

Príloha 1

Program pre 5- osú CNC frézovačku písaný v programovacom jazyku Heidenhain

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0 BEGIN PGM Maly Rovder MM
1 BLK FORM 0.1 Z X+0 Y+0 Z+0
2 BLK FORM 0.2 X+0 Y+0 Z+0
3 L B+0 A+0 R0 FMAX
4 PLANE RESET STAY
5 ;
6 TOOL DEF 29
7 TOOL CALL 29 S3000 F300
8 M3 M7
9 L X-20.71 Y-8 Z+400 R0 FMAX
10 CYCL DEF 208 FREZOVANI DIRY ~
    Q200=+2 ;BEZPEC. VZDALENOST ~
    Q201=-5 ;HLOUBKA ~
    Q206=+300 ;POSUV NA HLOUBKU ~
    Q334=+1 ;HLOUBKA PRISUVU ~
    Q203=+80 ;SOURADNICE POVRCHU ~
    Q204=+50 ;2. BEZPEC.VZDALENOST ~
    Q335=+11.8 ;ZADANY PRUMER ~
    Q342=+0 ;PRUMER PREDVRTANI ~
    Q351=+1 ;ZPUSOB FREZOVANI
11 L X-20.71 Y-8 B+0 R0 FMAX M99
12 L X-20.71 Y-8 B+13.333 R0 FMAX M99
13 L X-20.71 Y-8 B+26.666 R0 FMAX M99
14 L X-20.71 Y-8 B+39.999 R0 FMAX M99
15 L X-20.71 Y-8 B+53.332 R0 FMAX M99
16 L X-20.71 Y-8 B+66.665 R0 FMAX M99
17 L X-20.71 Y-8 B+79.998 R0 FMAX M99
18 L X-20.71 Y-8 B+93.331 R0 FMAX M99
19 L X-20.71 Y-8 B+106.664 R0 FMAX M99
20 L X-20.71 Y-8 B+119.997 R0 FMAX M99
21 L X-20.71 Y-8 B+133.33 R0 FMAX M99
22 L X-20.71 Y-8 B+146.663 R0 FMAX M99
23 L X-20.71 Y-8 B+159.996 R0 FMAX M99
24 L X-20.71 Y-8 B+173.329 R0 FMAX M99
25 L X-20.71 Y-8 B+186.662 R0 FMAX M99
26 L X-20.71 Y-8 B+199.995 R0 FMAX M99
27 L X-20.71 Y-8 B+213.328 R0 FMAX M99
28 L X-20.71 Y-8 B+226.661 R0 FMAX M99
29 L X-20.71 Y-8 B+239.994 R0 FMAX M99
30 L X-20.71 Y-8 B+253.327 R0 FMAX M99
31 L X-20.71 Y-8 B+266.66 R0 FMAX M99
32 L X-20.71 Y-8 B+279.993 R0 FMAX M99
33 L X-20.71 Y-8 B+293.326 R0 FMAX M99
34 L X-20.71 Y-8 B+306.659 R0 FMAX M99
35 L X-20.71 Y-8 B+319.992 R0 FMAX M99
36 L X-20.71 Y-8 B+333.325 R0 FMAX M99
37 L X-20.71 Y-8 B+346.658 R0 FMAX M99
38 ;
39 ;-----
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40 ;
41 L X-20.71 Y-22 B+0 R0 FMAX M99
42 L X-20.71 Y-22 B+13.333 R0 FMAX M99
43 L X-20.71 Y-22 B+26.666 R0 FMAX M99
44 L X-20.71 Y-22 B+39.999 R0 FMAX M99
45 L X-20.71 Y-22 B+53.332 R0 FMAX M99
46 L X-20.71 Y-22 B+66.665 R0 FMAX M99
47 L X-20.71 Y-22 B+79.998 R0 FMAX M99
48 L X-20.71 Y-22 B+93.331 R0 FMAX M99
49 L X-20.71 Y-22 B+106.664 R0 FMAX M99
50 L X-20.71 Y-22 B+119.997 R0 FMAX M99
51 L X-20.71 Y-22 B+133.33 R0 FMAX M99
52 L X-20.71 Y-22 B+146.663 R0 FMAX M99
53 L X-20.71 Y-22 B+159.996 R0 FMAX M99
54 L X-20.71 Y-22 B+173.329 R0 FMAX M99
55 L X-20.71 Y-22 B+186.662 R0 FMAX M99
56 L X-20.71 Y-22 B+199.995 R0 FMAX M99
57 L X-20.71 Y-22 B+213.328 R0 FMAX M99
58 L X-20.71 Y-22 B+226.661 R0 FMAX M99
59 L X-20.71 Y-22 B+239.994 R0 FMAX M99
60 L X-20.71 Y-22 B+253.327 R0 FMAX M99
61 L X-20.71 Y-22 B+266.66 R0 FMAX M99
62 L X-20.71 Y-22 B+279.993 R0 FMAX M99
63 L X-20.71 Y-22 B+293.326 R0 FMAX M99
64 L X-20.71 Y-22 B+306.659 R0 FMAX M99
65 L X-20.71 Y-22 B+319.992 R0 FMAX M99
66 L X-20.71 Y-22 B+333.325 R0 FMAX M99
67 L X-20.71 Y-22 B+346.658 R0 FMAX M99
68 ;
69 ;-----
70 ;
71 L X-20.71 Y-36 B+0 R0 FMAX M99
72 L X-20.71 Y-36 B+13.333 R0 FMAX M99
73 L X-20.71 Y-36 B+26.666 R0 FMAX M99
74 L X-20.71 Y-36 B+39.999 R0 FMAX M99
75 L X-20.71 Y-36 B+53.332 R0 FMAX M99
76 L X-20.71 Y-36 B+66.665 R0 FMAX M99
77 L X-20.71 Y-36 B+79.998 R0 FMAX M99
78 L X-20.71 Y-36 B+93.331 R0 FMAX M99
79 L X-20.71 Y-36 B+106.664 R0 FMAX M99
80 L X-20.71 Y-36 B+119.997 R0 FMAX M99
81 L X-20.71 Y-36 B+133.33 R0 FMAX M99
82 L X-20.71 Y-36 B+146.663 R0 FMAX M99
83 L X-20.71 Y-36 B+159.996 R0 FMAX M99
84 L X-20.71 Y-36 B+173.329 R0 FMAX M99
85 L X-20.71 Y-36 B+186.662 R0 FMAX M99
86 L X-20.71 Y-36 B+199.995 R0 FMAX M99
87 L X-20.71 Y-36 B+213.328 R0 FMAX M99
88 L X-20.71 Y-36 B+226.661 R0 FMAX M99
89 L X-20.71 Y-36 B+239.994 R0 FMAX M99
90 L X-20.71 Y-36 B+253.327 R0 FMAX M99
91 L X-20.71 Y-36 B+266.66 R0 FMAX M99
92 L X-20.71 Y-36 B+279.993 R0 FMAX M99
93 L X-20.71 Y-36 B+293.326 R0 FMAX M99
94 L X-20.71 Y-36 B+306.659 R0 FMAX M99
95 L X-20.71 Y-36 B+319.992 R0 FMAX M99

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96 L   X-20.71   Y-36   B+333.325 R0 FMAX M99
97 L   X-20.71   Y-36   B+346.658 R0 FMAX M99
98 ;
99 ;-----
100 ;
101 L   X-20.71   Y-50   B+0 R0 FMAX M99
102 L   X-20.71   Y-50   B+13.333 R0 FMAX M99
103 L   X-20.71   Y-50   B+26.666 R0 FMAX M99
104 L   X-20.71   Y-50   B+39.999 R0 FMAX M99
105 L   X-20.71   Y-50   B+53.332 R0 FMAX M99
106 L   X-20.71   Y-50   B+66.665 R0 FMAX M99
107 L   X-20.71   Y-50   B+79.998 R0 FMAX M99
108 L   X-20.71   Y-50   B+93.331 R0 FMAX M99
109 L   X-20.71   Y-50   B+106.664 R0 FMAX M99
110 L   X-20.71   Y-50   B+119.997 R0 FMAX M99
111 L   X-20.71   Y-50   B+133.33 R0 FMAX M99
112 L   X-20.71   Y-50   B+146.663 R0 FMAX M99
113 L   X-20.71   Y-50   B+159.996 R0 FMAX M99
114 L   X-20.71   Y-50   B+173.329 R0 FMAX M99
115 L   X-20.71   Y-50   B+186.662 R0 FMAX M99
116 L   X-20.71   Y-50   B+199.995 R0 FMAX M99
117 L   X-20.71   Y-50   B+213.328 R0 FMAX M99
118 L   X-20.71   Y-50   B+226.661 R0 FMAX M99
119 L   X-20.71   Y-50   B+239.994 R0 FMAX M99
120 L   X-20.71   Y-50   B+253.327 R0 FMAX M99
121 L   X-20.71   Y-50   B+266.66 R0 FMAX M99
122 L   X-20.71   Y-50   B+279.993 R0 FMAX M99
123 L   X-20.71   Y-50   B+293.326 R0 FMAX M99
124 L   X-20.71   Y-50   B+306.659 R0 FMAX M99
125 L   X-20.71   Y-50   B+319.992 R0 FMAX M99
126 L   X-20.71   Y-50   B+333.325 R0 FMAX M99
127 L   X-20.71   Y-50   B+346.658 R0 FMAX M99
128 ;
129 ;-----
130 ;
131 L   X-20.71   Y-64   B+0 R0 FMAX M99
132 L   X-20.71   Y-64   B+13.333 R0 FMAX M99
133 L   X-20.71   Y-64   B+26.666 R0 FMAX M99
134 L   X-20.71   Y-64   B+39.999 R0 FMAX M99
135 L   X-20.71   Y-64   B+53.332 R0 FMAX M99
136 L   X-20.71   Y-64   B+66.665 R0 FMAX M99
137 L   X-20.71   Y-64   B+79.998 R0 FMAX M99
138 L   X-20.71   Y-64   B+93.331 R0 FMAX M99
139 L   X-20.71   Y-64   B+106.664 R0 FMAX M99
140 L   X-20.71   Y-64   B+119.997 R0 FMAX M99
141 L   X-20.71   Y-64   B+133.33 R0 FMAX M99
142 L   X-20.71   Y-64   B+146.663 R0 FMAX M99
143 L   X-20.71   Y-64   B+159.996 R0 FMAX M99
144 L   X-20.71   Y-64   B+173.329 R0 FMAX M99
145 L   X-20.71   Y-64   B+186.662 R0 FMAX M99
146 L   X-20.71   Y-64   B+199.995 R0 FMAX M99
147 L   X-20.71   Y-64   B+213.328 R0 FMAX M99
148 L   X-20.71   Y-64   B+226.661 R0 FMAX M99
149 L   X-20.71   Y-64   B+239.994 R0 FMAX M99
150 L   X-20.71   Y-64   B+253.327 R0 FMAX M99
151 L   X-20.71   Y-64   B+266.66 R0 FMAX M99

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152 L X-20.71 Y-64 B+279.993 R0 FMAX M99
153 L X-20.71 Y-64 B+293.326 R0 FMAX M99
154 L X-20.71 Y-64 B+306.659 R0 FMAX M99
155 L X-20.71 Y-64 B+319.992 R0 FMAX M99
156 L X-20.71 Y-64 B+333.325 R0 FMAX M99
157 L X-20.71 Y-64 B+346.658 R0 FMAX M99
158 ;
159 ;-----
160 ;
161 L X-20.71 Y-78 B+0 R0 FMAX M99
162 L X-20.71 Y-78 B+13.333 R0 FMAX M99
163 L X-20.71 Y-78 B+26.666 R0 FMAX M99
164 L X-20.71 Y-78 B+39.999 R0 FMAX M99
165 L X-20.71 Y-78 B+53.332 R0 FMAX M99
166 L X-20.71 Y-78 B+66.665 R0 FMAX M99
167 L X-20.71 Y-78 B+79.998 R0 FMAX M99
168 L X-20.71 Y-78 B+93.331 R0 FMAX M99
169 L X-20.71 Y-78 B+106.664 R0 FMAX M99
170 L X-20.71 Y-78 B+119.997 R0 FMAX M99
171 L X-20.71 Y-78 B+133.33 R0 FMAX M99
172 L X-20.71 Y-78 B+146.663 R0 FMAX M99
173 L X-20.71 Y-78 B+159.996 R0 FMAX M99
174 L X-20.71 Y-78 B+173.329 R0 FMAX M99
175 L X-20.71 Y-78 B+186.662 R0 FMAX M99
176 L X-20.71 Y-78 B+199.995 R0 FMAX M99
177 L X-20.71 Y-78 B+213.328 R0 FMAX M99
178 L X-20.71 Y-78 B+226.661 R0 FMAX M99
179 L X-20.71 Y-78 B+239.994 R0 FMAX M99
180 L X-20.71 Y-78 B+253.327 R0 FMAX M99
181 L X-20.71 Y-78 B+266.66 R0 FMAX M99
182 L X-20.71 Y-78 B+279.993 R0 FMAX M99
183 L X-20.71 Y-78 B+293.326 R0 FMAX M99
184 L X-20.71 Y-78 B+306.659 R0 FMAX M99
185 L X-20.71 Y-78 B+319.992 R0 FMAX M99
186 L X-20.71 Y-78 B+333.325 R0 FMAX M99
187 L X-20.71 Y-78 B+346.658 R0 FMAX M99
188 ;
189 ;-----
190 ;
191 L Z+500 R0 FMAX
192 L B+0 R0 FMAX
193 ;
194 TOOL DEF 23
195 TOOL CALL 23 S1800 F300
196 M3
197 L X-20.71 Y-8 Z+400 R0 FMAX
198 CYCL DEF 200 VRTANI ~
    Q200=+2 ;BEZPEC. VZDALENOST ~
    Q201=-5 ;HLOUBKA ~
    Q206=+1000 ;POSUV NA HLOUBKU ~
    Q202=+5 ;HLOUBKA PRISUVU ~
    Q210=+0 ;CAS.PRODLEVA NAHORE ~
    Q203=+80 ;SOURADNICE POVRCHU ~
    Q204=+50 ;2. BEZPEC.VZDALENOST ~
    Q211=+0 ;CAS. PRODLEVA DOLE

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199 L X-20.71 Y-8 B+0 R0 FMAX M99
200 L X-20.71 Y-8 B+13.333 R0 FMAX M99
201 L X-20.71 Y-8 B+26.666 R0 FMAX M99
202 L X-20.71 Y-8 B+39.999 R0 FMAX M99
203 L X-20.71 Y-8 B+53.332 R0 FMAX M99
204 L X-20.71 Y-8 B+66.665 R0 FMAX M99
205 L X-20.71 Y-8 B+79.998 R0 FMAX M99
206 L X-20.71 Y-8 B+93.331 R0 FMAX M99
207 L X-20.71 Y-8 B+106.664 R0 FMAX M99
208 L X-20.71 Y-8 B+119.997 R0 FMAX M99
209 L X-20.71 Y-8 B+133.33 R0 FMAX M99
210 L X-20.71 Y-8 B+146.663 R0 FMAX M99
211 L X-20.71 Y-8 B+159.996 R0 FMAX M99
212 L X-20.71 Y-8 B+173.329 R0 FMAX M99
213 L X-20.71 Y-8 B+186.662 R0 FMAX M99
214 L X-20.71 Y-8 B+199.995 R0 FMAX M99
215 L X-20.71 Y-8 B+213.328 R0 FMAX M99
216 L X-20.71 Y-8 B+226.661 R0 FMAX M99
217 L X-20.71 Y-8 B+239.994 R0 FMAX M99
218 L X-20.71 Y-8 B+253.327 R0 FMAX M99
219 L X-20.71 Y-8 B+266.66 R0 FMAX M99
220 L X-20.71 Y-8 B+279.993 R0 FMAX M99
221 L X-20.71 Y-8 B+293.326 R0 FMAX M99
222 L X-20.71 Y-8 B+306.659 R0 FMAX M99
223 L X-20.71 Y-8 B+319.992 R0 FMAX M99
224 L X-20.71 Y-8 B+333.325 R0 FMAX M99
225 L X-20.71 Y-8 B+346.658 R0 FMAX M99
226 ;
227 ;-----
228 ;
229 L X-20.71 Y-22 B+0 R0 FMAX M99
230 L X-20.71 Y-22 B+13.333 R0 FMAX M99
231 L X-20.71 Y-22 B+26.666 R0 FMAX M99
232 L X-20.71 Y-22 B+39.999 R0 FMAX M99
233 L X-20.71 Y-22 B+53.332 R0 FMAX M99
234 L X-20.71 Y-22 B+66.665 R0 FMAX M99
235 L X-20.71 Y-22 B+79.998 R0 FMAX M99
236 L X-20.71 Y-22 B+93.331 R0 FMAX M99
237 L X-20.71 Y-22 B+106.664 R0 FMAX M99
238 L X-20.71 Y-22 B+119.997 R0 FMAX M99
239 L X-20.71 Y-22 B+133.33 R0 FMAX M99
240 L X-20.71 Y-22 B+146.663 R0 FMAX M99
241 L X-20.71 Y-22 B+159.996 R0 FMAX M99
242 L X-20.71 Y-22 B+173.329 R0 FMAX M99
243 L X-20.71 Y-22 B+186.662 R0 FMAX M99
244 L X-20.71 Y-22 B+199.995 R0 FMAX M99
245 L X-20.71 Y-22 B+213.328 R0 FMAX M99
246 L X-20.71 Y-22 B+226.661 R0 FMAX M99
247 L X-20.71 Y-22 B+239.994 R0 FMAX M99
248 L X-20.71 Y-22 B+253.327 R0 FMAX M99
249 L X-20.71 Y-22 B+266.66 R0 FMAX M99
250 L X-20.71 Y-22 B+279.993 R0 FMAX M99
251 L X-20.71 Y-22 B+293.326 R0 FMAX M99
252 L X-20.71 Y-22 B+306.659 R0 FMAX M99
253 L X-20.71 Y-22 B+319.992 R0 FMAX M99
254 L X-20.71 Y-22 B+333.325 R0 FMAX M99

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255 L   X-20.71   Y-22   B+346.658 R0 FMAX M99
256 ;
257 ;-----
258 ;
259 L   X-20.71   Y-36   B+0 R0 FMAX M99
260 L   X-20.71   Y-36   B+13.333 R0 FMAX M99
261 L   X-20.71   Y-36   B+26.666 R0 FMAX M99
262 L   X-20.71   Y-36   B+39.999 R0 FMAX M99
263 L   X-20.71   Y-36   B+53.332 R0 FMAX M99
264 L   X-20.71   Y-36   B+66.665 R0 FMAX M99
265 L   X-20.71   Y-36   B+79.998 R0 FMAX M99
266 L   X-20.71   Y-36   B+93.331 R0 FMAX M99
267 L   X-20.71   Y-36   B+106.664 R0 FMAX M99
268 L   X-20.71   Y-36   B+119.997 R0 FMAX M99
269 L   X-20.71   Y-36   B+133.33 R0 FMAX M99
270 L   X-20.71   Y-36   B+146.663 R0 FMAX M99
271 L   X-20.71   Y-36   B+159.996 R0 FMAX M99
272 L   X-20.71   Y-36   B+173.329 R0 FMAX M99
273 L   X-20.71   Y-36   B+186.662 R0 FMAX M99
274 L   X-20.71   Y-36   B+199.995 R0 FMAX M99
275 L   X-20.71   Y-36   B+213.328 R0 FMAX M99
276 L   X-20.71   Y-36   B+226.661 R0 FMAX M99
277 L   X-20.71   Y-36   B+239.994 R0 FMAX M99
278 L   X-20.71   Y-36   B+253.327 R0 FMAX M99
279 L   X-20.71   Y-36   B+266.66 R0 FMAX M99
280 L   X-20.71   Y-36   B+279.993 R0 FMAX M99
281 L   X-20.71   Y-36   B+293.326 R0 FMAX M99
282 L   X-20.71   Y-36   B+306.659 R0 FMAX M99
283 L   X-20.71   Y-36   B+319.992 R0 FMAX M99
284 L   X-20.71   Y-36   B+333.325 R0 FMAX M99
285 L   X-20.71   Y-36   B+346.658 R0 FMAX M99
286 ;
287 ;-----
288 ;
289 L   X-20.71   Y-50   B+0 R0 FMAX M99
290 L   X-20.71   Y-50   B+13.333 R0 FMAX M99
291 L   X-20.71   Y-50   B+26.666 R0 FMAX M99
292 L   X-20.71   Y-50   B+39.999 R0 FMAX M99
293 L   X-20.71   Y-50   B+53.332 R0 FMAX M99
294 L   X-20.71   Y-50   B+66.665 R0 FMAX M99
295 L   X-20.71   Y-50   B+79.998 R0 FMAX M99
296 L   X-20.71   Y-50   B+93.331 R0 FMAX M99
297 L   X-20.71   Y-50   B+106.664 R0 FMAX M99
298 L   X-20.71   Y-50   B+119.997 R0 FMAX M99
299 L   X-20.71   Y-50   B+133.33 R0 FMAX M99
300 L   X-20.71   Y-50   B+146.663 R0 FMAX M99
301 L   X-20.71   Y-50   B+159.996 R0 FMAX M99
302 L   X-20.71   Y-50   B+173.329 R0 FMAX M99
303 L   X-20.71   Y-50   B+186.662 R0 FMAX M99
304 L   X-20.71   Y-50   B+199.995 R0 FMAX M99
305 L   X-20.71   Y-50   B+213.328 R0 FMAX M99
306 L   X-20.71   Y-50   B+226.661 R0 FMAX M99
307 L   X-20.71   Y-50   B+239.994 R0 FMAX M99
308 L   X-20.71   Y-50   B+253.327 R0 FMAX M99
309 L   X-20.71   Y-50   B+266.66 R0 FMAX M99
310 L   X-20.71   Y-50   B+279.993 R0 FMAX M99

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311 L X-20.71 Y-50 B+293.326 R0 FMAX M99
312 L X-20.71 Y-50 B+306.659 R0 FMAX M99
313 L X-20.71 Y-50 B+319.992 R0 FMAX M99
314 L X-20.71 Y-50 B+333.325 R0 FMAX M99
315 L X-20.71 Y-50 B+346.658 R0 FMAX M99
316 ;
317 ;-----
318 ;
319 L X-20.71 Y-64 B+0 R0 FMAX M99
320 L X-20.71 Y-64 B+13.333 R0 FMAX M99
321 L X-20.71 Y-64 B+26.666 R0 FMAX M99
322 L X-20.71 Y-64 B+39.999 R0 FMAX M99
323 L X-20.71 Y-64 B+53.332 R0 FMAX M99
324 L X-20.71 Y-64 B+66.665 R0 FMAX M99
325 L X-20.71 Y-64 B+79.998 R0 FMAX M99
326 L X-20.71 Y-64 B+93.331 R0 FMAX M99
327 L X-20.71 Y-64 B+106.664 R0 FMAX M99
328 L X-20.71 Y-64 B+119.997 R0 FMAX M99
329 L X-20.71 Y-64 B+133.33 R0 FMAX M99
330 L X-20.71 Y-64 B+146.663 R0 FMAX M99
331 L X-20.71 Y-64 B+159.996 R0 FMAX M99
332 L X-20.71 Y-64 B+173.329 R0 FMAX M99
333 L X-20.71 Y-64 B+186.662 R0 FMAX M99
334 L X-20.71 Y-64 B+199.995 R0 FMAX M99
335 L X-20.71 Y-64 B+213.328 R0 FMAX M99
336 L X-20.71 Y-64 B+226.661 R0 FMAX M99
337 L X-20.71 Y-64 B+239.994 R0 FMAX M99
338 L X-20.71 Y-64 B+253.327 R0 FMAX M99
339 L X-20.71 Y-64 B+266.66 R0 FMAX M99
340 L X-20.71 Y-64 B+279.993 R0 FMAX M99
341 L X-20.71 Y-64 B+293.326 R0 FMAX M99
342 L X-20.71 Y-64 B+306.659 R0 FMAX M99
343 L X-20.71 Y-64 B+319.992 R0 FMAX M99
344 L X-20.71 Y-64 B+333.325 R0 FMAX M99
345 L X-20.71 Y-64 B+346.658 R0 FMAX M99
346 ;
347 ;-----
348 ;
349 L X-20.71 Y-78 B+0 R0 FMAX M99
350 L X-20.71 Y-78 B+13.333 R0 FMAX M99
351 L X-20.71 Y-78 B+26.666 R0 FMAX M99
352 L X-20.71 Y-78 B+39.999 R0 FMAX M99
353 L X-20.71 Y-78 B+53.332 R0 FMAX M99
354 L X-20.71 Y-78 B+66.665 R0 FMAX M99
355 L X-20.71 Y-78 B+79.998 R0 FMAX M99
356 L X-20.71 Y-78 B+93.331 R0 FMAX M99
357 L X-20.71 Y-78 B+106.664 R0 FMAX M99
358 L X-20.71 Y-78 B+119.997 R0 FMAX M99
359 L X-20.71 Y-78 B+133.33 R0 FMAX M99
360 L X-20.71 Y-78 B+146.663 R0 FMAX M99
361 L X-20.71 Y-78 B+159.996 R0 FMAX M99
362 L X-20.71 Y-78 B+173.329 R0 FMAX M99
363 L X-20.71 Y-78 B+186.662 R0 FMAX M99
364 L X-20.71 Y-78 B+199.995 R0 FMAX M99
365 L X-20.71 Y-78 B+213.328 R0 FMAX M99
366 L X-20.71 Y-78 B+226.661 R0 FMAX M99

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367 L X-20.71 Y-78 B+239.994 R0 FMAX M99
368 L X-20.71 Y-78 B+253.327 R0 FMAX M99
369 L X-20.71 Y-78 B+266.66 R0 FMAX M99
370 L X-20.71 Y-78 B+279.993 R0 FMAX M99
371 L X-20.71 Y-78 B+293.326 R0 FMAX M99
372 L X-20.71 Y-78 B+306.659 R0 FMAX M99
373 L X-20.71 Y-78 B+319.992 R0 FMAX M99
374 L X-20.71 Y-78 B+333.325 R0 FMAX M99
375 L X-20.71 Y-78 B+346.658 R0 FMAX M99
376 ;
377 ;-----
378 ;
379 M9
380 L Z+500 R0 FMAX
381 L B+0 Y+250 R0 FMAX
382 M30
383 ;
384 END PGM Maly Rovder MM
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