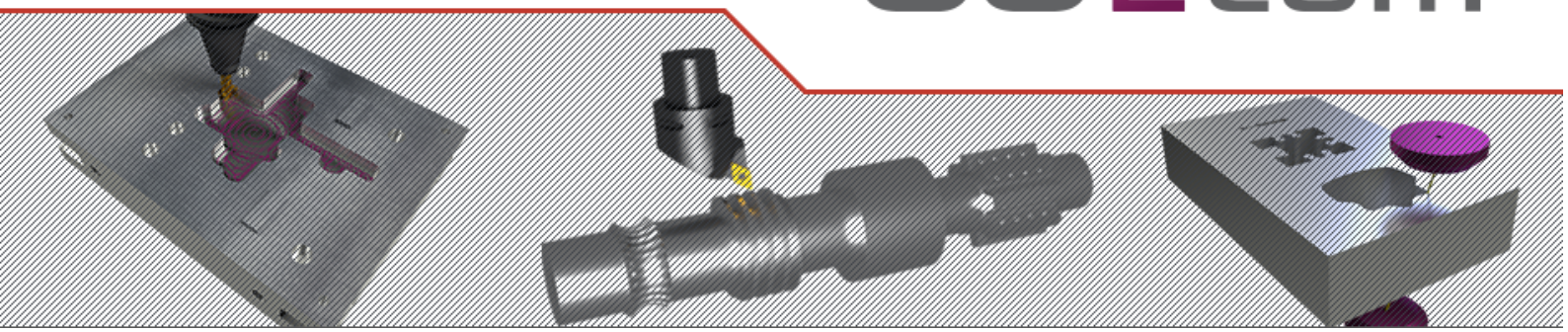
GO2cam



Nakamura Tome WY-150

The contents of this manual are relative to GO2cam version:

V6.09

Sptember 2023

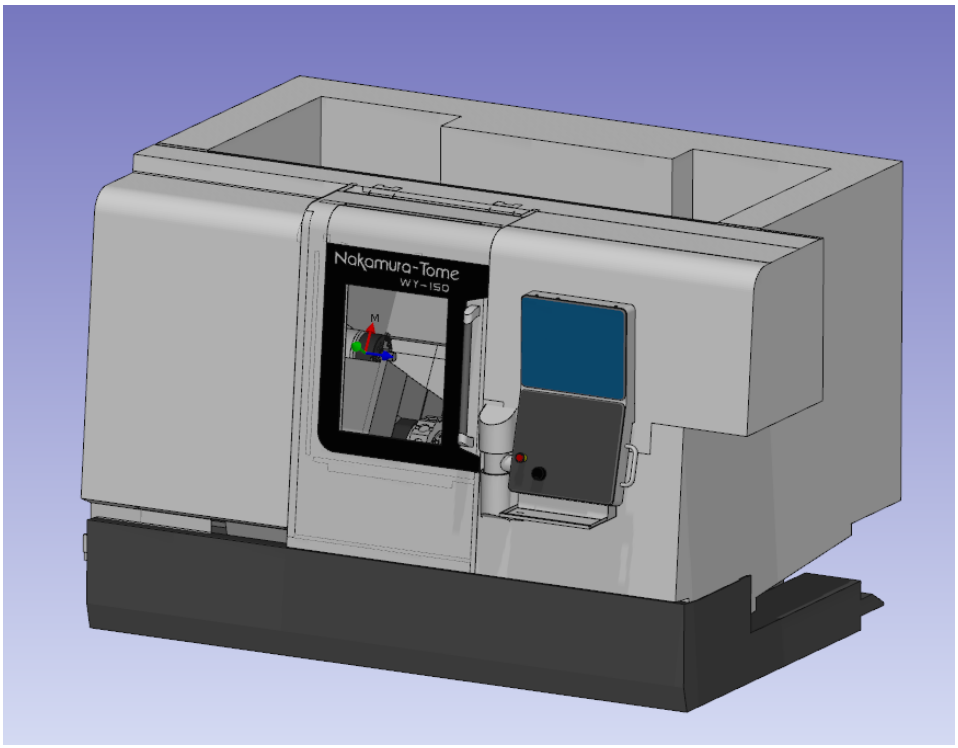
About GO2cam

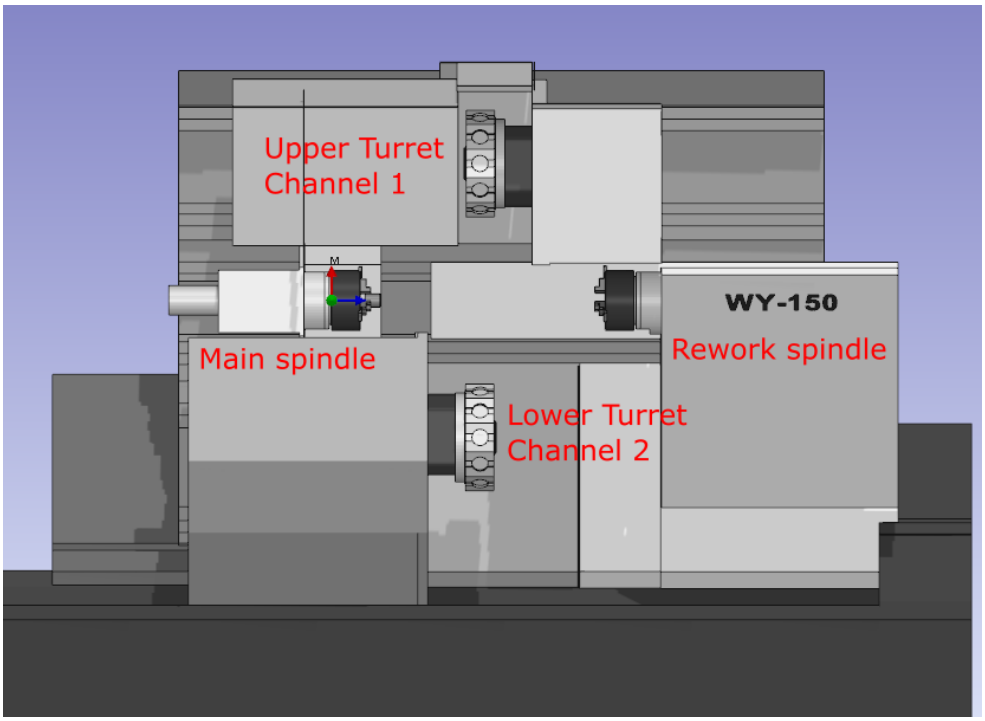
Warning to the user: all the forms included in this document are given as examples only. GO2cam International cannot be responsible for any consequences of their use.

Summary

1 Machine description

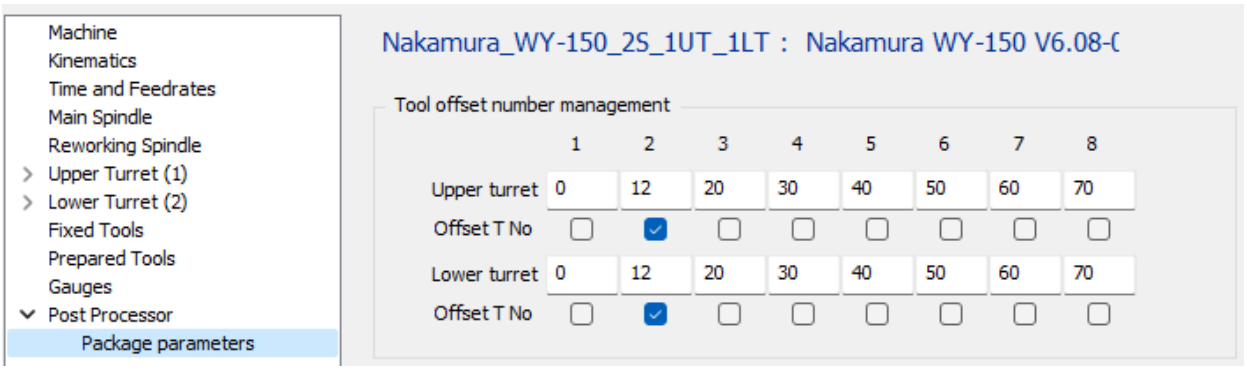
The machine is Nakamura Tome WY-150 with two spindles and 2 turrets. One upper, and one lower.





2 Package parameters

2.1 Tool offset number management



By default a tool is called with it number and offset number with the same than the tool number.

If the tool mounted on the tool support 1 of a turret, it will called with T0101.

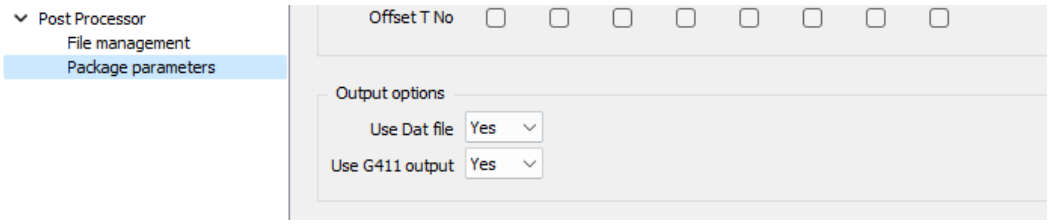
If there is more than one tool the second tool mount on the second position will be offset of 12. The tool will be called with T0113.

You can also check the “Offset T No” to be able to offset the tool number too.

If the option is check the tool number will be offset of 12. It will be called with T1313.

You can change the offset value for each tool position. By default the first triedrial of tool holder will offset of 0, the second offset of 10, the third offest of 20, …

2.2 Use Dat file



If you use this mode it means the parting rework operation will not be outputed by PP and have to be manage in the dat file. It means also the user will always work in bar and always use the same scenario in GO2cam.

This file has to be saved in the mac folder with the same name than MCT file and ".DAT" as extension.

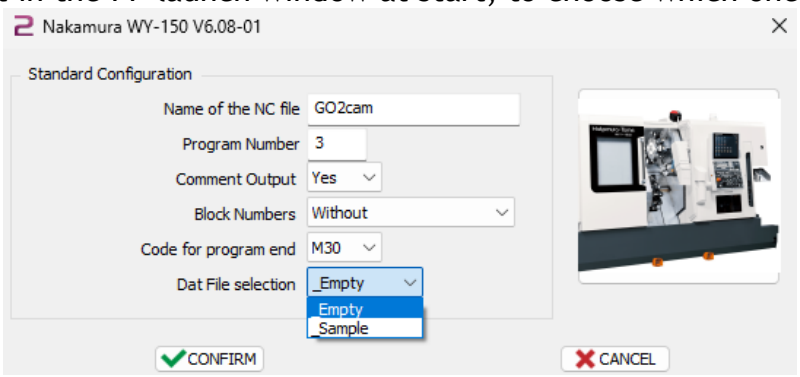
An empty file with only section defined is stored in the mac folder with the name of MCT following by "_Empty".

You can define several Dat files with these rules for the name :

- File name start with the name of machine
- Add a suffix to the name of dat file
- Don't use "-" in the suffix

Sample : "Nakamura_WY-150_2S_1UT_1LT_Sample.DAT" and "Nakamura_WY-150_2S_1UT_1LT_Empty.DAT"

You will have the list in the PP launch window at start, to choose which one use.

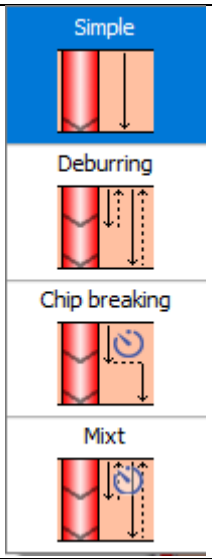
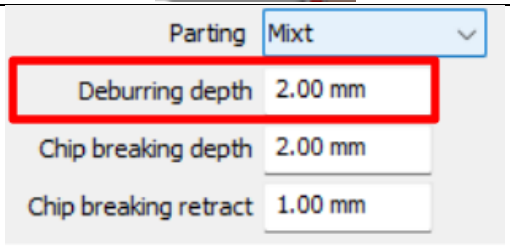
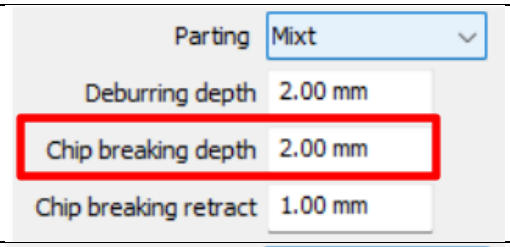
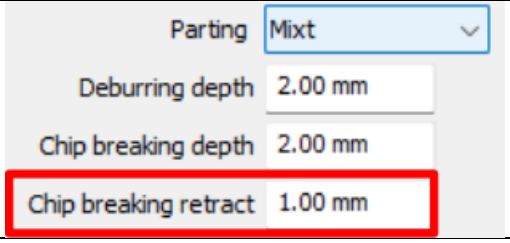
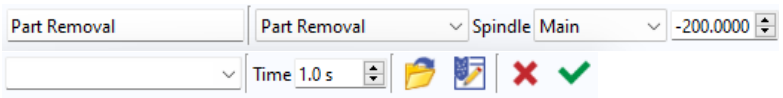


A dat file contains preformat NC code and you can use some variables that will be replaced by values when the program will be generated.

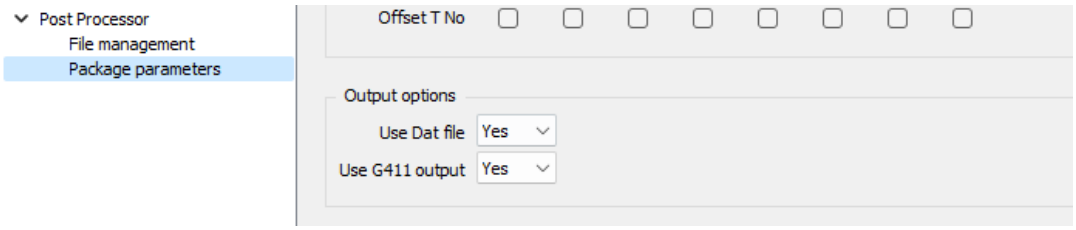
The available variables are the following

Variable	Meaning	
$PART_LG	Length of finish part	
$STOCK_LG	Length of stock	
$STOCK_ZMAX	Zmax of stock regarding the origin	

$STOCK_DIAM	Diameter of stock	
$STOCK_DIAM_IN	Inside diameter of stock	
$Z_ALLOWANCE	Allowance of the stock regarding the origin	
$MAIN_OUT	Length of part out of the main spindle	
$REWORK_IN	Length of part inside the chuck from the max of chuck in rework spindle	
$REWORK_OUT	Length of part out of the chuck in rework spindle	
$CUT_PART_LG	Length of part after parting	
$CUT_Z_ALLOWANCE	Allowance in the aprting cycle	
$CUT_UNIT	Spindle unit code 97 for rot/min 96 for m/min	
$CUT_CSS	Cutting speed for parting operation. 0 if unit is 97	
$CUT_RPM	Spindle speed in rotation per minute. 0 if unit is 96	

$CUT_TYPE	Type of parting cycle used 0 : Simple 1 : Deburring 2 : Chip Breaking 3 : Mixt	
$CUT_DEBURRING_DEPTH		
$CUT_CHIP_BREAK_DEPTH		
$CUT_CHIP_BREAK_RETRACT		
$NUM_PROG	Number of program	
$REWORK_PART_CATCHER	Position of part catcher	By default the value is set to -120 It can be change by using techno function “Part removal” 

2.3 Use G411 output (JUMP option)



When using G411, the PP will output a G411 command at the start of operation. For main spindle it will output G411 L1 I<xx> and for rework spindle G411 R1 I<xx> where <xx> is the block number of the end of operation.

If this option is used it will not have any other block number in the program.

The other statements of G411 have to be output with the DAT file. Check the machine manual to have more information about it.

2.4 Origin Option

It's possible to define a default value for origin number for main spindle and for rework spindle.