TB0448 Ecoline using winMulti setup notes

The Climatec Ecoline is the first to use winMulti as the control software. This document is to record the issues raised by the transfer of the parameters and functions from one to another.

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Technical Bulletin

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Tooling

- No plunging on Ecoline, so normal mnd files would create a problem when moving Y, Z and R together. Front end now overcomes this by automatically shifting the tooling command in front of the Y and Z move. Back end will wait for R axis idle on a tool command.
- DRAINS not possible
- Spindle on / off not controlled by tooling command
- Tool off returns Y and Z to safe position for rotation
- Safe rotation position now added as a PEP for each profile.
- All mnd files must have pl= and pl=- commands
- The tooling sequence is now as follows.
    - Bar starts with y and Z in safe position during loading
    - Tool command selects spindle and rotates, wait for R idle
    - Move Y and Z as per ma.y and ma.z in mnd file, wait for idle
    - Mnd file plunge
    - operation commands
    - Mnd file plunge minus
    - Tool off command returns Y and Z to safe position for profile
    - V Notching

- V notch mnd files VECO and WECO
    - uses xOffset.I and .Seperation for x positions
    - Using parameters from ecoline, VI around 544, seperation 138
    - V axis zero pos assumed to be backfence =129mm movetoafter=120
    - vStartPos=0, wStartPos=157 (ecoparameter FrontRearDiff)
    - v min position=5 (very deep front notch)
    - v max position = 140 (bit longer than datum

Y Notching

- No Y notching programmed