

(2016/03/28 V13. 6G\_C32 20160107 柱底付);

( PL ON OFF IP SV S UP DN JS LNS STEP V HP PP C ALV OC  
LF JM LS LNM);

C003 = + 0125 0040 002.4 050 22 010 020 010 0000 0.0000 02 000 01 0 2100 000  
0 0002 02 02 300;

C002 = + 0070 0040 001.6 050 62 012 030 005 0000 0.0000 02 000 01 0 0005 000  
0 0002 00 03 300;

C001 = + 0040 0030 001.1 070 63 018 040 002 0000 0.0000 02 000 00 0 0005 000  
0 1502 00 03 300;

;

H005 = +000000.0001 (飛び先 123:荒・中・仕、1:荒、13:荒・仕、12:荒・中、 );  
( 2:中、23:中・仕、3:仕 );

H017 = +000000.0000 (1:COMBINATION );

H002 = -000000.5000 (MACHINING DEPTH );

H019 = +000000.0000 (LNS );

H018 = +000000.0003 (LNM );

H011 = +000000.0900 (EL1 UNDER SIZE );

H012 = +000000.0000 (EL2 UNDER SIZE );

H013 = +000000.0000 (EL3 UNDER SIZE );

H027 = +000001.0000 (干渉回避位置 );

H010 = +000000.0000 (EL PROCESS NO. );

H028 = +000000.0000 (SIDE OFFSET );

H030 = +000000.0000 (BOTTOM OFFSET );

H048 = +000000.0000 (CONDITION COUNT );

H000 = +000049.0000 (投影面積 );

H003 = +000000.5000 (ACTUAL DEPTH );

H008 = +000095.0101 (CONDITION );

H009 = +000000.0000 (TIMER FOR BOTTOM );

H039 = +000000.0000 (TIMER FOR SIDE );

H001 = +000000.0000 (MACHINING DIRECTION );

H007 = +000000.0000 (ABS/INC );

H006 = +000000.0000 (SIDE MACHINING AREA );

H025 = +000000.0150 (SIDE 逃げ量 );

H026 = +000000.0200 (BOTTOM 逃げ量 );

H032 = +000000.0000 (LORAN ROTATION );

H037 = +000000.0000 (LP );

;

G90;

H900=H027 H940=0 H941=0 H942=1 H943=0 H950=1 H951=0 H952=0 H910=0 H947=0 H960=0;

IFH005=3(1100);

IFH005=23(1110);

IFH005=2(1110);

JUMP1120;

N1100 H942=3;

G83 Z920;

JUMP2300;

N1110 H942=2;

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G83 Z920;
JUMP2200;
N1120;
G83 Z920;
;
N2100;
CRT(- EL1-C003-HOLE1 -);
M98P2001;
CRT(- EL1-C002-HOLE1 -);
M98P2002;
CRT(- EL1-C001-HOLE1 -);
M98P2003;
;
N2200;
N2300;
N2400;
IF H017=1(9999);
M02;
;
N2001;
C003;
H010=1 H048=1 H028=0.0800 H030=0.1200 H039=0 H009=0;
M98 P3100;
M99;
N2002;
C002;
H010=1 H048=2 H028=0.0470 H030=0.0790 H039=0 H009=0;
M98 P3100;
M99;
N2003;
C001;
H010=1 H048=3 H028=0.0271 H030=0.0520 H039=0 H009=0;
M98 P3100;
M99;
;
(V13.0A_C32 0111 STANDARD NC);
N3100 (***** PATTERN 1 *****);
G183F0060923;
IF H923<1(3110);
M99;
N3110;
M98 P3500;
M98 P3600;
JUMP 3900;
;
N3200 (***** PATTERN 2 3 *****);
N3300;
G183F0060923;
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IF H923<1 (3210) ;
M99;
N3210;
M98 P3500;
M98 P3600;
JUMP 3900;
;
N3500      (*****  PARAMETER SET UP  *****) ;
MDIV16 A0D0.030 LEJL0.150 LEJS90.0;
G25;
LNMH018 LNSH019 LPH037;
G85 T H009;
N3530      ( **  WITH ROTATION  ** );
IF H960=0 (3550) ;
IF H001>0 (3550) ;
G83 U947;
LAH032+H947;
G326;
M99;
N3550;
LAH032;
G326;
M99;
;
N3600 (*****  MACHINING  *****) ;
G90+H007;
IF H048=801 (3605) ;
IF H048=1 (3608, 3610) ;
N3605;
G85 ZH009;
N3608;
STEP0      ( **  1ST MACHINING  ** );
G01 Z+H002+H030 M04;
M99;
N3610;
IF H048>800 (, 3660) ;
N3620      ( **  TIMER MACHINING  ** );
LSEA15.0;
IF H009=0 (3640) ;
IF H009>30 (3630) ;
H009=30;
N3630 G85 ZH009      (**  BOTTOM  ** );
M98 P3800      ( **  SET STEP  ** );
G01 Z+H002+H030 M04;
N3640;
IF H039=0 (3655) ;
IF H039>30 (3650) ;
H039=30;

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N3650 G85 ZH039                ( ** SIDE ** );
M98 P3700                       ( ** SET STEP ** );
G01 Z+H002+H030+H026 M04;
N3655;
LSEA5. 0;
M99;
N3660                ( ** 2ND MACH. AND LATER ** );
G83 IP915;
IF H915>70 (3670)                ( ** IP>7 ** );
IF H000<10. 0/1/1 (3670)        ( ** AREA<10SQ ** );
IF H[010+H010]-H028-H025<0. 003/1 (3670);
STEP0+H[010+H010]-H028-H025;
LSEA5. 0;
G01 Z+H002+H030+0 M04          ( ** BOTTOM ** );
M98 P3700                       ( ** SET STEP ** );
LSEA15. 0;
G85 T H039;
G01 Z+H002+H030+H026 M04      ( ** SIDE ** );
JUMP3673;
N3670;
M98 P3700                       ( ** SET STEP ** );
LSEA5. 0;
G01 Z+H002+H030 M04           ( ** ALL ** );
N3673;
LSEA5. 0;
M99;
;
N3700 (***** SET STEP 1 *****);
IF H[010+H010]-H028<0. 003/1 (3710);
STEP0+H[010+H010]-H028;
JUMP3720;
N3710;
STEP0;
N3720;
M99;
;
N3800 (***** SET STEP 2 *****);
IF H[010+H010]-H028-H025<0. 003/1 (3810);
STEP0+H[010+H010]-H028-H025;
JUMP3820;
N3810;
STEP0;
N3820;
M99;
;
N3900 (***** READ TIME *****);
G327;
G90;

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```
G83 T[300+H952];  
H[301+H952]=99999;  
IF H952>100(3999);  
H952=H952+1;  
M99;  
N3999;  
H952=0;  
M99;  
N9999;
```