

Příloha 2

NC kódy pro navařování

%Vzorek_cislo_1_G71	N215 G4 FQ1	N370 G4 FQ2
N35 G30 G17 X+0 Y+0 Z+0	N220 G01 X+29	N375 G00 Y+10 X-29
N40 G31 G90 X+100 Y+100 Z+40	N225 M52	N385 M51
N45 G40	N230 G4 FQ2	N390 G4 FQ1
N55 Q1=1.5	N235 G00 Y+26 X-29	N395 G01 X+29
N60 Q2=5	N245 M51	N400 MQ2
N75 M5	N250 G4 FQ1	N405 G4 F5
N80 T16 G17 S0	N255 G01 X+29	N410 G00 Y+6 X-29
N105 G53 P01 1	N260 M52	N420 M51
N110 M31 M72	N265 G4 FQ2	N425 G4 FQ1
N125 ; #####	N270 G00 Y+22 X-29	N430 G01 X+29
N130 G00 X-29 Y+38	N280 M51	N435 M52
N135 Z+10	N285 G4 FQ1	N440 G4 FQ2
N145 G01 Z+7.5 F300	N290 G01 X+29	N445 G00 Y+2 X-29
N150 M51	N295 M52	N455 M51
N155 G4 FQ1	N300 G4 FQ2	N460 G4 FQ1
N160 G01 X+29	N305 G00 Y+18 X-29	N465 G01 X+29
N165 M52	N315 M51	N470 M52
N170 G4 FQ2	N320 G4 FQ1	N475 G4 FQ2
N175 G00 Y+34 X-29	N325 G01 X+29	N480 G00 Y-2 X-29
N180 M51	N330 M52	N490 M51
N185 G4 FQ1	N335 G4 FQ2	N495 G4 FQ1
N190 G01 X+29	N340 G00 Y+14 X-29	N500 G01 X+29
N195 M52	N350 M51	N505 M52
N200 G4 FQ2	N355 G4 FQ1	N510 G4 FQ2
N205 G00 Y+30 X-29	N360 G01 X+29	N515 G00 Y-6 X-29
N210 M51	N365 M52	N525 M51

N530 G4 FQ1	N685 G4 FQ2	N1075 M30
N535 G01 X+29	N690 G00 Y-26 X-29	N99999999 %01_G71
N540 M52	N700 M51	
N545 G4 FQ2	N705 G4 FQ1	
N550 G00 Y-10 X-29	N710 G01 X+29	
N560 M51	N715 M52	
N565 G4 FQ1	N720 G4 FQ2	
N570 G01 X+29	N725 G00 Y-30 X-29	
N575 M52	N735 M51	
N580 G4 FQ2	N740 G4 FQ1	
N585 G00 Y-14 X-29	N745 G01 X+29	
N595 M51	N750 M52	
N600 G4 FQ1	N755 G4 FQ2	
N605 G01 X+29	N760 G00 Y-34 X-29	
N610 M52	N770 M51	
N615 G4 FQ	N775 G4 FQ1	
N620 G00 Y-18 X-29	N780 G01 X+29	
N630 M51	N785 M52	
N635 G4 FQ1	N790 G4 FQ2	
N640 G01 X+29	N795 G00 Y-38 X-29	
N645 M52	N785 M51	
N650 G4 FQ2	N790 G4 FQ1	
N655 G00 Y-22 X-29	N795 G01 X+29	
N665 M51	N800 M52	
N670 G4 FQ1	N805 G4 FQ2	
N675 G01 X+29	N1055 G00 Z+300	
N680 M52	N1065 ; #####	

%Vzorek_cislo_2_G71	N0215 G04 FQ1	N0370 G04 FQ2
N35 G30 G17 X+0 Y+0 Z+0	N0220 G01 X+29	N0375 G00 Y-26 X-29
N40 G31 G90 X+100 Y+100 Z+40	N0225 M52	N0385 M51
N45 G40	N0230 G04 FQ2	N0390 G04 FQ1
N55 Q1=1.5	N0235 G00 Y-22 X-29	N0395 G01 X+29
N60 Q2=5	N0245 M51	N0400 M52
N75 M5	N0250 G04 FQ1	N0405 G04 FQ2
N80 T16 G17 S0	N0255 G01 X+29	N0410 G00 Y +30 X -29
N105 G53 P01 1	N0260 M52	N0420 M51
N110 M31 M72	N0265 G04 FQ2	N0425 G04 FQ1
N0125 ; #####	N0270 G00 Y+34 X-29	N0430 G01 X+29
N0130G00 X-29 Y+38.0	N0280 M51	N0435 M52
N0135 Z+10*	N0285 G04 FQ1	N0440 G04 FQ2
N0145 G01 Z7.5 F300	N0290 G01 X+29	N0445 G00 Y+10 X-29
N0150 M51	N0295 M52	N0455 M51
N0155 G04 FQ1	N0300 G04 FQ2	N0460 G04 FQ1
N0160 G01 X+29	N0305 G00 Y+14 X-29	N0465 G01 X+29
N0165 M52	N0315 M51	N0470 M52
N0170 G04 FQ2	N0320 G04 FQ1	N0475 G04 FQ2
N0175 G00 Y+18 X-29	N0325 G01 X+29	N0480 G00 Y-10 X-29
N0180 M51	N0330 M52	N0490 M51
N0185 G04 FQ1	N0335 G04 FQ2	N0495 G04 FQ1
N0190 G01 X+29	N0340G00 Y-6 X-29*	N0500 G01 X+29
N0195 M52	N0350 M51	N0505 M52
N0200 G04 FQ2	N0355 G04 FQ1	N0510 G04 FQ2
N0205 G00 Y-2 X-29	N0360 G01 X+29	N0515 G00 Y-30 X-29
N0210 M51	N0365 M52	N0525 M51

N0530 G04 FQ1	N0685 G04 FQ2*	N1075 M30
N0535 G01 X+29	N0690 G00 Y+22 X-29	N99999999 %02_G71
N0540 M52	N0700 M51	
N0545 G04 FQ2	N0705 G04 FQ1	
N0550 G00 Y+26 X-29	N0710 G01 X+29	
N0560 M51	N0715 M52	
N0565 G04 FQ1	N0720 G04 FQ2	
N0570 G01 X+29	N0725 G00 Y+2.0 X-29	
N0575 M52	N0735 M51	
N0580 G04 FQ2	N0740 G04 FQ1	
N0585 G00 Y+6 X-29	N0745 G01 X+29	
N0595 M51	N0750 M52	
N0600 G04 FQ1	N0755 G04 FQ2	
N0605 G01 X+29	N0810 G00 Y-18 X-29	
N0610 M52	N0820 M51	
N0615 G04 FQ2	N0825 G04 FQ1	
N0620 G00 Y-14 X-29	N0830 G01 X+29	
N0630 M51	N0835 M52	
N0635 G04 FQ1	N0840 G04 FQ2	
N0640 G01 X+29	N0845 G00 Y-38 X-29	
N0645 M52	N0855 M51	
N0650 G04 FQ2	N0860 G04 FQ1	
N0655 G00 Y-34 X-29	N0865 G01 X+29	
N0665 M51	N0870 M52	
N0670 G04 FQ1	N0875 G04 FQ2	
N0675 G01 X+29	N1055 G00 Z300	
N0680 M52	N1065 ; #####	

%Vzorek_cislo_3_G71	N0205 X+12
N35 G30 G17 X+0 Y+0 Z+0	N0210 Y +22
N40 G31 G90 X+100 Y+100 Z+40	N0215 X -16 N0220 Y -26
N45 G40	N0225 X+16
N55 Q1=1.5	N0230 Y +26
N60 Q2=5	N0235 X -20
N75 M5	N0240 Y -30
N80 T16 G17 S0	N0245 X +20
N105 G53 P01 1	N0250 Y +30
N110 M31 M72*	N0255 X -24
N0125 ; #####	N0260 Y -34
N0130G00 X 0 Y -12	N0265 X +24
N0135 Z10	N0270 Y +34
N0145 G01 Z7.5 F300	N0275 X -28
N0150 M51	N0280 Y -38
N0155 G04 FQ1	N0285 X +28
N0160 G01 Y +10	N0290 Y +38
N0165 X-4	N0295 X +29
N0170 Y -14	N0870 M52
N0175 X +4	N0875 G04 FQ2
N0180 Y +14	N1055 G00 Z300
N0185 X -8	N1065 ; #####
N0190 Y -18	N1075 M30
N0195 X +8	N99999999 %03_G71
N0200 Y +18	
N0205 X -12	
N0203 Y – 22	

%Vzorek_cislo_4_G71	N0203 Y + 14	N0340 X- 29
N35 G30 G17 X+0 Y+0 Z+0	N0210 X + 28	N0350 M52
N40 G31 G90 X+100 Y+100 Z+40	N0215 Y +10	N0365 G04 FQ1
N45 G40	N0220 X -28	N0405 G00 Z300
N55 Q1=1.5	N0225 Y +6	N1065 ; #####
N60 Q2=5	N0230 X + 28	N1070 M54
N75 M5	N0235 Y +2	N1075 M30
N80 T16 G17 S0	N0240 X -28	N99999999 %07_G71
N105 G53 P01 1	N0245 Y -2	
N110 M31 M72	N0250 X +28	
N0125 ; #####	N0255 Y -6	
N0130 G00 X-29.0 Y+38.0	N0260 X -28	
N0135 Z10	N0265 Y -10	
N0145 G01 Z7.5 F300	N0270 X +28	
N0150 M51	N0275 Y -14	
N0155 G04 FQ1	N0280 X -28	
N0160 G01 X+28	N0285 Y -18	
N0165 Y +34	N0290 X +28	
N0170 X -28	N0295 Y -22	
N0173 Y +30	N0300 X-28*	
N0175 X + 28	N0305 Y-26*	
N0180 Y +26	N0310 X+28*	
N0185 X – 28	N0315 Y-30*	
N0190 Y +22	N0320 X -28*	
N0195 X + 28	N0325 Y -34*	
N0200 Y +18	N0330 X+28*	
N0205 X -28	N0335 Y-38*	

%Vzorek_cislo_5_G71	N0215 G04 FQ1	N0370 G04 FQ2
N35 G30 G17 X+0 Y+0 Z+0	N0220 G01 X-11	N0375 G00 Y-26 X-29
N40 G31 G90 X+100 Y+100 Z+40	N0225 M52	N0385 M51
N45 G40	N0230 G04 FQ2	N0390 G04 FQ1
N55 Q1=1.5	N0235 G00 Y-22 X-29	N0395 G01 X-11
N60 Q2=5	N0245 M51	N0400 M52
N75 M5	N0250 G04 FQ1	N0405 G04 FQ2
N80 T16 G17 S0	N0255 G01 X-11	N0410 G00 Y +30 X -29
N105 G53 P01 1	N0260 M52	N0420 M51
N110 M31 M72	N0265 G04 FQ2	N0425 G04 FQ1
N0125 ; #####	N0270 G00 Y+34 X-29	N0430 G01 X-11
N0130G00 X-29 Y+38	N0280 M51	N0435 M52
N0135 Z+10	N0285 G04 FQ1	N0440 G04 FQ2
N0145 G01 Z7.5 F300	N0290 G01 X-11	N0445 G00 Y+10 X-29
N0150 M51	N0295 M52	N0455 M51
N0155 G04 FQ1	N0300 G04 FQ2	N0460 G04 FQ1
N0160 G01 X-11	N0305 G00 Y+14 X-29	N0465 G01 X-11
N0165 M52	N0315 M51	N0470 M52
N0170 G04 FQ2	N0320 G04 FQ1	N0475 G04 FQ2
N0175 G00 Y+18 X-29	N0325 G01 X-11	N0480 G00 Y-10 X-29
N0180 M51	N0330 M52	N0490 M51
N0185 G04 FQ1	N0335 G04 FQ2	N0495 G04 FQ1
N0190 G01 X-11	N0340G00 Y-6 X-29	N0500 G01 X-11
N0195 M52	N0350 M51	N0505 M52
N0200 G04 FQ2	N0355 G04 FQ1	N0510 G04 FQ2
N0205 G00 Y-2 X-29	N0360 G01 X-11	N0515 G00 Y-30 X-29
N0210 M51	N0365 M52	N0525 M51

N0530 G04 FQ1	N0685 G04 FQ2	N0895 G04 FQ1
N0535 G01 X-11	N0690 G00 Y+22 X-29	N0900 G01 X+9
N0540 M52	N0700 M51	N0915 M52
N0545 G04 FQ2	N0705 G04 FQ1	N0920 G04 FQ2
N0550 G00 Y+26 X-29	N0710 G01 X-11	N0925 G00 Y+18 X-9
N0560 M51	N0715 M52	N0935 M51
N0565 G04 FQ1	N0720 G04 FQ2	N0940 G04 FQ1
N0570 G01 X-11	N0725 G00 Y+2 X-29	N0945 G01 X+9
N0575 M52	N0735 M51	N0950 M52
N0580 G04 FQ2	N0740 G04 FQ1	N0955 G04 FQ2
N0585 G00 Y+6 X-29	N0745 G01 X-11	N0960 G00 Y-2 X-9
N0595 M51	N0750 M52	N0970 M51
N0600 G04 FQ1	N0755 G04 FQ2	N0975 G04 FQ1
N0605 G01 X-11	N0810 G00 Y-18 X-29	N0980 G01 X+9
N0610 M52	N0820 M51	N0985 M52
N0615 G04 FQ2	N0825 G04 FQ1	N0990 G04 FQ2
N0620 G00 Y-14 X-29	N0830 G01 X-11	N0995 G00 Y-22 X-9
N0630 M51	N0835 M52	N1005 M51
N0635 G04 FQ1	N0840 G04 FQ2	N1010 G04 FQ1
N0640 G01 X-11	N0845 G00 Y-38 X-29	N1015 G01 X+9
N0645 M52	N0855 M51	N1020 M52
N0650 G04 FQ2	N0860 G04 FQ1	N1025 G04 FQ2
N0655 G00 Y-34 X-29	N0865 G01 X-11	N1030 G00 Y+34 X-9
N0665 M51	N0870 M52	N1040 M51
N0670 G04 FQ1	N0875 G04 FQ2	N1045 G04 FQ1
N0675 G01 X-11	N0880 G00 X-9 Y+38	N1050 G01 X+9
N0680 M52	N0890 M51	N1055 M52

N1060 G04 FQ2	N1230 G04 FQ1	N1375 G04 FQ2
N1065 G00 Y+14 X-9	N1235 G01 X+29	N1380 G00 Y-14 X-9
N1075 M51	N1240 M52	N1390 M51
N1080 G04 FQ1	N1245 G04 FQ2	N1395 G04 FQ1
N1085 G01 X+9	N1240 G00 Y-10 X-9	N1400 G01 X+9
N1090 M52	N1250 M51	N1405 M52
N1095 G04 FQ2	N1255 G04 FQ1	N1410 G04 FQ2
N1110 G00 Y-6 X-9	N1260 G01 X+29	N1415 G00Y-34 X-9
N1120 M51	N1265 M52	N1425 M51
N1125 G04 FQ1	N1270 G04 FQ2	N1430 G04 FQ1
N1130 G01 X+9	N1275 G00 Y-30 X-9	N1435 G01 X+9
N1135 M52	N1285 M51	N1440 M52
N1140 G04 FQ2	N1290 G04 FQ1	N1445 G04 FQ2
N1145 G00 Y-26 X-9	N1295 G01 X+9	N1450 G00 Y+22 X-9
N1155 M51	N1300 M52	N1450 M51
N1160 G04 FQ1	N1305 G04 FQ2	N1455 G04 FQ1
N1165 G01 X+9	N1310 G00 Y+26 X-9	N1460 G01 X+9
N1170 M52	N1320 M51	N1465 M52
N1175 G04 FQ2	N1325 G04 FQ1	N1470 G04 FQ2
N1180 G00 Y +30 X -9	N1330 G01 X+9	N1475 G00 Y+2.0 X-9
N1190 M51	N1335 M52	N1485 M51
N1195 G04 FQ1	N1340 G04 FQ2	N1490 G04 FQ1
N1200 G01 X+9	N1345 G00 Y+6 X-9	N1495 G01 X+9
N1205 M52	N1355 M51	N1500 M52
N1210 G04 FQ2	N1360 G04 FQ1	N1505 G04 FQ2
N1215 G00 Y+10 X-9	N1365 G01 X+9	N1510 G00 Y-18 X-9
N1225 M51	N1370 M52	N1520 M51

N1525 G04 FQ1	N1650 G04 FQ2	N1730 G04 FQ1
N1530 G01 X+9	N1652 G00 Y-22 X+11	N1735 G01 X+29
N1535 M52	N1656 M51	N1740 M52
N1540 G04 FQ2	N1658 G04 FQ1	N1745 G04 FQ2
N1545 G00 Y-38 X-9	N1660 G01 X+29	N1750 G00 Y +30 X +11
N1555 M51	N1662 M52	N1760 M51
N1560 G04 FQ1	N1664 G04 FQ2	N1765 G04 FQ1
N1565 G01 X+9	N1666 G00 Y+34 X+11	N1770 G01 X+29
N1570 M52	N1670 M51	N1775 M52
N1540 G04 FQ2	N1672 G04 FQ1	N1780 G04 FQ2
N1545G00 X+11 Y+38	N1674 G01 X+29	N1785 G00 Y+10 X+11
N1555 M51	N1676 M52	N1795 M51
N1560 G04 FQ1	N1678 G04 FQ2	N1800 G04 FQ1
N1565 G01 X+29	N1680 G00 Y+14 X+11	N1805 G01 X+29
N1570 M52	N1684 M51	N1810 M52
N1575 G04 FQ2	N1686 G04 FQ1	N1815 G04 FQ2
N1580 G00 Y+11 X-29	N1688 G01 X+29	N1820 G00 Y-10 X+11
N1590 M51	N1690 M52	N1830 M51
N1595 G04 FQ1	N1692 G04 FQ2	N1835 G04 FQ1
N1600 G01 X+29	N1694 G00 Y-6 X+11	N1840 G01 X+29
N1605 M52	N1698 M51	N1845 M52
N1610 G04 FQ2	N1700 G04 FQ1	N1850 G04 FQ2
N1615 G00 Y-2 X+11	N1703 G01 X+29	N1855 G00 Y-30 X+11
N1630 M51	N1705 M52	N1865 M51
N1635 G04 FQ1	N1710 G04 FQ2	N1870 G04 FQ1
N1640 G01 X+29	N1715 G00 Y-26 X+11	N1875 G01 X+29
N1645 M52	N1725 M51	N1870 M52

N1875 G04 FQ2	N2035 G04 FQ1
N1880 G00 Y+26 X+11	N2040 G01 X+29
N1890 M51	N2045 M52
N1895 G04 FQ1	N2050 G04 FQ2
N1900 G01 X+29	N2055 G00 Y+2 X+11
N1905 M52	N2065 M51
N1910 G04 FQ2	N2070 G04 FQ1
N1915 G00 Y+6 X+11	N2075 G01 X+29
N1925 M51	N2080 M52
N1930 G04 FQ1	N2085 G04 FQ2
N1935 G01 X+29	N2090 G00 Y-18 X+11
N1940 M52	N2100 M51
N1945 G04 FQ2	N2105 G04 FQ1
N1950 G00 Y-14 X+11	N2110 G01 X+29
N1960 M51	N2115 M52
N1965 G04 FQ1	N2120 G04 FQ2
N1970 G01 X+29	N2125 G00 Y-38 X+11
N1975 M52	N2135 M51
N1980 G04 FQ2	N2140 G04 FQ1
N1985 G00 Y-34 X+11	N2145 G01 X+29
N1995 M51	N2150 M52
N2000 G04 FQ1	N2155 G04 FQ2
N2005 G01 X+29	N2165 G00 Z300
N2010 M52	N2175 ; #####
N2015 G04 FQ2	N2200 M54
N2020 G00 Y+22 X+11	N2300 M30
N2030 M51	N99999999 %05_G71

%Vzorek_cislo_6_G71	N215 G4 FQ1	N370 G4 FQ2
N35 G30 G17 X+0 Y+0 Z+0	N220 G01 X+29	N375 G00 Y+10 X-29
N40 G31 G90 X+100 Y+100 Z+40	N225 M52	N385 M51
N45 G40	N230 G4 FQ2	N390 G4 FQ1
N55 Q1=1.5	N235 G00 Y+26 X-29	N395 G01 X+29
N60 Q2=5	N245 M51	N400 MQ2
N75 M5	N250 G4 FQ1	N405 G4 F5
N80 T16 G17 S0	N255 G01 X+29	N410 G00 Y+6 X-29
N105 G53 P01 1	N260 M52	N420 M51
N110 M31 M72	N265 G4 FQ2	N425 G4 FQ1
N125 ; #####	N270 G00 Y+22 X-29	N430 G01 X+29
N130 G00 X-29 Y+38	N280 M51	N435 M52
N135 Z+52	N285 G4 FQ1	N440 G4 FQ2
N145 G01 Z+49.5 F300	N290 G01 X+29	N445 G00 Y+2 X-29
N150 M51	N295 M52	N455 M51
N155 G4 FQ1	N300 G4 FQ2	N460 G4 FQ1
N160 G01 X+29	N305 G00 Y+18 X-29	N465 G01 X+29
N165 M52	N315 M51	N470 M52
N170 G4 FQ2	N320 G4 FQ1	N475 G4 FQ2
N175 G00 Y+34 X-29	N325 G01 X+29	N480 G00 Y-2 X-29
N180 M51	N330 M52	N490 M51
N185 G4 FQ1	N335 G4 FQ2	N495 G4 FQ1
N190 G01 X+29	N340 G00 Y+14 X-29	N500 G01 X+29
N195 M52	N350 M51	N505 M52
N200 G4 FQ2	N355 G4 FQ1	N510 G4 FQ2
N205 G00 Y+30 X-29	N360 G01 X+29	N515 G00 Y-6 X-29
N210 M51	N365 M52	N525 M51

N530 G4 FQ1	N685 G4 FQ2	N1075 M30
N535 G01 X+29	N690 G00 Y-26 X-29	N99999999 %06_G71
N540 M52	N700 M51	
N545 G4 FQ2	N705 G4 FQ1	
N550 G00 Y-10 X-29	N710 G01 X+29	
N560 M51	N715 M52	
N565 G4 FQ1	N720 G4 FQ2	
N570 G01 X+29	N725 G00 Y-30 X-29	
N575 M52	N735 M51	
N580 G4 FQ2	N740 G4 FQ1	
N585 G00 Y-14 X-29	N745 G01 X+29	
N595 M51	N750 M52	
N600 G4 FQ1	N755 G4 FQ2	
N605 G01 X+29	N760 G00 Y-34 X-29	
N610 M52	N770 M51	
N615 G4 FQ	N775 G4 FQ1	
N620 G00 Y-18 X-29	N780 G01 X+29	
N630 M51	N785 M52	
N635 G4 FQ1	N790 G4 FQ2	
N640 G01 X+29	N795 G00 Y-38 X-29	
N645 M52	N785 M51	
N650 G4 FQ2	N790 G4 FQ1	
N655 G00 Y-22 X-29	N795 G01 X+29	
N665 M51	N800 M52	
N670 G4 FQ1	N805 G4 FQ2	
N675 G01 X+29	N1055 G00 Z+300	
N680 M52	N1065 ; #####	