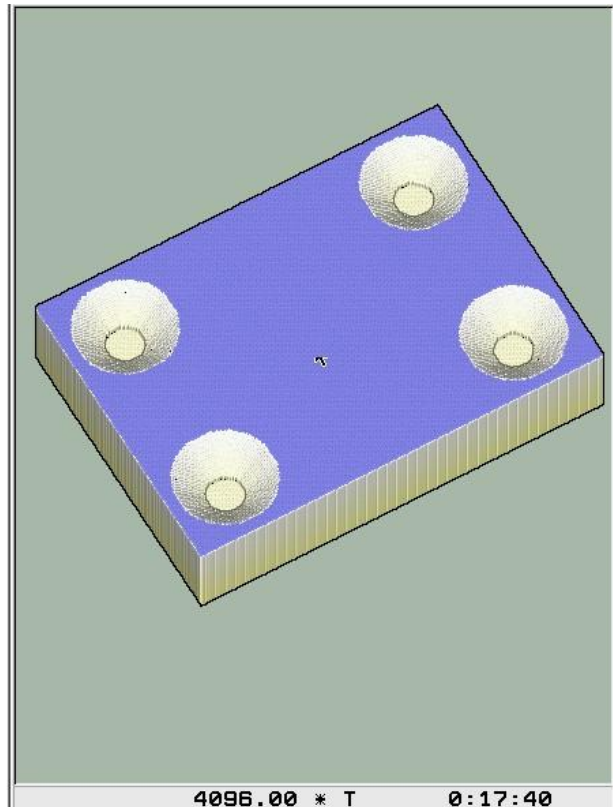


Kuželové sražení

```

0 BEGIN PGM TAWESCON E MM
1 ; (PGM PRO KUZELOVE SRAZENI
2 BLK FORM 0.1 Z X-70 Y-50 Z-30
3 BLK FORM 0.2 X+70 Y+50 Z+0
4 ; (NULA X,Y JE V OSE KUSU
5 ; (NULA Z JE NA HORN I PLOSE
6 ; *****
7 ; D E F I N I C E P A R A M E T R U
8 FN 0: Q2 =+12 ; HLOUBKA KUZELE
9 FN 0: Q3 =+16 ; HORN I P O L O M E R
10 FN 0: Q4 =+4 ; D O L N I P O L O M E R
11 ; *****
12 CYCL DEF 32.0 TOLERANCE
13 CYCL DEF 32.1 T0.02
14 STOP M0
15 ; *****FREZA TK,D=8,LL=30***
16 TOOL CALL 5 Z S5555 DL+5
17 L M13
18 ; (KUZEL SKORO CISTO
19 FN 0: Q0 =+1000 ;POSUV
20 FN 0: Q1 =+Q108 ;AKTIVNI CR
21 FN 0: Q5 =+25 ;POCET OT.SPIRALY
22 FN 0: Q6 =+10 ;KROK UHLU OBVODU
23 FN 0: Q7 =+0 ;PRIDAVEK NACISTO
24 CALL LBL 6
25 TOOL CALL 5
26 Q5 = 100
27 Q6 = 1
28 CALL LBL 6
29 L Y+200 R0 FMAX M30
30 LBL 2
31 ; (FREZOVANI KUZELE

```



```

0 BEGIN PGM TAWESCON E MM
1 ; (PGM PRO KUZELOVE SRAZENI
2 BLK FORM 0.1 Z X-70 Y-50 Z-30
3 BLK FORM 0.2 X+70 Y+50 Z+0
4 ; (NULA X,Y JE V OSE KUSU
5 ; (NULA Z JE NA HORN I PLOSE
6 ; *****
7 ; D E F I N I C E P A R A M E T R U
8 FN 0: Q2 =+12 ; HLOUBKA KUZELE
9 FN 0: Q3 =+16 ; HORN I P O L O M E R
10 FN 0: Q4 =+4 ; D O L N I P O L O M E R
11 ; *****
12 CYCL DEF 32.0 TOLERANCE
13 CYCL DEF 32.1 T0.02
14 STOP M0
15 ; *****FREZA TK,D=8,LL=30***
16 TOOL CALL 5 Z S5555 DL+5
17 L M13
18 ; (KUZEL SKORO CISTO
19 FN 0: Q0 =+1000 ;POSUV
20 FN 0: Q1 =+Q108 ;AKTIVNI CR
21 FN 0: Q5 =+25 ;POCET OT.SPIRALY
22 FN 0: Q6 =+10 ;KROK UHLU OBVODU
23 FN 0: Q7 =+0 ;PRIDAVEK NACISTO
24 CALL LBL 6
25 TOOL CALL 5
26 Q5 = 100
27 Q6 = 1
28 CALL LBL 6
29 L Y+200 R0 FMAX M30
30 LBL 2
31 ; (FREZOVANI KUZELE

```

```

32 L Z+150 R0 FMAX
33 L X+0 Y+0 R0 FMAX
34 L Z+0 R0 F999
35 FN 1: Q8 =+Q1 + +Q7
36 FN 3: Q11 =+360 * +Q5
37 FN 0: Q12 =+0
38 Q12 = Q12 - Q6
39 Q13 = Q12 + Q6
40 LBL 3
41 Q13 = Q13 + Q6
42 Q14 = ( Q13 * Q2 ) / Q11
43 Q15 = Q3 - Q14 * ( Q3 - Q4 ) / Q2
44 Q16 = Q15 - Q8
45 Q17 = Q16 * COS ( Q13 ) ; X
46 Q18 = Q16 * SIN ( Q13 ) ; Y
47 Q19 = 0 - Q14 ; Z
48 L X+Q17 Y+Q18 Z+Q19 R0 FQ0
49 FN 1: Q13 =+Q13 + +Q6
50 FN 11: IF +Q13 GT +Q11 GOTO LBL 4
51 FN 9: IF +0 EQU +0 GOTO LBL 3
52 LBL 4
53 L Z+150 R0 FMAX
54 LBL 0
55 LBL 6
56 ;(KOPIE LBL 2
57 CYCL DEF 7.0 NULOVY BOD
58 CYCL DEF 7.1 X-50
59 CYCL DEF 7.2 Y-30
60 CALL LBL 2
61 CYCL DEF 7.0 NULOVY BOD
62 CYCL DEF 7.1 X-50
63 CYCL DEF 7.2 Y+30

64 CALL LBL 2
65 CYCL DEF 7.0 NULOVY BOD
66 CYCL DEF 7.1 X+50
67 CYCL DEF 7.2 Y+30
68 CALL LBL 2
69 CYCL DEF 7.0 NULOVY BOD
70 CYCL DEF 7.1 X+50
71 CYCL DEF 7.2 Y-30
72 CALL LBL 2
73 CYCL DEF 7.0 NULOVY BOD
74 CYCL DEF 7.1 X+0
75 CYCL DEF 7.2 Y+0
76 LBL 0
77 LBL 50
78 ; (POPIS PARAMETRU
79 ; (DEFINICNI PARAMETRY
80 ; (Q0=POSUV
81 ; (Q1=AKTIVNI POLOMER FREZY
82 ; (Q2=HLOUBKA KUZELE
83 ; (Q3=HORNI POLOMER
84 ; (Q4=DOLNI POLOMER
85 ; (Q5=POCET OTACEK SPIRALY
86 ; (Q6=KROK UHLU PO OBVODE
87 ; (Q7=PRIDAVEK NA HRUBOVANI
88 ; (VYPOCTOVE PARAMETRY
89 ; (Q8=Q1+Q7 REALNY CR
90 ; (Q11=360*Q5 KONECNY UHEL
91 ; (Q12=0 POCATECNI UHEL
92 ; (Q13=X OKAMZITY UHEL
93 ; (Q14=(Q13*Q2)/Q11 TIME DEPTH
94 ; (Q15=Q3-Q14*(Q3-Q4)/Q2 TIME CR
95 ; (Q16=Q15-Q8 TIME CR

96 LBL 0
97 END PGM TAWESCONE MM

```