMAX M30 21 LBL 1 22 ; (CENTRALNI KAPSA 23 L X+0 Y+0 Z+100 R0 FMAX 24 L Z+2 R0 FMAX M99 25 L Z+100 R0 FMAX 26 LBL 0 27 LBL 2 28 ; (1.KOPIE PRAVA HORNI 29 CYCL DEF 7.0 NULOvy BOD 30 CYCL DEF 7.1 X+60 31 CYCL DEF 7.2 Y+50 32 CYCL DEF 10.0 OTACENI 33 CYCL DEF 10.1 ROT+50 34 CALL LBL 1 35 CALL LBL 6 36 LBL 0 37 LBL 3 38 ; (2.KOPIE LEVA HORNI 39 CYCL DEF 7.0 NULOvy BOD 40 CYCL DEF 7.1 X-60 41 CYCL DEF 7.2 Y+60 42 CYCL DEF 10.0 OTACENI 43 CYCL DEF 10.1 ROT+30 44 CALL LBL 1 45 CALL LBL 6 46 LBL 0 </pre>	 <p style="text-align: right;">30 H +60 V z 1:26:18</p>	<div style="text-align: right;">          </div>							
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