

PROGRAMA 4095

PROCURE SEMPRE UTILIZAR SUB-ROTINAS

ANOTE TODAS DIFICULDADES DO PREPARO

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%_N_4095_MPF
;$PATH=/_N_MPF_DIR
;TAMPA DO MANCAL
;COLOCAR EM N6 O PCNUMERO CORRETO

N1 DEF REAL TX,TZ,CC1,CC2,CC3,CC4,CC5,CC6

N2 DEF REAL CC7,CC8,DD1,DD2,DD3,CA2,CA3,CH1
N3 DEF REAL DD4,DD5,DD6,DD7,DD8,DD9,BB1,BB2
N4 DEF REAL BB3,BB4,BB5,BB6,BB7,BB8,BB9,CA1
N5 DEF REAL RT1,RT2,AV1,AV2,AV3,PR1,PR2,LA1

N6 GOTOF FIM

N10 PC1:
N11 ;SIGA CODIGO
N12 ;RPM=0 CAST.=0
N13 TX=0 TZ=0 CC1=0 CC2=0 CC3=0 CC4=0 CC5=0
N14 CC8=0 DD1=0 DD2=0 DD3=0 DD4=0 DD5=0
N15 DD6=0 DD7=0 DD8=0 DD9=0 CH1=0 LA1=0
N16 BB1=0 BB2=0 BB3=0 BB4=0 BB5=0 BB6=0
N17 BB7=0 BB8=0 BB9=0 RT1=0 RT2=0
N18 AV1=0 AV2=0 AV3=0 PR1=0 PR2=0
N19 GOTOF INICIO:

N1000 INICIO:
N1010 G0 G53 X=TX Z=TZ D0 M3 M9 S48
N1020 T1 M6 D1 ; DESB. E ACAB. EXT. LADO 1
N1030 G54 S=RT1 F=AV2 M8
N1040 CA1=BB7-BB5
N1050 ; FACEAR CC2
N1060 CYCLE412(BB2,CA1,BB1,CC2,PR2)
N1070 F=AV1 ; DIA. DD5+1
N1080 CYCLE407(BB2,CC2,DD5+1,BB6,PR1,0)
N1090 F=AV2 ; FACEAR CC5
N1100 CYCLE412(BB4,BB6,DD5+1,CC5,PR2)
N1110 F=AV1 ; DIA. DD6+1
N1120 CYCLE407(BB4,BB6,DD6+1,-3,PR1,0)
N1130 Z=CC2+3
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N1140 X=DD5-4
N1150 CA1=DD5-CH1-CH1
N1160 G1 X=CA1 Z=CC2 F1.9
N1170 CA1=CC2-CH1
N1180 X=DD5 Z=CA1 F=AV2
N1190 Z=CC5
N1200 CA1=DD6-CH1-CH1
N1210 X=CA1
N1220 CA1=CC5-CH1
N1230 X=DD6 Z=CA1
N1240 Z-3
N1250 G0 G53 X=TX Z=TZ D0 M3 M9 S48
N1260 T2 M6 D1 ; DESB. E ACAB. INT. LADO 2
N1270 G54 S=RT2 F=AV1 M8
N1280 CA1=CC2-CC1
N1290 CYCLE408(BB1,CC2,DD1-1,CA1,PR1,0)
N1300 X=DD2+4 Z=CC2+3
N1310 G1 X=DD2 Z=CC2 F1.9
N1320 CA1=CC2-CC3
N1330 X=DD1 Z=CA1 F=PR2
N1340 CA1=CC2-CC1
N1350 Z=CA1
N1360 G0 X=DD1-4 Z=CC2+3
N1370 G0 G53 X=TX Z=TZ D0 M3 M9 S48
N1380 T3 M6 D1 ; CANAL DA FACE
N1390 ; CORRETOR DIA. < DO CANAL
N1400 G54 X=DD3-3 Z=CC2+3 S=RT1 M8
N1410 G1 X=DD3 Z=CC2 F1.9
N1420 CA1=CC2-CC4
N1430 Z=CA1 F=AV3
N1440 G0 Z=CC2+3
N1450 T3 D2 ; CORRETOR DA OUTRA ARESTA
N1460 CA2=DD3+LA1+LA1
N1470 F=AV3
N1480 CYCLE408(CA2,CC2,DD4,CA1,LA1-1,0)
N1490 GOTOF FIM

N1500 G0 G53 X=TX Z=TZ D0 M3 M9 S48
N1510 T1 M6 D1 ; DESB. E ACAB. LADO 2
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N1520 G54 S=RT1 F=AV2 M8
N1530 ;FACEAR CC7
N1540 CYCLE412 (DD6,CC5,BB3,CC7+0.1,PR2)
N1550 ;FACEAR CC8
N1560 CA1=CC5+BB5 CA2=CC7+CC8
N1570 CYCLE412 (BB3,CA1,BB8,CA2,PR2)
N1580 ;DIA. DD9
N1590 CYCLE407 (BB3,CA2,DD9+1,CC7,PR1,0)
N1600 CA1=DD9-CH1-CH1
N1610 G0 X=CA1-3 Z=CA2+3
N1620 G1 X=CA1 Z=CA2 F1.9
N1630 CA1=CA2-CH1
N1640 X=DD9 Z=CA1 F=AV2
N1650 Z=CC7
N1660 CA1=DD6-CH1-CH1
N1670 X=CA1
N1680 CA1=CC7-CH1
N1690 X=DD6 Z=CA1
N1700 GOTO FIM
N1710 G0 G53 X=TX Z=TZ D0 M3 M9 S48
N1720 T2 M6 D1 ; DESB. E ACAB. INT.
N1730 G54 S=RT2 F=AV2 M8
N1740 CA1=CC7+CC8 CA2=DD7-RA1-RA1 CA3=CA1-
CC6+.1
N1750 CYCLE408 (DD1,CA1,CA2,CA3,PR1,0)
N1760 CA3=CA1-CC6+RA1
N1770 CYCLE408 (CA2,CA1,DD7,CA3,PR1,0)
N1780 G1 X=DD8 Z=CA1 F1.9
N1790 X=DD7 Z=CA3 F=AV2
N1800 CA3=CA1-CC6
N1810 G2 X=CA2 Z=CA3 CR=RA1
N1820 CA2=DD1-CH1-CH1
N1830 G1 X=CA2
N1840 CA2=CA3-CH1
N1850 X=DD1 Z=CA2
N1860 G0 Z=CA1
N1870 FIM:
N1880 G0 G53 X=TX Z=TZ D0 M9
N1890 M5
N1900 M30