

Řádkování koule

Ruční provoz
Test programu
ITNC 530

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0 BEGIN PGM CPKOULE-ALL-T MM
1 ;(RADKOVANI KOULE V POLARNIM SS
2 ;(PROGRAM PRO LIBOVOLNOU FREZU
3 BLK FORM 0.1 Z X-50 Y-50 Z-60
4 BLK FORM 0.2 X+50 Y+50 Z+0
5 ;NULA X,Y JE V OSE POLOKOULE
6 ;NULA Z JE NA HORNÍ PLOSE
7 ;*****
8 ; DEFINICNI PARAMETRY
9 Q1 = 50 ;POLOMER KOULE
10 Q2 = 1 ;RADKOVACI KROK
11 Q6 = 90 ;KONCOVY UHEL KOULE
12 ;*****
13 STOP M0
14 ;*****FREZA,D=20,R=10,L=60*****
15 TOOL CALL 13 Z S2000
16 L M13
17 Q0 = 1000
18 CALL LBL 1
19 L Y+200 R0 FMAX M2
20 LBL 1
21 ;(RADKOVANI KOULE
22 FN 18: SYSREAD Q7 = ID50 NR3
23 L Z+100 R0 FMAX
24 L X+0 Y+10 R0 FMAX
25 L Z+25 R0 FMAX
26 Q3 = Q100 - Q7 ;POSUN STREDU
27 Q4 = 0
28 ;(PREPOCET DELKY NA STRED KOULE
29 CVCL DEF 7.0 NULOvy BOD
30 CVCL DEF 7.1 Z-Q7
31 L X+Q3 FQ0
32 L Z+Q7 R0 FQ0
33 CALL LBL 2
34 L Z+100 R0 FMAX
35 LBL 0
36 LBL 2
37 ;(VLASTNI DRAHA
38 LBL 3
39 Q4 = Q4 + Q2
40 FN 11: IF +Q4 GT +Q6 GOTO LBL 4
41 CC X+Q3 Z-Q1
42 CP PA+Q4 DR+
43 L Y+0
44 CC X+0 Y+0
45 CP PA+0 DR-
46 L Y-10
47 L IX+10
48 L IY+20
49 L IX-10
50 FN 9: IF +0 EQU +0 GOTO LBL 3
51 LBL 4
52 L Z+10 R0 FMAX
53 LBL 0
54 END PGM CPKOULE-ALL-T MM
                    
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M

S

T

S

S100%

UVP ZAP

S

diagnostik

INFO UVP

MODE

30 H +60 U Z
0:31:32

STOP
na

START

Start
Po bloku

RESET
START

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52 L Z+10 R0 FMAX
53 LBL 0
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