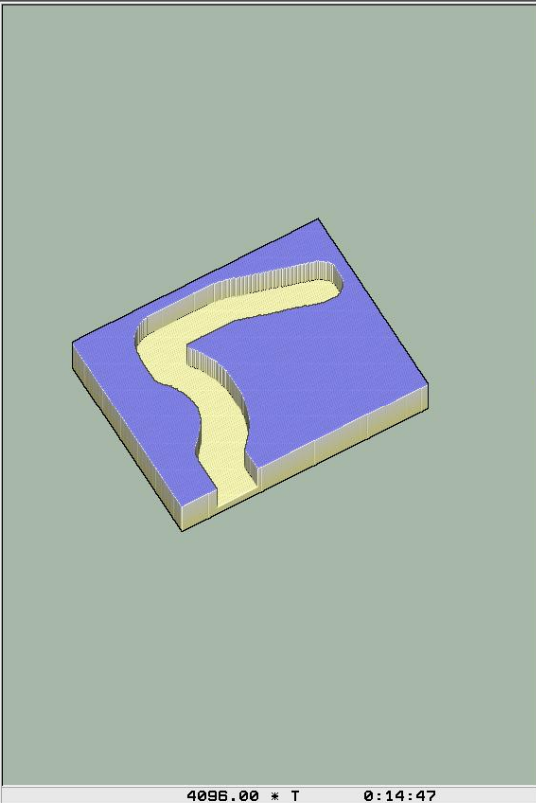



















Trochoidální drážka

Ruční provoz	Test programu	iTNC 530
<pre>0 BEGIN PGM CYKLUS275 MM 1 BLK FORM 0.1 Z X-35 Y-5 Z-28 2 BLK FORM 0.2 X+120 Y+115 Z+0 3 STOP M0 4 ; ***FREZA ISCAR,D=20,L=60***** 5 TOOL CALL 2 Z S3500 6 L M13 7 L X+0 Y-50 R0 FMAX 8 CYCL DEF 14.0 OBRVS 9 CYCL DEF 14.1 LBL OBRYSU1 10 CYCL DEF 275 TROCHOIDALNI DRAZKA Q215=+0 ;ZPUSOB OBRABENI Q219=+26 ;SIRKA DRAZKY Q368=+0.5 ;PRIDAVEK PRO STRANU Q436=+3 ;PRISUV NA OTACKU Q207=+1400 ;FREZOVACI POSUV Q351=+1 ;ZPUSOB FREZOVANI Q201=-20 ;HLOUBKA Q202=+5 ;HLOUBKA PRISUVU Q206=+150 ;POSUV NA HLOUBKU Q330=+10 ;PRISUV NA CISTO Q385=+2000 ;POSUV NACISTO Q200=+2 ;BEZPECNOSTNI VZDAL. Q203=+0 ;SOURADNICE POVRCHU Q204=+50 ;Z. BEZPEC.VZDALENOST Q366=+2 ;ZANOROVANI 11 CYCL CALL 12 L Y+100 R0 FMAX M30 13 LBL 1 14 ; OBRVS 15 APPR LT X+0 Y-10 LEN10 R0 F300 16 L X+0 Y+0 17 L Y+15 18 L X+5 Y+20 19 CT X+5 Y+75 20 L Y+95 21 RND R7.5 22 L X+50 23 RND R7.5 24 L X+100 Y+80 25 LBL 0 26 END PGM CYKLUS275 MM</pre>	 <p>4096.00 * T 0:14:47</p>	<p>M </p> <p>S </p> <p>T </p> <p>S </p> <p>S100% </p> <p>UVP ZAP </p> <p>S </p> <p>diagnostk </p> <p>INFO UVP </p> <p>MODE </p>
  		<p>START </p> <p>Start Po bloku </p> <p>RESET + START </p>