

```

1 (2018/04/19 V13.6G_C32 20180101 柱底付);
2 (      PL ON OFF IP SV S UP DN JS LNS STEP V HP PP C ALV OC
3 LF JM LS LNM);
4 C006 = + 0149 0035 004.3 048 22 010 067 010 0000 0.0000 02 000 00 0 2100 000
5 0 1502 02 02 003;
6 C005 = + 0115 0033 003.3 060 42 010 059 010 0000 0.0595 03 000 00 0 0015 000
7 0 1502 02 02 003;
8 C004 = + 0055 0023 001.6 059 52 012 056 005 0000 0.0894 03 000 00 0 0015 000
9 0 1302 02 03 003;
10 C003 = + 0023 0015 001.3 061 53 015 057 003 0000 0.1114 03 000 00 0 0015 000
11 0 1202 02 03 003;
12 C002 = + 0009 0009 000.5 069 63 018 068 002 0000 0.1360 03 000 00 0 0015 000
13 0 1202 02 04 003;
14 C801 = - 0000 0015 001.6 085 75 020 086 003 0000 0.1505 02 000 10 4 0015 000
15 0 1302 02 05 003;
16 ;
17 H005 = +000000.0001 (飛び先 123:荒・中・仕、1:荒、13:荒・仕、12:荒・中、 );
18 ( 2:中、23:中・仕、3:仕 );
19 H017 = +000000.0000 (1:COMBINATION );
20 H002 = -000001.0000 (MACHINING DEPTH );
21 H019 = +000000.0000 (LNS );
22 H018 = +000000.0003 (LNM );
23 H011 = +000000.1600 (EL1 UNDER SIZE );
24 H012 = +000000.0000 (EL2 UNDER SIZE );
25 H013 = +000000.0000 (EL3 UNDER SIZE );
26 H027 = +000001.0000 (干涉回避位置 );
27 H010 = +000000.0001 (EL PROCESS NO. );
28 H028 = +000000.0095 (SIDE OFFSET );
29 H030 = +000000.0036 (BOTTOM OFFSET );
30 H048 = +000000.0806 (CONDITION COUNT );
31 H000 = +000625.0000 (投影面積 );
32 H003 = +000001.0000 (ACTUAL DEPTH );
33 H008 = +000095.0101 (CONDITION );
34 H009 = +000000.1845 (TIMER FOR BOTTOM );
35 H039 = +000000.0100 (TIMER FOR SIDE );
36 H001 = +000000.0000 (MACHINING DIRECTION );
37 H007 = +000000.0000 (ABS/INC );
38 H006 = +000000.0000 (SIDE MACHINING AREA );
39 H025 = +000000.0150 (SIDE 逃げ量 );
40 H026 = +000000.0200 (BOTTOM 逃げ量 );
41 H032 = +000000.0000 (LORAN ROTATION );
42 H037 = +000000.0000 (LP );
43 ;
44 G90;
45 H900=H027 H940=0 H941=0 H942=1 H943=0 H950=1 H951=0 H952=0 H910=0 H947=0 H960=0;
46
47 IFH005=3(1100);
48 IFH005=23(1110);
49 IFH005=2(1110);
50 JUMP1120;
51 N1100 H942=3;
52 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=0.1589 H030=0.1749 H039=0 H009=0;
83 M98 P3100;
84 M99;
85 N2002;
86 C005;
87 H010=1 H048=2 H028=0.1005 H030=0.1321 H039=0 H009=0;
88 M98 P3100;
89 M99;
90 N2003;
91 C004;
92 H010=1 H048=3 H028=0.0706 H030=0.0850 H039=0 H009=0;
93 M98 P3100;
94 M99;
95 N2004;
96 C003;
97 H010=1 H048=4 H028=0.0486 H030=0.0560 H039=0 H009=0;
98 M98 P3100;
99 M99;
100 N2005;
101 C002;
102 H010=1 H048=5 H028=0.0240 H030=0.0249 H039=0 H009=0;
103 M98 P3100;
104 M99;
105 N2006;
106 C801;
107 H010=1 H048=806 H028=0.0095 H030=0.0036 H039=100 H009=1845;
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 AOD0.030 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;
```