

Shopfloor programmer v0.2.1 for EdingCNC by Saarloos.net

A tool to easy make simple shapes programmed on the machine.

This version is the Release Candidate and could contain some flaws and glitches. So be aware while using this software!

The machine can make movements not expected or even start automatic! Emergency stops and or driver disable options are mandatory!

The installation is easy and you can do this without any special know-how.

Needed:

1. macro.cnc
2. dialogpictures folder
3. icons
4. config change

1. Macro.cnc

The macro file contains the software to use the programming interface.

This file is based on EdingCNC version v4.02.xx and can be overwritten in the default folder if you did not change it at all yourself.

With a 32 bits version of windows it is in:

C:\Program files\CNC4.02/

And the 64 bits version:

C:\Program Files (x86)\CNC4.02/

Overwrite the file if you want to use defaults. Else you can change your macro with notepad.exe or similar.

The code begins at:

```
#####  
##### BEGIN SHOPFLOOR PROGRAMMER #####  
#####
```

And ends at:

```
#####  
##### END SHOPFLOOR PROGRAMMER #####  
#####
```

2. Dialogpictures folder

Copy the dialog pictures to the folder of your installation where the same folder is.

3. Icons folder

Copy the icons to the folder of your installation.

4. Change the config

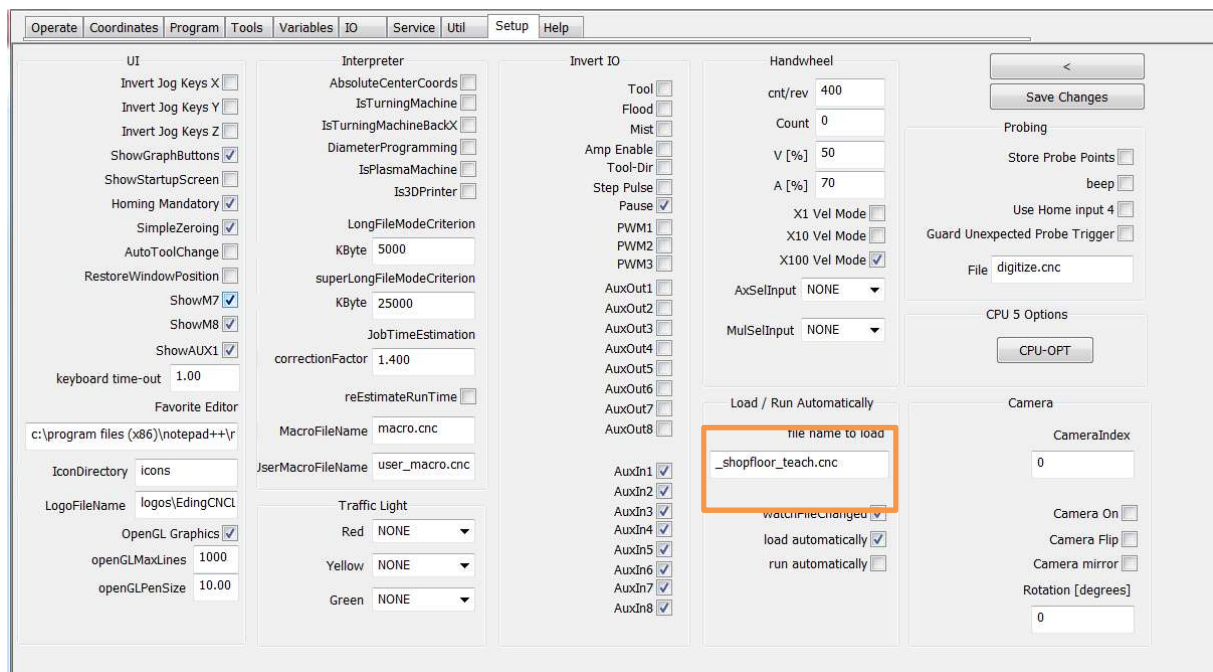
In EdingCNC you need to make some changes to have the interface work well.

Change the Load/Run Automatically to checked.

The file written for the interface is `_shopfloor_teach.cnc` and needs to be filled in the file name to load cell.

To auto load it, check the load automatically option

Example configuration:



The interface is now ready.

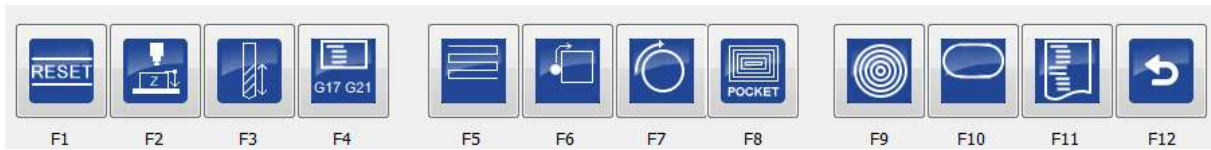
Restart EdingCNC to make the config operational.

Run the machine in simulation mode. (Safety first! So disconnect your EdingCNC board)

Check for errors in the message window and fix them first before proceeding.

5. Cycli

You can start the cycli from the usersubmenus.



Next options are now available:

Usersub 3:

Header and footers

The header and footer for a teach in list.

Usersub 4:

Flatten

Flattening your workpiece before all other cycles.

Usersub 5:

Contour square

Make a square contour inside or outside with the tool compensated automatic.

Usersub 6:

Contour round

Make a round contour inside or outside with the tool compensated automatic.

Usersub 7:

Pocket square

Square pocket with helix lead in in the center.

Usersub 8:

Pocket round

Round pocket with helix lead in in the center.

Usersub 9:

Slotting

Slot milling where the longest side has rounded edges.

Usersub 10:

Teachin programming

1 to make a new file.

0 to add a tested cycle

Besides the _shopfloor_teach.cnc there will be a _shopfloor_part.cnc file made in the main directory of EdingCNC.

When you choose 0, the last cyclus will be added to _shopfloor_part.cnc

If you are ready you can open _shopfloor_part.cnc in the file menu and start all cycli at once.

Usersub 11:

Drilling

Hole drilling made easy

Usersub 12:

Circular drilling

Make a circular pattern for drilling, number of holes and starting angle.

Usersub 13:

Tapping

Thread tapping using the spindle speed sensor as index.

Usersub 20:

Warm Up

The machine moves all axles to it's maximum make the lubrication on the spindles and rails evenly.

After the moves the main spindle will be running at different speeds to warm up the bearings.

When the cycle is ended, the machine will do a home sequence again.

Disclaimer:

This software is under development and can contain errors. Usage is for your own risk.
In simulation mode every thing can be tested.
You may distribute the software but not commercially.

www.saarloos.net