

General information:

Date: 2021-10-29

Time: 14:56:38

Measurement Unit: millimeters

Number of tools: 7

Number of blocks: 173

Operation time information: cuttingTime="0h:06m:02,0s" startTime="0h:00m:00,0s" endTime="0h:06m:02,0s" dwellTime="0h:00m:00,0s" toolChangingTime="0h:00m:32,4s" workingTime="0h:04m:33,2s" movingTime="0h:00m:56,3s"

Tool information:

SCHAFTFRAESER_D12

SCHAFTFRAESER_D14

SCHAFTFRAESER_D11

SCHAFTFRAESER_D10

SCHAFTFRAESER_D9

Bohrer_d10

Gewindebohrer_M12

Operation information:

operations count="37"

operation id="4" description=KOLLISION tool=SCHAFTFRAESER_D12 firstBlk="6" lastBlk="14" no_blocks="9" no_nci="9"

timeInfo cuttingTime="0h:00m:17,3s" startTime="0h:00m:03,7s" endTime="0h:00m:21,0s" workingTime="0h:00m:14,1s" movingTime="0h:00m:03,1s"

operation id="7" description=KOLLISION_RANGE tool=SCHAFTFRAESER_D14 firstBlk="19" lastBlk="27" no_blocks="9" no_nci="9"

timeInfo cuttingTime="0h:01m:09,1s" startTime="0h:00m:24,7s" endTime="0h:01m:33,8s" workingTime="0h:01m:03,4s" movingTime="0h:00m:05,6s"

operation id="10" description=FRAESER_D11 tool=SCHAFTFRAESER_D11 firstBlk="32" lastBlk="40" no_blocks="9" no_nci="9"

timeInfo cuttingTime="0h:00m:17,4s" startTime="0h:01m:37,5s" endTime="0h:01m:54,9s" workingTime="0h:00m:14,1s" movingTime="0h:00m:03,2s"

operation id="13" description=FRAESER_D10 tool=SCHAFTFRAESER_D10 firstBlk="45" lastBlk="53" no_blocks="9" no_nci="9"

timeInfo cuttingTime="0h:00m:17,4s" startTime="0h:01m:58,6s" endTime="0h:02m:16,0s" workingTime="0h:00m:14,1s" movingTime="0h:00m:03,2s"

operation id="16" description=FRAESER_D9 tool=SCHAFTFRAESER_D9 firstBlk="58" lastBlk="66" no_blocks="9" no_nci="9"

timeInfo cuttingTime="0h:00m:17,4s" startTime="0h:02m:19,7s" endTime="0h:02m:37,1s" workingTime="0h:00m:14,1s" movingTime="0h:00m:03,2s"

operation id="19" description=KOLLISION_2 tool=SCHAFTFRAESER_D12 firstBlk="71" lastBlk="79" no_blocks="9" no_nci="9"

timeInfo cuttingTime="0h:00m:17,3s" startTime="0h:02m:40,8s" endTime="0h:02m:58,2s" workingTime="0h:00m:14,1s" movingTime="0h:00m:03,1s"

operation id="22" description=KOLLISION_RANGE2 tool=SCHAFTFRAESER_D14 firstBlk="84" lastBlk="92" no_blocks="9" no_nci="9"

timeInfo cuttingTime="0h:01m:09,1s" startTime="0h:03m:01,9s" endTime="0h:04m:11,0s" workingTime="0h:01m:03,4s" movingTime="0h:00m:05,6s"

operation id="25" description=BOHREN_1 tool=Bohrer_d10 firstBlk="97" lastBlk="105" no_blocks="9" no_nci="9"

timeInfo cuttingTime="0h:00m:07,6s" startTime="0h:04m:14,7s" endTime="0h:04m:22,3s" workingTime="0h:00m:04,4s" movingTime="0h:00m:03,2s"

operation id="28" description=GEWINDESCHNEIDEN_1 tool=Gewindebohrer_M12 firstBlk="110" lastBlk="118" no_blocks="9" no_nci="9"

timeInfo cuttingTime="0h:00m:04,9s" startTime="0h:04m:26,0s" endTime="0h:04m:30,9s" workingTime="0h:00m:01,9s" movingTime="0h:00m:02,9s"

operation id="31" description=KOLLISION_3 tool=SCHAFTFRAESER_D12 firstBlk="123" lastBlk="146" no_blocks="24" no_nci="24"

timeInfo cuttingTime="0h:00m:42,8s" startTime="0h:04m:34,6s" endTime="0h:05m:17,4s" workingTime="0h:00m:39,4s" movingTime="0h:00m:03,3s"

operation id="34" description=KOLLISION_4 tool=SCHAFTFRAESER_D14 firstBlk="151" lastBlk="159" no_blocks="9" no_nci="9"

timeInfo cuttingTime="0h:00m:17,5s" startTime="0h:05m:21,1s" endTime="0h:05m:38,6s" workingTime="0h:00m:14,6s" movingTime="0h:00m:02,8s"

operation id="37" description=FRAESER_D12 tool=SCHAFTFRAESER_D12 firstBlk="164" lastBlk="173" no_blocks="10" no_nci="10"

timeInfo cuttingTime="0h:00m:19,7s" startTime="0h:05m:42,3s" endTime="0h:06m:02,0s" workingTime="0h:00m:15,3s" movingTime="0h:00m:04,3s"

Error information:

SCHAFTFRAESER_D12

nci= 10

<simulator_collision firstObjId="tool" secondObjId="stock" firstObjCollComponentId="tool (Flute Part)" />

SCHAFTFRAESER_D14

nci= 22

<simulator_out_of_range type="overflow" axis="Z" custom_information=" G0 X-93 Y+1100 Z-125 A-90 B0" />

nci= 23

<simulator_collision firstObjId="tool" secondObjId="stock" firstObjCollComponentId="tool (Flute Part)" />

<simulator_out_of_range type="overflow" axis="Z" custom_information=" G0 X-93 Y+101.400 Z-125 A-90 B0" />

nci= 25

nci= 26

<simulator_out_of_range type="overflow" axis="Z" custom_information=" G1 X-93 Y+1100 Z+125 A-90 B0" />

nci= 27

<simulator_out_of_range type="overflow" axis="Z" custom_information=" Z+600 TOOLCHANGEPOINT Z" />

SCHAFTFRAESER_D12

nci= 75

<simulator_collision firstObjId="tool" secondObjId="stock" firstObjCollComponentId="tool (Flute Part)" />

nci= 76

SCHAFTFRAESER_D14

nci= 87

<simulator_out_of_range type="overflow" axis="Z" custom_information=" G0 X+93 Y+1100 Z+125 A-90 B0" />

nci= 88

<simulator_collision firstObjId="tool" secondObjId="stock" firstObjCollComponentId="tool (Flute Part)" />

<simulator_out_of_range type="overflow" axis="Z" custom_information=" G0 X+93 Y+101.400 Z+125 A-90 B0" />

nci= 89

nci= 91

<simulator_out_of_range type="overflow" axis="Z" custom_information=" G1 X+93 Y+1100 Z-125 A-90 B0" />

nci= 92

<simulator_out_of_range type="overflow" axis="Z" custom_information=" Z+600 TOOLCHANGEPOINT Z" />

Bohrer_d10

nci= 101

<simulator_collision firstObjId="tool" secondObjId="stock" firstObjCollComponentId="tool (Flute Part)" />

nci= 102

<simulator_collision firstObjId="z" secondObjId="stock" />

nci= 103

<simulator_collision firstObjId="z" secondObjId="stock" />

Gewindebohrer_M12

nci= 115

SCHAFTFRAESER_D12

nci= 132

<simulator_collision firstObjId="tool" secondObjId="stock" firstObjCollComponentId="tool (Flute Part)" />

nci= 134

nci= 135

nci= 142

<simulator_collision firstObjId="tool" secondObjId="stock" firstObjCollComponentId="tool (Flute Part)" />

nci= 143

SCHAFTFRAESER_D14

nci= 155

<simulator_collision firstObjId="tool" secondObjId="stock" firstObjCollComponentId="tool (Flute Part)" />

nci= 157