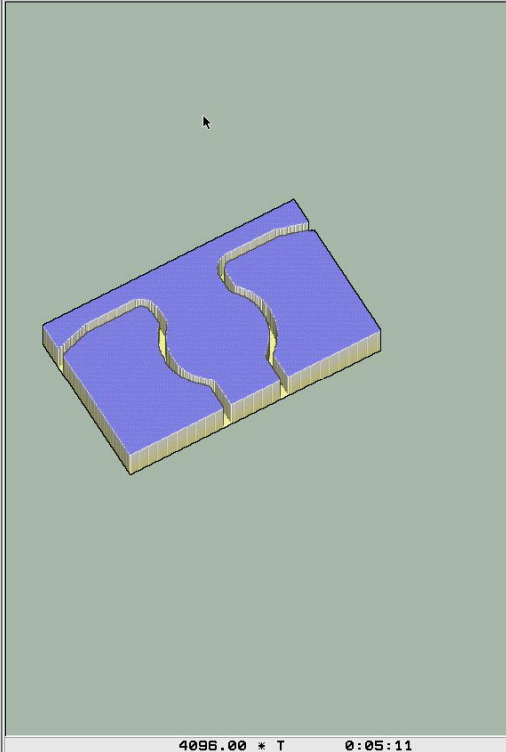



















# 9. KONTUROVÉ FRÉZOVÁNÍ SE ZRCADLENÍM

Ruční provoz	Test programu	iTNC 530						
<pre>0 BEGIN PGM CYKLUS025 MM 1 BLK FORM 0.1 Z X-100 Y-5 Z-20 2 BLK FORM 0.2 X+100 Y+115 Z+0 3 STOP M0 4 ; ***FREZA ISCAR,D=20,L=60***** 5 TOOL CALL 2 Z S3500 6 L M13 7 CYCL DEF 270 DATA TAHU KONTUROU   Q390=+2 ;ZPUSOB NAJETI   Q391=+1 ;KOREKCE RADIUSU   Q392=+5 ;RADIUS   Q393=+90 ;UHEL STREDU   Q394=+15 ;VZDALENOST 8 CYCL DEF 14.0 OBRYS 9 CYCL DEF 14.1 LBL OBRYSU1 10 CYCL DEF 25 LINIE OBRYSU   Q1=-25 ;HLOUBKA FREZOVANI   Q3=+1 ;PRIDAVEK PRO STRANU   Q5=+0 ;SOURADNICE POVRCHU   Q7=+100 ;BEZPECNA UVSKA   Q10=+10 ;HLOUBKA PRISUVU   Q11=+100 ;POSUV NA HLOUBKU   Q12=+800 ;POSUV PRO FREZOVANI   Q15=+1 ;ZPUSOB FREZOVANI 11 CYCL CALL 12 Q3 = 0 13 CYCL CALL 14 CYCL DEF 8.0 ZRCADLENI 15 CYCL DEF 8.1 X 16 Q3 = 1 17 CYCL CALL 18 Q3 = 0 19 CYCL CALL 20 L Y+100 R0 FMAX M30 21 LBL 1 22 ; OBRYS 23 CYCL DEF 7.0 NULOUVY BOD 24 CYCL DEF 7.1 X+25 25 L X+0 Y+0 RL 26 L Y+15 27 L X+5 Y+20 28 CT X+5 Y+75 29 L Y+95 30 RND R7.5 31 L X+50 32 RND R7.5 33 L X+100 Y+80</pre>	 <p>4095.00 * T 0:05:11</p>	<p>M </p> <p>S </p> <p>T </p> <p>S </p> <p>S100% </p> <p>UVP ZAP </p> <p>S </p> <p>diagnostik </p> <p>INFO UVP </p> <p>MODE </p>						
					STOP na 	START	Start Po bloku 	RESET + START

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0 BEGIN PGM CYKLUS025 MM
1 BLK FORM 0.1 Z X-100 Y-5 Z-28
2 BLK FORM 0.2 X+100 Y+115 Z+0
3 STOP M0
4 ; **FREZA ISCAR,D=20,L=60*****
5 TOOL CALL Z Z S3500
6 L M13
7 CYCL DEF 270 DATA TAHU KONTUROU
  Q390=+2 ;ZPUSOB NAJETI
  Q391=+1 ;KOREKCE RADIUSU
  Q392=+5 ;RADIUS
  Q393=+90 ;UHEL STREDU
  Q394=+15 ;VZDALENOST
8 CYCL DEF 14.0 OBRYŠ
9 CYCL DEF 14.1 LBL OBRYŠU1
10 CYCL DEF 25 LINIE OBRYŠU
  Q1=-25 ;HLOUBKA FREZOVANI
  Q3=+1 ;PRIDAVEK PRO STRANU
  Q5=+0 ;SOURADNICE POVRCHU
  Q7=+100 ;BEZPECNA VYSKA
  Q10=+10 ;HLOUBKA PRISUVU
  Q11=+100 ;POSUV NA HLOUBKU
  Q12=+800 ;POSUV PRO FREZOVANI
  Q15=+1 ;ZPUSOB FREZOVANI
11 CYCL CALL
12 Q3 = 0
13 CYCL CALL
14 CYCL DEF 8.0 ZRCADLENI
15 CYCL DEF 8.1 X
16 Q3 = 1
17 CYCL CALL
18 Q3 = 0
19 CYCL CALL
20 L Y+100 R0 FMAX M30
21 LBL 1
22 ; (OBRYŠ
23 CYCL DEF 7.0 NULOvy BOD
24 CYCL DEF 7.1 X+25
25 L X+0 Y+0 RL
26 L Y+15
27 L X+5 Y+20
28 CT X+5 Y+75
29 L Y+95
30 RND R7.5
31 L X+50
32 RND R7.5
33 L X+100 Y+80
34 CYCL DEF 7.0 NULOvy BOD
35 CYCL DEF 7.1 X+0
36 LBL 0
37 END PGM CYKLUS025 MM

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