

ヘリカル補間

ACCEL ti2k-190807 (LastUpdate Aug 8, 2019)

■ サポート VER : 1.14_89 2019/08/05、対象PGボード: MPG-3514

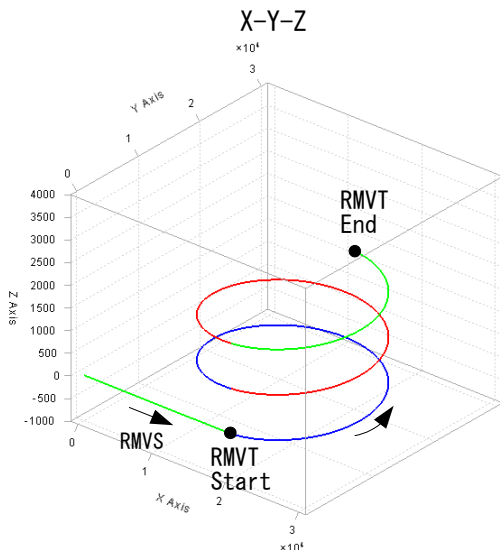
■ プログラム(抜粋)

```
PG 0
ACCEL 20000 1000 20000
/*ACCEL 100000 5000 100000
FEED 100
CLRPOS
DS_DACL
```

```
RMVS 20000 0
WAIT RR(ALL_A)==0
TIME 1000
```

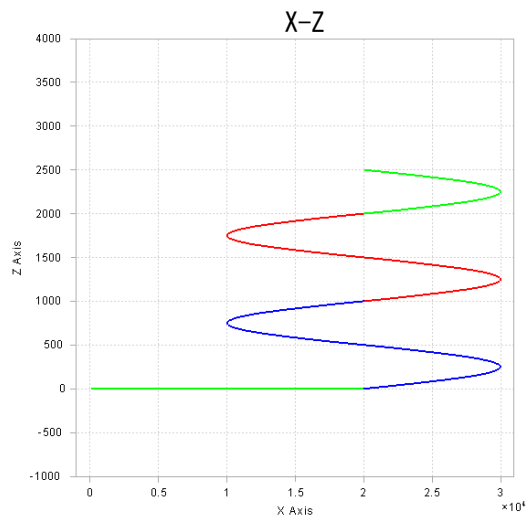
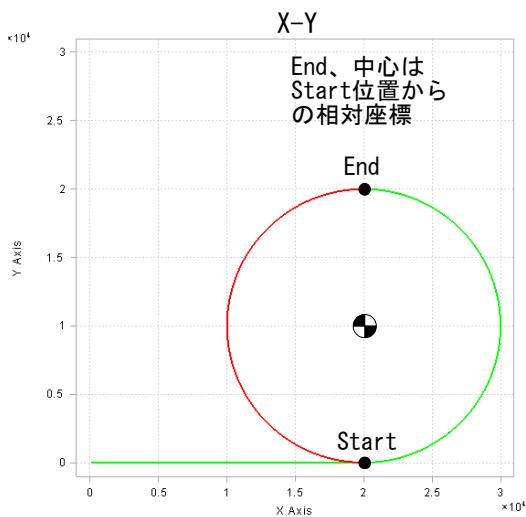
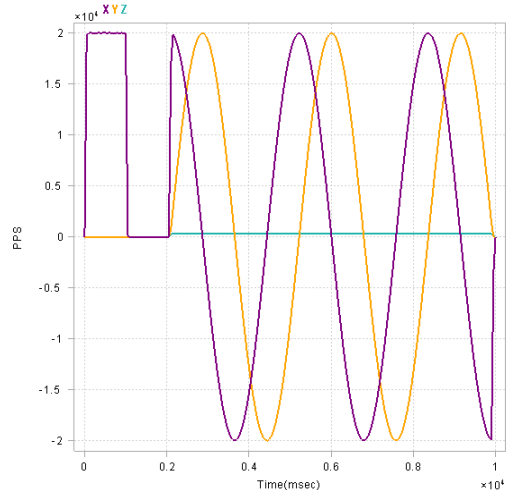
```
rev=2
RMVT X_A|Y_A|Z_A 0 20000 CCW 0 10000 rev 1000 /* ここを変更してサンプリング
/* 目的座標 DIR 中心座標 回転数 Z移動量
WAIT RR(0)==0
```

(1) RMVT X_A|Y_A|Z_A 0 20000 CCW 0 10000 2 1000

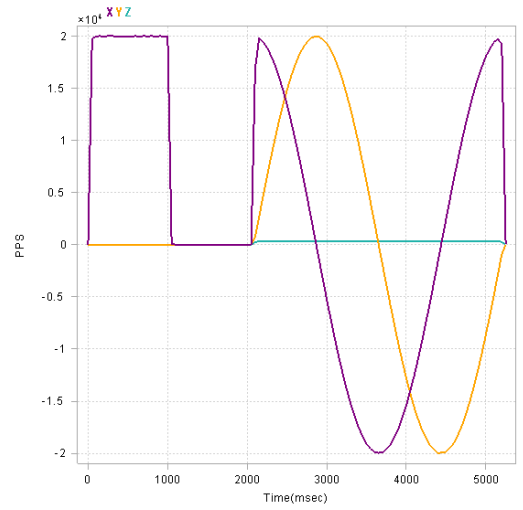
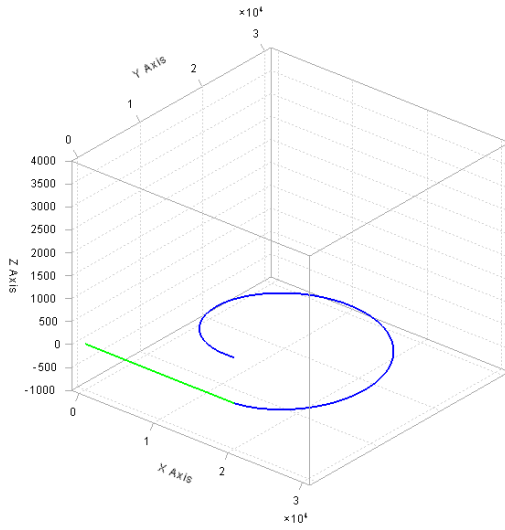


(※1周毎に色を変えています)

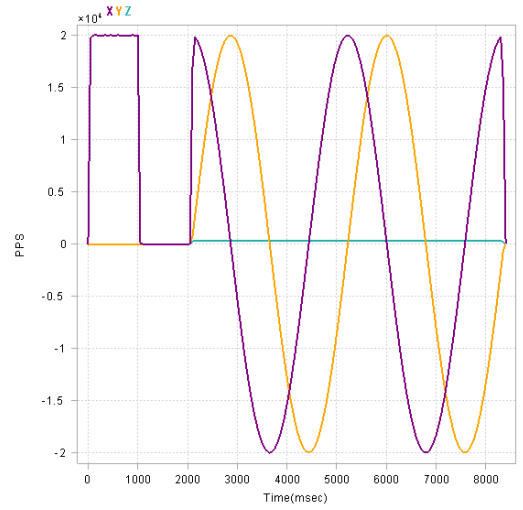
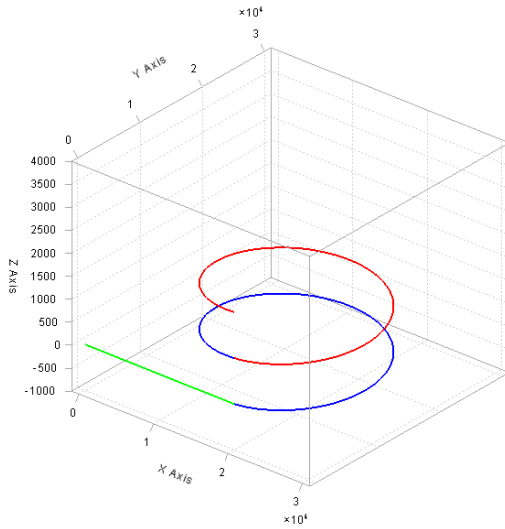
加減速



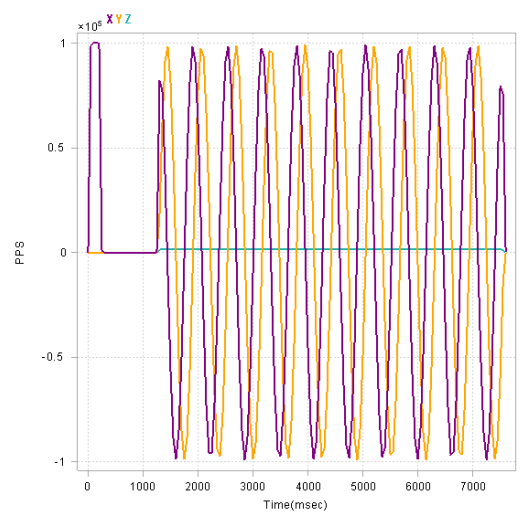
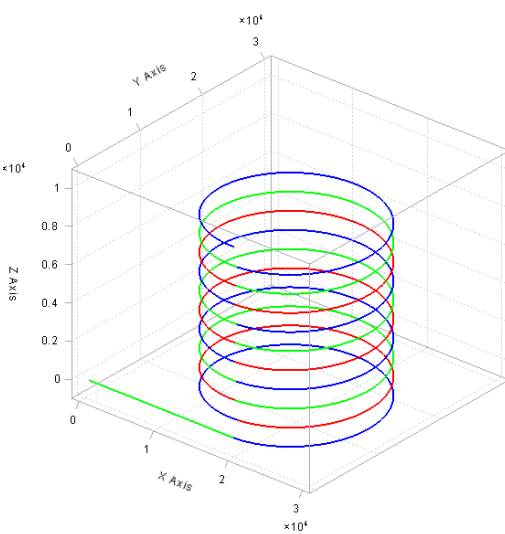
(2) RMVT X_A|Y_A|Z_A 0 0 CCW 0 10000 1 1000



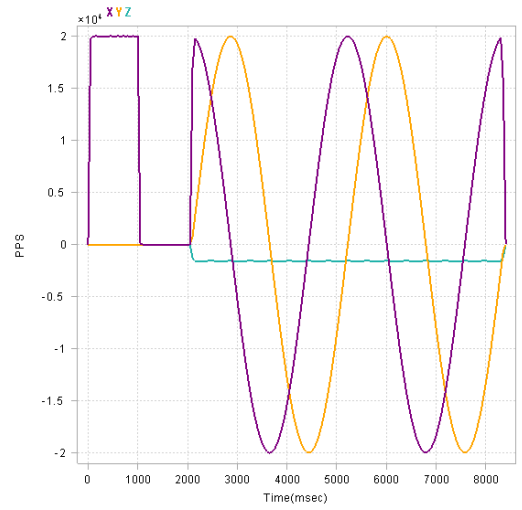
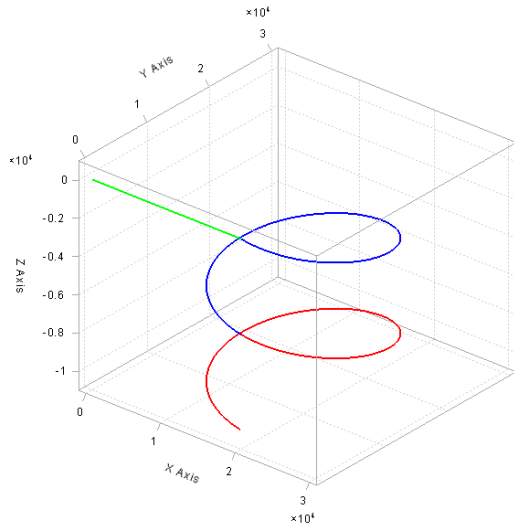
(3) RMVT X_A|Y_A|Z_A 0 0 CCW 0 10000 2 1000



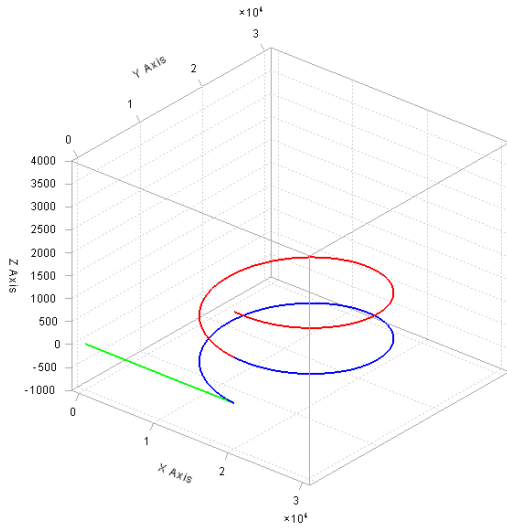
(4) 速度を ACCEL 100000 5000 100000 に変更
RMVT X_A|Y_A|Z_A 0 0 CCW 0 10000 10 1000



(5) RMVT X_A|Y_A|Z_A 0 0 CCW 0 10000 2 -5000



(6) RMVT X_A|Y_A|Z_A 0 0 CW 0 10000 2 1000



(7) RMVT X_A|Y_A|Z_A 0 0 CCW 0 1000 20 500

