



HEIDENHAIN



NC Solutions

Description of NC program 9035

English (en)
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1 Description of the NC program 9035_en.h

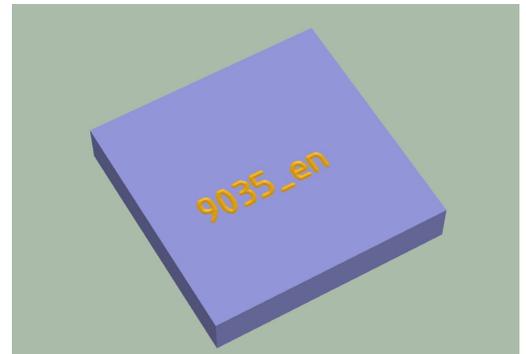
NC program for engraving the name of the current program.



The NC program runs on the iTNC 530 starting with NC software number 340 49x 07 or 606 42x 02.



In combination with the NC program 9020_de.h of the NC solutions, you can also implement the application on the iTNC 530 starting with NC software number 340 49x 04.



Description

With this NC program, the control saves the file path of the currently active NC program in a text file. From this text file, the control saves the file path in a string parameter. Then the control separates the file name of the NC program from the string parameter and, using Cycle 225 **ENGRAVING**, engraves it onto the workpiece.

NC program 9035_en.h

You define the tool at the beginning of the program. Then the control moves the tool to a clearance height. In the following program section, the control identifies the current program name. You do not need to make any modifications in this section. In this program section, the control writes the content of the mask file mask.a into the text file FILE.a using **FN16 F-PRINT**. Then the control calls the NC program 90351_en.h.

After the program has been called, Cycle 225 **ENGRAVING** is defined. The control uses the identified string parameter QS1 as the text to be engraved. You define the other cycle parameters according to your needs. The control then positions the tool at the starting point of the engraving and calls the cycle.

In the final step, the control retracts the tool and ends the NC program.

NC program 90351_en.h

With this program, the control identifies the program name of the main program and saves it in a string parameter. No modifications are needed in the program.

In the first step, the control copies the text file FILE.a into an NC program with the name FILE.h using **FUNCTION FILECOPY**. The control then defines the backslash as string parameter QS2. After this, the control calls the previously created NC program FILE.h using the command **CALL PGM**. In this NC program, the control defines the string parameter QS1 with the file name of the main program.

A program loop is then programmed in which the control deletes the names of the drive and the path until only the file name remains. In this program section repeat, the control searches for a backslash in the string parameter QS1, in which the file name is defined. When the program finds a backslash, it writes the position of the backslash into parameter Q50. The control then raises the value by one and saves the result in Q52. In the next step, the control reads out the entire length of string QS1. If the control cannot find a backslash in string parameter QS1, it jumps out of the loop and continues the program with the **LBL "END"**. If a backslash was found, then the control deletes it as well as the section before it from the string. Then the program loop is repeated until no more backslashes are present in the string.

In the next step, the control deletes the last two characters from the string parameter. This is the definition of file type .h in the file path. As a result, only the file name QS1 remains in the string.

The control then deletes the FILE.a and FILE.h auxiliary files using **FUNCTION FILEDELETE**.

At the end of the program, the control transmits the program name to the main program as a string in QS1 so that the name can then be available there as the text to be engraved.

Mask file mask.a

The mask file specifies the format of the output file. In this case, it automatically enters the file path of the current NC program. The mask design also makes it possible to copy the created text file into an NC program. To make this possible, the rows **BEGIN PGM** and **END PGM** are integrated.