

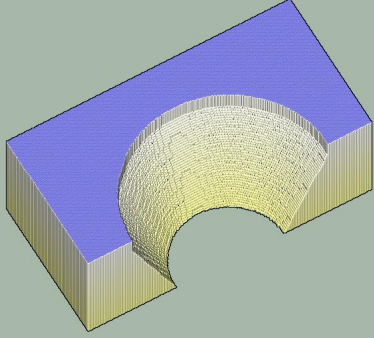
Výroba obecného kužele

Ruční provoz

Test programu

```

0 BEGIN PGM CONE-SRAZ-CR-R 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 =+40 ; HORNÍ POLOMER
10 FN 0: Q4 =+18 ; 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 STOP M0
16 ; *FREZA ISCAR,D=20,R=10,LL=80**
17 TOOL CALL 13 Z S8000
18 L M13
19 ; (KUZELE CISTO
20 FN 0: Q0 =+2000
21 CALL LBL 5
22 TOOL CALL 13 Z DL-Q33
23 FN 0: Q1 =+Q31 ; AKTIVNI CR
24 ; (PRI DANEM UHLU KUZELE JE TO
25 ; (MIRA,KDE SE TOOL DOTYKA KUSU
26 ; (Q33 JE POSUN SPICKY DOLU
27 FN 0: Q5 =+50
28 FN 0: Q6 =+2
29 FN 0: Q7 =+0.05 ; NA ZAMECNIKA
30 CALL LBL 2
31 L Y+200 R0 FMAX M30
32 LBL 1
33 ; (DIRA DO KUZELE
34 L Z+150 R0 FMAX
35 L X+0 Y+0 R0 FMAX M99
36 L Z+150 R0 FMAX
37 LBL 0
38 LBL 2
39 ; (FREZOVANI KUZELE
40 L Z+150 R0 FMAX
41 L X+0 Y+0 R0 FMAX
42 L Z+Q2 R0 F999
43 FN 1: Q8 =+Q1 + +Q7
44 FN 3: Q11 =+360 * +Q5
45 FN 0: Q12 =+0
46 Q12 = Q12 - Q6
                    
```



30 H +60 V 0:02:51

ITNC 530

M

S

T

S

S100%

UVP ZAP

S

diagnostk

INFO UVP

MODE

RESET + START

```

0 BEGIN PGM CONE-SRAZ-CR-R 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
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12 ; *****
13 CYCL DEF 32.0 TOLERANCE
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27 FN 0: Q5 =+50
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30 CALL LBL 2
31 L Y+200 R0 FMAX M30
32 LBL 1
33 ; (DIRA DO KUZELE
34 L Z+150 R0 FMAX
35 L X+0 Y+0 R0 FMAX M99
36 L Z+150 R0 FMAX
37 LBL 0
38 LBL 2
39 ; (FREZOVANI KUZELE
40 L Z+150 R0 FMAX
41 L X+0 Y+0 R0 FMAX
42 L Z+Q2 R0 F999
43 FN 1: Q8 =+Q1 + +Q7
44 FN 3: Q11 =+360 * +Q5
45 FN 0: Q12 =+0
46 Q12 = Q12 - Q6
                    
```

```

47 Q13 = Q12 + Q6
48 LBL 3
49 Q13 = Q13 + Q6
50 Q14 = ( Q13 * Q2 ) / Q11
51 Q15 = Q3 - Q14 * ( Q3 - Q4 ) / Q2
52 Q16 = Q15 - Q8
53 Q17 = Q16 * COS ( Q13 ) ; X
54 Q18 = Q16 * SIN ( Q13 ) ; Y
55 Q19 = Q2 - Q14 ; Z
56 L X+Q17 Y+Q18 Z+Q19 R0 FQ0
57 FN 1: Q13 =+Q13 + +Q6
58 FN 11: IF +Q13 GT +Q11 GOTO LBL 4
59 FN 9: IF +0 EQU +0 GOTO LBL 3
60 LBL 4
61 L Z+150 R0 FMAX
62 LBL 0
63 LBL 5
64 ; (VYPOCET UHLU KUZELE A CR AKT
65 Q30 = ATAN ( ( Q3 - Q4 ) / Q2 )
66 Q31 = Q108 * COS ( Q30 ) ; AKT CR
67 Q32 = Q108 * SIN ( Q30 )
68 Q33 = Q108 - Q32 ; POSUN Z
69 LBL 0
70 END PGM CONE-SRAZ-CR-R MM

```