20170101.NC

```
(2003/01/01 V13.6G_C32 20170101 柱底付);
(        PL  ON   OFF    IP   SV  S  UP  DN  JS  LNS  STEP    V  HP PP C  ALV  OC
   LF  JM LS LNM);
C006   =  + 0149 0035 004.3 048 22 010 067 010 0000 0.0000  02 000 00 0 2100 000
0 1502 02 02 000;
C005   =  + 0115 0033 003.3 060 42 010 059 010 0000 0.0000  03 000 00 0 0015 000
0 1502 02 02 000;
C004   =  + 0055 0023 001.6 059 52 012 056 005 0000 0.0000  03 000 00 0 0015 000
0 1302 02 03 000;
C003   =  + 0023 0015 001.3 061 53 015 057 003 0000 0.0000  03 000 00 0 0015 000
0 1202 02 03 000;
C002   =  + 0009 0009 000.5 069 63 018 068 002 0000 0.0000  03 000 00 0 0015 000
0 1202 02 04 000;
C801   =  - 0002 0020 001.6 085 75 020 086 003 0000 0.0000  02 000 10 5 0015 000
0 1302 02 05 000;
;
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   = +000000.1600   (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   = +000625.0000   (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;
```

```
 53 JUMP2300;
 54 N1110 H942=2;
 55 G83 Z920;
 56 JUMP2200;
 57 N1120;
 58 G83 Z920;
 59 ;
 60 N2100;
 61 CRT(- EL1-C006-HOLE1 -);
 62 M98P2001;
 63 CRT(- EL1-C005-HOLE1 -);
 64 M98P2002;
 65 CRT(- EL1-C004-HOLE1 -);
 66 M98P2003;
 67 CRT(- EL1-C003-HOLE1 -);
 68 M98P2004;
 69 CRT(- EL1-C002-HOLE1 -);
 70 M98P2005;
 71 CRT(- EL1-C801-HOLE1 -);
 72 M98P2006;
 73 ;
 74 N2200;
 75 N2300;
 76 N2400;
 77 IF H017=1(9999);
 78 M02;
 79 ;
 80 N2001;
 81 C006;
 82 H010=1 H048=1 H028=0.1571 H030=0.1724 H039=0 H009=0;
 83 M98 P3100;
 84 M99;
 85 N2002;
 86 C005;
 87 H010=1 H048=2 H028=0.0987 H030=0.1296 H039=0 H009=0;
 88 M98 P3100;
 89 M99;
 90 N2003;
 91 C004;
 92 H010=1 H048=3 H028=0.0688 H030=0.0825 H039=0 H009=0;
 93 M98 P3100;
 94 M99;
 95 N2004;
 96 C003;
 97 H010=1 H048=4 H028=0.0468 H030=0.0535 H039=0 H009=0;
 98 M98 P3100;
 99 M99;
100 N2005;
101 C002;
102 H010=1 H048=5 H028=0.0222 H030=0.0224 H039=0 H009=0;
103 M98 P3100;
104 M99;
```

```
 105 N2006;
 106 C801;
 107 H010=1 H048=806 H028=0.0120 H030=0.0062 H039=100 H009=1127;
 108 M98 P3100;
 109 M99;
 110 ;
 111 (V13.0A_C32 0111 STANDARD NC);
 112 N3100 (*************** PATTERN 1 ***************);
 113 G183F0060923;
 114 IF H923<1(3110);
 115 M99;
 116 N3110;
 117 M98 P3500;
 118 M98 P3600;
 119 JUMP 3900;
 120 ;
 121 N3200 (*************  PATTERN 2 3  *************);
 122 N3300;
 123 G183F0060923;
 124 IF H923<1(3210);
 125 M99;
 126 N3210;
 127 M98 P3500;
 128 M98 P3600;
 129 JUMP 3900;
 130 ;
 131 N3500    (********   PARAMETER SET UP **********);
 132 MDIV16 A0D0.030 LEJL0.150 LEJS90.0;
 133 G25;
 134 LNMH018 LNSH019 LPH037;
 135 G85 T H009;
 136 N3530                  ( **   WITH ROTATION   ** );
 137 IF H960=0(3550);
 138 IF H001>0(3550);
 139 G83 U947;
 140 LAH032+H947;
 141 G326;
 142 M99;
 143 N3550;
 144 LAH032;
 145 G326;
 146 M99;
 147 ;
 148 N3600(*************   MACHINING   **************);
 149 G90+H007;
 150 IF H048=801(3605);
 151 IF H048=1(3608,3610);
 152 N3605;
 153 G85 ZH009;
 154 N3608;
 155 STEP0                    ( **  1ST MACHINING  ** );
 156 G01 Z+H002+H030 M04;
```

```
 157 M99;
 158 N3610;
 159 IF H048>800(,3660);
 160 N3620                  ( **  TIMER MACHINING  ** );
 161 LSEA15.0;
 162 IF H009=0(3640);
 163 IF H009>30(3630);
 164 H009=30;
 165 N3630 G85 ZH009                 (**  BOTTOM  ** );
 166 M98 P3800                      ( ** SET STEP ** );
 167 G01 Z+H002+H030 M04;
 168 N3640;
 169 IF H039=0(3655);
 170 IF H039>30(3650);
 171 H039=30;
 172 N3650 G85 ZH039                    ( ** SIDE ** );
 173 M98 P3700                      ( ** SET STEP ** );
 174 G01 Z+H002+H030+H026 M04;
 175 N3655;
 176 LSEA5.0;
 177 M99;
 178 N3660               ( ** 2ND MACH. AND LATER ** );
 179 G83 IP915;
 180 IF H915>70(3670)                   ( ** IP>7 ** );
 181 IF H000<10.0/1/1(3670)         ( ** AREA<10SQ ** );
 182 IF H[010+H010]-H028-H025<0.003/1(3670);
 183 STEP0+H[010+H010]-H028-H025;
 184 LSEA5.0;
 185 G01 Z+H002+H030+0 M04            ( ** BOTTOM ** );
 186 M98 P3700                      ( ** SET STEP ** );
 187 LSEA15.0;
 188 G85 T H039;
 189 G01 Z+H002+H030+H026 M04           ( ** SIDE ** );
 190 JUMP3673;
 191 N3670;
 192 M98 P3700                      ( ** SET STEP ** );
 193 LSEA5.0;
 194 G01 Z+H002+H030 M04                ( ** ALL ** );
 195 N3673;
 196 LSEA5.0;
 197 M99;
 198 ;
 199 N3700(**************   SET STEP 1  **************);
 200 IF H[010+H010]-H028<0.003/1(3710);
 201 STEP0+H[010+H010]-H028;
 202 JUMP3720;
 203 N3710;
 204 STEP0;
 205 N3720;
 206 M99;
 207 ;
 208 N3800(**************   SET STEP 2  **************);
```

```
 209 IF H[010+H010]-H028-H025<0.003/1(3810);
 210 STEP0+H[010+H010]-H028-H025;
 211 JUMP3820;
 212 N3810;
 213 STEP0;
 214 N3820;
 215 M99;
 216 ;
 217 N3900 (*************   READ TIME   *************);
 218 G327;
 219 G90;
 220 G83 T[300+H952];
 221 H[301+H952]=99999;
 222 IF H952>100(3999);
 223 H952=H952+1;
 224 M99;
 225 N3999;
 226 H952=0;
 227 M99;
 228 N9999;
```