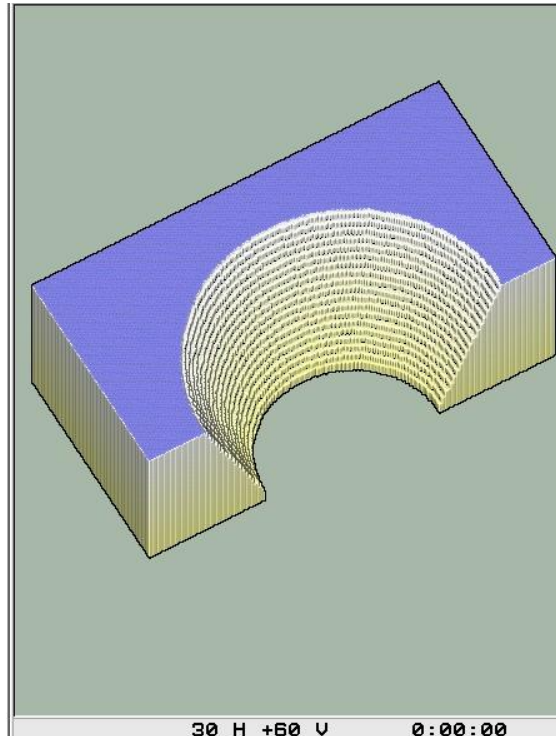


Frézování vnitřních kuželů

```
0 BEGIN PGM SKOLCONE MM
1 ; (PGM PRO VYROBU OBECEHO KUZELE
2 BLK FORM 0.1 Z X-60 Y+0 Z+0
3 BLK FORM 0.2 X+60 Y+60 Z+50
4 ; (NULA X,Y JE V OSE KUSU
5 ; (NULA Z JE NA DOLNI PLOSE
6 ; *****
7 ; D E F I N I C E PARAMETRU
8 FN 0: Q2 =+50 ; HLOUBKA KUZELE
9 FN 0: Q3 =+45 ; HORNÍ POLOMER
10 FN 0: Q4 =+25 ; DOLNI POLOMER
11 FN 3: Q9 =+Q4 * +2 ; DOLNI D
12 ; *****
13 CYCL DEF 32.0 TOLERANCE
14 CYCL DEF 32.1 T0.02
15 CALL LBL 81
16 LBL 81
17 STOP M0
18 ; *****VRTAK,D=32,LL=100*****
19 TOOL CALL 11 Z S1600
20 L M13
21 CYCL DEF 200 VRTANI
  Q200=+2 ;BEZPECNOSTNI VZDAL.
  Q201=-Q2 ;HLOUBKA
  Q206=+150 ;POSUV NA HLOUBKU
  Q202=+5 ;HLOUBKA PRISUVU
  Q210=+0 ;CAS.PRODLEVA NAHORE
  Q203=+Q2 ;SOURADNICE POVRCHU
  Q204=+50 ;2. BEZPEC.VZDALENOST
  Q211=+0 ;CAS. PRODLEVA DOLE
22 CALL LBL 1
23 LBL 82
```



```
24 STOP M0
25 ; ****FREZA PRAMET,D=25,LL=80***
26 TOOL CALL 12 Z S2000
27 L M13
28 ; (PRUCHOZI DIRA,D=Q9
29 CYCL DEF 208 FREZOVANI DIRY
  Q200=+2 ;BEZPECNOSTNI VZDAL.
  Q201=-Q2 ;HLOUBKA
  Q206=+1000 ;POSUV NA HLOUBKU
  Q334=+2 ;HLOUBKA PRISUVU
  Q203=+Q2 ;SOURADNICE POVRCHU
  Q204=+50 ;2. BEZPEC.VZDALENOST
  Q335=+Q9 ;ZADANY PRUMER
  Q342=+30 ;PRUMER PREDVRTANI
30 CALL LBL 1
31 ; (HRUB KUZELE
32 FN 0: Q0 =+1000
33 FN 0: Q1 =+12.5
34 FN 0: Q5 =+15
35 FN 0: Q6 =+5
36 FN 0: Q7 =+2
37 CALL LBL 2
38 ; (KUZEL SKORO CISTO
39 FN 0: Q0 =+1000
40 FN 0: Q1 =+12.5
41 FN 0: Q5 =+20
42 FN 0: Q6 =+5
43 FN 0: Q7 =+0.5
44 CALL LBL 2
```

```

45 LBL 83
46 STOP M0
47 ; *FREZA ISCAR,D=20,R=10,LL=80**
48 TOOL CALL 13 Z S8000
49 L M13
50 ; (KUZEL CISTO
51 FN 0: Q0 =+2000
52 CALL LBL 5
53 TOOL CALL 13 Z DL-Q33
54 FN 0: Q1 =+Q31 ; AKTIVNI CR
55 ; (PRI DANEM UHLU KUZELE JE TO
56 ; (MIRA,KDE SE TOOL DOTYKA KUSU
57 ; (Q33 JE POSUN SPICKY DOLU
58 FN 0: Q5 =+50
59 FN 0: Q6 =+2
60 FN 0: Q7 =+0.05 ; NA ZAMECNIKA
61 CALL LBL 2
62 L Y+200 R0 FMAX M30
63 LBL 1
64 ; (DIRA DO KUZELE
65 L Z+150 R0 FMAX
66 L X+0 Y+0 R0 FMAX M99
67 L Z+150 R0 FMAX
68 LBL 0
69 LBL 2
70 ; (FREZOVANI KUZELE
71 L Z+150 R0 FMAX
72 L X+0 Y+0 R0 FMAX
73 L Z+Q2 R0 F999
74 FN 1: Q8 =+Q1 + +Q7
75 FN 3: Q11 =+360 * +Q5
76 FN 0: Q12 =+0
77 Q12 = Q12 - Q6
78 Q13 = Q12 + Q6
79 LBL 3
80 Q13 = Q13 + Q6
81 Q14 = ( Q13 * Q2 ) / Q11
82 Q15 = Q3 - Q14 * ( Q3 - Q4 ) / Q2
83 Q16 = Q15 - Q8
84 Q17 = Q16 * COS ( Q13 ) ; X
85 Q18 = Q16 * SIN ( Q13 ) ; Y
86 Q19 = Q2 - Q14 ; Z
87 L X+Q17 Y+Q18 Z+Q19 R0 FQ0
88 FN 1: Q13 =+Q13 + +Q6
89 FN 11: IF +Q13 GT +Q11 GOTO LBL 4
90 FN 9: IF +0 EQU +0 GOTO LBL 3
91 LBL 4
92 L Z+150 R0 FMAX
93 LBL 0
94 LBL 5
95 ; (VYPOCET UHLU KUZELE A CR AKT
96 Q30 = ATAN ( ( Q3 - Q4 ) / Q2 )
97 Q31 = Q108 * COS ( Q30 ) ; AKT CR
98 Q32 = Q108 * SIN ( Q30 )
99 Q33 = Q108 - Q32 ; POSUN Z
100 END PGM SKOLCONE MM

```