



HEIDENHAIN



NC Solutions

Description of NC program 9015

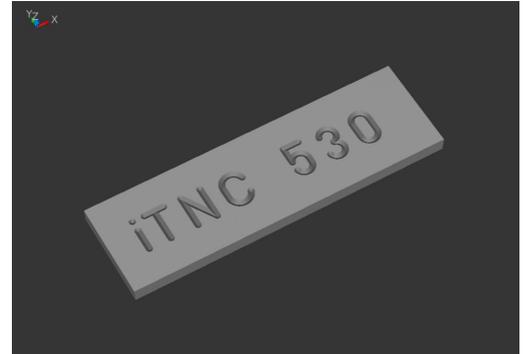
English (en)
4/2017

1 Description of the NC program 9015_en.h

NC program for engraving texts in a linear layout.



The NC program is operable as of iTNC 530
NC software number 340 49x 03 SP3



Description

With this NC program the control engraves texts defined by you into a workpiece. You define the texts as string parameters. You can use uppercase letters, lowercase letters and the most important special characters for the engraving text.

Geometric capabilities

Texts can be defined horizontally. The position and font height are selectable; these do not influence each other.

The font is of a vertical, simple, standard style.

The characters used are kept fully proportional. This means that the control automatically modifies the character width and distance between characters to your defined font height.

Define your desired engraving depth with the milling depth (Q4) input value.

Remark on control used

For circular arcs the NC program uses the CC and C functions. These circular arcs are programmed with three decimal places. On controls with four enterable decimal places you must check whether you need to modify the accuracy requirements for the circle definitions in MP 7431 (machine parameter or user parameter).

Determining positions

The position of the first character is defined in two parameters.

After engraving a character the control shifts the momentary position by the width of the engraved character. The control saves the new position (or angle of rotation as the case may be) and uses this position for the next character.

This is defined in the NC program and does not involve you as the operator—the control executes all the required calculations.

Program layout

The engraving program is designed as a single complete program.

It consists of the following program sections:

- 1 Definition of the cutting data and the tool call
- 2 Definition of the text blocks
- 3 Subprograms with the necessary calculations and path contours

Using the program

The operator defines all required parameters in the main section of the NC program. The subprograms remain unchanged because these contain complex calculations.

In the main program you define the tool, all parameters required for machining and the texts to be engraved.

You can also simply expand the main program with further texts.

Each text requires the input parameters of the layout and the characters to be engraved by defining the string parameter

DECLARE STRING QS1= "xxx" and by calling the subprogram **CALL LBL "WRITE"**.

General parameters

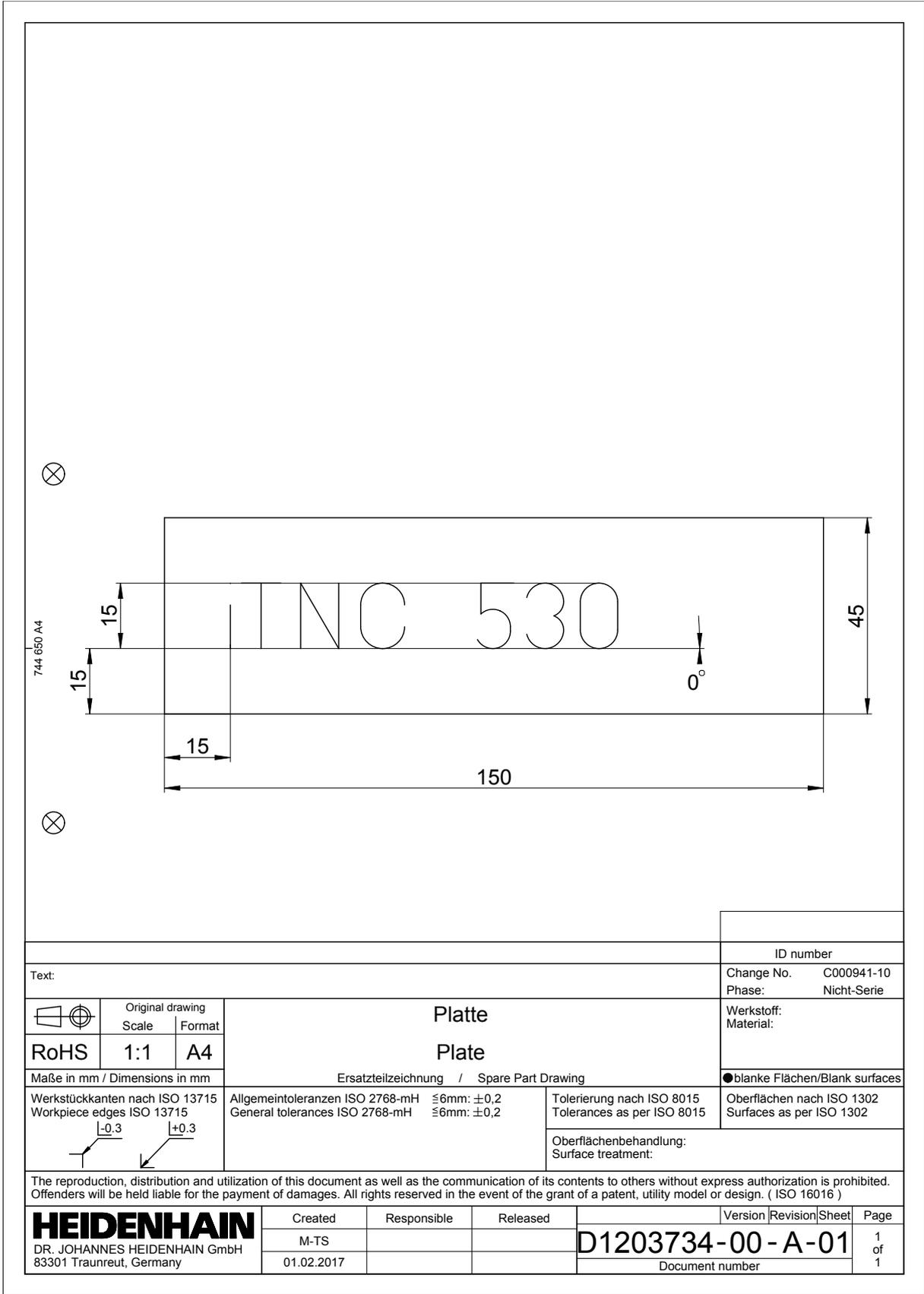
Parameter	Name	Meaning
Q2	SCALING FACTOR EFFECT	Input 0 or 1 matching the entry in machine parameter 7410 The scaling factor is effective on 2 or 3 axes
Q4	MILLING DEPTH	Depth of engraving—absolute value from the datum
Q6	FEED RATE FOR MILLING	Traversing speed of the tool during machining
Q7	FEED RATE FOR PECKING	Traversing speed of the tool in the Z axis
Q8	SAFETY CLEARANCE	Z clearance between the tool and datum approached by the control in rapid traverse before machining

Parameters for text on a straight line

Parameter	Name	Meaning
Q5	FONT HEIGHT	Character height in mm
Q21	STARTING POINT IN X	X coordinate of the first character relative to the datum
Q22	STARTING POINT IN Y	Y coordinate of the text line relative to the datum
Q29	ROTATION	Absolute rotation angle of the text line relative to the positive X direction

Explanation

The datum of every character lies at the height of the text line in the center of the character. You define the starting position before execution of the first character and at the beginning of each line with Q21 and Q22. The control recalculates each datum for the character within the line. If desired you can also individually specify the position of single characters before the call with Q21 and Q22, if for example you wish to carry out a fine adjustment of the position.



Q7

Q6

Q2--> MP7410

Q8

Q4

Q5

Q22

Y+

X+

W

Q21

Q29

TNC 530

Text:		ID number	
Change No. C000941-10		Phase: Nicht-Serie	
	Original drawing Scale: 1:1 Format: A4	Bausatz Assembly kit	
Maße in mm / Dimensions in mm			
Werkstückkanten nach ISO 13715 Workpiece edges ISO 13715 		Montage-ZZ / Assembly Drawing ●Tolerierung nach ISO 8015 Tolerances as per ISO 8015 ●Oberflächenbehandlung: Surface treatment:	
Allgmeintoleranzen ISO 2768-mH ≤6mm: ±0,2 General tolerances ISO 2768-mH ≤6mm: ±0,2		Oberflächen nach ISO 1302 Surfaces as per ISO 1302	
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