

Příloha č. 1 – NC kód pro výrobu technologického demonstrátoru

N10	G0	X-60	Y-30	Z60		
N20	M6					T80 ;Fréza D50
N30	M3					S1300
N40	G0	X-30	Y25	Z-1		;Srovnání povrchu
N50	G1	X180				F455
N60	G0		Y70			
N70	G1	X-40				
N80	M5					
N90	G0	X-60	Y-30	Z60		
N100	M6					T83 ;Vrták D4
N110	M3					S4750
N120	G0	X26.5	Y55.5	Z1		;Vrtání děr D4
N140	G81			Z-4		F140.5
N150	G0			Z1		
N160	G0	X113.5				
N180	G81			Z-4		
N190	G0			Z1		
N200	M5					
N210	G0	X-60	Y-30	Z60		
N220	M6					T84 ;Vrták D8.8
N230	M3					S750
N240	G0	X26.5	Y55.5	Z1		;Vrtání děr D8.8
N250	G81			Z-25		F37.5
N260	G0			Z1		
N270	G0	X113.5				
N280	G81			Z-25		
N290	G0			Z1		
N300	M5					
N310	G0	X-60	Y-30	Z60		
N320	M6					T81 ;Fréza D12
N330	M3					S3200
N340	G0	X26.5	Y55.5	Z1		;Zavrtání D16
N350	G75	D16		Z-7.5	W1	F144
N360	G0	X113.5				
N370	G75	D16		Z-7.5	W1	
N380	G0			Z-1.5		;Drážky 15
N390	G1	X113.5	Y57			
N400	G1	X124				F480
N410	G1		Y54			
N420	G1	X16				
N430	G1		Y57			
N440	G1	X112				
N450	G1		Y66			

N460	G1	X115			
N470	G1		Y16		
N480	G1	X112			
N490	G1		Y54		
N400	G0			Z1	
N410	G0	X115	Y28		
N420	G1			Z-1.5	
N430	G1	X124			
N440	G1		Y25		
N450	G1	X16			
N460	G1		Y28		
N470	G1	X115			
N480	G0			Z1	
N490	G0	X86			
N500	G1			Z-1.5	
N510	G1		Y16		
N520	G1	X83			
N530	G1		Y66		
N540	G1	X86			
N550	G1		Y28		
N560	G0			Z1	
N570	G0	X57			
N580	G1			Z-1.5	
N590	G1		Y16		
N600	G1	X54			
N610	G1		Y66		
N620	G1	X57			
N630	G1		Y28		
N640	G0			Z1	
N650	G0	X28			
N660	G1			Z-1.5	
N670	G1		Y16		
N680	G1	X25			
N690	G1		Y66		
N700	G1	X28			
N710	G1		Y28		
N720	G0			Z1	
N730	M5				
N740	G0	X-60	Y-30	Z60	
N750	M6				T82 ;Fréza D3
N760	M3				S4800
N770	G0	X17	Y20.5	Z1	
N780	G1		Z-1.5	F720	;Zarovnání po dráze frézy D12
N790	G1	X12.5			
N800	G1		Y32.5		
N810	G1	X17			

N820	G1	X12.5	
N830	G1		Y49.5
N840	G1	X17	
N850	G1	X12.5	
N860	G1		Y61.5
N870	G1	X17	
N880	G1	X12.5	
N890	G1		Y69.5
N900	G1	X20.5	
N910	G1		Y65
N920	G1		Y69.5
N930	G1	X32.5	
N940	G1		Y65
N950	G1		Y69.5
N960	G1	X49.5	
N970	G1		Y65
N980	G1		Y69.5
N990	G1	X61.5	
N1000	G1		Y65
N1010	G1		Y69.5
N1020	G1	X78.5	
N1030	G1		Y65
N1040	G1		Y69.5
N1050	G1	X90.5	
N1060	G1		Y65
N1070	G1		Y65
N1080	G1		Y69.5
N1090	G1	X107.5	
N1100	G1		Y65
N1110	G1		Y69.5
N1120	G1	X119.5	
N1130	G1		Y65
N1140	G1		Y69.5
N1150	G1	X127.5	
N1160	G1		Y61.5
N1170	G1	X123	
N1180	G1	X127.5	
N1190	G1		Y49.5
N1200	G1	X123	
N1210	G1	X127.5	
N1220	G1		Y32.5
N1230	G1	X123	
N1240	G1	X127.5	
N1250	G1		Y20.5
N1260	G1	X123	
N1270	G1	X127.5	
N1280	G1		Y12.5
N1290	G1	X119.5	
N1300	G1		Y17
N1310	G1		Y12.5
N1320	G1	X107.5	
N1330	G1		Y17
N1340	G1		Y12.5
N1350	G1	X90.5	

N1360	G1		Y17		
N1370	G1		Y12.5		
N1380	G1	X78.5			
N1390	G1		Y17		
N1400	G1		Y12.5		
N1410	G1	X61.5			
N1420	G1		Y17		
N1430	G1		Y12.5		
N1440	G1	X49.5			
N1450	G1		Y17		
N1460	G1		Y12.5		
N1470	G1	X32.5			
N1480	G1		Y17		
N1490	G1		Y12.5		
N1500	G1	X20.5			
N1510	G1		Y17		
N1520	G1		Y12.5		
N1530	G1	X12.5			
N1540	G1		Y20.5		
N1550	G1			Z-2.2	;Drážky 4
N1560	G1		Y69.5		
N1570	G1	X127.5			
N1580	G1		Y12.5		
N1590	G1	X12.5			
N1600	G1		Y20.5		
N1610	G1			Z-2.8	
N1620	G1		Y69.5		
N1630	G1	X127.5			
N1640	G1		Y12.5		
N1650	G1	X12.5			
N1660	G1		Y20.5		
N1670	G1			Z-3.4	
N1680	G1		Y69.5		
N1690	G1	X127.5			
N1700	G1		Y12.5		
N1710	G1	X12.5			
N1720	G1		Y20.5		
N1730	G1			Z-4	
N1740	G1		Y69.5		
N1750	G1	X127.5			
N1760	G1		Y12.5		
N1770	G1	X12.5			
N1780	G1		Y20.5		
N1790	G0			Z1	
N1800	G0	X11.5			;Vnějšíšek s kruhovým vybráním
N1810	G1			Z-1.5	
N1820	G1		Y70		
N1830	G2	X12	Y70.5		R2
N1840	G1	X128			

N1850	G2	X128.5	Y70	R2
N1860	G1		Y12	
N1870	G2	X128	Y11.5	R2
N1880	G1	X12		
N1890	G2	X11.5	Y12	R2
N1900	G1		Y20.5	
N1910	G1			Z-2.2
N1920	G1		Y70	
N1930	G2	X12	Y70.5	R2
N1940	G1	X128		
N1950	G2	X128.5	Y70	R2
N1960	G1		Y12	
N1970	G2	X128	Y11.5	R2
N1980	G1	X12		
N1990	G2	X11.5	Y12	R2
N2000	G1		Y20.5	
N2010	G1			Z-2.8
N2020	G1		Y70	
N2030	G2	X12	Y70.5	R2
N2040	G1	X128		
N2050	G2	X128.5	Y70	R2
N2060	G1		Y12	
N2070	G2	X128	Y11.5	R2
N2080	G1	X12		
N2090	G2	X11.5	Y12	R2
N2100	G1		Y20.5	
N2110	G1			Z-3.4
N2120	G1		Y70	
N2130	G2	X12	Y70.5	R2
N2140	G1	X128		
N2150	G2	X128.5	Y70	R2
N2160	G1		Y12	
N2170	G2	X128	Y11.5	R2
N2180	G1	X12		
N2190	G2	X11.5	Y12	R2
N2200	G1		Y20.5	
N2210	G1			Z-4
N2220	G1		Y70	
N2230	G2	X12	Y70.5	R2
N2240	G1	X128		
N2250	G2	X128.5	Y70	R2
N2260	G1		Y12	
N2270	G2	X128	Y11.5	R2
N2280	G1	X12		
N2290	G2	X11.5	Y12	R2
N2300	G1		Y20.5	

N2310	G1			Z-2.2	
N2320	G1	X11.5			
N2330	G1		Y70.5		
N2340	G1	X128.5			
N2350	G1		Y11.5		
N2360	G1	X11.5			
N2370	G1		Y20.5		
N2380	G1	X12.5			
N2390	G1		Y69.5		
N2400	G1	X127.5			
N2410	G1		Y12.5		
N2420	G1	X12.5			
N2430	G1		Y20.5		
N2440	G0	X12	Y20.5	Z-4	
N2450	G1	X11.5			
N2460	G1		Y70.5		
N2470	G1	X128.5			
N2480	G1		Y11.5		
N2490	G1	X11.5			
N2500	G1		Y20.5		
N2510	G1	X12.5			
N2520	G1		Y69.5		
N2530	G1	X127.5			
N2540	G1		Y12.5		
N2550	G1	X12.5			
N2560	G1		Y20.5		
N2570	G0			Z1	
N2580	G0		Y40.5		;Střední drážka
N2590	G1			Z-1.6	
N2600	G1	X128.5			
N2610	G1		Y41.5		
N2620	G1	X12.5			
N2630	G0			Z-2.2	
N2640	G1	X128.5			
N2650	G1		Y40.5		
N2660	G1	X12.5			
N2670	G0			Z-2.8	
N2680	G1	X128.5			
N2690	G1		Y41.5		
N2700	G1	X12.5			
N2710	G0			Z-3.4	
N2720	G1	X128.5			
N2730	G1		Y40.5		
N2740	G1	X12.5			
N2750	G0			Z-4	
N2760	G1	X128.5			
N2770	G1		Y41.5		
N2780	G1	X12.5			

N2790	G0			Z1	
N2800	G0	X40.5	Y12.5		;Drážka levá střední
N2810	G1			Z-2.2	
N2820	G1		Y69.5		
N2830	G1	X41.5			
N2840	G1		Y12.5		
N2850	G1			Z-2.8	
N2860	G1		Y69.5		
N2870	G1	X40.5			
N2880	G1		Y12.5		
N2890	G1			Z-3.4	
N2900	G1		Y69.5		
N2910	G1	X41.5			
N2920	G1		Y12.5		
N2930	G1			Z-4	
N2940	G1		Y69.5		
N2950	G1	X40.5			
N2960	G1		Y12.5		
N2970	G0			Z1	
N2980	G0	X69.5			;Vnitřní střední
N2990	G1			Z-2.2	
N3000	G1		Y69.5		
N3010	G1	X70.5			
N3020	G1		Y12.5		
N3030	G1			Z-2.8	
N3040	G1		Y69.5		
N3050	G1	X69.5			
N3060	G1		Y12.5		
N3070	G1			Z-3.4	
N3080	G1		Y69.5		
N3090	G1	X70.5			
N3100	G1		Y12.5		
N3110	G1			Z-4	
N3120	G1		Y69.5		
N3130	G1	X69.5			
N3140	G1		Y12.5		
N3150	G0			Z1	
N3160	G0	X98.5			;Vnitřní střední pravá
N3170	G1			Z-2.2	
N3180	G1		Y69.5		
N3190	G1	X99.5			
N3200	G1		Y12.5		
N3210	G1			Z-2.8	

N3220	G1		Y69.5		
N3230	G1	X98.5			
N3240	G1		Y12.5		
N3250	G1			Z-3.4	
N3260	G1		Y69.5		
N3270	G1	X99.5			
N3280	G1		Y12.5		
N3290	G1			Z-4	
N3300	G1		Y69.5		
N3310	G1	X98.5			
N3320	G1		Y12.5		
N3330	G0			Z1	
N3340	M5				
N3350	G0	X-60	Y-30	Z60	
N3360	M6				T83 ;Vrták D4
N3370	M3				S4800
N3380	G0	X55.5	Y55.5	Z1	;Vrtání děr D4
N3390	G81			Z-7.5	F144
N3400	G0	X84.5			
N3410	G81			Z-7.5	
N3420	G0	X113.5	Y26.5		
N3430	G81			Z-7.5	
N3440	G0	X84.5			
N3450	G81			Z-7.5	
N3460	G0	X55.5			
N3470	G81			Z-7.5	
N3480	G0	X26.5			
N3490	G81			Z-7.5	
N3500	M5				
N3510	G0	X-60	Y-30	Z60	
N3520	M30				