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NC Solutions

Description of NC program 9040

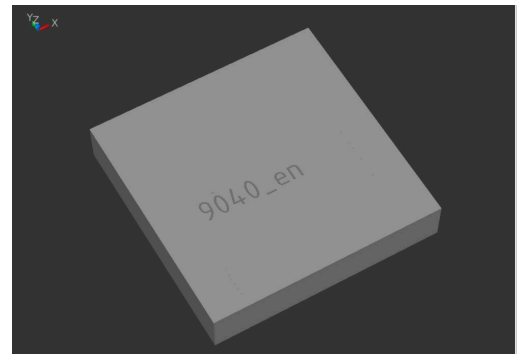
English (en)
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1 Description of the NC program 9040_en.h

NC program for engraving the name of the current program.



This NC program can run on the TNC 640 starting with NC software number 340 59x 02 and on the TNC 620 starting with NC software number 734 98x 02.



Description

With this NC program, the control saves the file path of the currently active NC program 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 along the workpiece.

NC program 9040_en.h

You define the tool at the beginning of the program. The control then moves the tool to a clearance height. In the subsequent program section, the control identifies the current program name. You do not need to make any modifications at this point. In this program section, the control writes the file path into the string parameter QS1 using the command **QS1 = SYSSTR(ID10010 NR1)**. Then the control calls the NC program 90401_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. Define the other cycle parameters in accordance with 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 90401_en.h

With this program, the control identifies the program name of the main program and saves it in a string parameter. No modifications need to be made in the program.

In the first step, the control defines the backslash “\” as string parameter QS2.

A program loop is then programmed in which the control deletes the name 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 stores 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, the control deletes it and the section in front of 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.

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.