





| Pořadí | Název dílu    | Materiál            | Počet |
|--------|---------------|---------------------|-------|
| 1      | Kolenní kloub | CoCrMo (ISO 5832-4) | 1     |
| 2      | Prípravokl    | ČSN 19.312          | 1     |
| 3      | Erowa         |                     | 1     |

|                        |                |                       |         |        |
|------------------------|----------------|-----------------------|---------|--------|
| MATERIÁL               | INDEX          | ZMĚNA                 | DATUM   | PODPIS |
| POLOTOVAR              |                |                       |         |        |
| TOLEROVÁNÍ NO 8015 AHO |                |                       |         |        |
| PŘESNOST NO 2768 m K   |                |                       |         |        |
| PROMĚTÁNÍ              |                |                       | MĚŘÍTKO |        |
|                        |                |                       | 1:1     |        |
| VYPRACOVAL R. Polách   | SCHVÁLIL       | HMOTNOST              | SEST.   |        |
| Kontroloval            | DATUM 1.2.2011 | ST. V.                |         |        |
| VŠB - TU Ostrava       |                | NÁZEV                 |         |        |
|                        |                | Sestava kolenní kloub |         |        |
|                        |                | ČÍSLO VÝKRESU         |         |        |

; Date : 14 02 2011  
; Programmer : Polach  
; Part File Name: C:\DMG\_Brno\koleno\_medin.prt  
N1 G40 G17 G94 G90 G71  
N2 M01  
; Path Name : MILL\_CONTROL\_COPY\_COPY\_COP~16  
; Tool Number: 3  
; Tool Name : T3\_D6\_KUL\_2Z Tool Diameter: 6.00 Tool Length: 75.00  
N3 T03  
N4 M06  
N5 D1  
N6 CYCLE832(0.05,112101) ; TRAORI  
N7 G54  
N8 G00 X50. Y-50. Z20. S20000 C=DC(0.0) A0.0 M03  
N9 M01  
; Path Name : FIN\_POVRCH\_-0.55  
N10 G00 X53.746004 Y-36.259962 Z-2.518698 S20000 C=DC(47.060667) A88.87556 M12  
N11 X17.451084 Y-2.486179 Z-3.491802  
N12 G01 X17.408576 Y-2.438679 Z-3.49272 F4000.  
N13 X17.372096 Y-2.381965 Z-3.493063  
N14 X17.342394 Y-2.318337 Z-3.492855  
N15 X17.320221 Y-2.250097 Z-3.492121  
N16 X17.30633 Y-2.179545 Z-3.490885  
N17 X17.30147 Y-2.108984 Z-3.489172  
N18 X17.306395 Y-2.040714 Z-3.487007  
N19 X17.321855 Y-1.977037 Z-3.484414  
N20 X17.348602 Y-1.920253 Z-3.481417  
N21 X17.387386 Y-1.872664 Z-3.478042  
N22 X17.493357 Y-1.785659 Z-3.470021  
N23 X17.609787 Y-1.71326 Z-3.461855  
N24 X17.734683 Y-1.656707 Z-3.453685  
N25 X17.774791 Y-1.641628 Z-3.451147 C=DC(47.317653) A88.877135  
N26 X17.814819 Y-1.626344 Z-3.448613 C=DC(47.574965) A88.878752  
N27 X17.854765 Y-1.610855 Z-3.446082 C=DC(47.83261) A88.88041  
N28 X17.894628 Y-1.595162 Z-3.443555 C=DC(48.090593) A88.882109  
N29 X17.934406 Y-1.579266 Z-3.441032 C=DC(48.348922) A88.883844  
N30 X17.974099 Y-1.563168 Z-3.438512 C=DC(48.607603) A88.88562  
N31 X18.013706 Y-1.546867 Z-3.435996 C=DC(48.866643) A88.887437  
N32 X18.053225 Y-1.530366 Z-3.433484 C=DC(49.126049) A88.889294  
N33 X18.092655 Y-1.513663 Z-3.430976 C=DC(49.385826) A88.891188  
N34 X18.131995 Y-1.496761 Z-3.428471 C=DC(49.645982) A88.893122  
N35 X18.171244 Y-1.479659 Z-3.425971 C=DC(49.906523) A88.895097  
N36 X18.2104 Y-1.462359 Z-3.423475 C=DC(50.167455) A88.897111  
N37 X18.249463 Y-1.44486 Z-3.420982 C=DC(50.428784) A88.899163  
N38 X18.288432 Y-1.427164 Z-3.418494 C=DC(50.690517) A88.901255  
N39 X18.327304 Y-1.409271 Z-3.41601 C=DC(50.952661) A88.903387  
N40 X18.36608 Y-1.391182 Z-3.41353 C=DC(51.21522) A88.905557  
N41 X18.404758 Y-1.372897 Z-3.411055 C=DC(51.478202) A88.907767  
N42 X18.443337 Y-1.354417 Z-3.408584 C=DC(51.741612) A88.910015  
N43 X18.481815 Y-1.335743 Z-3.406117 C=DC(52.005457) A88.912303  
N44 X18.520192 Y-1.316876 Z-3.403654 C=DC(52.269742) A88.914629  
N45 X18.558467 Y-1.297815 Z-3.401196 C=DC(52.534474) A88.916994  
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N47 X18.634705 Y-1.259117 Z-3.396293 C=DC(53.0653) A88.921841  
N48 X18.672668 Y-1.239483 Z-3.393849 C=DC(53.331406) A88.924322  
N49 X18.710524 Y-1.21966 Z-3.391409 C=DC(53.597982) A88.926844  
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N56 X18.972526 Y-1.07573 Z-3.374463 C=DC(55.477622) A88.945566  
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N59 X19.083184 Y-1.011349 Z-3.367273 C=DC(56.290768) A88.954171  
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N61 X19.156405 Y-.967555 Z-3.362506 C=DC(56.835497) A88.960098  
N62 X19.19285 Y-.9454 Z-3.36013 C=DC(57.108665) A88.963121  
N63 X19.229184 Y-.923074 Z-3.35776 C=DC(57.382376) A88.966179  
N64 X19.265406 Y-.90058 Z-3.355394 C=DC(57.656633) A88.969274  
N65 X19.301516 Y-.877914 Z-3.353035 C=DC(57.931308) A88.972398  
N66 X19.33751 Y-.85507 Z-3.350681 C=DC(58.205852) A88.975558  
N67 X19.373387 Y-.832047 Z-3.348333 C=DC(58.480209) A88.978751  
N68 X19.409146 Y-.808847 Z-3.34599 C=DC(58.754386) A88.981979  
N69 X19.444788 Y-.785471 Z-3.343654 C=DC(59.028388) A88.985215  
N70 X19.480311 Y-.76192 Z-3.341324 C=DC(59.302222) A88.988484  
N71 X19.515717 Y-.738196 Z-3.338999 C=DC(59.575895) A88.991786  
N72 X19.551003 Y-.7143 Z-3.336681 C=DC(59.849412) A88.995121  
N73 X19.58617 Y-.690233 Z-3.334369 C=DC(60.12278) A88.998464  
N74 X19.621218 Y-.665996 Z-3.332063 C=DC(60.396006) A89.001838  
N75 X19.656146 Y-.641591 Z-3.329763 C=DC(60.669096) A89.005245  
N76 X19.690953 Y-.61702 Z-3.327469 C=DC(60.942056) A89.008683  
N77 X19.725641 Y-.592282 Z-3.325182 C=DC(61.214892) A89.012128  
N78 X19.760207 Y-.56738 Z-3.322902 C=DC(61.487612) A89.015604  
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N91 X20.198476 Y-.229242 Z-3.293838 C=DC(65.025288) A89.063015  
N92 X20.231327 Y-.202165 Z-3.291649 C=DC(65.297051) A89.066829  
N93 X20.264055 Y-.17494 Z-3.289467 C=DC(65.568795) A89.07065  
N94 X20.296658 Y-.14757 Z-3.287292 C=DC(65.840527) A89.074497  
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N101 X20.521399 Y.048015 Z-3.272261 C=DC(67.742868) A89.102039  
N102 X20.553006 Y.076514 Z-3.270142 C=DC(68.014741) A89.106053  
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N109 X20.770691 Y.279872 Z-3.255517 C=DC(69.913567) A89.134607

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N1957 X-27.748871 Y6.166761 Z-50.794156 C=DC(286.618986) A86.392835  
N1958 X-27.763125 Y6.003407 Z-50.748757 C=DC(286.963269) A86.423375  
N1959 X-27.776393 Y5.839925 Z-50.703502 C=DC(287.306228) A86.454103  
N1960 X-27.788681 Y5.676322 Z-50.658391 C=DC(287.648098) A86.485026  
N1961 X-27.799994 Y5.512605 Z-50.613426 C=DC(287.988895) A86.516142  
N1962 X-27.810333 Y5.348778 Z-50.56861 C=DC(288.328626) A86.547447  
N1963 X-27.819701 Y5.184846 Z-50.523944 C=DC(288.667299) A86.578938  
N1964 X-27.828102 Y5.020816 Z-50.47943 C=DC(289.00492) A86.610612  
N1965 X-27.830051 Y4.979794 Z-50.468325 C=DC(289.089162) A86.618562  
N1966 X-27.830529 Y4.969538 Z-50.465551 C=DC(289.110212) A86.62055  
N1967 X-27.830767 Y4.964409 Z-50.464164 C=DC(289.120736) A86.621545  
N1968 X-27.830885 Y4.961845 Z-50.46347 C=DC(289.125997) A86.622042  
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N1971 X-27.914773 Y4.544194 Z-50.352572  
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N1978 X-28.470812 Y3.957861 Z-50.210833  
N1979 X-28.683887 Y3.841517 Z-50.185977  
N1980 X-28.782999 Y3.796323 Z-50.176843  
N1981 X-28.872388 Y3.761676 Z-50.170266  
N1982 G00 X-75.474763 Y-12.399527 Z-47.258858 M13  
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N1984 M01  
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N1986 C=DC(0.0) A0.0  
N1987 ; Machine time : 6.7 min.  
N1988 M17