



























50 L	X-49.45	
51 L	Y-49.45	
52 L	X+49.45	
53 L	Y+65	
54 L	Z+10 Y+80 R0	
55 L	Z+150 R0 F3000	
56 CYCL DEF 7.0 DATUM SHIF		偏移座標原點
57 CYCL DEF 7.1 X+0		
58 CYCL DEF 7.2 Y+49.45		
59 CYCL DEF 7.3 Z+0		
60 CYCL DEF 19.0 WORKING PLANE		定義
61 CYCL DEF 19.1 A-90 C+0		
62 L A-90 C+0 R0 F2000		動作
63 CALL LBL 1		
64 M3		
65 CYCL DEF 7.0 DATUM SHIFT		偏移回原點(取消先前定義)
66 CYCL DEF 7.1 X+0		
67 CYCL DEF 7.2 Y+0		
68 CYCL DEF 7.3 Z+0		
69 CYCL DEF 19.0 WORKING PLANE		定義(回一開始的座標)
70 CYCL DEF 19.1		
71 CYCL DEF 7.0 DATUM SHIFT		
72 CYCL DEF 7.1 X-49.45		
73 CYCL DEF 7.2 Y+0		
74 CYCL DEF 7.3 Z+0		
75 CYCL DEF 19.0 WORKING PLANE		

76 CYCL DEF 19.1 A-90 C+90

77 L A-90 C+90 R0 F2000

78 CALL LBL 1

79 CYCL DEF 7.0 DATUM SHIFT

80 CYCL DEF 7.1 X+0

81 CYCL DEF 7.2 Y+0

82 CYCL DEF 7.3 Z+0

83 CYCL DEF 19.0 WORKING PLANE

84 CYCL DEF 19.1

85 CYCL DEF 7.0 DATUM SHIFT

86 CYCL DEF 7.1 X+0

87 CYCL DEF 7.2 Y-49.45

88 CYCL DEF 7.3 Z+0

89 CYCL DEF 19.0 WORKING PLANE

90 CYCL DEF 19.1 A-90 C-180

91 L A-90 C-180 R0 F2000

92 CALL LBL 1

93 CYCL DEF 7.0 DATUM SHIFT

94 CYCL DEF 7.1 X+0

95 CYCL DEF 7.2 Y+0

96 CYCL DEF 7.3 Z+0

97 CYCL DEF 19.0 WORKING PLANE

98 CYCL DEF 19.1

99 CYCL DEF 7.0 DATUM SHIFT

100 CYCL DEF 7.1 X+49.45

101 CYCL DEF 7.2 Y+0



102 CYCL DEF 7.3 Z+0  
103 CYCL DEF 19.0 WORKING PLANE  
104 CYCL DEF 19.1 A-90 C+270  
105 L A-90 C+270 R0 F2000  
106 CALL LBL 1  
107 CYCL DEF 7.0 DATUM SHIFT  
108 CYCL DEF 7.1 X+0  
109 CYCL DEF 7.2 Y+0  
110 CYCL DEF 7.3 Z+0  
111 CYCL DEF 19.0 WORKING PLANE  
112 CYCL DEF 19.1  
113 L A+0 C+0 R0 F2000  
114 CYCL DEF 19.0 WORKING PLANE  
115 CYCL DEF 19.1  
116 M30  
117 LBL 1  
118 L X-48.1 Y-20 Z-5 RL F1000  
119 L Y+10.2  
120 L X+48.1  
121 L Y-20  
122 L Z-10 X-48.1  
123 L Y+10.2  
124 L X+48.1  
125 L Y-20  
126 L X-48  
127 L Y+10



副程式

章節：操作程序

128 L X+48

129 L Y-20

130 L Z+150 R0 F3000

131 LBL 0

132 END PGM 19 MM

提高 Z 軸至安全區域



章節：操作程序