

Příloha č. 6

NC kód pro inovovaný způsob výroby

%;N_SOUSTRUŽENÍ_MPF

;\$PATH=/_N_MPF_DIR

;STROJ : VLC2000

;PROGRAM : SOUSTRUŽENÍ

;TYP : SL3000

;POLOZKA :

;OPERACE :

;PROGRAMOVAL : KASPAR

;DATUM : 3.4.2017-8:14:35

;

;T1 STRANOVY D1 R0.4

;T2 TU_INTE-LL06C2M-QP12 D1 R0.4

N10 M65

N20 T1 ;Nožová_hlava ;STRANOVY

N30 M6

N40 D1

N50 G90 G95

N60 M1=42

N70 G96 S1=310 M1=3 M8

N80 LIMS=200

N90 M50 ;(OPLACH)

N100 G0 X240.8 Z0.9

N110 G1 X117.2 F.4

N120 X121.2 Z2.9 F.4

N130 X124.028 Z4.314 F.4
N140 M50 ;(OPLACH)
N150 G0 G42 X235.8 Z5.5
N160 G1 Z-16 F.4
N170 G40 X240.6 F.4
N180 S1=300
N190 M50 ;(OPLACH)
N200 G0 X239.8 Z-1.6
N210 G1 X199.8 F.4
N220 X202.628 Z-0.186 F.4
N230 G0 X239.8
N240 G0 Z-4.1
N250 G1 X199.8 F.4
N260 X202.628 Z-2.686 F.4
N270 G0 X239.8
N280 G0 Z-6.6
N290 G1 X199.8 F.4
N300 X202.628 Z-5.186 F.4
N310 G0 Z-4.752
N320 G0 X237.331
N330 G1 X235.8 Z-6.6 F.4
N340 X235 F.4
N350 X199.8 F.4
N360 Z0.9 F.4
N370 X202.628 Z2.314 F.4
N380 S1=340
N390 M50 ;(OPLACH)
N400 G0 X203.8 Z0.4
N410 G1 X117.2 F.22
N420 X118.2 Z0.9 F.22

N430 X121.028 Z2.314 F.22
N440 S1=420
N450 M50 ;(OPLACH)
N460 G0 G42 X191.323 Z5.798
N470 G2 X191.323 Z2.404 CR=2.4 F.11
N480 G1 X198.8 Z-1.334 F.11
N490 Z-7.1 F.11
N500 X230.331 F.11
N510 X234.8 Z-9.334 F.11
N520 Z-16 F.11
N530 G40 X239.6 F.11
N540 M51
N550 M1=5 M9
N560 T2 ;Nožová_hlava ;TU_INTE-LL06C2M-QP12
N570 M6
N580 D2
N590 G90 G95
N600 G0 X142.274 Z23.355 M8
N610 M1=42
N620 S1=300 M1=3
N630 LIMS=200
N640 M50 ;(OPLACH)
N650 G0 X120.7 Z2.4
N660 G1 Z-30.9 F.3
N670 G0 X117.2
N680 G0 Z2.4
N690 G0 X124.2
N700 G1 Z-30.9 F.3
N710 G0 X120.7
N720 G0 Z2.4

N730 G0 X127.7
N740 G1 Z-5.627 F.3
N750 X126.7 Z-6.127 F.3
N760 Z-30.9 F.3
N770 Z-28.9 F.3
N780 G0 X142.274 Z23.355
N790 M50 ;(OPLACH)
N800 G0 X123.7 Z-1.609
N810 G1 X139.2 F.3
N820 Z0 F.3
N830 Z0.4 F.3
N840 X134.4 F.3
N850 G0 X123.7
N860 G0 Z-3.618
N870 G1 X139.2 F.3
N880 Z-1.609 F.3
N890 X134.4 F.3
N900 G0 X123.7
N910 G0 Z-5.627
N920 G1 X127.7 F.3
N930 X130.754 Z-4.1 F.3
N940 X139.2 F.3
N950 Z-3.618 F.3
N960 Z-1.618 F.3
N970 M50 ;(OPLACH)
N980 G0 X135.2 Z-0.6
N990 G1 X174.2 F.2
N1000 Z0 F.2
N1010 Z0.4 F.2
N1020 X171.372 Z1.814 F.2

N1030 M50 ;(OPLACH)
N1040 G0 G41 X150 Z-0.6
N1050 G3 X149 Z-1.1 CR=.5 F.2
N1060 G1 X146.786 F.2
N1070 X140.2 Z-3.001 F.2
N1080 Z-4.5 F.2
N1090 G3 X140 Z-4.6 CR=.1 F.079
N1100 G1 X131.169 F.2
N1110 X127.934 Z-6.217 F.2
N1120 G40 X124.54 Z-4.52 F.2
N1130 M51
N1140 M1=5 M9
N1150 M30

%;_N_SOUSTRUŽENÍ-2_MPF

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; STROJ : VLC2000
; PROGRAM : SOUSTRUŽENÍ-2
; TYP : SL3000
; POLOZKA :
; OPERACE :
; PROGRAMOVAL : KASPAR
; DATUM : 3.4.2017-8:17:51

;

;T1 STRANOVY D1 R0.4
;T2 TU_INTE-LL06C2M-QP12 D1 R0.4

N10 M65

N20 T1 ;Nožová_hlava ;STRANOVY

N30 M6

N40 D1

N50 G90 G95

N60 M1=42

N70 G96 S1=310 M1=3 M8

N80 LIMS=200

N90 M50 ;(OPLACH)

N100 G0 X240.8 Z0.9

N110 G1 X126.7 F.4

N120 X130.7 Z2.9 F.4

N130 X133.528 Z4.314 F.4

N140 M50 ;(OPLACH)

N150 G0 X234.8 Z2.9

N160 G1 Z-12 F.4

N170 X236.8 Z-11 F.4

N180 X239.628 Z-9.586 F.4

N190 S1=300

N200 M50 ;(OPLACH)

N210 G0 X238.8 Z-1.767

N220 G1 X181.8 F.4

N230 Z0.9 F.4

N240 G0 X238.8

N250 G0 Z-4.433

N260 G1 X181.8 F.4

N270 Z-1.767 F.4

N280 G0 X238.8

N290 G0 Z-7.1

N300 G1 X181.8 F.4

N310 Z-4.433 F.4

N320 X184.628 Z-3.019 F.4
N330 S1=350
N340 M50 ;(OPLACH)
N350 G0 G41 X190.8 Z2.8
N360 G3 X186 Z0.4 CR=2.4 F.22
N370 G1 X128.5 F.22
N380 G40 Z2.8 F.22
N390 S1=420
N400 M50 ;(OPLACH)
N410 G0 X176.172 Z1.98
N420 G1 G42 X179.566 Z0.283 F.1
N430 X180.8 Z-0.334 F.1
N440 Z-7.6 F.1
N450 X234 F.1
N460 G40 Z-5.2 F.1
N470 M51
N480 M1=5 M9
N490 T2 ;Nožová_hlava ;TU_INTE-LL06C2M-QP12
N500 M6
N510 D2
N520 G90 G95
N530 M1=42
N540 S1=330 M1=3 M8
N550 LIMS=200
N560 M50 ;(OPLACH)
N570 G0 X122.7 Z-3.1
N580 G1 X164.2 F.3
N590 Z0 F.3
N600 Z0.4 F.3
N610 X163.2 Z0.9 F.3

N620 G0 X122.7
N630 G0 Z-7.1
N640 G1 X164.2 F.3
N650 Z-3.1 F.3
N660 X161.372 Z-1.686 F.3
N670 S1=400
N680 M50 ;(OPLACH)
N690 G0 X122.9
N700 G0 G42 Z-23.9
N710 G2 X127.7 Z-21.5 CR=2.4 F.11
N720 G1 Z-8 F.11
N730 G40 X122.9 F.11
N740 M51
N750 M1=5 M9
N760 M30

%;_N_VRTANI_MPF

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; STROJ : VLC2000

; PROGRAM : VRTANI

; TYP : SL3000

; POLOZKA :

; OPERACE :

; PROGRAMOVAL : KASPAR

; DATUM : 3.4.2017-8:18:37

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;T1 FO_HELI-013090S-SA50 D1 R0

;T2 FO_HELI-005050F-MACH D1 R0

;T3 10.2 D1 R0
;T4 NAVRTAVAK 16 SECO D1 R0
;T5 TR_TAPP-006010R-BT40 D1 R3
;T6 TR_TAPP-012020F-MACH D1 R6
;T7 FREZA ZAHLUB 20 SANDVIK D1 R10

N10 M65
N20 M66
N30 T1 ;FO_HELI-013090S-SA50
N40 M6
N50 D1
N60 SETMS(2)
N70 DIAMON
N80 M50 ;(OPLACH)
N90 G17 G54 G90
N100 M40 LIMS=2400
N110 G97 M2=3 S2=2081 M8
N120 G0 X-169.9 Z28.997 F1082.254
N130 G95 F1082.254
N140 MCALL CYCLE81 (28.997,-1.004,30,-24.753,)
N150 X-169.9 Z28.997
N160 MCALL
N170 G0 X-207.42
N180 M51
N190 M2=5 M9
N200 M51
N210 M1=5 M9
N220 M66
N230 T3 ;10.2
N240 M6

N250 D3
N260 SETMS(2)
N270 DIAMON
N280 M50 ;(OPLACH)
N290 G17 G54 G90
N300 M40 LIMS=2400
N310 G97 M2=3 S2=2965 M8
N320 G0 X-209.06 Z2 F1304.45
N330 G95 F1304.45
N340 MCALL CYCLE81 (2,-7.5,2,-23.944,)
N350 X-209.06 Z2
N360 MCALL
N370 G0 X209.06
N380 M51
N390 M2=5 M9
N400 M51
N410 M1=5 M9
N420 M66
N430 T2 ;FO_HELI-005050F-MACH
N440 M6
N450 D2
N460 SETMS(2)
N470 DIAMON
N480 M50 ;(OPLACH)
N490 G17 G54 G90
N500 M40 LIMS=2400
N510 G97 M2=3 S2=5730 M8
N520 G0 X-97.7 Z50 F1489.69
N530 G95 F1489.69
N540 MCALL CYCLE81 (50,0,2,-16,)

N550 X-97.7 Z50
N560 MCALL
N570 G0 X-181.84
N580 M51
N590 M2=5 M9
N600 M51
N610 M1=5 M9
N620 M66
N630 T4 ;NAVRTAVAK 16 SECO
N640 M6
N650 D4
N660 SETMS(2)
N670 DIAMON
N680 M50 ;(OPLACH)
N690 G17 G54 G90
N700 M40 LIMS=2400
N710 G97 M2=3 S2=1989 M8
N720 G0 X-169.9 F1790.493
N730 G95 F1790.493
N740 MCALL CYCLE81 (50,0,2,-14.4,)
N750 X-169.9 Z50
N760 MCALL
N770 G0 X-207.42
N780 G0 X-209.06
N790 F420
N800 MCALL CYCLE81 (50,-7.5,2,-13.8,)
N810 X-209.06 Z50
N820 MCALL
N830 G0 X209.06
N840 G0 X181.84 F420

N850 F420
N860 MCALL CYCLE81 (50,0,2,-3.3,)
N870 X181.84 Z50
N880 MCALL
N890 G0 X97.7
N900 M51
N910 M2=5 M9
N920 M51
N930 M1=5 M9
N940 M66
N950 T5 ;TR_TAPP-006010R-BT40
N960 M6
N970 D5
N980 SETMS(2)
N990 DIAMON
N1000 M50 ;(OPLACH)
N1010 G17 G54 G90
N1020 M40 LIMS=2400
N1030 G0 G94 X-97.7 Y79.72 Z50 M8
N1040 G0 F1326.291
N1050 G95 F1326.291
N1060 MCALL CYCLE84 (50,-.3,2,-14.5,,0,3,,1,45,1326,1326)
N1070 X-97.7 Z50
N1080 X43.66 Y90.92
N1090 Z1.7
N1100 G331 Z-14.5 K1 S1326
N1110 G332 Z1.7 K1 S1326
N1120 G0 Z50
N1130 X159.44 Y48.85
N1140 Z1.7

N1150 G331 Z-14.5 K1 S1326
N1160 G332 Z1.7 K1 S1326
N1170 G0 Z50
N1180 X181.84 Y-21.83
N1190 Z1.7
N1200 G331 Z-14.5 K1 S1326
N1210 G332 Z1.7 K1 S1326
N1220 G0 Z50
N1230 X97.7 Y-79.72
N1240 Z1.7
N1250 G331 Z-14.5 K1 S1326
N1260 G332 Z1.7 K1 S1326
N1270 G0 Z50
N1280 X-43.66 Y-90.92
N1290 Z1.7
N1300 G331 Z-14.5 K1 S1326
N1310 G332 Z1.7 K1 S1326
N1320 G0 Z50
N1330 X-159.44 Y-48.85
N1340 Z1.7
N1350 G331 Z-14.5 K1 S1326
N1360 G332 Z1.7 K1 S1326
N1370 G0 Z50
N1380 X-181.84 Y21.83
N1390 Z1.7
N1400 G331 Z-14.5 K1 S1326
N1410 G332 Z1.7 K1 S1326
N1420 G0 Z50
N1430 M51
N1440 M2=5 M9

N1450 M51
N1460 M1=5 M9
N1470 M66
N1480 T6 ;TR_TAPP-012020F-MACH
N1490 M6
N1500 D6
N1510 SETMS(2)
N1520 DIAMON
N1530 M50 ;(OPLACH)
N1540 G17 G54 G90
N1550 M40 LIMS=2400
N1560 G0 G94 X-209.06 Y25.1 Z50 M8
N1570 G0 F1160.506
N1580 G95 F1160.506
N1590 MCALL CYCLE84 (50,-7.8,3.5,-25.25,,0.3,,1.75,45,663,663)
N1600 X-209.06 Z50
N1610 X209.06 Y-25.1
N1620 Z-4.3
N1630 G331 Z-25.25 K1.75 S663
N1640 G332 Z-4.3 K1.75 S663
N1650 G0 Z50
N1660 M51
N1670 M2=5 M9
N1680 M51
N1690 M1=5 M9
N1700 M66
N1710 T7 ;FREZA ZAHLUB 20 SANDVIK
N1720 M6
N1730 D7
N1740 SETMS(2)

N1750 DIAMON
N1760 M50 ;(OPLACH)
N1770 G17 G54 G90
N1780 M40 LIMS=2400
N1790 G97 M2=3 S2=1751 M8
N1800 G0 X-169.9 F87.535
N1810 G95 F87.535
N1820 MCALL CYCLE81 (50,0,2,-8.1.)
N1830 X-169.9 Z50
N1840 MCALL
N1850 G0 X-207.42
N1860 M51
N1870 M2=5 M9
N1880 M51
N1890 M1=5 M9
N1900 M30

%;_N_VRTANI-2_MPF

;\$PATH=/_N_MPF_DIR

; STROJ : VLC2000

; PROGRAM : VRTANI-2

; TYP : SL3000

; POLOZKA :

; OPERACE :

; PROGRAMOVAL : KASPAR

; DATUM : 3.4.2017-8:20:20

;

;T8 FO_HELI-010080K-MACH D1 R0

;T9 NAVRTAVAK 16 SECO DR90 DW D1 R0

;T11 DVOUBRITA PRESAZ. 8 HSS D1 R4

N10 M65

N20 M66

N30 T8 ;FO_HELI-010080K-MACH

N40 M6

N50 D8

N60 SETMS(2)

N70 DIAMON

N80 M50 ;(OPLACH)

N90 G17 G54 G90

N100 M40 LIMS=2400

N110 G97 M2=3 S2=2706 M8

N120 G0 X-12.82 Z10 F1190.479

N130 G95 F1190.479

N140 MCALL CYCLE81 (10,0,2,-9.887,)

N150 X-12.82 Z10

N160 MCALL

N170 M51

N180 M2=5 M9

N190 M51

N200 M1=5 M9

N210 M66

N220 T9 ;NAVRTAVAK 16 SECO DR90 DW

N230 M6

N240 D9

N250 SETMS(2)

N260 DIAMON

N270 M50 ;(OPLACH)

N280 G17 G54 G90
N290 M40 LIMS=2400
N300 G97 M2=3 S2=1989 M8
N310 G0 F1790.493
N320 G95 F1790.493
N330 MCALL CYCLE81 (10,0,2,-6.3,)
N340 X-12.82 Z10
N350 MCALL
N360 M51
N370 M2=5 M9
N380 M51
N390 M1=5 M9
N400 M66
N410 T11 ;DVOUBRITA PRESAZ. 8 HSS
N420 M6
N430 D11
N440 SETMS(2)
N450 DIAMON
N460 M50 ;(OPLACH)
N470 G17 G54 G90
N480 M40 LIMS=2400
N490 G97 M2=3 S2=4588 M8
N500 G0 X29.512 Z18 F798
N510 G0 Z10
N520 G0 Z4.25 F599
N530 G1 X28.911 Y95.108 F798
N540 Y74.714 F798
N550 X16.126 F798
N560 Y96.186 F798
N570 X3.34 F798

N580 Y75.953 F798
N590 X-9.445 F798
N600 Y96.084 F798
N610 G0 Z10 F798
N620 G0 X-7.718
N630 G0 Z4.25 F599
N640 G1 X-18.166 Y73.541 F798
N650 G0 Z10 F798
N660 G0 X27.432
N670 G0 Z4.25 F599
N680 G1 X38.016 Y96.309 F798
N690 G0 Z10 F798
N700 G0 X29.512
N710 G0 Z6.25
N720 G0 Z0.5 F599
N730 G1 X28.911 Y95.108 F798
N740 Y74.714 F798
N750 X16.126 F798
N760 Y96.186 F798
N770 X3.34 F798
N780 Y75.953 F798
N790 X-9.445 F798
N800 Y96.084 F798
N810 G0 Z10 F798
N820 G0 X-7.718
N830 G0 Z6.25
N840 G0 Z0.5 F599
N850 G1 X-18.166 Y73.541 F798
N860 G0 Z10 F798
N870 G0 X27.432

N880 G0 Z6.25

N890 G0 Z0.5 F599

N900 G1 X38.016 Y96.309 F798

N910 G0 Z10 F798

N920 G0 X-191.464

N930 G0 Z5 F689

N940 G1 X-152.521 Y4.664 F367.018

N950 G0 Z2

N960 G1 X-191.464 Y5.855 F367.018

N970 G0 Z10 F367.018

N980 G0 X191.464

N990 G0 Z5 F689

N1000 G1 X152.521 Y-4.664 F918

N1010 G0 Z2

N1020 G1 X191.464 Y-5.855 F918

N1030 G0 Z10 F918

N1040 M51

N1050 M2=5 M9

N1060 M51

N1070 M1=5 M9

N1080 M30