Frézování řetězového kola

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0   BEGIN PGM ROZETA-ZUBY MM
1   ;OBECNY PROGRAM PRO VYROBU ROZET
2   ;PGM PRO ROZETY S VICE NEZ 16 Z
3   ;*****DEFINICE PARAMETRU*****
4   Q1 = 45 ;POCET ZUBU
5   Q2 = 8.5 ;PRUMER VALECKU
6   Q3 = 12.7 ;ROZTEC ZUBU
7   Q4 = 1 / ( SIN ( 180 / Q1 ) ) ;X
8   Q5 = Q3 * Q4 ;ROZTECNY PRUMER
9   Q6 = Q5 + 0.5 * Q2 ;VNEJSI PRUMER
10  Q7 = 0.004 * Q3 + 0.15 ;PLOSKA
11  Q8 = 0.503 * Q2 ;POLOMER R1
12  Q9 = 1.3 * Q2 ;POLOMER R2
13  Q10 = Q5 - Q2 - 0.07 ;PATNI D
14  Q21 = Q5 / 2 ;R ROZTECNE KRUZNICE
15  Q22 = 360 / Q1 ;UHLOVA ROZTEC
16  Q24 = Q6 / 2 ;VNEJSI R
17  Q31 = Q10 / 2 ;PATNI R
18  Q24 = Q6 / 2 ;VNEJSI R
19  Q25 = Q31 + 0.18 * Q2 ;BOD TECEN
20  Q26 = Q7 / 2 ;1/2 PLOSKU U DNA
21  Q27 = Q31 + Q8 ;CCY R1
22  Q32 = Q24 + 15 ;NAJIZDECI R
23  ;****************************
24  ;(STREDNI DIRA A DIRY PRO SROUBY
25  ;(NUTNO UPRAVIT DLE KUSU
26  ;****************************
27  BLK FORM 0.1 Z  X-110  Y-110  Z-15
28  BLK FORM 0.2  X+110  Y+110  Z+0
29  STOP M0
30  ;******TK VRTAK;D=8;L=40******
31  TOOL CALL 4 Z S6000
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32 L M13
33 CYCL DEF 200 VRTANI
   Q200=+2      ;BEZPECNOSTNI VZDAL.
   Q201=-14     ;HLOUBKA
   Q206=+150    ;POSUV NA HLOUBKU
   Q202=+5      ;HLOUBKA PRISUVU
   Q210=+0      ;CAS.PRODLEVA NAHORE
   Q203=+0      ;SOURADNICE POVRCHU
   Q204=+50     ;2. BEZPEC.VZDALENOST
   Q211=+0      ;CAS. PRODLEVA DOLE
34 CALL LBL 1
35 STOP M0
36 ;******MONOKARBID,D=20,L=36****
37 TOOL CALL 2 Z S5000
38 L M13
39 Q0 = 2000
40 CALL LBL 4
41 LBL 81
42 STOP M0
43 ;******MONOKARBID,D=6,L=16****
44 TOOL CALL 3 Z S14000 DR+0.2
45 L M13
46 Q0 = 2000
47 CALL LBL 7


47 CALL LBL 7
48 TOOL CALL 3
49 CALL LBL 6
50 L   Y+200 R0 FMAX M2
51 LBL 1
52 ;(JEDNA DIRA A KOPIE
53 L   Z+100 R0 FMAX
54 Q23 = 90
55 CC  X+0   Y+0
56 LBL 3
57 LP  PR+Q21  PA+Q23 R0 FMAX M99
58 Q23 = Q23 + Q22
59 FN 11: IF +Q23 GT +450 GOTO LBL 2
60 FN 9: IF +Q23 EQU +450 GOTO LBL 2
61 FN 9: IF +0 EQU +0 GOTO LBL 3
62 LBL 2
63 L   Z+100 R0 FMAX
64 LBL 0
65 LBL 4
66 ;(OBJETI KRUHU
67 L   Z+100 R0 FMAX
68 L   X+99  Y+99 R0 FMAX
69 L   Z+10 R0 FMAX
70 L   Z-14 R0 FQ0
71 L   X+Q24  Y+99 RL FQ0
72 L   Y+0
73 CC  X+0  Y+0
74 C   X+Q24  Y+0 DR-
75 L   Y-5
76 L   Z+100 R0 FMAX
77 L   Z+100 R0 FMAX
78 LBL 0
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78 LBL 0
79 LBL 5
80 ;FREZOVANI JEDNOHO ZUBU
81 L   Z+10 R0 FMAX
82 L   X+3  Y+Q32 R0 FMAX
83 L   Z-1 R0 FMAX
84 L   Z-10 R0 FQ0
85 FL  AN+180 RL
86 FL  AN-60
87 FCT DR+  Y+Q25 RQ9
88 FCT DR+ RQ8  Y+Q31   CCX-Q26
     CCY+Q27
89 FSELECT2
90 FLT  AN+0  X+Q26
91 FCT DR+ RQ8  Y+Q25   CCX+Q26
     CCY+Q27
92 FSELECT1
93 FCT DR+ RQ9
94 FLT  AN+60  Y+Q32
95 L   Z+10 R0 FMAX
96 LBL 0
97 LBL 6
98 ;(KOPIE LBL 5
99 Q20 = 0 ;HODNOTA UHLU
100 END PGM ROZETA-ZUBY MM
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