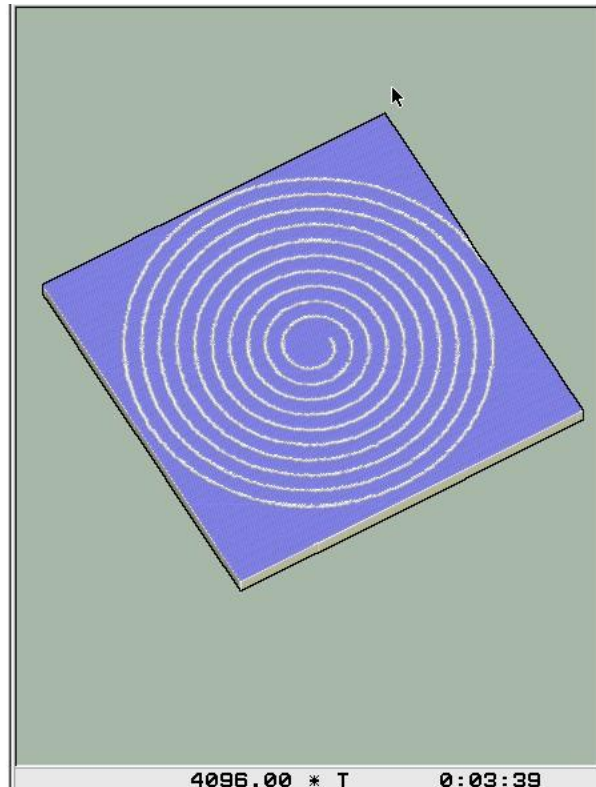


# Frézování spirály

```

0 BEGIN PGM SPIRALAIN MM
1 ; (PGM PRO POHYB PO SPIRALE IN
2 ; (POZORNE ZADAVAT PARAMETRY!!!!)
3 BLK FORM 0.1 Z X-100 Y-100 Z-10
4 BLK FORM 0.2 X+100 Y+100 Z+1
5 ; (NULA X,Y JE V OSE KUSU
6 ; (NULA Z JE NA HORNI PLOSE
7 ; *****
8 ; D E F I N I C E PARAMETRU
9 Q0 = 1000 ;POSUV
10 Q1 = 99 ;POCATECNI POLOMER
11 Q2 = 10 ;KONCOVY POLOMER
12 Q3 = 1 ;UHLOVY KROK
13 Q4 = 10 ;POCET OTACEK SPIRALY
14 Q5 = 0 ;POCATECNI UHEL
15 Q6 = 360 * Q4 ;KONCOVY UHEL
16 Q7 = 0 ;OKAMZITY UHEL
17 Q8 = ( Q1 - Q2 ) / Q6 ;DELTA R
18 Q9 = Q1 - ( Q8 * Q7 ) ;OKAMZITY R
19 ; *****
20 CYCL DEF 32.0 TOLERANCE
21 CYCL DEF 32.1 T0.02
22 STOP M0
23 ;****GRAVIROVACI HROT,D=1*****
24 TOOL CALL 20 Z S6666
25 L M3
26 ;(SPIRALA
27 CALL LBL 1
28 L Y+200 R0 FMAX M30
29 LBL 1
30 ; (SPIRALA
31 L Z+150 R0 FMAX

```



```

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2 ; (POZORNE ZADAVAT PARAMETRY!!!!)
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25 L M3
26 ;(SPIRALA
27 CALL LBL 1
28 L Y+200 R0 FMAX M30
29 LBL 1
30 ; (SPIRALA
31 L Z+150 R0 FMAX

```

```

32 L X+0 Y+0 R0 FMAX
33 L Z+1 R0 F999
34 L X+Q1 Y+0 R0 FMAX
35 L Z+0 R0 FQ0
36 LBL 3
37 Q9 = Q1 - ( Q8 * Q7 )
38 Q11 = Q9 * COS ( Q7 ) ;X
39 Q12 = Q9 * SIN ( Q7 ) ;Y
40 L X+Q11 Y+Q12 R0 FQ0
41 Q7 = Q7 + Q3
42 FN 11: IF +Q7 GT +Q6 GOTO LBL 4
43 FN 9: IF +0 EQU +0 GOTO LBL 3
44 LBL 4
45 L Z+150 R0 FMAX
46 LBL 0
47 END PGM SPIRALAIN MM

```