

Manuál obrábania - 2. Časť

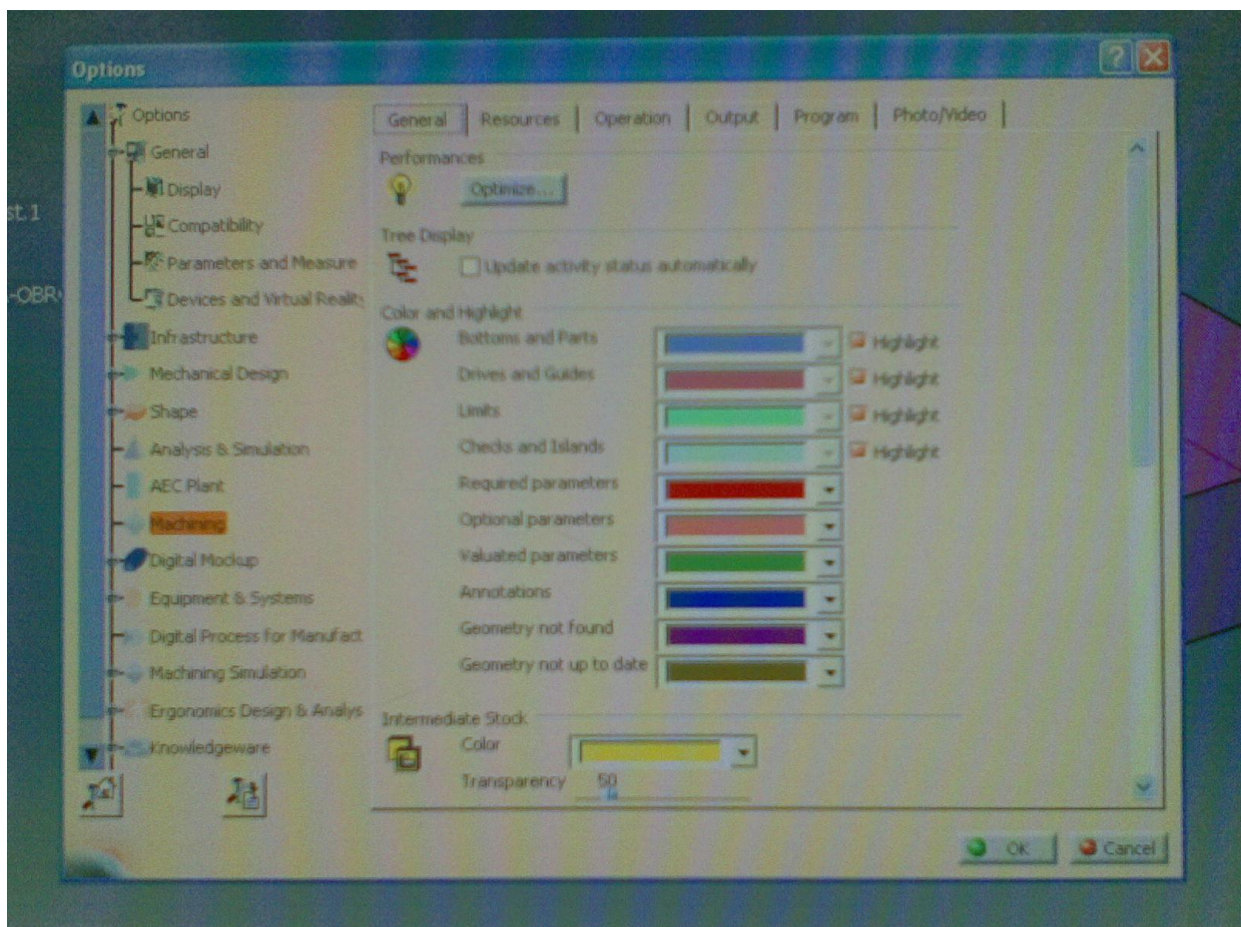
Generovanie NC-programu

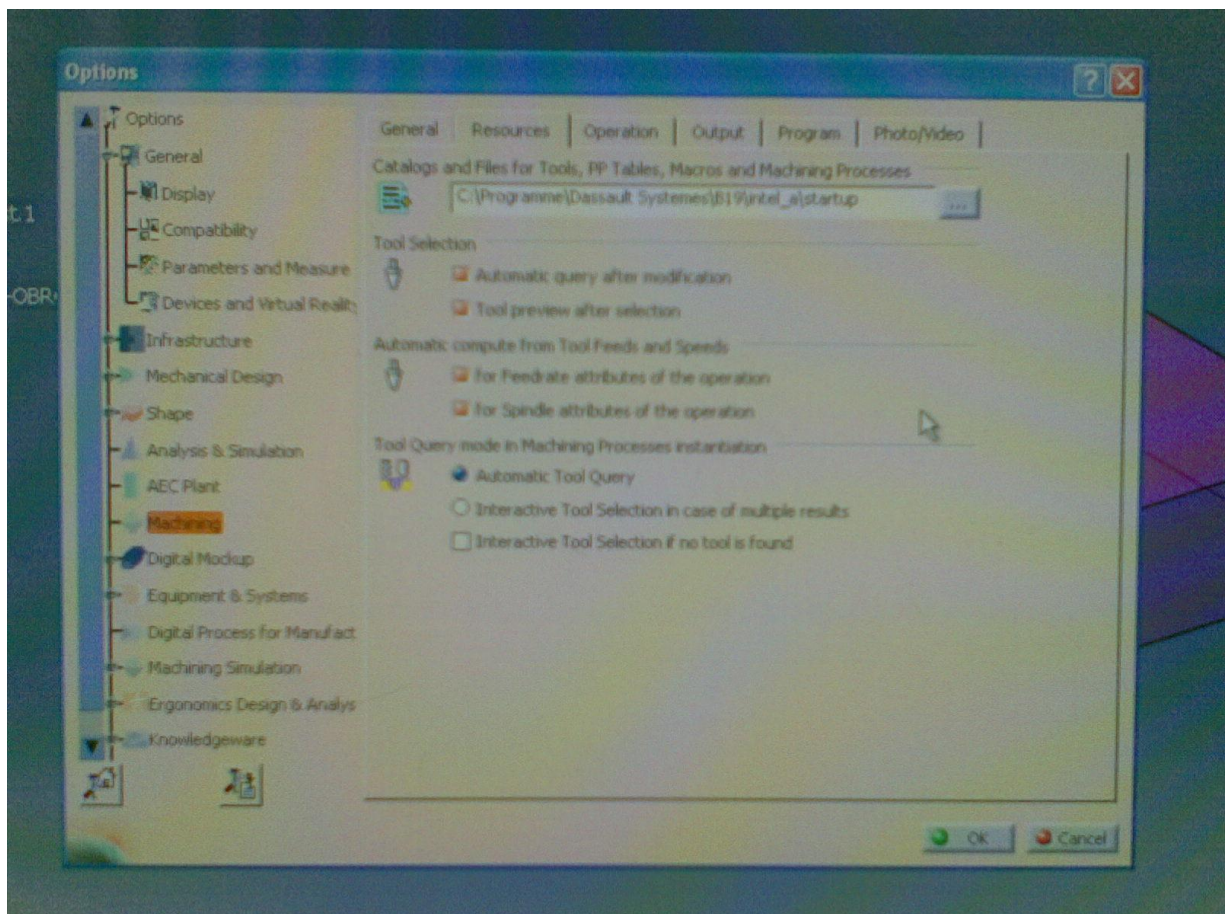
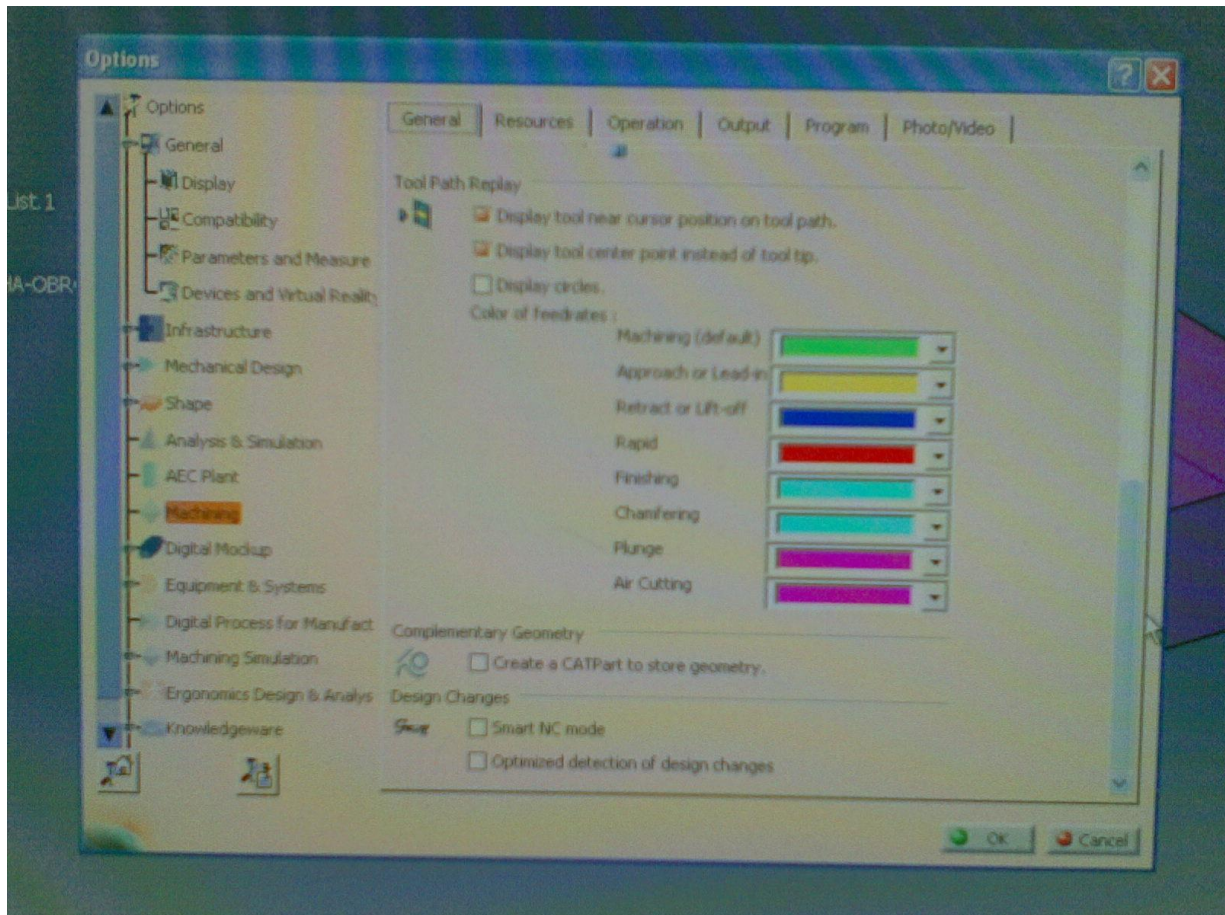
Najskor musime mat postprocesor (dalej PP) k danemu stroju nakopirovany v priecinku PP CATIA-e . Poznamka: V CATIA-i su niektore PP , ale iba na generovanie APT suboru (vseobecny PP) , s ktorym mozeme dalej pracovat . Priznam sa , ja to nepouzivam , kedze pouzivam priamo PP na dany stroj (HDH_426_5x.PPPAR – stroj so systemom Heidenhain ; 3-osi) . Da sa pouzit na stroje so systemom Heidenhain 407 , 426 , 430 aj 530 a iTNC 530 .

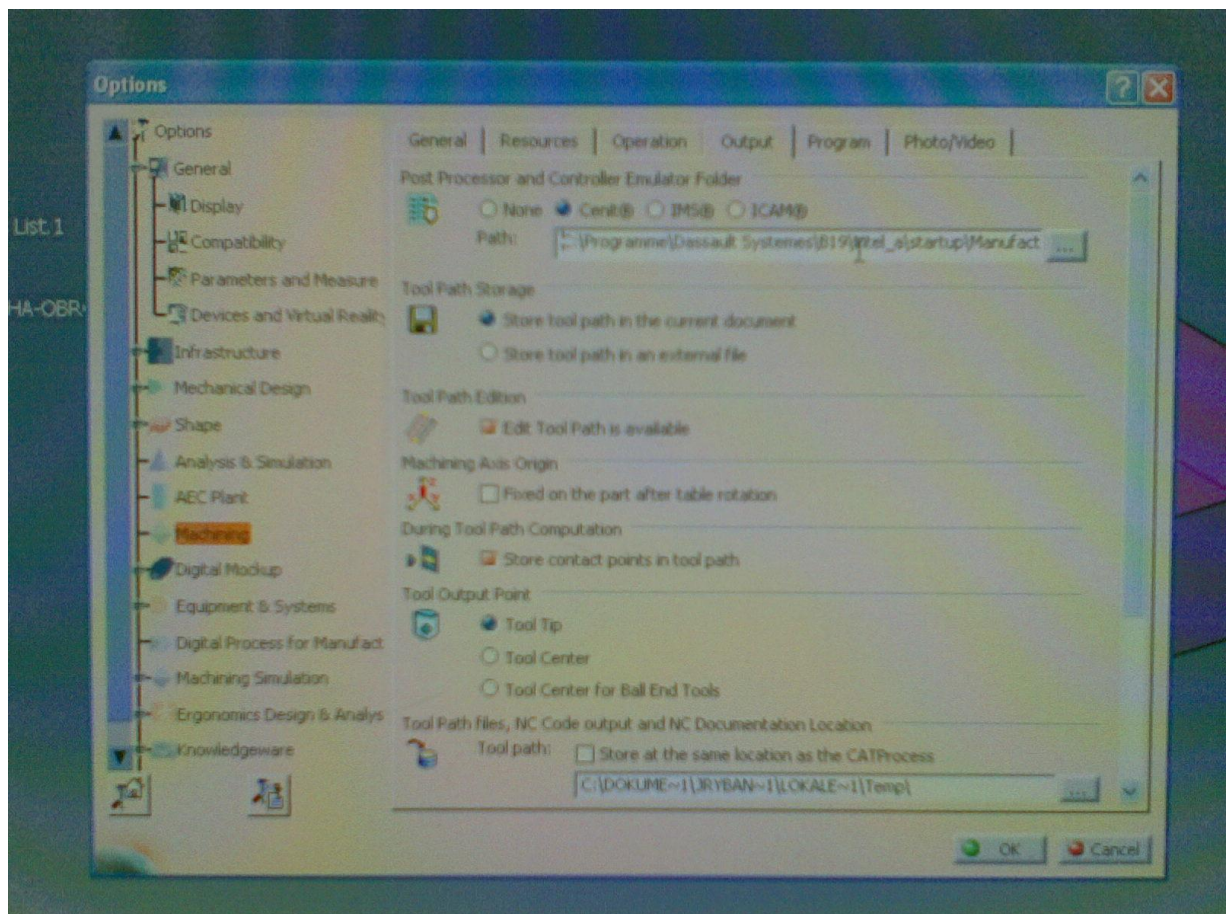
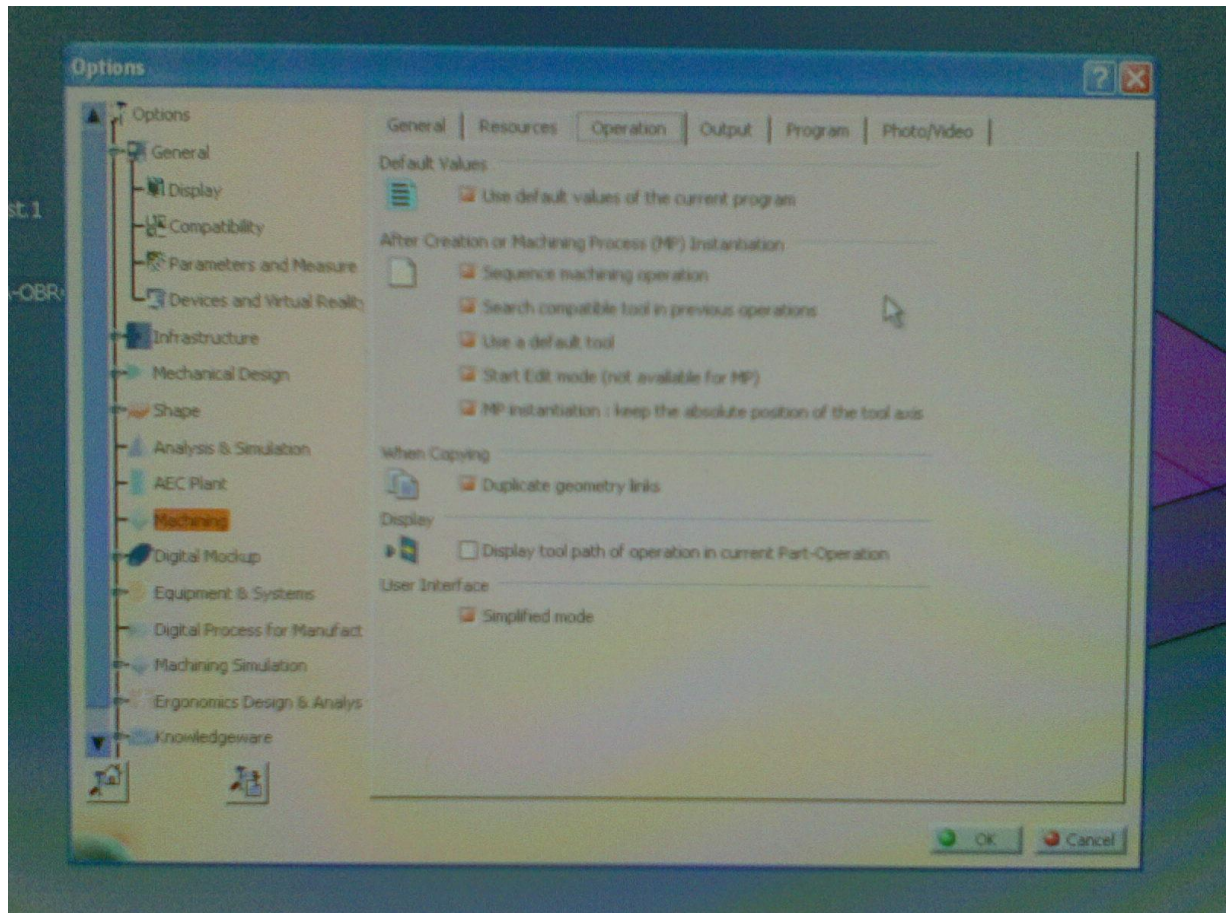
PP treba nakopirovat do :

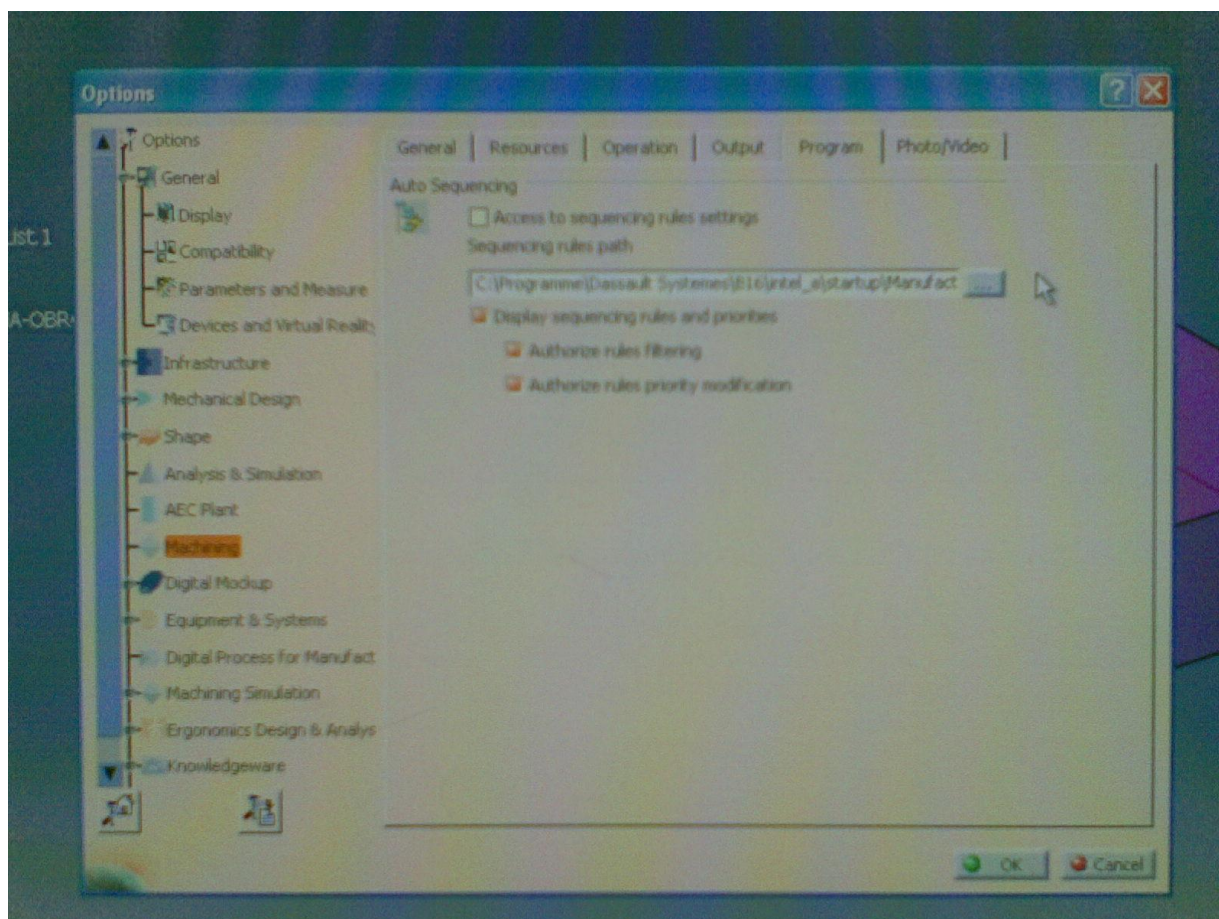
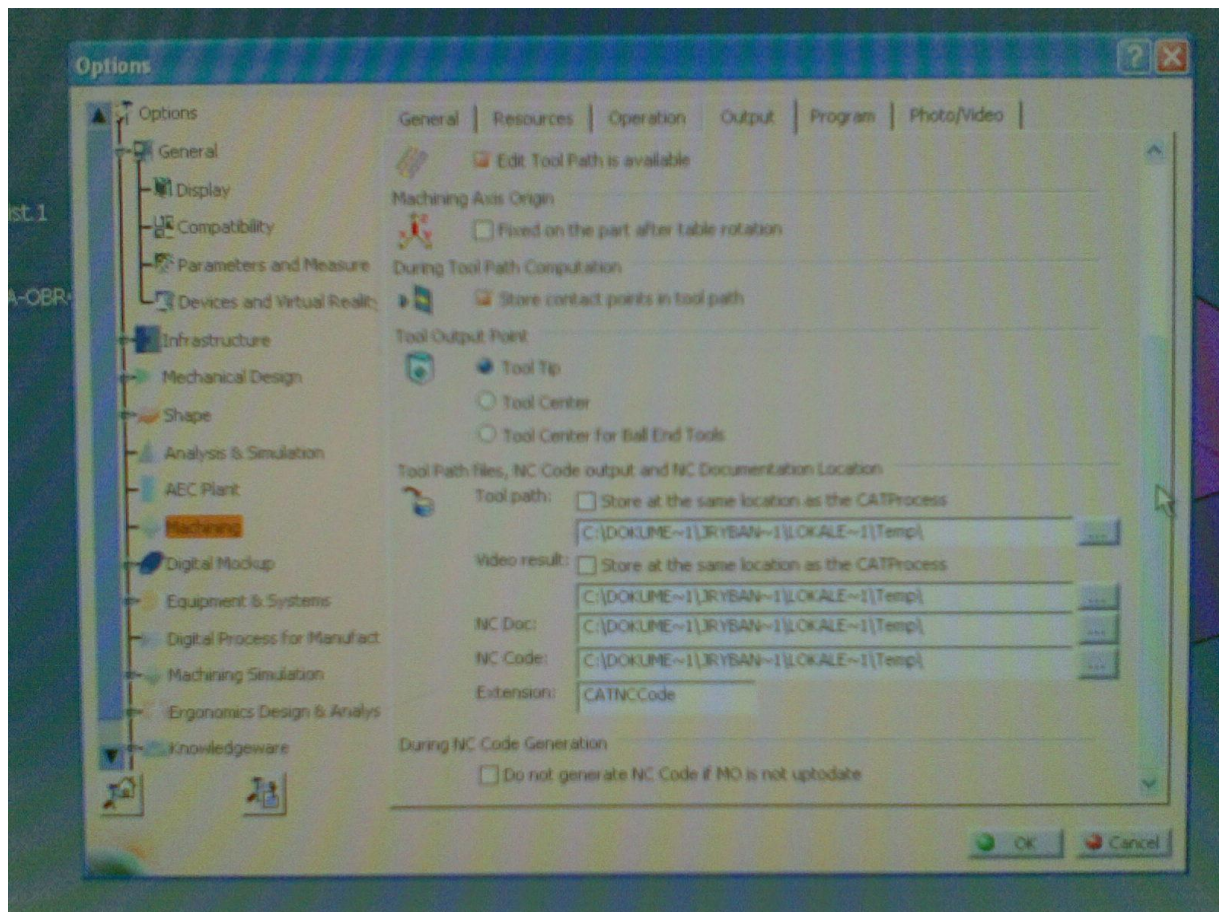
C:\Program Files\DassaultSystemes\B19\intel_a\startup\Manufacturing\PPPar

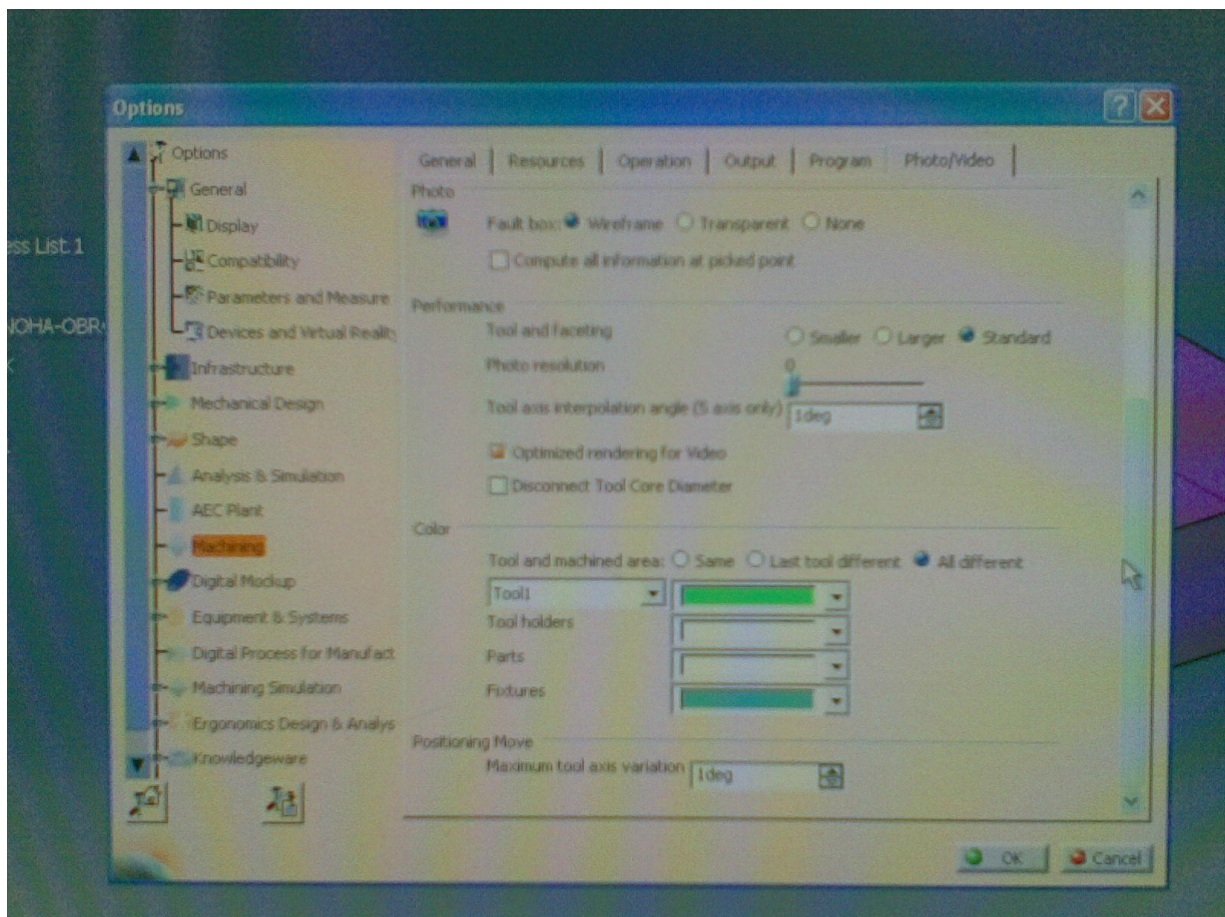
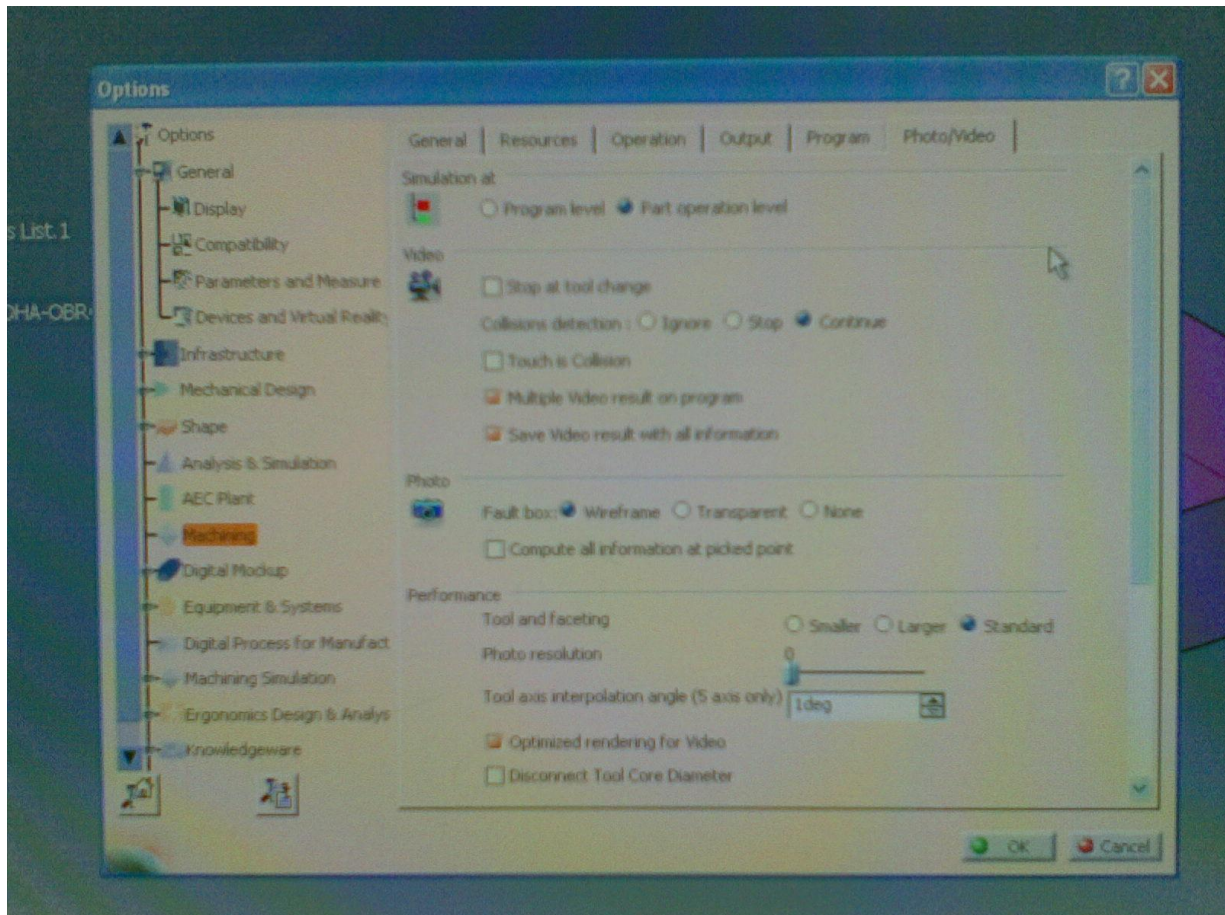
Dalej si treba nastavit CATIA-u cez TOOLS > OPTIONS , podla nasledovnych obrazkov .





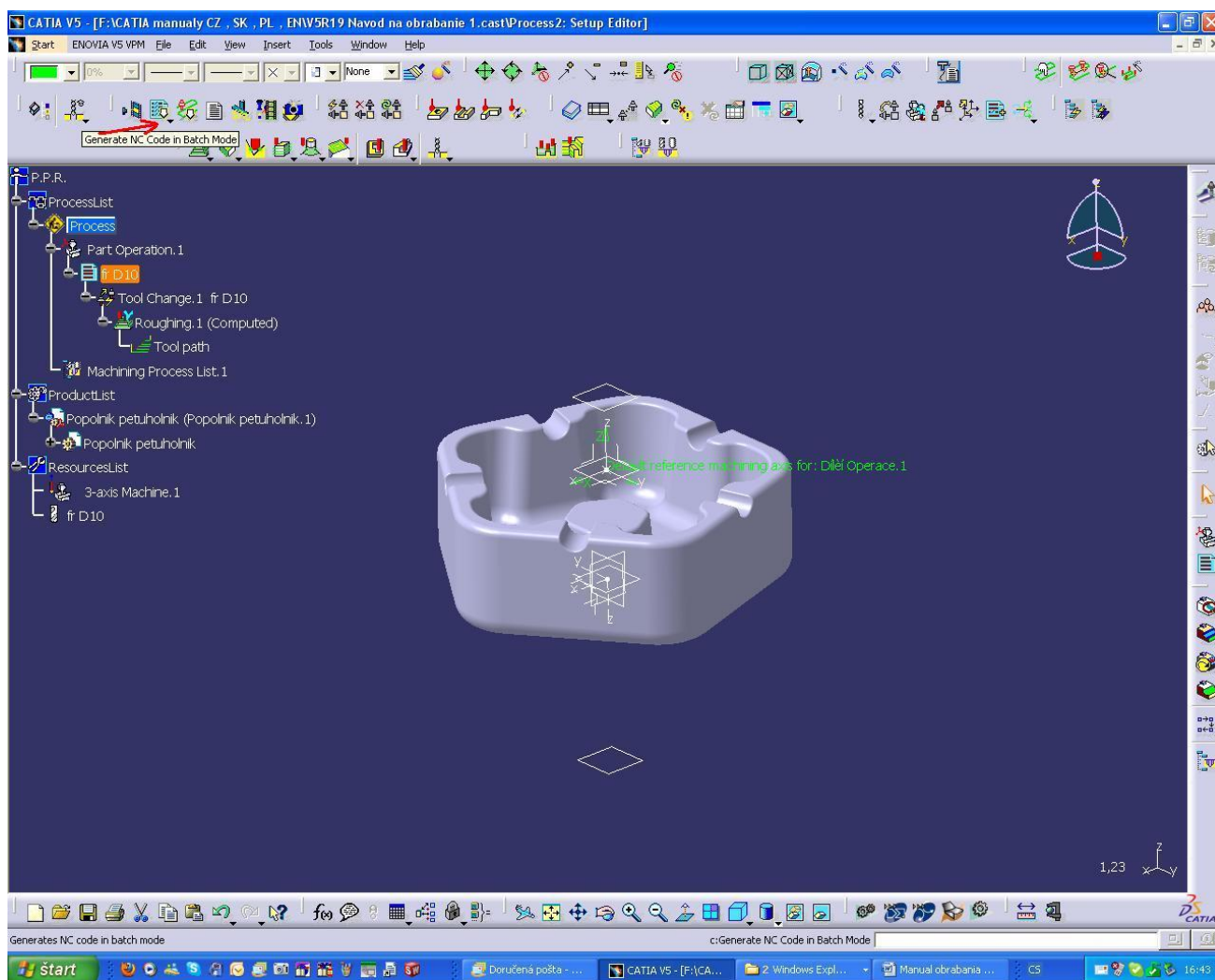




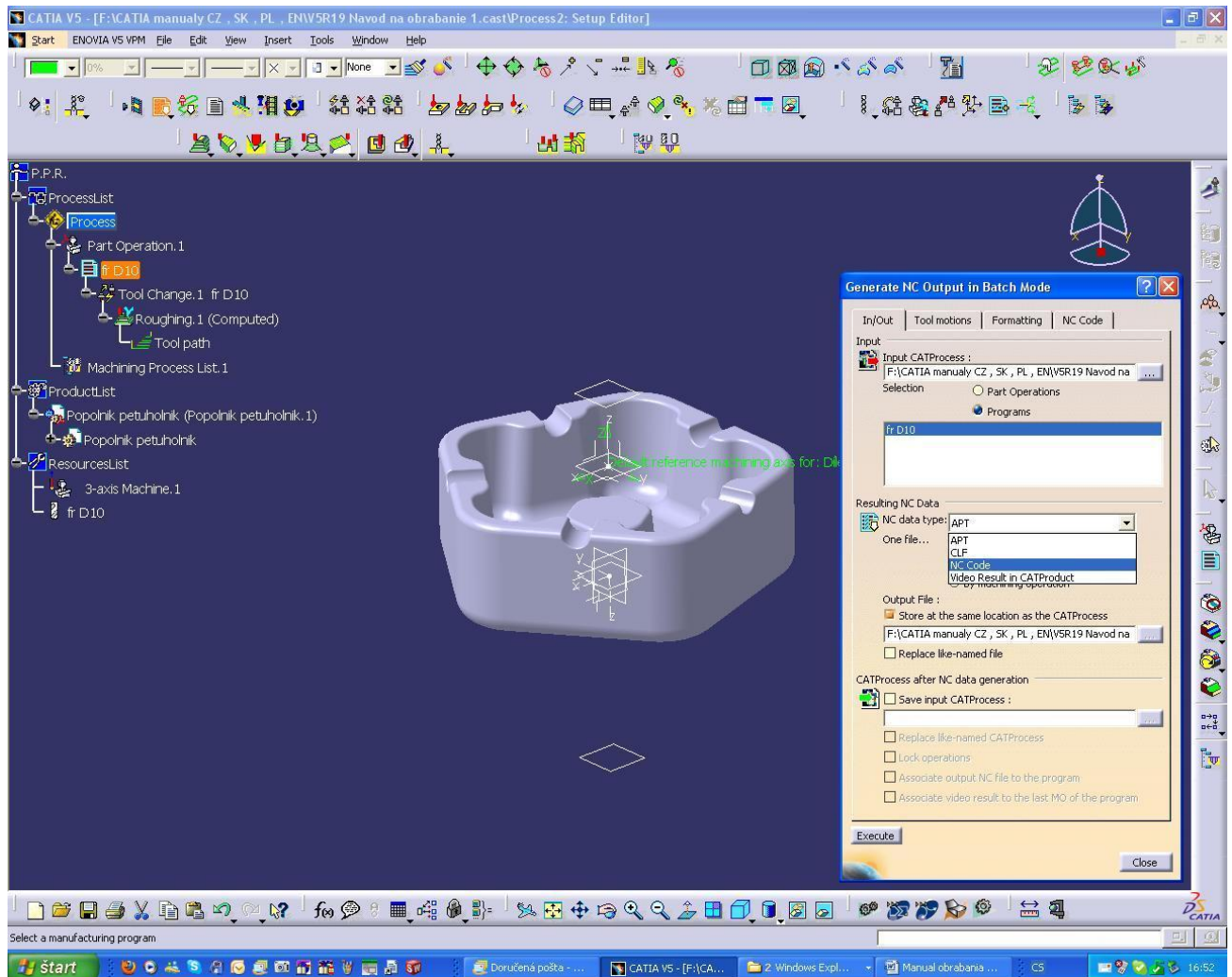


Teraz mozeme ist na generovanie programu .

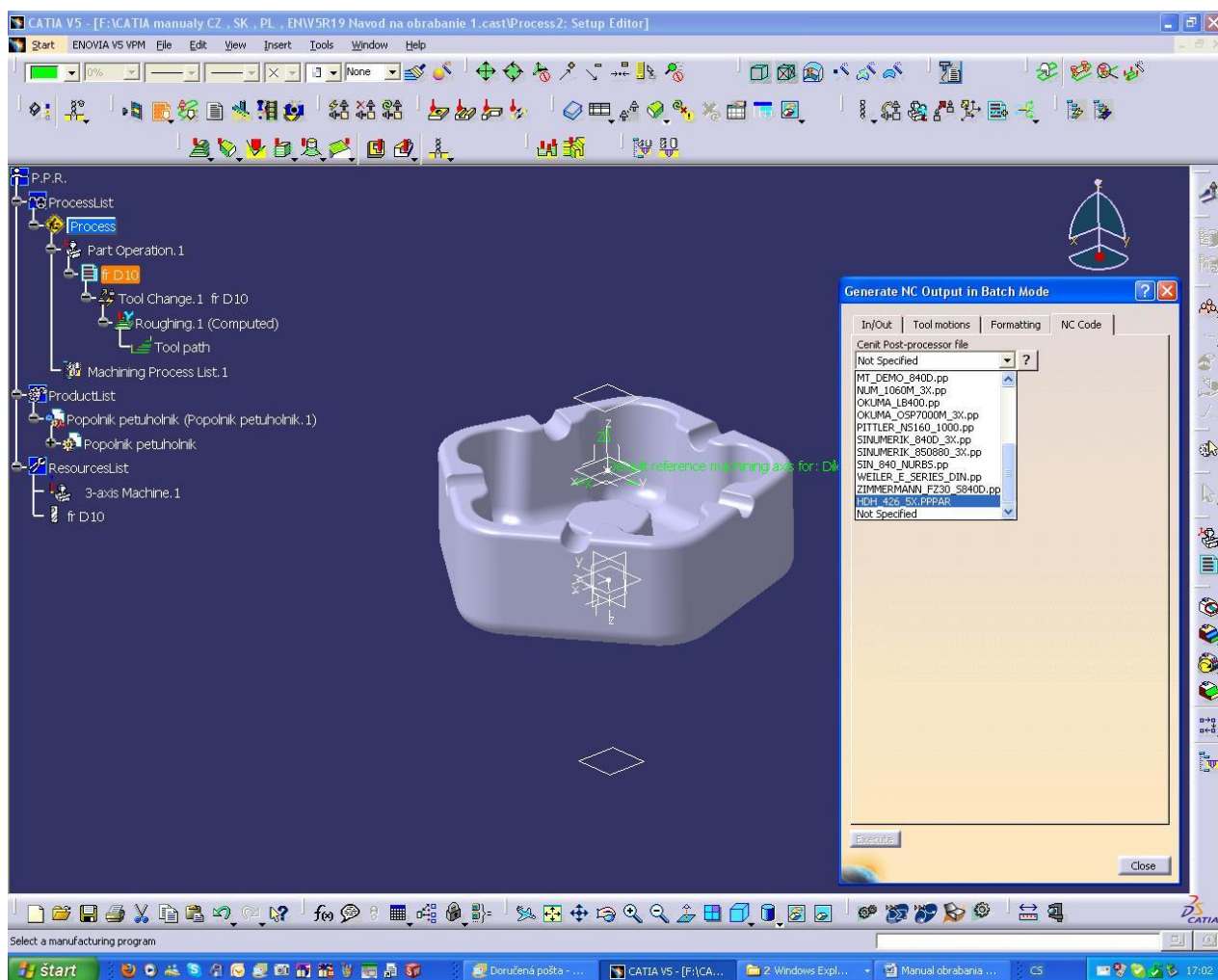
V strome si oznacime frD10 (vysvieti sa na orange) a klik na Generate NC Code in Batch Mode .



Vyskoci nam tabulka , v ktorej zmenime APT za NC Code ; a zasktrneme Output file . Vygenerovany program bude ulozeny tam , kde mame subor procesu obrabania .



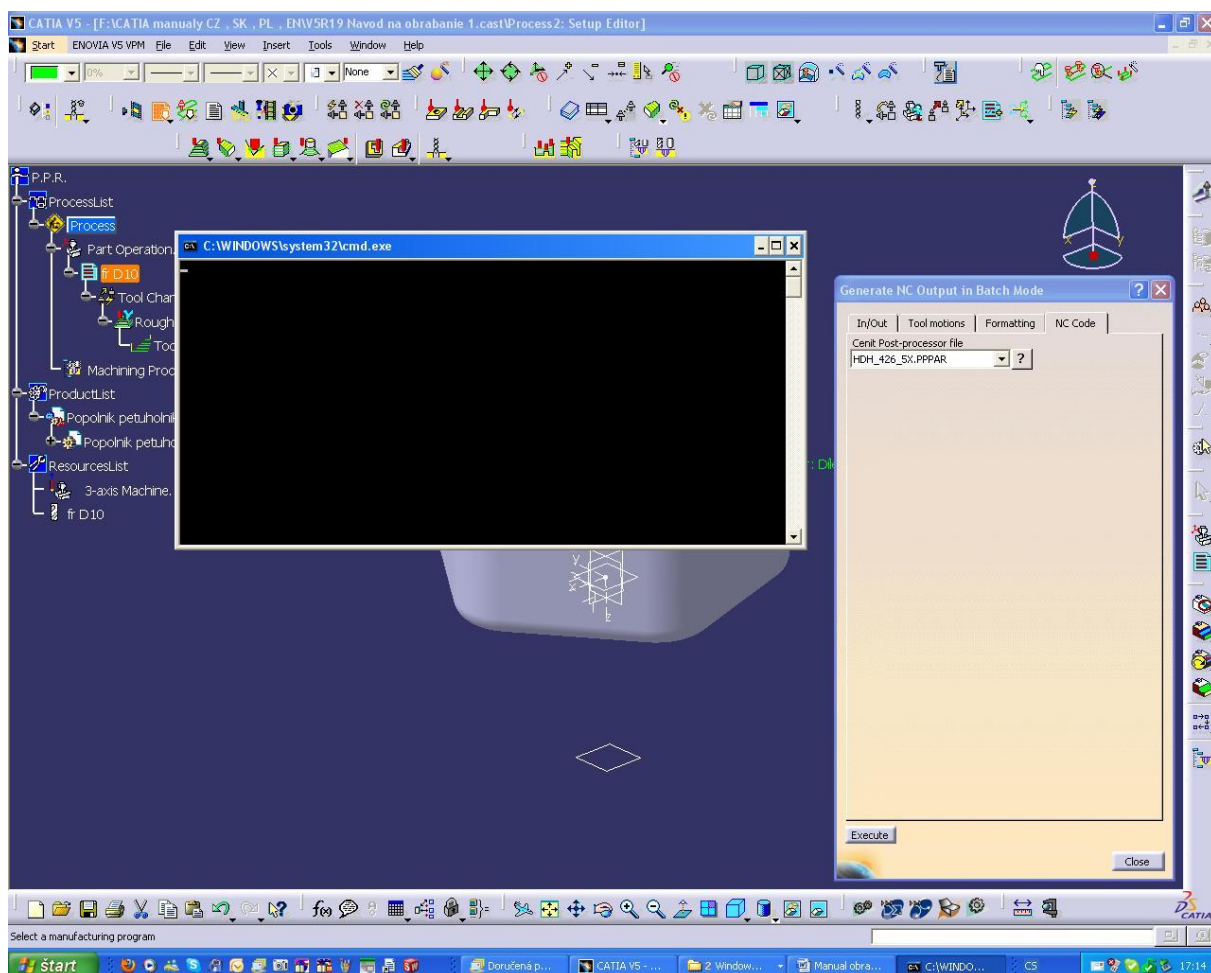
Dalej v položke NC Code vyberieme nas PP (HDH_426_5x.PPPAR).



Vsimnite si , ze ostatne PP maju koncovku .pp , a iba nas ma koncovku .PPPAR .

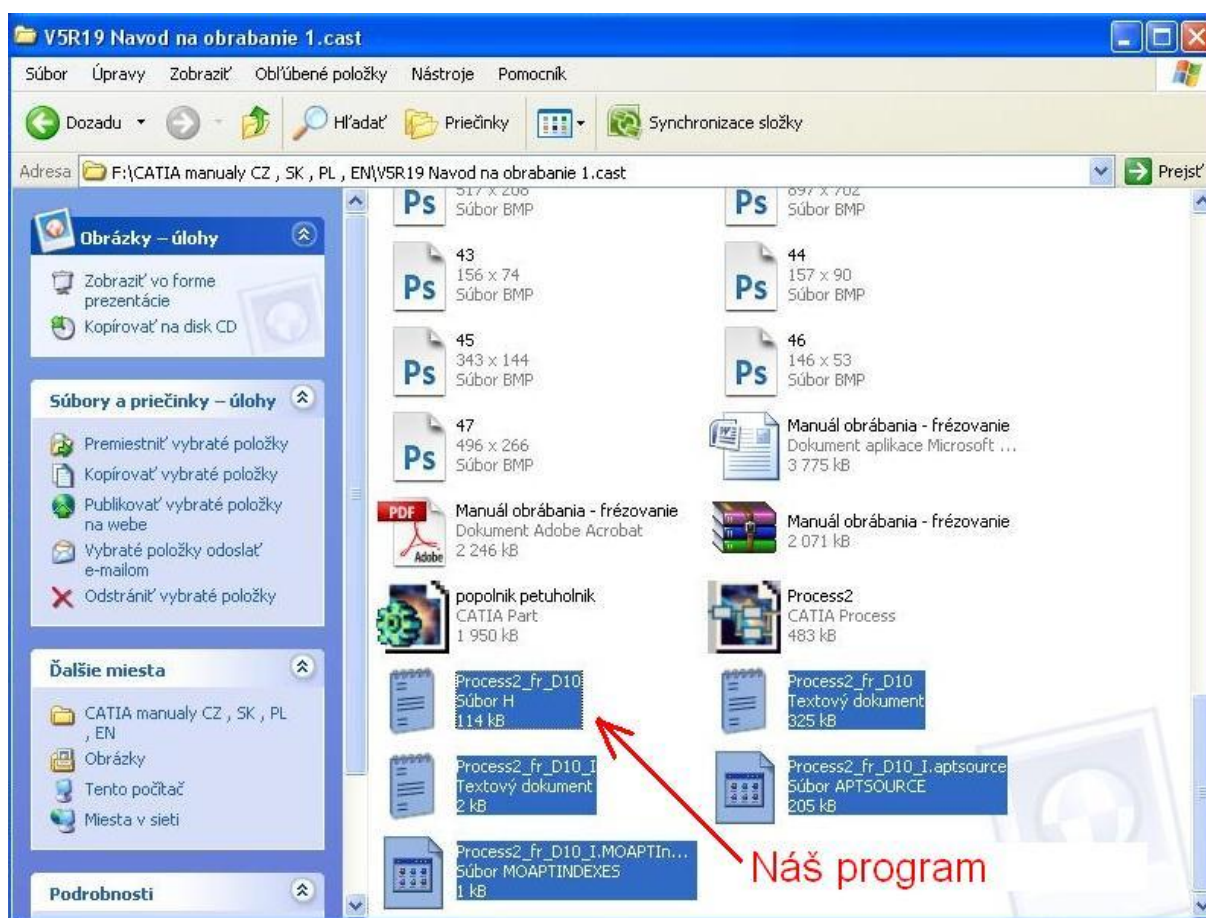
Pretoze je priamo na dany stroj .

Na zaver stlacime Execute . Vyskoci okno cmd.exe .



Akonahle nam zmizne z obrazovky , znamena , ze drahy nastroja su vygenerovane a mozeme stlacit Close . Tym je program vygenerovany a ulozeny v priecinku procesu obrabania .

Teraz si mozeme otvorit dany priecinok , v ktorom sa nachadzaju vsetky subory generovania . Sklada sa s 5-tich suborov , medzi ktorymi je aj subor h , pre nas najvzacnejši :-). Staci ho iba nakopirovat do stroja a mozeme s nim dalej pracovat . **Pozor na BLK , cislo nastroja a koniec programu !!!** To je generovane automaticky .



Ostatne vysvietene subory mozeme bez obav vymazat . Su to len informacie o generovanom procese .

Subor H si mozeme pozriet (skontrolovat) vo WordPad-e .

```

1 BEGIN PGM Part Operation.1 MM
2 BLK FORM 0.1 Z X-100 Y-100 Z-50
3 BLK FORM 0.2 X+100 Y+100 Z+0
4 TOOL CALL 22 Z S3000
5 L M03
6 L X-17.441 Y-55.405 Z+20 FMAX
7 L Z+9.063 FMAX
8 L Z-0.938 F1000
9 L X-15.426 Y-47.559
10 L X-15.451 Y-47.553 F1500
11 L X-21.289 Y-45.241
12 L X-26.791 Y-42.216
13 L X-31.871 Y-38.526
14 L X-33.761 Y-36.751
15 L X-31.64 Y-37.662
16 L X-17.935 Y-42.115
17 L X-15.993 Y-42.406
18 L X-13.936 Y-41.989
19 L X-13.537 Y-41.949
20 L X-12.899 Y-42.807
21 L X-11.427 Y-44.025
22 L X-10.403 Y-44.559
23 L X+3.533 Y-49.089
24 L X+5.761 Y-49.57
25 L X+3.14 Y-49.901
26 L X-3.14
27 L X-9.369 Y-49.114
28 L X-15.426 Y-47.559
29 L X-15.434 Y-47.557 Z-0.935
30 L X-15.441 Y-47.555 Z-0.933
31 L Z+9.067 F2000
32 L Z+20 FMAX
33 L X-0.737 Y+4.592 FMAX
34 L Z+11.1 FMAX

```

Ak chcete generovat dalsie drahy nastroja , postup je ten isty , s tym , ze si vyberiete dany nastroj .

Neodporucam ukladat vsetky procesy do jedneho priecinku . T.z. jedna suciastka so vsetkymi nastrojmi v jednom priecinku . Mali by ste s toho chaos :-)

To je asi tak vsetko .

Blizsie info na <http://heidenhain.webnode.cz> .