

%zk6.nc "TURN\_V1.0"

HEADER [ Hlavicka Progr. ]

#MATERIAL Stah [ MATERIAL ]

#MEASURE\_UNITS METRIC [ JEDNOTKA ]

#COMMENT poháněné nástroje - plášť [ KOMENTAR ]

#COMMENT díry po obvodu [ KOMENTAR ]

TURRET 1 [ Revolver ]

T1 ID"A-SCHR-35-08"

T2 ID"A-SCHL-35-04"

T3 ID"M-BOHR-5.2-20"

CLAMPS [ Upínač ]

CLAMPS 2 [ Upínač ]

BLANK [ Polotovar ]

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

[zápich]

N 5 G25 H6 I0.3 K2.5 R0.6 P0.2 W15 A8

N 6 G1 X100

N 7 G1 Z-40

N 8 G1 X0

LATERAL\_C X70 [ Plášť C ]

N 9 G308 P-10

N 10 G411 Q12 Z-10 CY0

N 11 G310 B5.2 P10 W118

N 12 G309

MACHINING [ Obrábění ]

N 13 G140 D1 X400 Z200

N 14 G14 D1 T1

N 15 G47 P2 G26 S3000

N 16 G96 S200

N 17 G95 F0.2 M4

N 18 G820 NS3 NE3 P2 K0.2 V3

N 19 G810 NS4 NE6 P10 I0.3 K0.1 D1

N 20 G14 D1 T2

N 21 G96 S250 G95 F0.1

N 22 G890 NS3 NE3 V3 H3

N 23 G890 NS4 NE6 H3

N 24 M5

[obrábění na plášti]

N 25 M14

N 26 G14 D1 T3 G197 S1000 G195 F0.2 M103

N 27 G71 NS11

N 28 G14 D1 M105

N 29 M15

N 30 UNIT ID"END" [Konec programu]

N 31 [<unit ID="END" ME="30" NS="" G14="-1" MFS="" MFE="" />]

N 32 M30

N 33 END\_OF\_UNIT S785716360

END

