

%zk5.nc "TURN_V1.0"

HEADER [Hlavicka Progr.]

```
#MATERIAL      Stahl [ MATERIAL ]
#MEASURE_UNITS METRIC [ JEDNOTKA ]
#COMMENT       poháněné nástroje - čelo [ KOMENTAR ]
#COMMENT       díry na roztečné kružnici [ KOMENTAR ]
```

TURRET 1 [Revolver]

```
T1  ID"A-SCHR-35-08"
T2  ID"A-SCHL-35-04"
T3  ID"S-BOHR-6-40"
```

CLAMPS [Upínač]

CLAMPS 2 [Upínač]

BLANK [Polotovár]

```
N 1 G20 X100 Z42 K2
```

FINISHED [Hotový obrobek]

```
N 2 G0 X0 Z0
N 3 G1 X70 BR-2
N 4 G1 Z-20
N 5 G25 H6
N 6 G1 X100
N 7 G1 Z-40
N 8 G1 X0
```

FACE_C Z0 [Čelo C]

```
N 9 G308 P0
N 10 G402 Q6 K40
N 11 G300 B6 P5
N 12 G309
```

FACE_C Z-20 [Čelo C]

```
N 13 G308 P0
N 14 G402 Q12 K85
N 15 G300 B6 P21
N 16 G309
```

MACHINING [Obrábění]

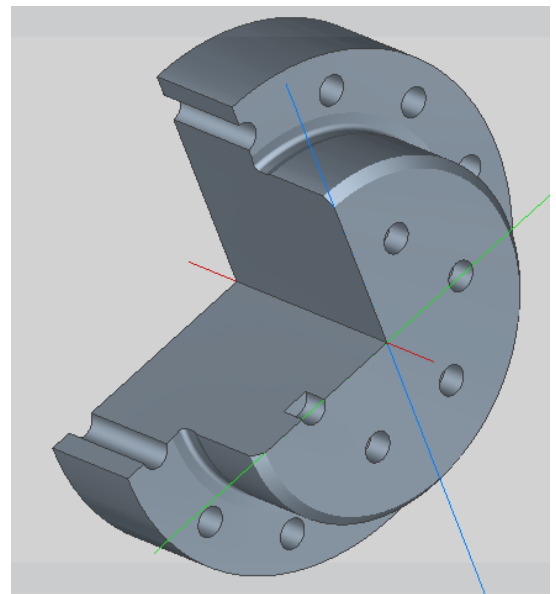
```
N 17 G140 D1 X300 Z200
```

```
N 18 G14 D1 T1
```

```
N 19 G47 P2 G26 S3000
```

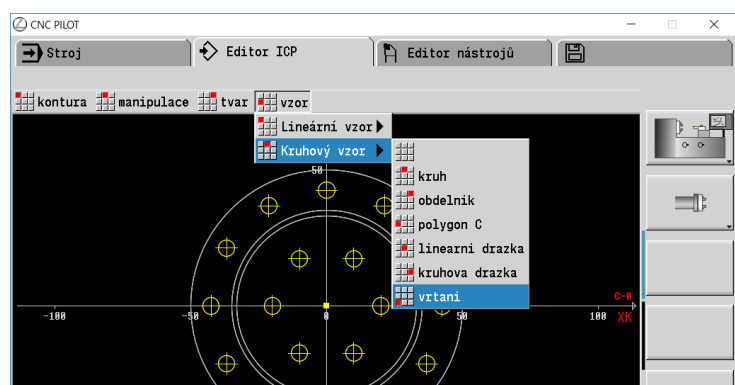
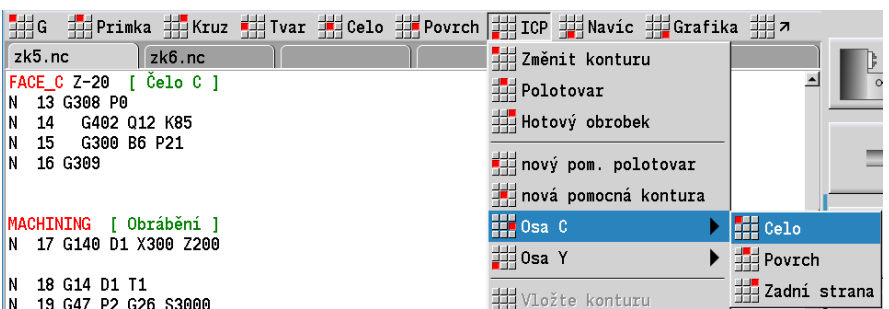
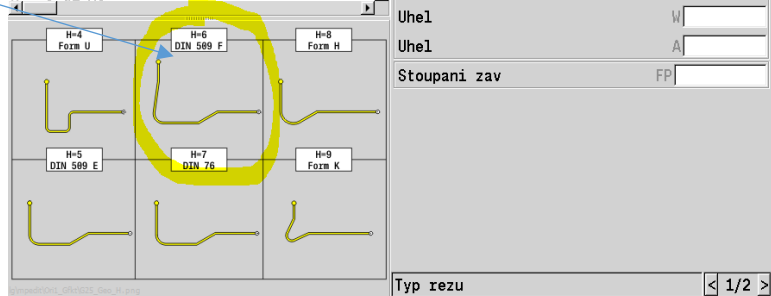
```
N 20 G96 S200
```

```
N 21 G95 F0.2 M4
```



FINISHED [Hotový obrobek]

```
N 2 G0 X0 Z0
N 3 G1 X70 BR-2
N 4 G1 Z-20
N 5 G25 H6
N 6 G1 X100
N 7 G1 Z-40
N 8 G1 X0
```



N 22 G820 NS3 NE3 P2 K0.2 V3
N 23 G810 NS4 NE6 P10 I0.3 K0.1 D1
N 24 G14 D1 T2
N 25 G96 S250 G95 F0.1
N 26 G890 NS3 NE3 V3 H3
N 27 G890 NS4 NE6 H3
N 32 M5

[obrábění na čele]

N 35 M14

Zapnutí osy C

N 33 G14 D1 T3 G197 S1000 G195 F0.2 M103

N 37 G71 NS11

N 40 G71 NS15

N 41 G14 D1 M105

N 36 M15

vypnutí osy C

Řezné podmínky

Jednod. vrtání G71	
Kontura vrt... ID	
Číslo bloku kontury	NS11
Značka polohy	HF
Poc. bod	XS
Poc. bod	ZS
Konc. bod	XE
Konc. bod	ZE
Hloubka vrt.	K
Zav/Vrt.podel.	A
Var. vyvit.	V0: bez reduk
Zpetna urov.	RB
Prodleva	E
Zpětný pohyb	D0: rychlopos
Start prv. cis	BS
Kon: prv. cis	BE
Vypnutí brzdy (1)	H

N 28 UNIT ID"END" [Konec programu]

N 29 [<unit ID="END" ME="30" NS="" G14="-1" MFS="" MFE="" />]

N 30 M30

N 31 END_OF_UNIT S4134096400

END