

%zk3.nc "TURN_V1.0"

HEADER [Hlavicka Progr.]

#MATERIAL Stahl [MATERIAL]
#MEASURE_UNITS METRIC [JEDNOTKA]
#COMMENT závit [KOMENTAR]

TURRET 1 [Revolver]

T1 ID"A-SCHR-35-08"
T2 ID"A-SCHL-35-04"
T3 ID"A-GEW-60-2"

CLAMPS [Upínač]

CLAMPS 2 [Upínač]

BLANK [Polotovár]

N 1 G20 X30 Z102 K2

FINISHED [Hotový obrobek]

N 2 G0 X0 Z0
N 3 G1 X20 BR-2
N 4 G1 Z-50

[zápich]

N 17 G25 H7 I2 K8 R0.5 W30 FP1.5

[závit]

N 25 G37 Q2 F1.5

N 5 G1 X30 Z-50

N 6 G1 Z-100

N 7 G1 X0

MACHINING [Obrábění]

N 8 G140 D1 X300 Z100

N 9 G14 D1 T1

N 10 G47 P2 G26 S3000

N 11 G96 S200

N 12 G95 F0.2 M4

N 13 G820 NS3 NE3 P2 K0.2 V3

N 14 G810 NS4 NE5 P10 I0.3 K0.1

N 15 G14 D1 T2

N 16 G96 S250 G95 F0.1

N 18 G890 NS3 NE3 V3 H3

N 18 G890 NS4 NE5 H3

[závit]

N 19 G14 D1 T3 G97 S500

N 26 M4

N 24 G31 NS4 NE4 O1 J0 I0.2 V3 BDO

N 20 UNIT ID"END" [Konec programu]

N 21 [<unit ID="END" ME="30" NS="" G14="-1" MFS="" MFE="" />]

N 22 M30

N 23 END_OF_UNIT S1223854417

END

