Beispiel Konverter Sinumerik 840C => 840D-sl

Maschine: G200
D-Nummern: nach INDEX-Norm
Wait-Marken: neu durchnummerieren

```
%MPF1021


( "VERLAENGERUNG" ART.NR. xxxxx REV.1)
N0005 L100
N0010 G0 G53 X340. Y0. D0
N0015 G0 G53 Z250 D0

N8888 G59 X=R901 Z=R902
(N0020 R10=0 R11=0 L184     (B-ACHSE AUF 0)
N0025 G92 S4=3500
N0026 D0 L144
(**** PLANEN +KOPIEREN aussen KOMET R0.4)
N0030 T1 D1 L144 (an_der HAUPTSPINDEL)
N1010 [ WAIT M , 10 , 1 , 2 ]
N0035 M4=26 M4=33
N0040 M4=3 S4=2000
N0045 G0 X57 Z0.05 Y0 M1=8
N0046 M50 M150
N0050 G1 G95 X-0.8 F0.15
N0055 G0 Z0.1
N0056 G0 X48
N0060 G1 X49.3 B-0.6 F0.07
N0065 G1 G9 Z-23
N0070 G1 X52 B-0.5
N0075 G1 Z-52
N0080 G1 X56 F0.5
N0085 G0 X140 Z60 M1=9 M151
N0086 D0 L144
(**** FORMBOHREN VHM RA= D18.3 AN HS)
N0090 R10=0 L140
N0095 T2 D2 L144
N0100 G0 Z6 M1=8
N0046 M50 M150
N0105 M1=33 M1=26
N0110 S1=2000 M1=3
N1015 [ WAIT M , 15 , 1 , 2 ]
N0115 G0 X11.6 Y0 C4=0
N0120 G1 G9 G94 Z-1.2 F200
N0125 G1 Z-1.45 F20
N0130 G0 Z-1.4
N0135 G1 Z-1.5 F100
```

```
%_N_1_0_MPF
;$PATH=/_N_WKS_DIR/_N_BspHomepage_WPD
;Konverter Siemens 840C_840D-sl  V1.1.0.1   G200
; "VERLAENGERUNG" ART.NR. xxxxx REV.1
N0005 L100
N0010 G0 G53 X340. Y0. D0
N0015 G0 G53 Z250 D0
START_:
N8888 G59 X=XMW_1 Z=ZMW_1
;N0020 R10=0 R11=0 L184     ;B-ACHSE AUF 0
N0025 G92=3500
N0026 D0
;**** PLANEN +KOPIEREN aussen KOMET R0.4
N0030 T1 D101 ;an_der HAUPTSPINDEL
N1010 WAITM (1, 1 , 2 )
N0035 SETMS(4)
N0040 M4=3 S4=2000
N0045 G0 X57 Z0.05 Y0 M11=8
N0046 M50 M10=150
N0050 G1 G95 X-0.8 F0.15
N0055 G0 Z0.1
N0056 G0 X48
N0060 G1 X49.3 CHR=0.6 F0.07
N0065 G1 G9 Z-23
N0070 G1 X52 CHR=0.5
N0075 G1 Z-52
N0080 G1 X56 F0.5
N0085 G0 X140 Z60 M11=9 M10=151
N0086 D0
;**** FORMBOHREN VHM RA= D18.3 AN HS
N0090 L140(0,4,0)
N0095 T2 D102
N0100 G0 Z6 M11=8
N0046 M50 M10=150
N0105 SETMS(1)
N0110 S1=2000 M1=3
N1015 WAITM (2, 1 , 2 )
N0115 G0 X11.6 Y0 C=0
N0120 G1 G9 G94 Z-1.2 F200
N0125 G1 Z-1.45 F20
N0130 G0 Z-1.4
N0135 G1 Z-1.5 F100
```

```
N0140 G0 Z10                                N0140 G0 Z10
N0141 M1=5 M1=9 M151                        N0141 M1=5 M11=9 M10=151
N0142 D0 L144                               N0142 D0
(**** FORMBOHREN VHM RA= D15.3 AN HS)        ;**** FORMBOHREN VHM RA= D15.3 AN HS
…..
…..
…..
(***************** BOHREN D=10mm)           ;******************** BOHREN D=10mm
N0205 T4 D4 L144                            N0205 T4 D104
N0215 M1=4 S1=6000                          N0215 M1=4 S1=6000
N0220 G0 Z3 Y0 M1=8                         N0220 G0 Z3 Y0 M11=8
N0046 M50 M150                              N0046 M50 M10=150
N0225 G0 X11.6 C4=0                         N0225 G0 X11.6 C=0
N0230 G1 G94 Z-45 F200                      N0230 G1 G94 Z-45 F200
N0232 G0 Z-15                               N0232 G0 Z-15
N0233 G0 Z-43                               N0233 G0 Z-43
N0230 G1 Z-54                               N0230 G1 Z-54
N0235 G0 Z30                                N0235 G0 Z30
N0141 M1=5 M1=9 M151                        N0141 M1=5 M11=9 M10=151
N0142 D0 L144                               N0142 D0
(********************** BOHREN D=8mm)       ;********************** BOHREN D=8mm
…..
…..
…..
(***** BOHREN VHM RA=12348 D7.15 AN HS)      ;**** BOHREN VHM RA=12348 D7.15 AN HS
…..
…..
…..
(********** BOHREN VHM RA=  D=6 AN HS)       ;********** BOHREN VHM RA=  D=6 AN HS
…..
…..
…..
(************ BOHREN HSS D=4.35 AN HS)       ;************* BOHREN HSS D=4.35 AN HS
…..
…..
…..
(************* GEWINDEBOHREN M5 HSS)         ;************ GEWINDEBOHREN M5 HSS
N0455 T10 D10 L144                          N0455 T10 D110
N0460 G0 Y0                                 N0460 G0 Y0
N0465 G0 X42 C4=90 M1=3 M1=8                N0465 G0 X42 C=90 M1=3 M11=8
N0466 M50 M150                              N0466 M50 M10=150
N0470 M1=70                                 N0470 M1=70
N0475 G0 G60 Z3 C1=30                       N0475 G0 G60 Z3 C1=30
/1N0480 G36 C1=Z-16.5 K0.8 F500             /1N0480 G331 Z-16.5 K0.8 S500
/1N0485 G36 C1=Z3 K-0.8                     /1N0485 G332 Z3 K0.8
N0490 G0 G64                                N0490 G0 G64
N0495 C4=270                                N0495 C=270
N0500 G0 G60 C1=30                          N0500 G0 G60 C1=30
/1N0505 G36 C1=Z-16.5 K0.8 F500             /1N0505 G331 Z-16.5 K0.8 S500
/1N0510 G36 C1=Z3 K-0.8                     /1N0510 G332 Z3 K0.8
```

```
N0515 G0 G64
N0520 M1=71
N0525 G0 Z50
N0530 G0 Y0
N0141 M1=5 M1=9 M151
N0142 D0 L144
(********** BOHREN HSS D=4.2 AN HS)
…..
…..
…..
(** PLANEN +KOPIEREN aussen KOMET R0.4)
N0030 T1 D1 L144 (an_der HAUPTSPINDEL)
N0035 M4=26 M4=33
N0040 M4=3 S4=2000
N0045 G0 Z0 Y0 M1=8
N0046 G0 X51 M50 M150
N0050 G1 G95 X-0.8 F0.15
N0055 G0 Z3
N0085 G0 G53 X340 D0 M1=9 M4=5 M151
N0086 D0 L144
(* ABSTECHEN ISCAR 4.1 mit GEGENSPINDEL)
N0550 T13 D13
N0565 G0 X57
N0570 G0 Z-50.5 M0=8
N1020 [ WAIT M , 20 , 1 , 2 ]
N1030 [ WAIT M , 30 , 1 , 2 ]
N0555 M4=26 M4=33
N0560 M4=3 S4=2000
(********* WARTEN BIS TEIL AN GSP ENTN)
N0580 M4=97
N0585 G1 G95 X-1 F0.1
N1040 [ WAIT M , 40 , 1 , 2 ]
N1050 [ WAIT M , 50 , 1 , 2 ]
N0590 G1 Z-49.5 F1

/N0595 R511=R511+1
N0600 G0 G53 X340 Z200 D0 T1 M4=5 M0=9
N1060 [ WAIT M , 60 , 1 , 2 ]
N0605 M392
N0610 @100 K-8888
N9999 M30


%MPF2021

( "VERLAENGERUNG" ART.NR. xxxxx REV.2 )
N0005 L100
N0010 G0 G53 X340 Z300 D0

N8888 G59 X=R901 Z=R902
```

```
N0515 G0 G64
N0520 M1=71
N0525 G0 Z50
N0530 G0 Y0
N0141 M1=5 M11=9 M10=151
N0142 D0
;********** BOHREN HSS D=4.2 AN HS




;** PLANEN +KOPIEREN aussen KOMET R0.4
N0030 T1 D101 ;an_der HAUPTSPINDEL
N0035 SETMS(4)
N0040 M4=3 S4=2000
N0045 G0 Z0 Y0 M11=8
N0046 G0 X51 M50 M10=150
N0050 G1 G95 X-0.8 F0.15
N0055 G0 Z3
N0085 G0 G53 X340 D0 M11=9 M4=5 M10=151
N0086 D0
;* ABSTECHEN ISCAR 4.1 mit GEGENSPINDEL
N0550 T13 D113
N0565 G0 X57
N0570 G0 Z-50.5 M0=8
N1020 WAITM (4, 1 , 2 )
N1030 WAITM (5, 1 , 2 )
N0555 SETMS(4)
N0560 M4=3 S4=2000
;********* WARTEN BIS TEIL AN GSP ENTN
N0580 M4=97
N0585 G1 G95 X-1 F0.1
N1040 WAITM (6, 1 , 2 )
N1050 WAITM (7, 1 , 2 )
N0590 G1 Z-49.5 F1
; A c h t u n g : Parameteraenderung !
/N0595 R211=R211+1
N0600 G0 G53 X340 Z200 D0 T1 M4=5 M0=9
N1060 WAITM (8, 1 , 2 )
N0605 I_M392
N0610 IF I_START GOTOB START_
N9999 M30


%_N_2_0_MPF
;$PATH=/_N_WKS_DIR/_N_BspHomepage_WPD
; "VERLAENGERUNG" ART.NR. xxxxx REV.2
N0005 L100
N0010 G0 G53 X340 Z300 D0
START_:
N8888 G59 X=XMW_1 Z=ZMW_1
```

```
N0015 M4=26 M4=33
N0020 T1 D31
N0025 G0 Z1
/N0030 G0 X0
/N0035 M1=69 M187
N0040 G4 X2
N0045 M1=68
N0050 G0 Z3
N0055 G0 G95 G53 X340 D0 M3=8
N1010 [ WAIT M , 10 , 1 , 2 ]
N0065 L130
N0070 G59 X=0 Z=R905
(*** FORMBOHREN VHM RA= D18.3 AN GS)
N0080 R10=3 L140
N0085 T8 D38
N0090 M2=33 M2=26
N0095 S2=6000 M2=4
N0100 G0 Z5 M2=8 M50 M250
N0105 G0 X50 C3=0
N0106 R10=3 L137
N0107 G1 G94 U5.8 V0.07 F3000
N0110 G1 G9 G94 Z-3.1 F150
N0115 G1 G9 G94 Z-3.32 F20
N0120 G0 Z10
N0121 R10=3 L135
N0125 M2=5 M251 M2=9
(**** FORMBOHREN VHM RA= D15.3 AN GS)
…..
…..
…..
(****************** SENKER D=18 AN GS)
N0185 T7 D37
N0190 M2=3 S2=4500
N0195 G0 C3=59
N0200 G0 X40 M2=8 M50 M250
N0205 G0 Z2
N0210 G1 G9 G94 Z-2.8 F350
N0215 G0 Z2
N0220 G0 C3=179
N0225 G1 G9 G94 Z-2.8 F350
N0230 G0 Z2
N0235 G0 C3=299
N0240 G1 G9 G94 Z-2.8 F350
N0245 G0 Z30
N0250 M2=5  M251 M2=9
(************* BOHREN HSS  D5.15 AN GS)
N0255 T6 D36
N0260 M2=3 S2=3000
N0265 G0 C3=299
N0270 G0 Z3 M2=8 M50 M250
```

```
N0015 SETMS(4)
N0020 T1 D201
N0025 G0 Z1
/N0030 G0 X0
/N0035 M1=69 M187
N0040 G4 F2
N0045 M1=68
N0050 G0 Z3
N0055 G0 G95 G53 X340 D0 M51=8
N1010 WAITM (1, 1 , 2 )
N0065 L130
N0070 G59 X=0 Z=XMW_3
;**** FORMBOHREN VHM RA= D18.3 AN GS
N0080 L140(0,3,0)
N0085 T8 D208
N0090 SETMS(2)
N0095 S2=6000 M2=4
N0100 G0 Z5 M21=8 M50 M20=150
N0105 G0 X50 C5=0
N0106 L137(0,0)
N0107 G1 G94 X5.8 Y0.07 F3000
N0110 G1 G9 G94 Z-3.1 F150
N0115 G1 G9 G94 Z-3.32 F20
N0120 G0 Z10
N0121 L135
N0125 M2=5 M20=151 M21=9
;**** FORMBOHREN VHM RA= D15.3 AN GS
```

```
;****************** SENKER D=18 AN GS
N0185 T7 D207
N0190 M2=3 S2=4500
N0195 G0 C5=59
N0200 G0 X40 M21=8 M50 M20=150
N0205 G0 Z2
N0210 G1 G9 G94 Z-2.8 F350
N0215 G0 Z2
N0220 G0 C5=179
N0225 G1 G9 G94 Z-2.8 F350
N0230 G0 Z2
N0235 G0 C5=299
N0240 G1 G9 G94 Z-2.8 F350
N0245 G0 Z30
N0250 M2=5 M20=151 M21=9
;************* BOHREN HSS  D5.15 AN GS
N0255 T6 D206
N0260 M2=3 S2=3000
N0265 G0 C5=299
N0270 G0 Z3 M21=8 M50 M20=150
```

```
N0275 G0 X40
N0280 G0 Z2
N0285 G1 G94 Z-5 F250
N0286 G1 Z-25 F400
N0290 G0 Z2
N0295 G0 C3=179
N0300 G1 Z-5 F250
N0301 G1 Z-25 F400
N0305 G0 Z2
N0310 G0 C3=59
N0315 G1 Z-5 F250
N0316 G1 Z-25 F400
N0320 G0 Z10
N0325 G0 G53 X330 D0 M2=5 M2=9 M251
N0330 R10=3 L142
(* PLANDREHEN aussen KOMET R0.8 Nr.6/2983)
N0335 T3 D33(an_der GEGENSPINDEL)
N0340 M3=26 M3=33
N0345 M3=3 S3=2000
N0350 G0 G9 Z0.1 M2=8 M50 M250
N0351 G0 X55
N0355 G1 G95 X-1.6 F0.2
N0360 G0 Z0.2
N0361 G0 X55
N0350 G0 G9 Z0
N0355 G1 G95 X-1.6 F0.2
N0360 G0 Z0.1
N0364 G0 X50
N0365 G1 X52.3 B-1.05
N0370 G1 Z-3
N0375 G0 G53 X340 D0 M3=5
N0380 G0 Z70 M2=9 M251
(******** STEMPEL SDT **************)
N0080 R10=3 L140
N0385 T4 D34 (an_der GEGENSPINDEL)
N0390 G0 Z3
N0391 G0 C3=0
N0395 G0 X38
N0400 G1 G94 Z-0.2 F250
N0405 G1 Z3
N0410 G0 G95 G53 X340 D0 M3=5
N0415 G0 Z70 M2=9 M251
N0330 R10=3 L142
N2015 [ WAIT M , 15 , 1 , 2 ]
N0385 L131
N0390 G59 X=R901 Z=R902
N2017 [ WAIT M , 17 , 1 , 2 ]
(******** TEIL AUS GSP MIT ABNREV ENTN)
N0400 M3=26 M3=33
N0405 M2=8 M3=8
```

```
N0275 G0 X40
N0280 G0 Z2
N0285 G1 G94 Z-5 F250
N0286 G1 Z-25 F400
N0290 G0 Z2
N0295 G0 C5=179
N0300 G1 Z-5 F250
N0301 G1 Z-25 F400
N0305 G0 Z2
N0310 G0 C5=59
N0315 G1 Z-5 F250
N0316 G1 Z-25 F400
N0320 G0 Z10
N0325 G0 G53 X330 D0 M2=5 M21=9 M20=151

;* PLANDREHEN aussen KOMET R0.8 Nr.6/2983
N0335 T3 D203 ;an_der GEGENSPINDEL
N0340 SETMS(3)
N0345 M3=3 S3=2000
N0350 G0 G9 Z0.1 M21=8 M50 M20=150
N0351 G0 X55
N0355 G1 G95 X-1.6 F0.2
N0360 G0 Z0.2
N0361 G0 X55
N0350 G0 G9 Z0
N0355 G1 G95 X-1.6 F0.2
N0360 G0 Z0.1
N0364 G0 X50
N0365 G1 X52.3 CHR=1.05
N0370 G1 Z-3
N0375 G0 G53 X340 D0 M3=5
N0380 G0 Z70 M21=9 M20=151
;******** STEMPEL SDT **********
N0080 L140(0,3,0)
N0385 T4 D204 ;an_der GEGENSPINDEL
N0390 G0 Z3
N0391 G0 C5=0
N0395 G0 X38
N0400 G1 G94 Z-0.2 F250
N0405 G1 Z3
N0410 G0 G95 G53 X340 D0 M3=5
N0415 G0 Z70 M21=9 M20=151
N0330 L135
N2015 WAITM (2, 1 , 2 )
N0385 L131
N0390 G59 X=XMW_1 Z=ZMW_1
N2017 WAITM (3, 1 , 2 )
;******** TEIL AUS GSP MIT ABNREV ENTN
N0400 SETMS(3)
N0405 M21=8 M51=8
```

```
N0410 R912=200 R913=30 L132
N0540 G0 G53 X340 D0
N0550 G0 G53 Z190 D0
N0545 T14
N2020 [ WAIT M , 20 , 1 , 2 ]
(***** WZ FREISCHALTEN UND FREIFAHREN)
N0560 M3=26
(************* GEGENSPINDEL VOR ****)
N0565 R10=359 R11=0 R12=3 R13=-21 R14=1 R15=162.8 R16=0 L128
N2030 [ WAIT M , 30 , 1 , 2 ]
N2040 [ WAIT M , 40 , 1 , 2 ]
(************ GEGENSPINDEL ZURUECK **)
N0570 R16=1 L129
N0575 R10=6 R11=1 R12=500. L146
N2050 [ WAIT M , 50 , 1 , 2 ]
N0580 M3=5 M3=9
N2060 [ WAIT M , 60 , 1 , 2 ]
N0585 M392
N0590 @100 K-8888
N9999 M30
```

```
N0410 L132(0,0,200,30,,,,,,,,)
N0540 G0 G53 X340 D0
N0550 G0 G53 Z190 D0
N0545 T14
N2020 WAITM (4, 1 , 2 )
;***** WZ FREISCHALTEN UND FREIFAHREN
N0560 SETMS(3)
;************* GEGENSPINDEL VOR ****
N0565 L128 (0,359,0,3,-21,1,162.8,500)
N0565 M9=25
N2030 WAITM (5, 1 , 2 )
N2040 WAITM (6, 1 , 2 )
;************ GEGENSPINDEL ZURUECK **
N0570 L129 (1)
N0575 L146 (Z4,1,500)
N2050 WAITM (7, 1 , 2 )
N0580 M3=5 M51=9
N2060 WAITM (8, 1 , 2 )
N0585 I_M392
N0590 IF I_START GOTOB START_
N9999 M30
```

```
%MPF1721
(*** STANGENANFANG REV.1 ***)
N0005 L100
L421
@100 R50
N1
N0010 G0 G53 X340 Z300 D0
N0015 G59 X=R901 Z=R902
N0016 T13 D13
N0030 G0 Y0 Z-5 M1=8
N1010 [ WAIT  M  10 , 1 , 2 ]
N0028 M4=26 M4=33
N0029 M4=3 S4=2000
N0030 G0 X57
N0031 G1 X-1 F0.12
N0032 G1 Z-4 F1
N0033 G0 X58 M0=9 M4=5
N0034 G0 G53 X340 Z300 D0
N1015 [ WAIT  M  15 , 1 , 2 ]
R50=31 R51=0 L420
@100 K9999
N2
N1020 [ WAIT  M  20 , 1 , 2 ]
R50=33 R51=1 L420
R50=32 R51=0 L420
```

```
%_N_1_7_MPF
;$PATH=/_N_WKS_DIR/_N_BspHomepage_WPD
;*** STANGENANFANG REV.1 ***
N0005 L100
L421
CASE R50 OF 1 GOTOF STA_ANF 2 GOTOF STA_ZER 3 GOTOF STA_END
N1 STA_ANF:
N0010 G0 G53 X340 Z300 D0
N0015 G59 X=XMW_1 Z=ZMW_1
N0016 T13 D113
N0030 G0 Y0 Z-5 M11=8
N1010 WAITM (1, 1 , 2 )
N0028 SETMS(4)
N0029 M4=3 S4=2000
N0030 G0 X57
N0031 G1 X-1 F0.12
N0032 G1 Z-4 F1
N0033 G0 X58 M0=9 M4=5
N0034 G0 G53 X340 Z300 D0
N1015 WAITM (2, 1 , 2 )
 ;ENTFÄLLT
 GOTOF _N9999
N2 STA_ZER:
N1020 WAITM (3, 1 , 2 )
 ;ENTFÄLLT
 ;ENTFÄLLT
```

```
@100 K9999
N3
N1030 [ WAIT  M  30 , 1 , 2 ]
R50=31 R51=1 L420
R50=33 R51=0 L420
@100 K9999

N9999 M30
```

```
 GOTOF _N9999
N3 STA_END:
N1030 WAITM (4, 1 , 2 )
 ;ENTFÄLLT
 ;ENTFÄLLT
 GOTOF _N9999
_N9999:
N9999 M30
```

```
%MPF2721

(*** STANGENANFANG REV.2 ***)
N0005 L100
N0010 G0 G53 X340
N0011 G0 G53 Z200 D0
N0015 G59 X=R901 Z=R902
L421
@100 R50
N1
N0015 T1 D31 (ANSCHLAG)
N0016 G0 Z1
N0017 G0 X0
N0020 M1=69
N0021 G4 X.5
/N0022 M687
/N0023 R10=100 R11=1.5 R16=0 L185
N0024 M1=68
N0025 G0 Z3
N1010 [ WAIT  M  10 , 1 , 2 ]
N0026 G0 G53 X340 D0
N0027 G0 G53 Z440 D0
N1015 [ WAIT  M  15 , 1 , 2 ]
R50=31 R51=0 L420
@100 K9999
N2
N2020 [ WAIT  M  20 , 1 , 2 ]
R50=33 R51=1 L420
R50=32 R51=0 L420
@100 K9999
N3
N2030 [ WAIT  M  30 , 1 , 2 ]
R50=31 R51=1 L420
R50=33 R51=0 L420
@100 K9999

N9999 M30
```

```
%_N_2_7_MPF
;$PATH=/_N_WKS_DIR/_N_BspHomepage_WPD
;*** STANGENANFANG REV.2 ***
N0005 L100
N0010 G0 G53 X340
N0011 G0 G53 Z200 D0
N0015 G59 X=XMW_1 Z=ZMW_1
L421
CASE R50 OF 1 GOTOF STA_ANF 2 GOTOF STA_ZER 3 GOTOF STA_END
N1 STA_ANF:
N0015 T1 D201 ;ANSCHLAG
N0016 G0 Z1
N0017 G0 X0
N0020 M1=69
N0021 G4 F.5
/N0022 M687
/N0023 L185 (1,100,1.5)
N0024 M1=68
N0025 G0 Z3
N1010 WAITM (1, 1 , 2 )
N0026 G0 G53 X340 D0
N0027 G0 G53 Z440 D0
N1015 WAITM (2, 1 , 2 )
 ;ENTFÄLLT
 GOTOF _N9999
N2 STA_ZER:
N2020 WAITM (3, 1 , 2 )
 ;ENTFÄLLT
 ;ENTFÄLLT
 GOTOF _N9999
N3 STA_END:
N2030 WAITM (4, 1 , 2 )
 ;ENTFÄLLT
 ;ENTFÄLLT
 GOTOF _N9999
_N9999:
N9999 M30
```

```
%MPF21
```

```
%_N_INDEX_INI
```

```
( xxxxx )
R1=1  ( Daten fuer Kanal 1 laden )
R5=10000001  ( Zerspanung 1.Seite )
R6=0  ( kein Sonderprogramm )
R11=340  ( Werkzeugwechselpunkt X )
R12=300  ( Werkzeugwechselpunkt Z )
L410
R1=2  ( Daten fuer Kanal 2 laden )
R5=10000001  ( Zerspanung 1.Seite )
R6=0  ( kein Sonderprogramm )
R11=340  ( Werkzeugwechselpunkt X )
R12=350  ( Werkzeugwechselpunkt Z )
L410
R1=5  ( Daten fuer Kanal 5 laden )
R5=100  ( Umruestprog. )
R6=0  ( kein Sonderprogramm )
L410
R901=0  ( NPV in X )
R902=162  ( 1. NPV in Z an Hauptspi. )
R905=-191.8 ( 1. NPV in Z an Gegenspi. )
R906=0 (C-ACHSE)
N9999 L400
M30

%MPF5221
(UMRUESTPRG.)
()
(MAFU-DATEN)
R50=9 L150        (MAFU SETZEN)
R1=1 R2=1 L151  (SPANNZYL.)
R1=3 R2=1 L151  (SPANNZYL. GSP.)
R1=9 R2=1 L151    ( Nachschub )
R1=11 R2=1 L151 ( Greifer )
N9999 M30
```

```
;$PATH=/_N_WKS_DIR/_N_BspHomepage_WPD
[G59_VAR]
XMW_1=0
ZMW_1=162
CMW_1=0
YMW_1=0
XMW_3=191.8
ZMW_3=0
CMW_3=0
YMW_3=0

[G..73_CHAN_1]
I_SPX=340
I_SPY=0
I_SPZ=300
I_SPX2=0
I_SPY2=0
I_SPZ2=0

[G..73_CHAN_2]
I_SPX=340
I_SPY=0
I_SPZ=350
I_SPX2=0
I_SPY2=0
I_SPZ2=0

[MAFU]
GRP_1=00000001
GRP_2=00000000
GRP_3=00000001
GRP_4=00000000
GRP_5=00000000
GRP_6=00000000
GRP_7=00000001
GRP_8=00000000
GRP_9=00000001
GRP_10=00000000
GRP_11=00000001
GRP_12=00000000
GRP_13=00000000
GRP_14=00000000
GRP_15=00000000
GRP_16=00000000
GRP_17=00000000
GRP_18=00000000
GRP_19=00000000
```