

name MTS FREZKA

DRIVE *.fnc

% 00

(0

) 0

O >4

N 4

G 2

g >2 G

X +-3.3

Y +-3.3

Z +-3.3

W +>2.>2

I +-3.3

J +-3.3

K +-3.3

Q ->3.>4

D >2

d >2

R ->3.>4

P ->3.>4

H >2

T 2 limit 1 99

t 2 limit 1 99

S 4

A +3.3

B +3.3

F 4.3

M 2

ModalLetters F # List of letters that are modal

ModalGs 73 74 76 79 81 82 84 85 # List of g codes that are modal

Sequence#s N 1 10 10 # Char, freq, incr & start

First#? Y # Y or N 'Output 1st sequence no.

Last#? Y # Y or N 'Output last sequence no.

HCode X # X or X U 'Horizontal char.

VCode Y # Y or Y V 'Vertical char.

Dcode Z # Depth char.

FeedCode F # Feed rate char.

Comment () # Begin End comment char.

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Spindle 3 4 5          # Cw, ccw & stop m codes
Coolant 8 9 7         # On, Off & Mist m codes
DComp 41 42 40        # Left, Right & Cancel m codes
LComp 43 49           # On & Off codes

Feed G1               # Linear move
Rapid G0              # Rapid positioning word
Cw G2                 # Circular move clockwise
Ccw G3                # Circular move counter clockwise

Inc/Abs G 91 90      # Inc & Abs char. & values

CtrCode I J          # I J or R or I J K L
Helical? Y
Spaces? Y            # Y or N 'Spaces between words

Incremental? N        # Y or N 'Inc or abs output
CtrIncremental? Y    # Y or N 'Inc or abs I & J
ByQuadrants? N       # Y or N 'Break arcs at quadrants

UppercaseComments? Y      # Y or N 'Require uppercase comments

Drill                 # Vrtac•yklus/manual cycle
G81 Z[D]
G79
end cancel

Peck                  # Vrtac•yklus s v•n•b. d•n•tø•y
G83 Z[D] K[VBite] A<1> B<1>
G79
end cancel

Tap                   # Tapping canned/manual cycle
G84
G79
end cancel

LTap                 # Left handed tapping cycle
G74 X[H] Y[V] Z[D] W[Vclear] F[FRate]
G79
end cancel

Ream                  # cyklus vystružov•
G85 Z[D]

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G79
end cancel

Bore                # cyklus vyvrt•n•
G86 Z[D]
G79
end cancel

Cancel              # Cancel a canned/manual cycle
G79
end

StartCode           # Start of the program
G90
End

1stToolChange       # First tool change
T[Tool] t[Tool] M6 M[Direct] S[Speed] F[FRate]
G0 X[H] Y[V]
Z[D] M[Cool]
End

Infeed              # Enable cutter comp
G<Side>
G1 X[H] Y[V] Z[D] F[Frate]
end

Outfeed             # Disable cutter comp
G40
G1 X[H] Y[V]
Z[D]
end

ToolChange          # Secondary tool changes
M9
G26
T[Tool] t[Tool] M6 M[Direct] S[Speed] F[FRate]
G0 G90 X[H] Y[V]
Z[D]
M[Cool]
End

EndCode             # End of the program
G0
G26
M30
```

End

Replace " t" with ""