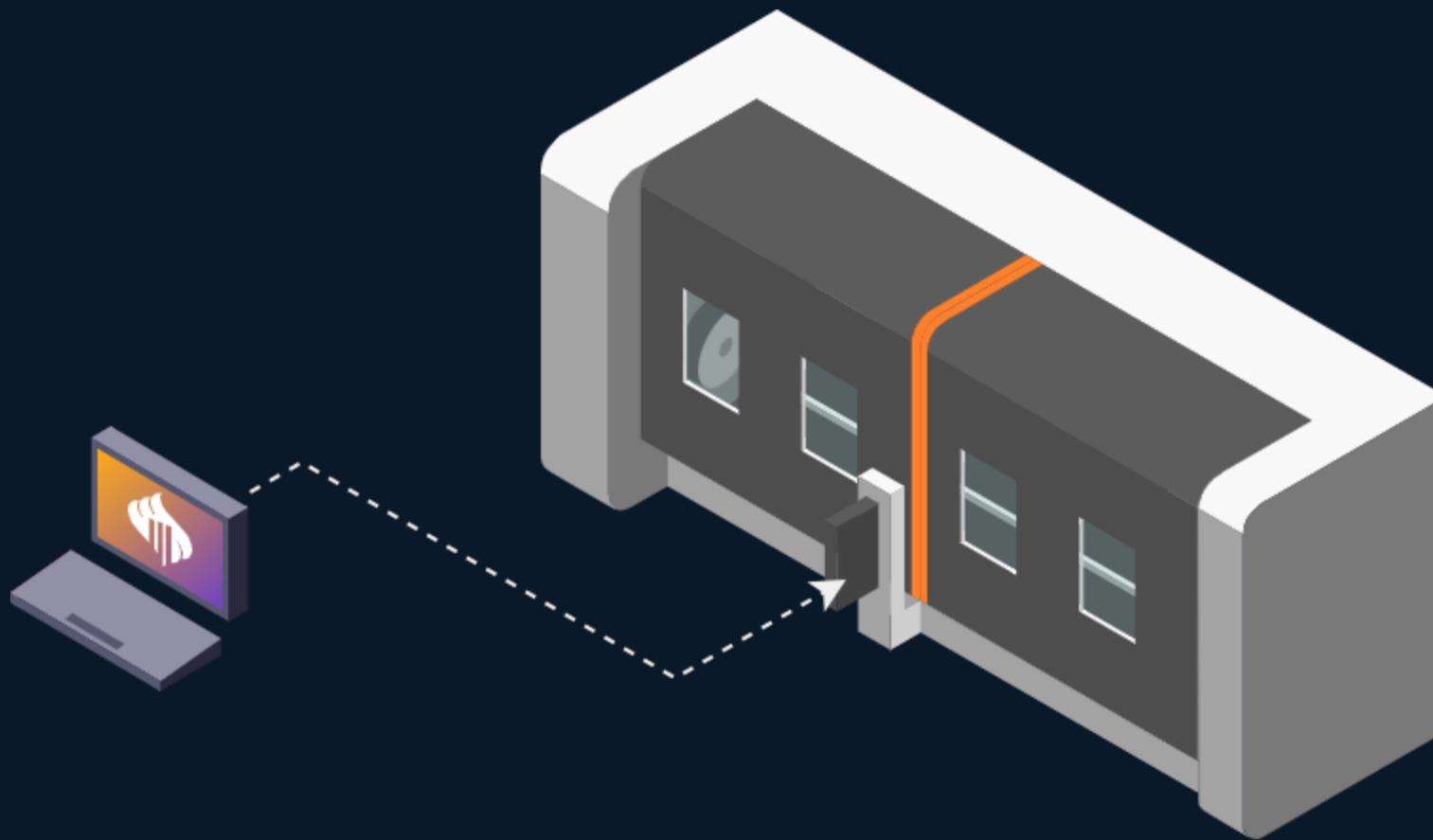


Send program fra Keep til maskin



Send program fra Keep til maskin

Operations Add new

1 **MA20 (demo)**

Grovkjøring draft

Operation **Files**

Programs

1001.PBE 6 seconds ago 552 B ... X

Attachments

Drop files here to upload

Send program to machine →
Fetch program from machine ←
Upload program ↑
Upload

+ Add tool + Add from default toolkit

Type	Sub Type	Number	Suffix	Geometry	Size	Diameter	Grade	Radius	Width	Pitch	Stick...	AP Max	Usabl...	Length	KAPR	Teeth	Description	Actions
Turning	Turning External	T003	A	CNMG	16			1.2						245	93			
Turning	Turning External	T007	C	DNMG	15			0.8						245	93			
Threading	Thread Turning Exter...	T006	G		27					6.35				145			1 dgr underlagsplate.	
Turning	Turning Internal	T080	A	DCMT	11	63		0.8			500				93			
Threading	Thread Turning Exter...	T014	G		16					3				200				
Milling	Insert Mill	T025	A	hhh	11	32		0.8			35			150	90	5		
Milling	Insert Mill	T025	A		11	32		0.8			35			150	90	5		
Holemaking	Solid Drill	T026	S				5				35			200	140			
Milling	Chamfer Mill	T027	V				12				50			250	45	2		
Grooving	Grooving Axial	T015	S					2	4					25			Fullradie stikkstål	
Milling	Solid End Mill	T009																
Milling	Solid End Mill	T010	A			25		0.8				10	35	250		5		

Total Rows: 12

Fremgangsmåte Mazak

Steg 2

0% **0min⁻¹** **0mm/min**

ANr. 12345E Komp test fasfres

ENr. SNr. BNr. 0 0 0 TELLER 0(0) TID 0:00'08"

POSISJON	BUFFER	NESTE KOMAND
∅X 1430.	∅X 0.	G
Y 0.	Y 0.	M
Z -363.6535	Z 0.	V
B 0.	B 0.	A
C 0.	C 0.	
W 0.	W 0.	
V 0.	V 0.	
Sv 0.	Sv 0.	

MASKIN	REST	NPT
∅X 0.	∅X 0.	∅X -1430.
Y 0.	Y 0.	Y 0.
Z 0.	Z 0.	Z 0.
B 0.	B 0.	B 0.
C 0.	C 0.	C 0.
W 0.	W 0.	W 0.
V 0.	V 0.	V 0.
Sv 0.	Sv 0.	Sv 0.

VNr. 12M VNr. 0 MAG.1 LONr. 12M

ENHT : V-OFFSET D#(0) H#(0) X 0. Y 0. Z 198.6749

FAKTI.-∅ 1. Z 198.6749

MODAL

S	∅ F	∅.	M	∅ A	∅
G 1	G 17	G 91	G 23	G 94	G 21
G 49	G 80	G 98	G 50	G 54	G 64
G 40.1	G 67	G 69	G 97	G 15	G 50.1
	G 111	G 50.2	G 113	G 13.1	G 65 P0

BELASTINGSMETER

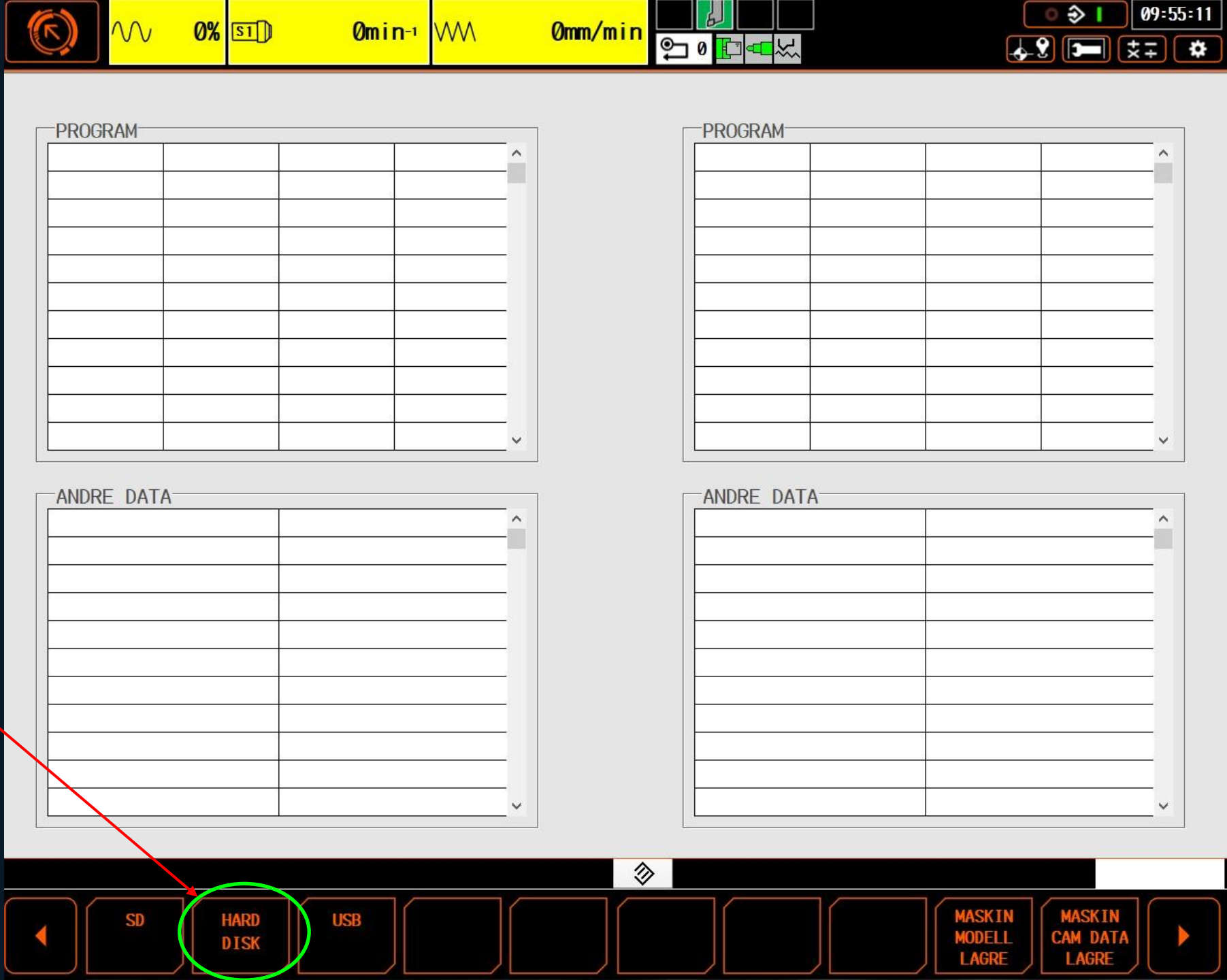
F.SPDL (1)	∅ MIN ⁻¹	∅ M/MIN	∅ X
D.SPDL (1)	∅ MIN ⁻¹	∅ M/MIN	∅ Y
MATN	∅ MM/MIN	∅ MM/REV	∅ Z
B	∅ °/min		∅ B
C	∅ °/min		∅ C
			∅ W
			∅ V
			∅ Sv

DATA INN/UT

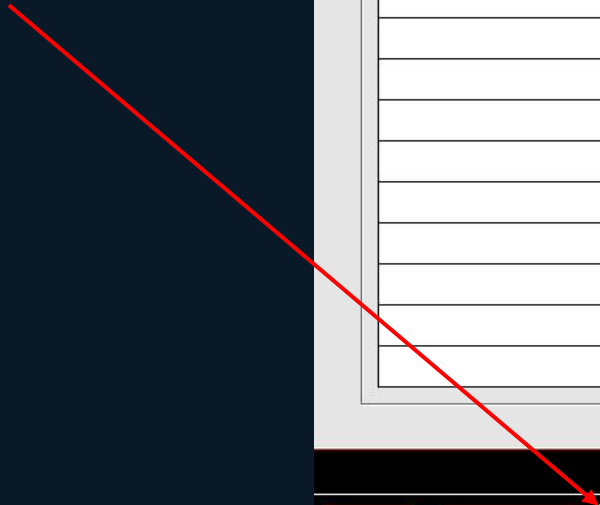
Dette er likt på Smooth/Matrix

Velg:

DATA INN/UT



Velg:
HARDDISK



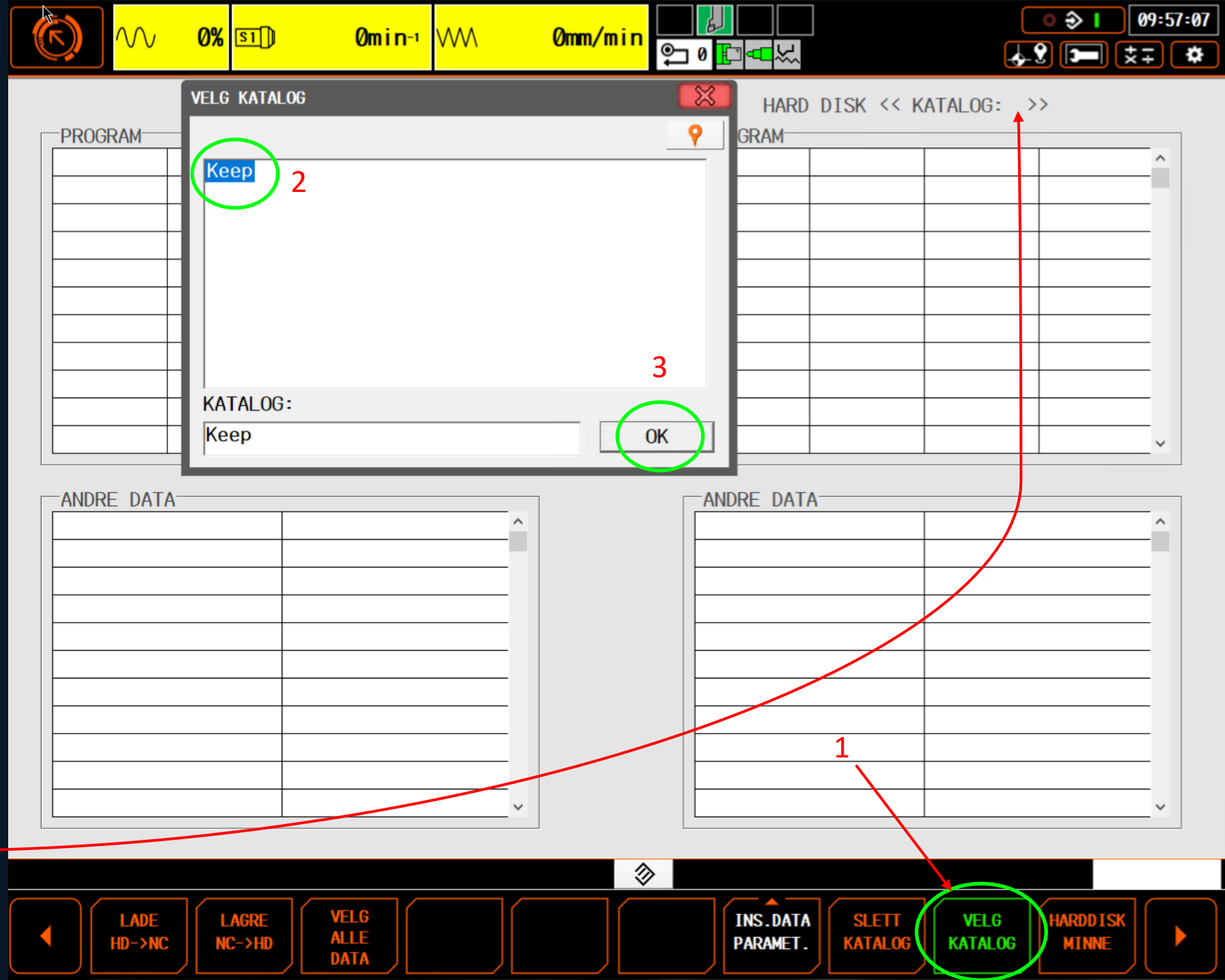
1. Trykk VELG KATALOG

2. Velg mappen med navn "Keep"

3. Trykk OK.

Dette steget trenger man bare å gjøre på nytt hvis maskinen blir skrudd av.

Legg merke til om det er blankt, eller står "Keep" her:



1. Trykk VELG ALLE DATA

2. Trykk OK

The screenshot shows a CNC control interface with four main panels: 'PROGRAM' and 'ANDRE DATA' for both 'NC' and 'HARD DISK << KATALOG: Keep >>'. A dialog box titled 'VELG ALL DATA<INPUT>' is overlaid on the bottom-left 'ANDRE DATA' panel. The dialog has two buttons: 'OK' and 'SLETTE'. A red '1' points to the 'VELG ALL DATA<INPUT>' dialog box, and a red '2' points to the 'OK' button. The 'OK' button is also circled in green. At the bottom of the screen, a row of function buttons is visible, with 'VELG ALLE DATA' circled in green and highlighted by a red arrow pointing from the 'OK' button in the dialog box.

0% 0min⁻¹ 0mm/min 10:07:17

NC HARD DISK << KATALOG: Keep >>

PROGRAM

PROGRAM

1001			

INHOLD ←

ANDRE DATA

ANDRE DATA

VERK.DATA	VERK.KOMP
VERK.FIL	VERKT. MODEL
SKJÆREDATA	NULLP. KOM
KUND PARAM.	MASK.PARAM.
TILLE. NULLP	MAKRO VAR.
	BAKKE DATA
VEDLIKEHOL	

LADE HD->NC LAGRE NC->HD VELG ALLE DATA INS. DATA PARAMET. SLETT KATALOG VELG KATALOG HARDDISK MINNE

Program(er) dukker opp i tabellen for KATALOG: Keep

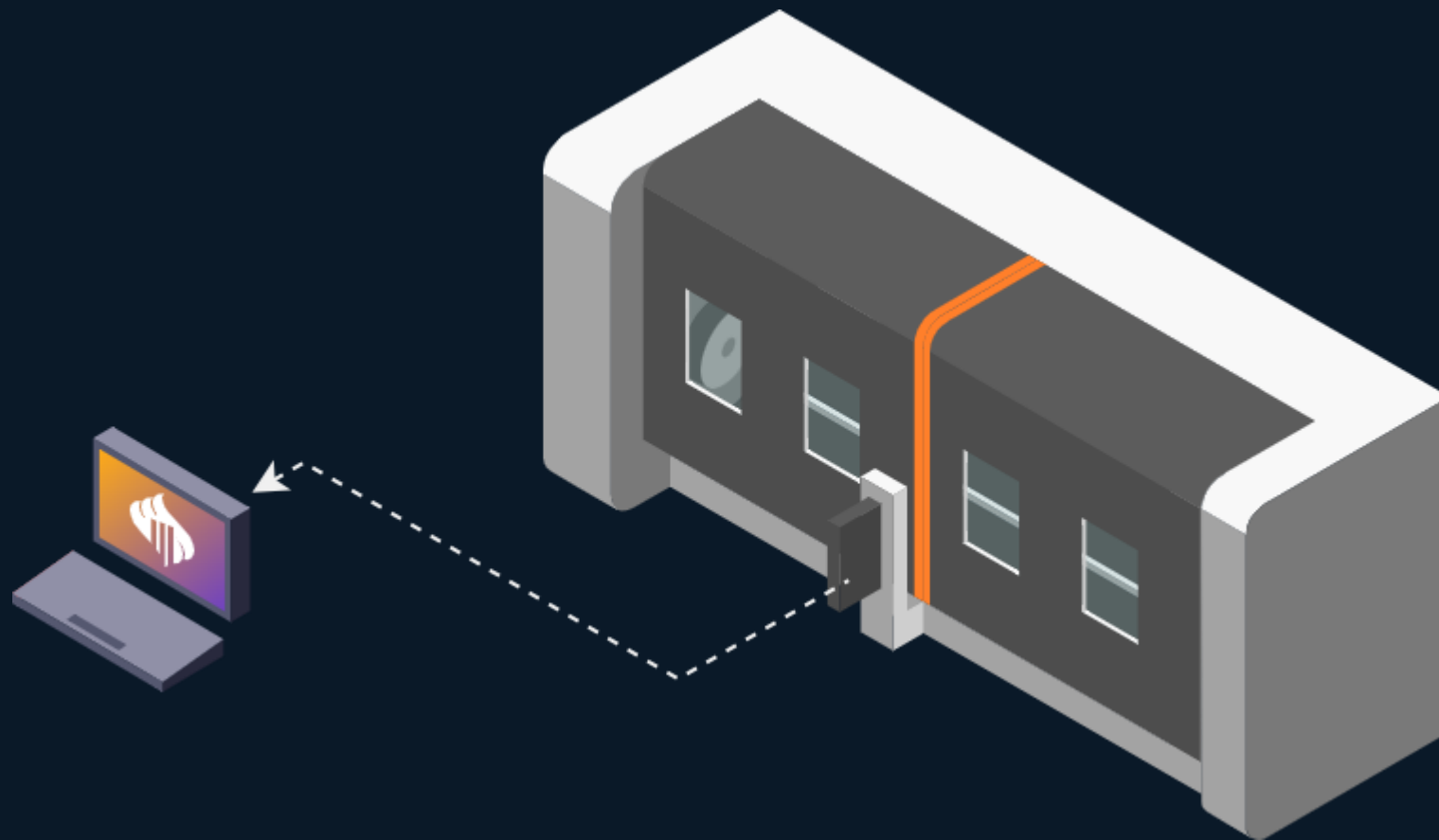
Trykk på LADE HD->NC

The screenshot shows a CNC control interface with a top status bar and a bottom control bar. The status bar displays various parameters: a speed indicator (0%), a feed rate indicator (0mm/min), and a spindle speed indicator (0min-1). The main display area is divided into four quadrants. The top-left quadrant is titled 'PROGRAM' and shows a list with '1001' selected, circled in green. A red '2' is above this quadrant. The top-right quadrant is titled 'HARD DISK << KATALOG: Keep >>' and shows a list with '1001' selected, highlighted in blue. The bottom-left quadrant is titled 'ANDRE DATA' and is empty. The bottom-right quadrant is titled 'ANDRE DATA' and contains a list of data types: VERK.DATA, VERK.FIL, SKJÆREDATA, KUND PARAM., TILLE. NULLP, VEDLIKEHOL, VERK.KOMP, VERKT. MODEL, NULLP. KOM, MASK.PARAM., MAKRO VAR., and BAKKE DATA. A 'LADE' button with a left-pointing arrow is between the top and bottom quadrants. The bottom control bar has several buttons: 'VELG MODUS', 'VELG ALLE', 'VELG ALLE SLETT', 'SLETT ALT', 'PROGRAM FIL', 'START' (circled in green), and a right-pointing arrow. A red '1' is above the 'START' button. A red arrow points from the 'START' button to the '1001' program entry in the top-left quadrant.

1. Trykk på START.

2. Programmet havner inn i PROGRAM FIL katalogen på maskinen.

Send program fra Maskin til Keep



Fremgangsmåte Mazak

0% ST 0min⁻¹ 0mm/min 09:52:54

ANr. 12345E Komp test fasfres
 () ()
 ENr. 0 SNr. 0 BNr. 0
 TELLER 0(0)
 TID 0:00'08"

MODAL

S	0	F	0.	M	0	A	0
G 1	G 17	G 91	G 23	G 94	G 21	G 40	
G 49	G 80	G 98	G 50	G 54		G 64	
G 40.1	G 67	G 69	G 97	G 15	G 50.1	G 5 P0	
	G111	G 50.2	G113	G 13.1			

POSISJON	BUFFER	NESTE KOMAND
∅X 1430.	∅X 0.	G
Y 0.	Y 0.	M
Z -363.6535	Z 0.	V
B 0.	B 0.	A
C 0.	C 0.	
W 0.	W 0.	
V 0.	V 0.	
Sv 0.	Sv 0.	

MASKIN	REST	NPT
∅X 0.	∅X 0.	∅X -1430.
Y 0.	Y 0.	Y 0.
Z 0.	Z 0.	Z 0.
B 0.	B 0.	B 0.
C 0.	C 0.	C 0.
W 0.	W 0.	W 0.
V 0.	V 0.	V 0.
Sv 0.	Sv 0.	Sv 0.

BELASTINGSMETER

F.SPDL (1)	0 MIN ⁻¹		0	X		0
D.SPDL (1)	0 M/MIN		0	Y		0
MATN	0. MM/MIN			Z		0
B	0. MM/REV			B		0
C	0. °/min			C		0
				W		0
				V		0
				Sv		0

VNr. 12M --> VNr. 0 MAG.1 LONr. 12M
 () () ()
 ENHT : V-OFFSET
 D#(0) 0.
 H#(0) X 0.
 Y 0.
 Z 198.6749

Dette er likt på Smooth/Matrix

Velg: DATA INN/UT

SMART TILEGGS NULLPUN. SKJÆRE DATA VEIVISER RESULTAT PARAM. DIAGNOSE DATA INN/UT SPESIAL MENY

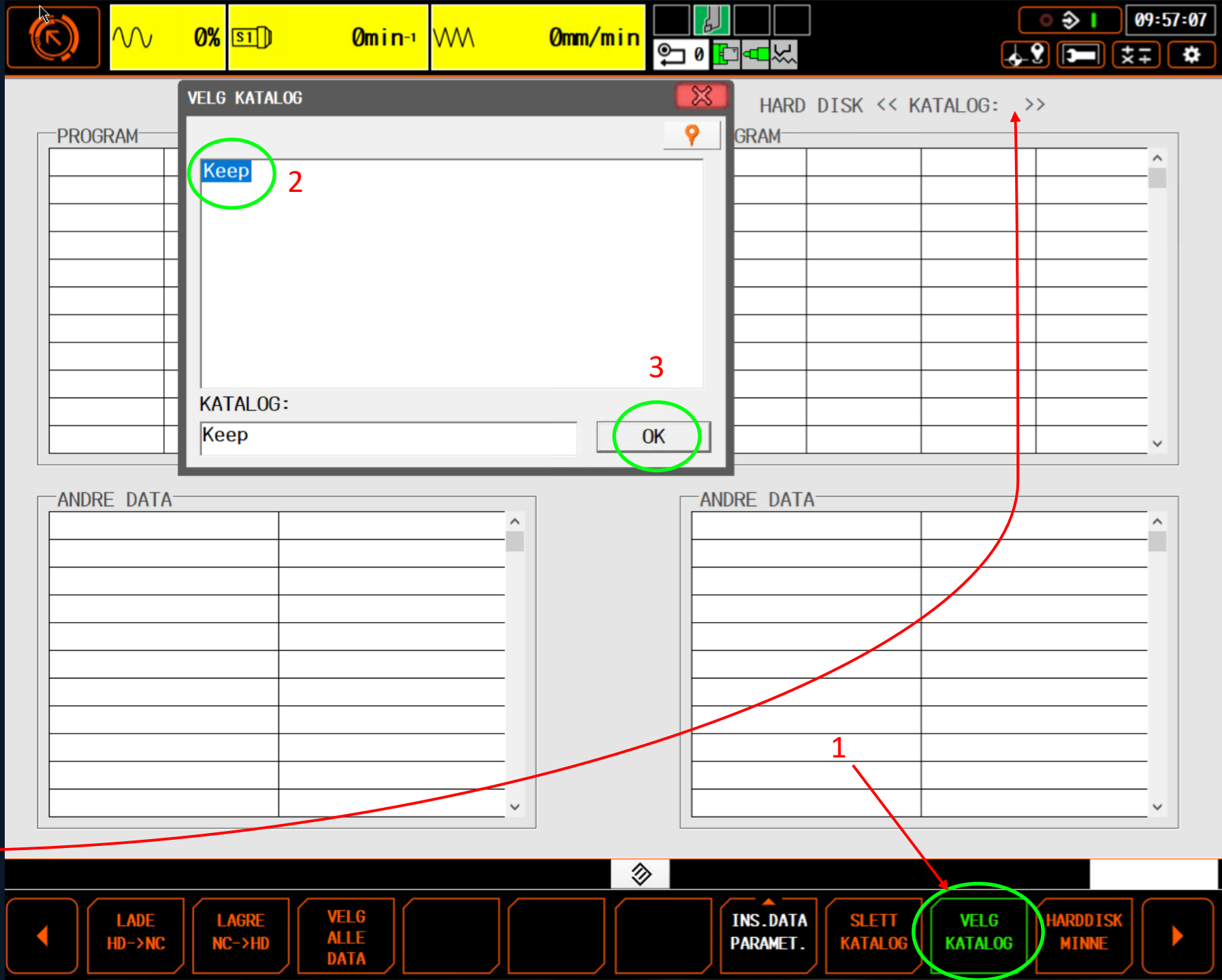
1. Trykk VELG KATALOG

2. Velg mappen med navn "Keep"

3. Trykk OK.

Dette steget trenger man bare å gjøre på nytt hvis maskinen blir skrudd av.

Legg merke til om det er blankt, eller står "Keep" her:



1. Trykk PROGRAM FIL

2. Velg program

3. Trykk OK

4. Trykk START

NC

HARD DISK << KATALOG: Keep >>

PROGRAM

PROGRAM

VELG PRG.NR.

MINNE BRUKT 0.20 %

PROGR.NR	PROGRAM	REDIGERT
1001	232458-0-1	2024/02/0
1002		2022/11/2
9629	REN*B90*VERTICAL ARC	2022/06/2
5007	TORNADO MED C-AKSE	2021/12/0
5013	TORNADO MED DREIE...	2021/10/0
5000	FRESE GJENGE INNG...	2021/09/3
7003	C-AKSE PLANE MACRO	2021/03/0
5015	Heule COFA / SNAP...	2020/10/2
7000	Brille flytting m...	2020/09/0
9825	REN*B0*BX	2020/04/3

PROGR.NR: 1002

OK

LAGRE

ANDRE DATA

VERK.DATA	VERK.KOMP
VERK.FIL	VERKT. MODEL
SKJÆREDATA	NULLP. KOM
KUND PARAM.	
TILLE. NULLP	MAKRO VAR.
	BAKKE DATA
VEDLIKEHOL	

1

4

PROGRAM FIL

START

NC

HARD DISK << KATALOG: Keep >>

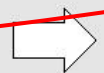
PROGRAM

M 1002			

PROGRAM

M 1002			

LAGRE



Programmet ligger nå i "Keep" mappen:

ANDRE DATA

VERK.DATA	VERK.KOMP
VERK.FIL	VERKT. MODEL
SKJÆREDATA	NULLP. KOM
KUND PARAM.	
TILLE. NULLP	MAKRO VAR.
	BAKKE DATA
VEDLIKEHOL	

ANDRE DATA

Hent program fra Maskin til Keep

Operations Add new

1 **MA20 (demo)**

Grovkjøring draft

Operation **Files**

Programs

Attachments

Drop files here to upload

1001.PBE 6 seconds ago 552 B ... X

Send program to machine → **Fetch program from machine** ← Upload program ↑ Upload

+ Add tool + Add from default toolkit

Type	Sub Type	Number	Suffix	Geometry	Size	Diameter	Grade	Radius	Width	Pitch	Stick...	AP Max	Usabl...	Length	KAPR	Teeth	Description	Actions
Turning	Turning External	T003	A	CNMG	16			1.2						245	93			
Turning	Turning External	T007	C	DNMG	15			0.8						245	93			
Threading	Thread Turning Exter...	T006	G		27					6.35				145			1 dgr underlagsplate.	
Turning	Turning Internal	T080	A	DCMT	11	63		0.8			500				93			
Threading	Thread Turning Exter...	T014	G		16					3				200				
Milling	Insert Mill	T025	A	hhh	11	32		0.8			35			150	90	5		
Milling	Insert Mill	T025	A		11	32		0.8			35			150	90	5		
Holemaking	Solid Drill	T026	S			5					35			200	140			
Milling	Chamfer Mill	T027	V			12					50			250	45	2		
Grooving	Grooving Axial	T015	S					2	4					25			Fullradie stikkstål	
Milling	Solid End Mill	T009																
Milling	Solid End Mill	T010	A			25		0.8				10	35	250		5		

Total Rows: 12