

Converting NC Formats from CYCLE 19 to PLANE SPATIAL

Oct 27, 2007

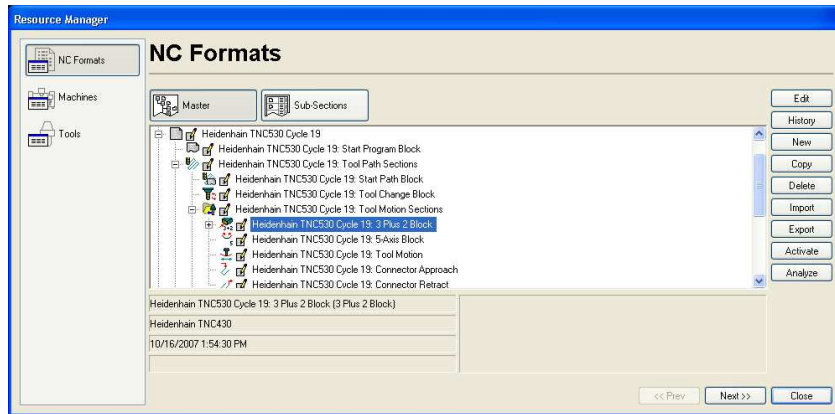
1.0 Overview

This document explains how you can convert CYCLE 19 NC formats to PLANE SPATIAL

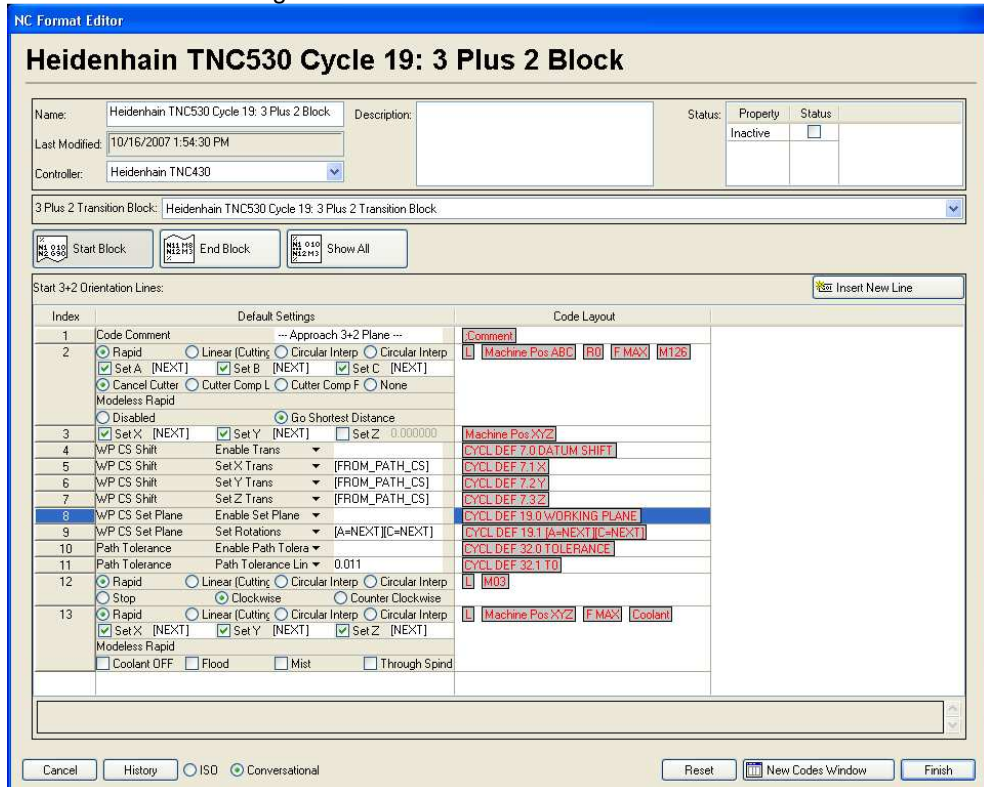
2.0 Modifying the NC Format

Select the NC Format section(s) that contain the CYCLE 19 codes. Most likely, these are in the Program Start and 3+2 Machining Section:

- 1) Start the CAMplete TruePath application
- 2) Go to Tools > Edit NC Formats
- 3) Select the NC Format section you wish to modify (for example 3 Plus 2 Block)
- 4) Click Edit



- 5) Find the CYCLE 19 lines in the grid



Converting NC Formats from CYCLE 19 to PLANE SPATIAL

Oct 27, 2007

6) Modify the first CYCLE 19 code: (a) change the option to Set Spatial Rot and (b) add the text [A=NEXT][B=NEXT][C=NEXT] in the edit box

7) Delete the second WP CS Set Plane command line

8) When you're done, the Start Block should look like the following:

8	WP CS Set Plane	Set Spatial Rot	[A=NEXT][B=NEXT][C=NEXT]	CYCL DEF 19.0 WORKING PLANE
9	Path Tolerance	Enable Path Tolerance		CYCL DEF 32.0 TOLERANCE

9) Now switch to the "End Block"

10) There will be 4 CYCLE 19 codes:

11	WP CS Shift	Set Z Trans	0.0	CYCL DEF 7.3 Z
12	WP CS Set Plane	Enable Set Plane		CYCL DEF 19.0 WORKING PLANE
13	WP CS Set Plane	Set Rotations	A0 C0	CYCL DEF 19.1 A0 C0
14	WP CS Set Plane	Enable Set Plane		CYCL DEF 19.0 WORKING PLANE
15	WP CS Set Plane	Set Rotations		CYCL DEF 19.1

11) For the first CYCLE 19 code, change the option to Spatial Reset

12) Delete the remaining codes

13) Your NC Format should look like this when you are done:

12	WP CS Set Plane	Spatial Reset		CYCL DEF 19.0 WORKING PLANE
----	-----------------	---------------	--	-----------------------------

14) Click Finish to commit this change

15) Repeat this process on any other CYCLE 19's in your NC Format (for example, Program Start and Program End blocks)