ATC File changes for PRS4

11/06/17 – Gordon Bergfors

To accommodate the PRS4 ATC tool rack configuration and still work for the older ATC tool bar configuration there were a good number of files that needed to be modified. A majority of the changes involved checking for a PRS4 or PRS3 and earlier setting in my_variables as the variable &ATC. A 3rd option has been added in my_variables for PRS4 ATCs, making the options 0 for manual toolchange machines, 1 for PRS3 and earlier ATC machines and 2 for PRS4 ATCs. This option is set in the ShopBot setup program and saved to my_variables. The following is a list of the files that have changed and need to be updated in the SB3 installation.

        C:\SbParts
                Set_Limits.sbp (new file)

        C:\Custom
                Custom1.sbc
                Custom2.sbc
                Custom3.sbc
                Custom6.sbc
                Custom7.sbc
                Custom9.sbc
                Custom72.sbc
                Custom73.sbc
                Custom74.sbc
                my_variables.sbc

        C:\SbParts\Custom\ATC
                ATC.sbp
                ATC_calibration.sbp
                ATC_check_status.sbp
                ATC_Get_PlateOffset.sbp
                ATC_Warmup.sbp
                ATC_XYZ_Home.sbp
                ATC_Zoffset.sbp
                ATC_ZZero.sbp

        C:\SbParts\Custom\ATC_Local_Data (These have defaults that are set to a default value and not as our table is set up. Don't overwrite these if they already exist. This will wipe out the users calibration.)
                ATC_tool_variables.sbc
                ATC_variables.abc