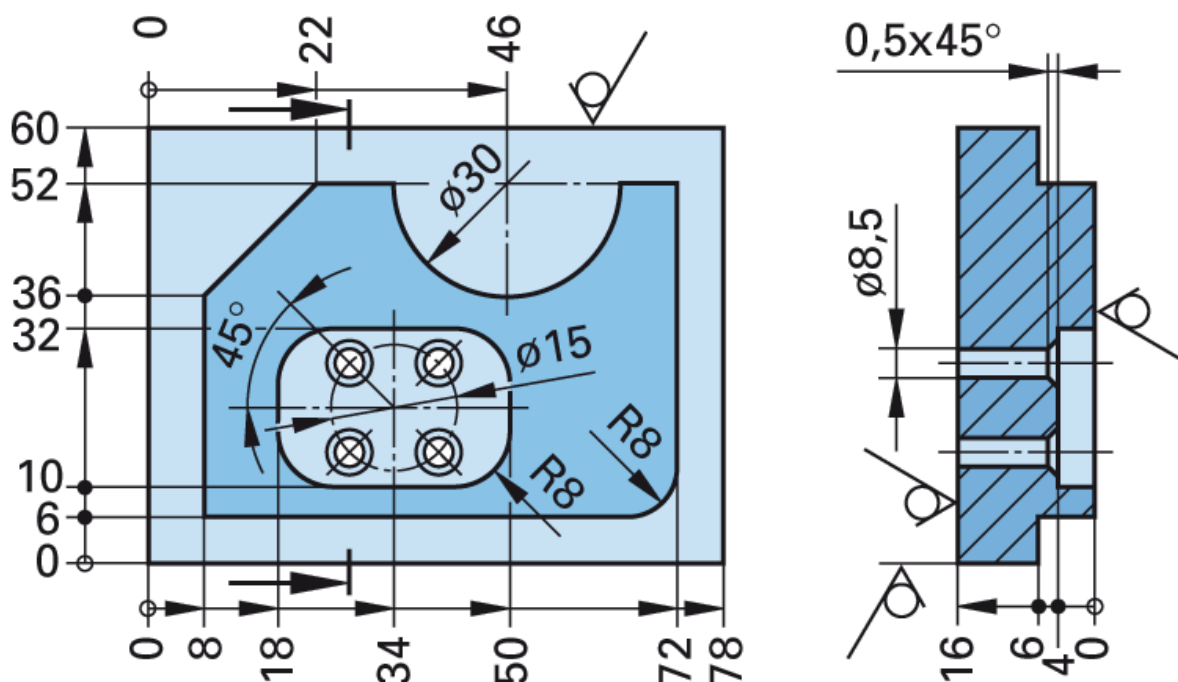


Najděte 12 chyb v ISO programu. Mohou to být chyby buď v souřadném systému, ale také chyby v G-kódu nebo M-kódu.



N1 G90 G17 G40

N2 G54

N3 T1 M6

; Schaftfräser schlicht 20

N3 G90 G0 X-10 Y-10 Z2 S1273 M04

N4 G1 Z-6 F200

N5 G42 G1 X8

N6 G1 Y36

N7 X22 Y52

N8 X31

N9 G3 X61 Y52 J15 I0

N10 G1 X72

N11 G1 Y14

N12 G2 X64 Y6 R8

N13 G1 X-10

N14 G40 G0 Y-10

N15 G0 Z100

N16 T2 M0

; Schaftfräser 12

N17 G90 G0 X34 Y21 Z2 S2122 M13

N18 G1 Z-4 F150

N19 G41 G1 Y10

N20 G1 X44

N21 G3 X50 Y18 R8

N22 G1 Y24

N23 G3 X42 Y32 R8

N24 G1 X26

N25 G2 X18 Y24 R8

N26 G1 Y18

N27 G3 X26 Y10 R3

N28 G1 X34

N29 G80 G1 X34 Y21

N30 G0 Z100

N31 T3 M6

; Zentrierbohrer 10

N32 G90 G0 X39.303 Y26.303 Z2 S2546 M13

N33 G84 R-3 Z-8.75 F100

N34 G22 L 100 H1

N35 G80

N36 G90 G0 Z100

N37 T4 M6

; Spiralbohrer HSS 8.5

N38 G90 G0 X59.303 Y26.303 Z2 S2995 M13

N39 G83 R-3 Z-19.5 Q3 F300

N40 G22 L 100 H1

N41 G80

N42 G90 G0 Z100

N43 M5 M9

N44 M60

Unterprogramm L100

N1000 G79 X39.303 Y26.303

N1001 G79 X28.696 Y15.696

N1002 G79 X39.303 Y15.696

N1003 M17