YNotchStartGap Parameter

Definition and use of the yNotchStartGap parmeter

Contents
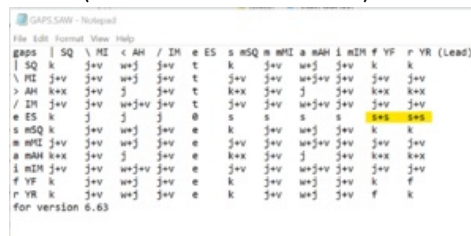
Problem

Solution

Comments

Problem

Applies to machines with V notching on the ring - worse if the blade size is 200mm
If a Y notch is at the very start of the bar, there is a combination of the gripper location inside the ring with the Y and Z axes in an extrreme position. This leads to a clash between the gripper and the ring.

Solution

Original solution was to build a big "minable" into the gaps.saw file to force a big waste cut at the beginning of the bar. This was done by specifying a gap of "s+s" (minable+minable) or "s+s+s" (minable+minable+minable).
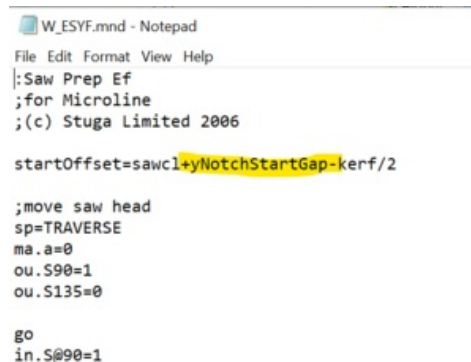

This is a bit cumbersome, and there are downsides to it when using it on a Microline becasue this amount needs to be reflected in the mnd files used to control the saw blade - W_ESYF.mnd and W_ESYR.mnd

From software version 4.65.0.0 a new parameter was introduced, specifically for this purpose - YNotchStartGap. This is normally set at a value of 270 for a Microline or ZX3
This allows the variable to be used in the mnd files

The gaps file calls on this with the variable "y"

```
GAPS.SAW - Notepad
File Edit Format View Help
gaps  | SQ  \ MI  < AH  / IM  e ES  s mSQ m mMI a mAH i mIM f YF  r YR (Lead)
| SQ  k    j+v    w+j    j+v    t    k     j+v    w+j    j+v    k    k
\ MI  k+x  j+v    w+j    j+v    t    k+x   j+v    w+j+v  j+v    k+x  k+x
> AH  k+x  j+v    j      j+v    t    k+x   j+v    j      j+v    k+x  k+x
/ IM  k+x  j+v    w+j+v  j+v    t    k+x   j+v    w+j+v  j+v    k+x  k+x
e ES  k    j      j      j      e    e     e      e      e      e    e
s mSQ k    j+v    w+j    j+v    s    k     j+v    w+j    j+v    k    k
m mMI j+v  j+v    w+j    j+v    s    j+v   j+v    w+j+v  j+v    j+v  j+v
a mAH k+x  j+v    j      j+v    s    k+x   j+v    j      j+v    k+x  k+x
i mIM j+v  j+v    w+j+v  j+v    s    j+v   j+v    w+j+v  j+v    j+v  j+v
f YF  k    j+v    w+j    j+v    y    k     j+v    w+j    j+v    k    f
r YR  k    j+v    w+j    j+v    y    k     j+v    w+j    j+v    f    k
winMulti Microline version 2013
reduced gap for ]\ to k+x (was j+v)
y=yNotchStartGap parameter
```