Legacy Issue with Reverse Loading on Opposite Hand Machines

Details of the legacy software problem with machining reverse loaded profiles on left to right feed (OH) machines.

Contents

Problem

No Solution

Comments

Problem

Seemingly at random, operations are shifted along a piece.

The issue only happens under the following conditions
1. The machine is running software version 5 or earlier on a Baldor - Nextmove control system
2. The machine is opposite hand
3. The profile is "Reverse Loaded"
4. The piece at the start of the bar has an operation footprint that overlaps the end of bar "maxable" area.

> ⓘ ...The maxable area is an area where the machine cannot clamp the bar correctly as it is too close to the end. The machine deals with this by adding a larger waste on the end and offsetting all operations by a "maxable" distance

No Solution

Regrettably, there is <u>no solution</u> for this legacy problem. The reasons are complex but irrevocable, and not of Stuga's making, but driven by ABB's takeover of Baldor and Microsoft security updates.

- Version **6** of the software has eliminated this particular problem, which is fitted to all machines controlled with the Beckhoff system (2016 onwards)
- The Baldor - Nextmove control system <u>is only compatible with version 5</u> of the software, version 6 cannot be downgraded to interface with the Nextmove controller
- Version 5 of software is end of life support, as it pre-dated Microsoft .NET security vulnerability updates since Windows XP. It cannot be updated or recompiled on a complier running on Windows 10 / 11, as the .Net version is upgraded to a point beyond the compatibility with the Nextmove drivers.
- The Baldor / Nextmove system is obsolete so there is no support or driver updates from the original supplier.

> ℹ ...The company Baldor was bought out by ABB in 2018, and they promptly shut down the "Nextmove" support and development path, forcing Stuga to move to Beckhoff completely, and creating this and other support issues for Stuga and its customers