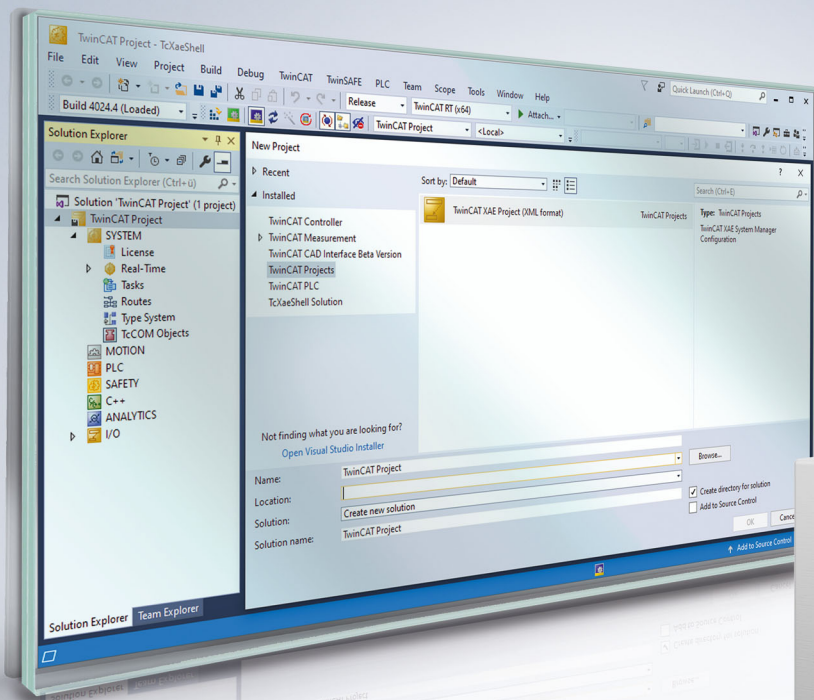


Functional description | EN

TF5290 | TwinCAT 3 CNC

Cutting Plus



Notes on the documentation

This description is only intended for the use of trained specialists in control and automation engineering who are familiar with the applicable national standards.

It is essential that the documentation and the following notes and explanations are followed when installing and commissioning the components.

It is the duty of the technical personnel to use the documentation published at the respective time of each installation and commissioning.

The responsible staff must ensure that the application or use of the products described satisfy all the requirements for safety, including all the relevant laws, regulations, guidelines and standards.

Disclaimer

The documentation has been prepared with care. The products described are, however, constantly under development.

We reserve the right to revise and change the documentation at any time and without prior announcement.

No claims for the modification of products that have already been supplied may be made on the basis of the data, diagrams and descriptions in this documentation.

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EP1590927, EP1789857, EP1456722, EP2137893, DE102015105702

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General and safety instructions

Icons used and their meanings

This documentation uses the following icons next to the safety instruction and the associated text. Please read the (safety) instructions carefully and comply with them at all times.

Icons in explanatory text

1. Indicates an action.

⇒ Indicates an action statement.

DANGER

Acute danger to life!

If you fail to comply with the safety instruction next to this icon, there is immediate danger to human life and health.

CAUTION

Personal injury and damage to machines!

If you fail to comply with the safety instruction next to this icon, it may result in personal injury or damage to machines.

NOTICE

Restriction or error

This icon describes restrictions or warns of errors.

Tips and other notes



This icon indicates information to assist in general understanding or to provide additional information.

General example

Example that clarifies the text.

NC programming example

Programming example (complete NC program or program sequence) of the described function or NC command.

Specific version information



Optional or restricted function. The availability of this function depends on the configuration and the scope of the version.

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1 Lift functionality

1.1 Overview

Task

When positioning operations are executed in the XY plane, the Z axis is lifted as far above the workpiece as possible to avoid collision with cut-out parts between cutting operations (G01/G02/G03, M04 laser on, M05 laser off). This is called Smart Collision Guard. The CNC automatically calculates motion of the Z axis between contour elements.

Properties

The user can specify a maximum lifting distance to lift the Z axis. Lifting/lowering is executed automatically and across blocks so that the path feedrate in the XY plane is reduced as little as possible and the Z axis reaches the specified target height at the start of the next machining contour.

The path motion is normally not affected by the lifting/lowering motion, i.e. the Z axis can be attached and detached without feed stop (on the path). The Z axis moves with jerk limiting.

The Smart Collision Guard is available in 2 methods.

- Advanced Lifting
- Lifting



This document uses the terms lift axis and Z axis synonymously.

Parameterisation

Neither of the two methods is activated in the basic setting.

In order to use the recommended Advanced Lifting method, the start-up list parameters described in the section "[Parameterisation](#)" [[▶ 12](#)], P-STUP-00060 and P-STUP-00070 are assigned the value **FCT_LIFT_UP_TIME**. In addition, the channel parameter P-CHAN-00345 "enable_time_based_lift" must be set to 1.

For lifting, the P-STUP-00060 parameter must be assigned the value **FCT_LIFT_UP**. Do not set the channel parameter P-CHAN-00345 "enable_time_based_lift".

Programming

The lift range is defined by the two commands Z[LIFT_START...] and Z[LIFT_END]. The lift axis is automatically moved by the lift function in the intermediate motion blocks.



This function is an additional option requiring a license.

Mandatory note on references to other documents

For the sake of clarity, links to other documents and parameters are abbreviated, e.g. [PROG] for the Programming Manual or P-AXIS-00001 for an axis parameter.

For technical reasons, these links only function in the Online Help (HTML5, CHM) but not in pdf files since pdfs do not support cross-linking.

1.2 Description



This functionality has been available since CNC Build V2.11.2800.

Lifting minimises the risk of tool collisions, e.g. during laser cutting, with workpiece parts that are already cut out.

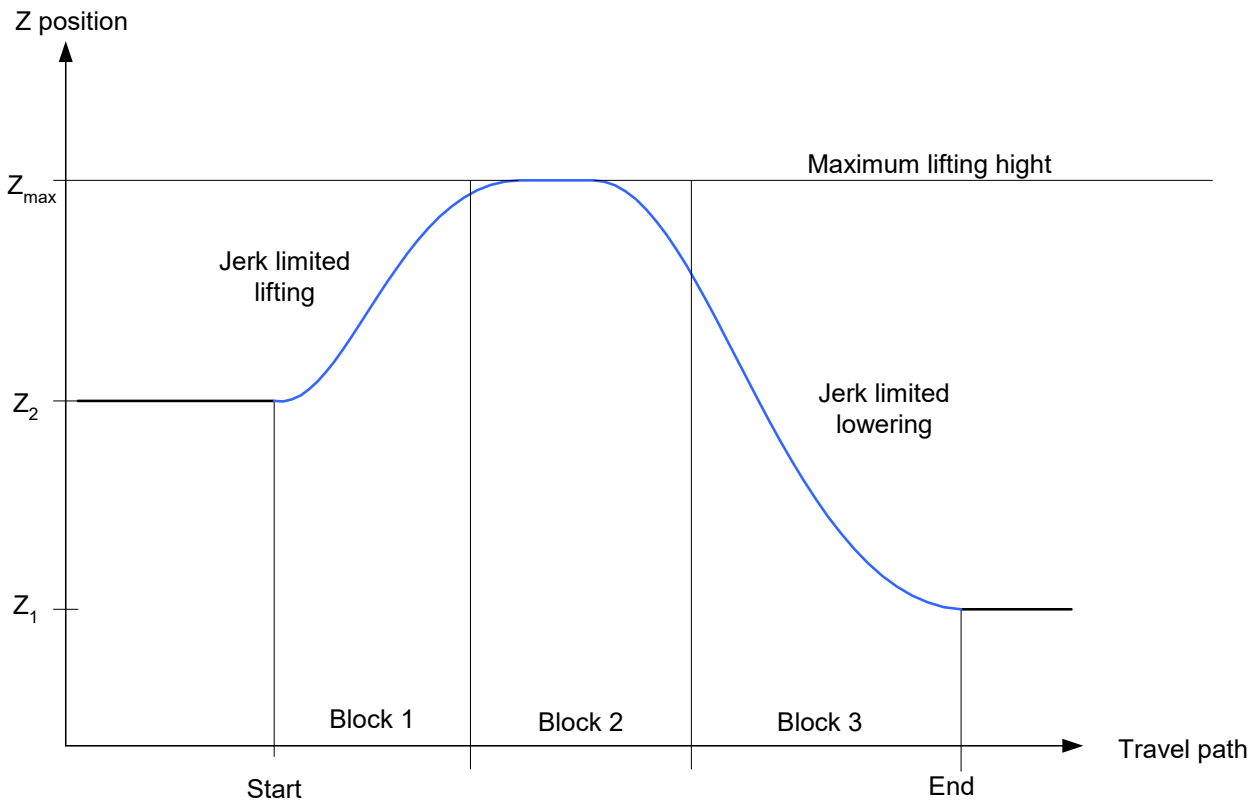


Fig. 1: Description of lifting in 3 NC blocks

A comparison table of the two methods is contained in the section [Differences between Advanced Lifting and Lifting](#). [▶ 23]

1.2.1 Advanced Lifting

This method is recommended.

Reason:

- Advanced Lifting permits a greater lifting height to be reached.
- It increases collision protection.
- Advanced Lifting has no negative impact on lifting height caused by changes in feed rate or path override.
- Conventional lifting may result in Z axis overload.

Exception: A Type 3 slope is used or less computing time is required for technical reasons.

1.2.1.1 Advanced Lifting properties

The target position and position limiting are specified at the start of the lifting motion.

If the start or target position of the lift axis is outside the programmed maximum lifting height, the maximum height is increased, e.g. for lifting to the maximum of the start and target positions. Therefore, any Max/Min limiting of the position has no effect.

If a height difference [POS] was programmed for the lifting motion and the lift axis dynamics are not sufficient to reach the required height in the time defined by the path feed rate, the path feed rate is reduced automatically. In extreme cases (e.g. if the motion path = 0), the path axes stop and the lift axis is linearly positioned at the target position.

Waiting conditions (M functions with synchronisation, G04, M00, etc.) are possible during lifting/lowering. With Advanced Lifting the lift axis moves on to target height.



The Advanced Lifting function requires slope type 'TRAPEZ', [#SLOPE [TYPE=TRAPEZ], (or TYPE=STEP) (or TYPE = SIN²).

HSC (Type 3 slope) is not supported with Advanced Lifting.

Minimum path length

The channel parameter P-CHAN-00244 defines the minimum path length. If the path motion between lift start and lift end is shorter than the minimum path length, the lifting motion is suppressed. The programmed target position of the Z axis is approached directly.

When P-CHAN-00244 = 0 is in the default setting, the lifting motion is always executed irrespective of the real path distance.

1.2.1.2 Parameterisation

The channel parameter P-CHAN-00345 is switched when it is enabled to Advanced Lifting. These calculations must be carried out in the GEO real-time task of the controller.

To enable this function, the function must also be activated in the controller start-up list in the parameters P-STUP-00060 and P-STUP-00070 by the keyword **FCT_LIFT_UP_TIME**.

Automatic lifting/lowering is currently not included in the basic scope of functions (FCT_DEFAULT) and must therefore always be activated.

Further information on the start-up list parameter P-STUP-00060

The parameter P-STUP-00060 in the start-up list defines the individual functions in the contour planning. As a result, individual functions can be selected for testing, deselected for performance reasons (by not setting them) or activated as a specific function.

For Advanced Lifting the identifier **FCT_LIFT_UP_TIME** must be set.

Advanced Lifting P-STUP-00060

```
configuration.channel[0].path_preparation.function FCT_DEFAULT | FCT_LIFT_UP_TIME
```

Further information on the start-up list parameter P-STUP-00070

In the start-up list the parameter P-STUP-00070 defines the individual functions of the path interpolator. As a result, individual functions can be selected for testing, deselected for performance reasons (by not setting them) or activated as a specific function.

To activate Advanced Lifting the identifier **FCT_LIFT_UP_TIME** must be set.

Advanced Lifting P-STUP-00070

```
configuration.channel[0].interpolator.function FCT_DEFAULT | FCT_LIFT_UP_TIME
```

1.2.1.3 Special cases

Special case 1: POS greater than POS_LIMIT

If the specified lift axis target position is outside the limit, the limit has no effect. This means that the axis is positioned at the target position at the start of the lifting motion and not at the end. This also applies if the start position > limit.

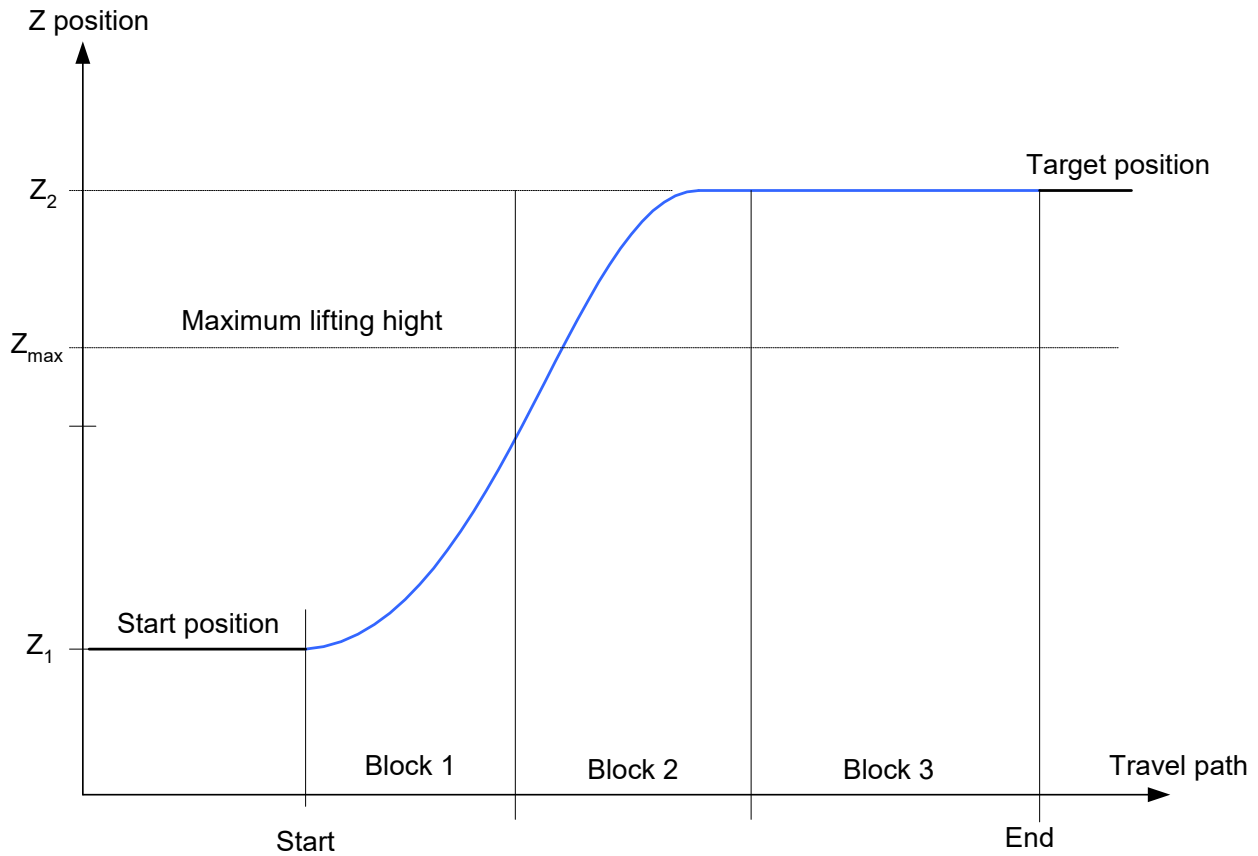


Fig. 2: Target position > limit

POS greater than POS_LIMIT

```
N10 Z10
N20 Z[LIFT_START POS=40 POS_LIMIT=30]
N30 X10
N40 X20
N50 X35
N60 Z[LIFT_END]
```

Special case 2: Syntax error within the lift range

Programming error within START – END

In the event of a syntax error in the NC program, the path motion is always executed up to the last correctly decoded point in the NC program. If the error location lies within a LIFT_START – LIFT_END range, the lift axis is positioned at the maximum lift height at the error location.

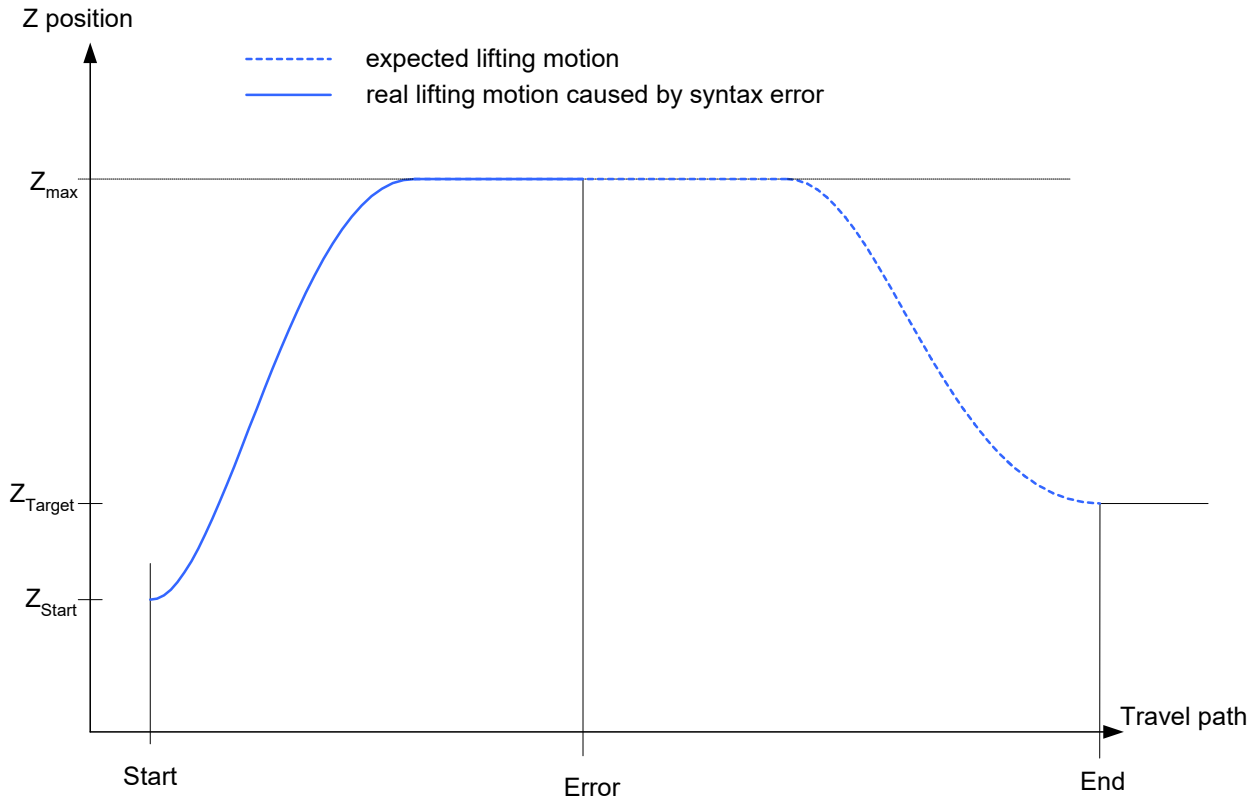


Fig. 3: Premature termination of lifting due to a syntax error

Syntax error within the lift range

```

N10 Z10
N20 Z[LIFT_START POS_LIMIT=30]
N30 X10
N40 X20
N50 X35
...
N100 syntax error
...
N560 X50
N570 X60
N580 X100
N600 Z[LIFT_END]

```

Special case 3: #FLUSH, #FLUSH WAIT

Flushing the channel (#FLUSH, #FLUSH WAIT) may mean that the path must be stopped if the lift axis is unable to reach the lift position in time. Otherwise, #FLUSH WAIT has no effect on the lifting profile.

1.2.2 Lifting

This method is only recommended if Advanced Lifting is not possible for technical reasons.

Normally, the lift axis motion is planned as an independent motion in path preparation and is then coupled to the motion of the main axes.

1.2.2.1 Lifting properties

The lifting motion is coupled to the path motion in this method. i.e. if the velocity of the path is changed, the LIFT motion changes to the same extent. Therefore, the same position of the path axes is identical to the position of the lift axis, regardless of the current velocity. This means that if the path motion is stopped (feed hold) or decelerated (override), the motion of the lift axis stops accordingly.

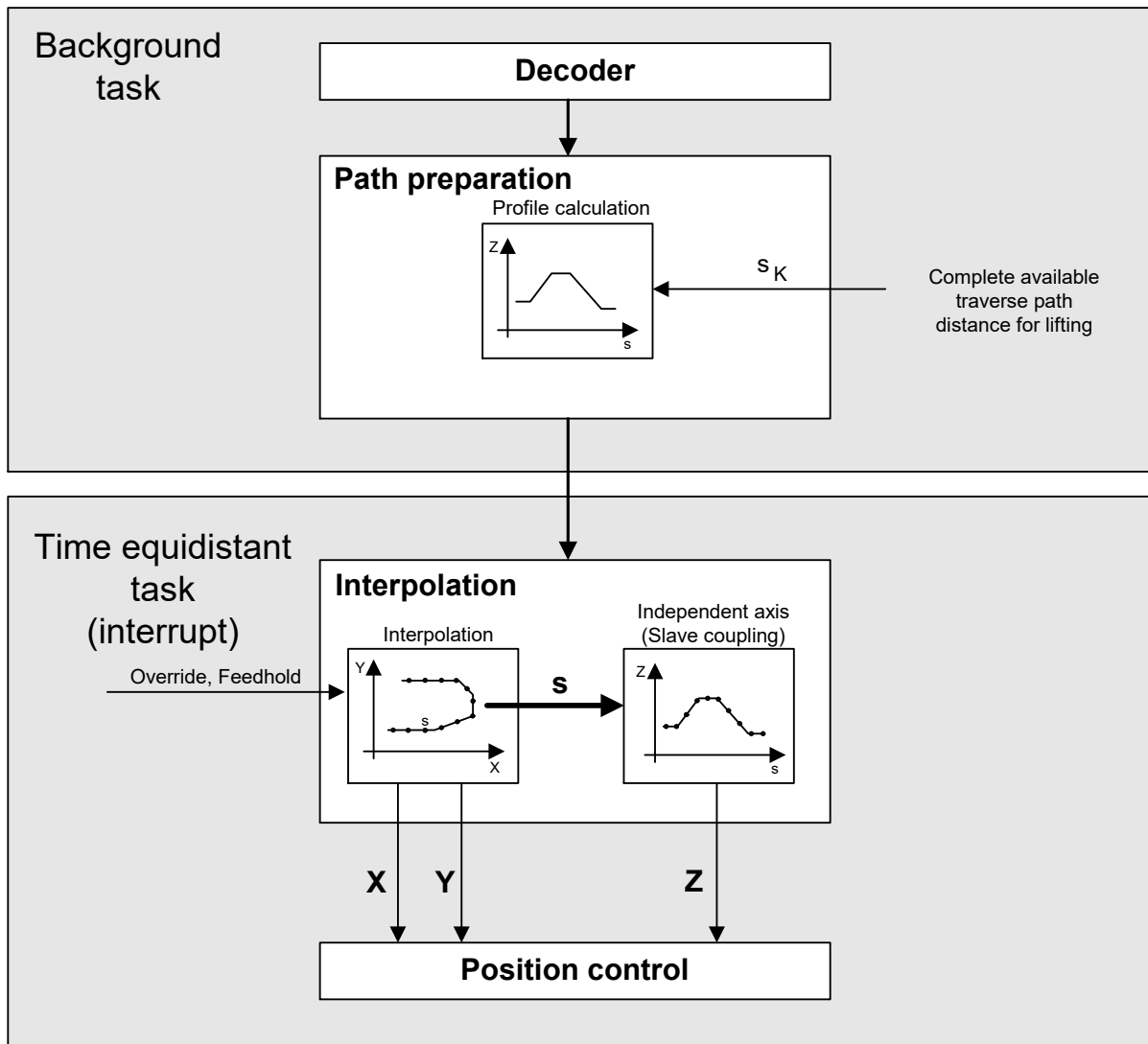


Fig. 4: Structure of planning and executing the LIFT motion

Within the LIFT range, the permitted acceleration on the path is defined so that the maximum permitted acceleration of the lift axis is not exceeded.

Waiting conditions (M functions with synchronisation, G04, M00, etc.) are possible during lifting/lowering. During the lifting motion, waiting conditions therefore lead to an interruption of the path and also of the lifting motion.

In the case of strongly bent curves (spline or polynomial contouring) or kinematic transformations, the original blocks can be further subdivided to improve planning the dynamics. This may lead to an increased number of blocks.

If there is an insufficient number of blocks (Look Ahead range)

- due to the large number of motion blocks of the path axes or
- due to the large number of technology functions (M functions),

premature lowering is avoided. Internally, a LIFT_END is added to the programmed height and a LIFT_START is then added.

At present, a maximum number of 20 CNC internal blocks (Look Ahead range) is considered between the lifting motion (START) and the lowering motion (END). A programmed motion block (G0, G1, G2, G3) normally generates an internal CNC block. Smoothing methods generate additional internal blocks.

Planning the dynamics

The lifting motion is planned so that, at constant path velocity, the lift axis is lifted and lowered again with jerk limiting at its maximum acceleration.

If the path feed rate is changed during the lifting motion (feed hold, override, etc.), this leads to additional acceleration of the lift axis. As a result, lift axis acceleration may briefly exceed its maximum limit. However, the overall acceleration due to the feed rate change on the path and the lifting motion itself always remain within the specified overload range. Therefore, the following applies to the axis:

$$|a_{\text{active}}| < a_{\text{max}} * \text{overloadfactor}$$

where

$$\text{overloadfactor} = \frac{\text{dyn_monitor_a_err}}{1000} = \frac{P - \text{AXIS} - 00442}{1000}$$



Planning lift axis dynamics requires slope type 'TRAPEZ' ([#SLOPE [...]]). Slope type STEP may result in Z axis overload.

Path smoothing and lifting

The LIFT function can be programmed if a smoothing method was previously activated (1st case). The LIFT axis has velocity = 0 at the start and end of the lifting motion. Therefore, smoothing is temporarily suppressed at these points.

Exception: With CONTOUR MODE (G61, G261) the lift axis in the block does not move before lifting or directly after lifting (2nd case).

1st case: Lift axis motion before/after lifting

If the lift axis is moved before lift start (block N10) or directly after lift end (block N20), the contouring of all axes at the start or end of lifting is briefly suppressed.

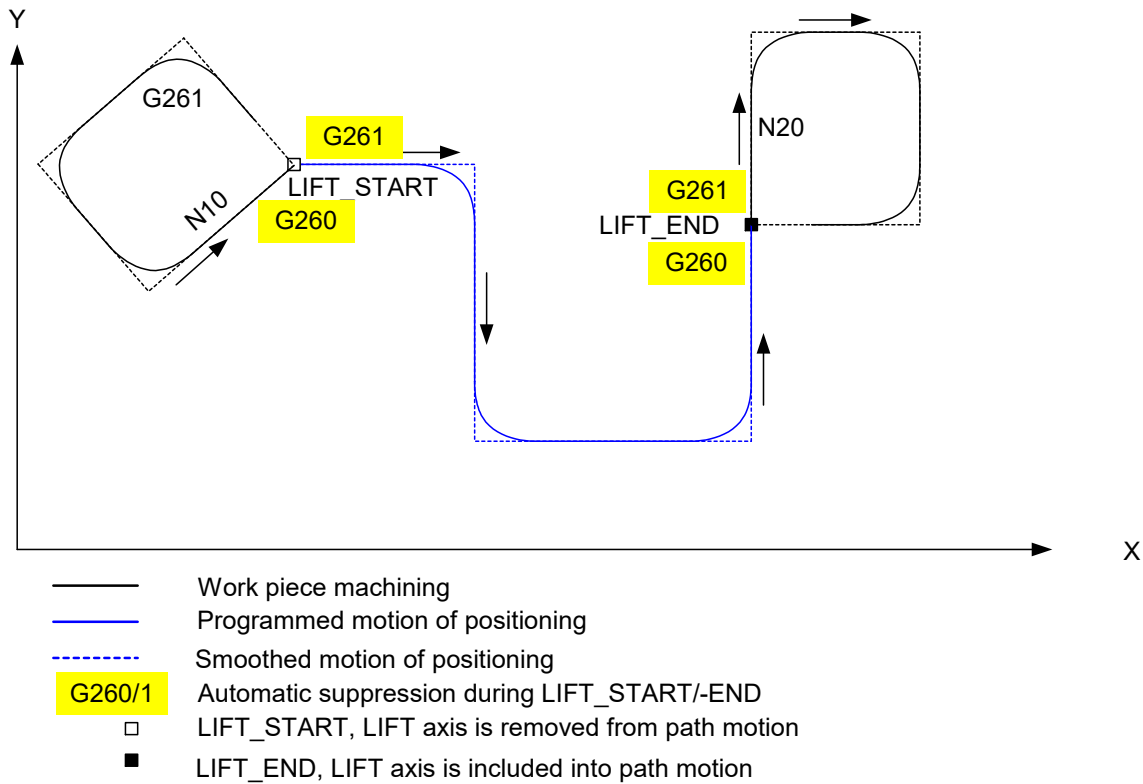


Fig. 5: Contour smoothing with automatic activation/deactivation at LIFT start/end

2nd case: No lift axis motion before/after lifting

The other axes can be smoothed if the lift axis is not moved before lift start (block N10) or directly after lift end (block N20).

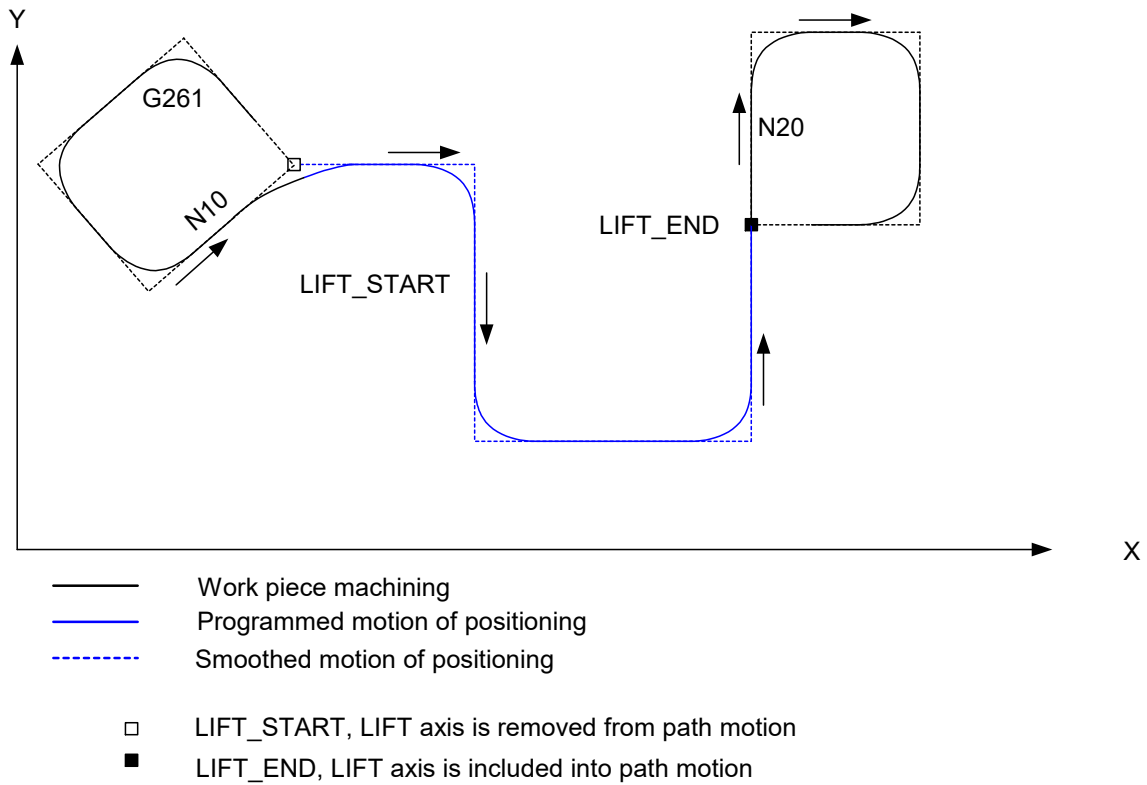


Fig. 6: Contour smoothing without lift axis movement before/after lifting



Smoothing methods may not be additionally selected or deselected between LIFT_START and LIFT_END.

1.2.2.2 Parameterisation

To activate lifting, the parameter P-STUP-00060 must be assigned the value **FCT_LIFT_UP**.

Lifting

```
configuration.channel[0].path_preparation.function FCT_DEFAULT | FCT_LIFT_UP
```

1.2.2.3 Special cases

Special case 1: Look Ahead range overflow

Large number of blocks between START – END

The Look Ahead range comprises a maximum of 20 NC blocks. Lifting is executed prematurely if the range of the motion path (Look Ahead range) considered during lifting is fully occupied due to a large number of blocks. In this case, the axis is first lifted to the specified maximum height and lowered shortly before END (see blue curve in the figure)..

Premature lifting can lead to a situation where less motion path is available for the lifting motion than the user actually assumes. As a result, path velocity may be reduced in order to execute the lifting motion and re-engagement.

Conclusion: A high number of blocks between lift start and end leads to premature lifting of the lift axis and to a possible deceleration of the path motion. For this reason Advanced Lifting is recommended.

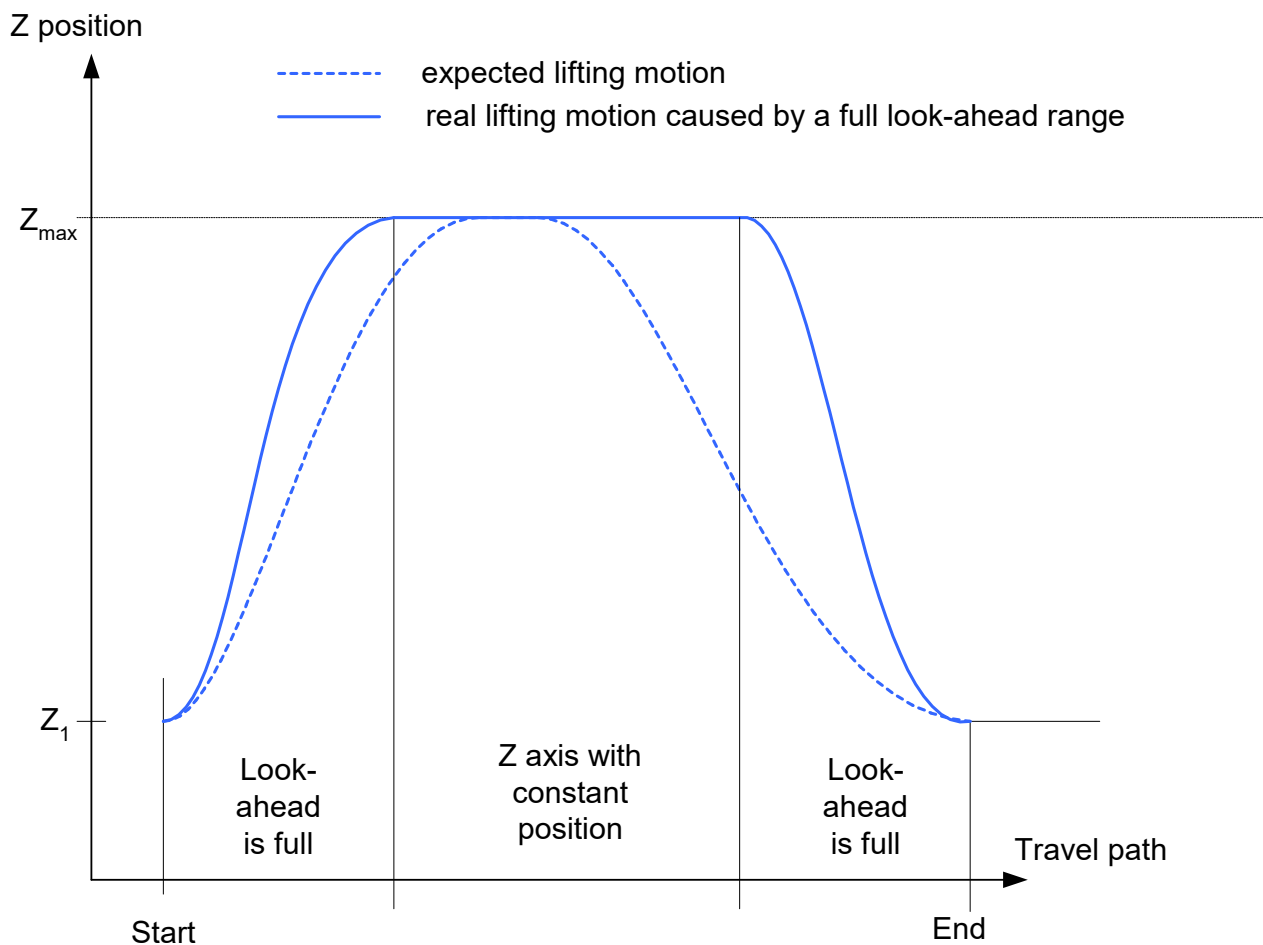


Fig. 7: Diagram of Look Ahead range overflow

Look Ahead range overflow

```
N10 Z10  
N20 Z[LIFT_START POS_LIMIT=30]  
N30 X10  
N40 X20  
N50 X35  
...  
N550 X31  
N560 X32  
N570 X33  
N580 X34  
N600 Z[LIFT_END]
```

Special case 2: Lifting and explicit flushing of the channel

LIFT and flushing the channel (#FLUSH)

During lifting, the motion blocks are first stored to enable calculation of the optimum lifting motion from LIFT start to end. With various NC commands, however, immediate execution is necessary and this is achieved implicitly by "flushing the channel".

If channel output of the NC blocks is compelled during lifting (e.g. NC command #FLUSH), the LIFT motion is executed as if LIFT_END and again LIFT_START were programmed at this point.

Lifting and explicit flushing of the channel

```
N20 X40 Z2
N30 Z[LIFT_START POS=12 POS_LIMIT=40]
N40 X50
N50 X40
N60 #FLUSH
N70 X30
N80 X20
N90 Z[LIFT_END]
```

Operating principle of #FLUSH with comparable programming

```
N20 X40 Z2
N30 Z[LIFT_START POS=40 POS_LIMIT=40]
N40 X50
N50 X40
N60 Z[LIFT_END]
N60 Z[LIFT_START POS=12 POS_LIMIT=40]
N70 X30
N80 X20
N90 Z[LIFT_END]
```

1.2.3 Permitted functions

Permitted CNC functions that may be active when lifting is selected:

- #ROTATION ON and #CS ON: but only if the lift axis is not affected by the rotation. When the Z axis is lifted, only one coordinate system rotation about the Z axis is permitted. Otherwise, the decoder outputs the error P-ERR-21071. If #ROTATION ON/OFF is programmed within the lift range, the path preparation application outputs the error P-ERR-120606
- #TRAFO ON: If #TRAFO ON/OFF is programmed within the lift range, BAVO outputs the error P-ERR-120606.

1.2.4 Limitations and error response

The following limitations apply both to Lifting and Advanced Lifting.

If a programming error occurs during the lifting motion, the lifting motion is executed up to the error location and the axis stops at the specified maximum lifting height (POS_LIMIT).

If the end of the program is reached during the lifting motion without a prior, explicit LIFT_END, the lifting motion is executed as if LIFT_END was programmed at the end of the program.

Limitations during the lifting motion for both methods:

- The axis affected by lifting may not be programmed.
- Flushing the channel (#FLUSH, #FLUSH WAIT) interrupts the current lifting motion (this corresponds to implicit programming of LIFT_END followed by LIFT_START). The programmed target position of the lift axis is reached for a short time in the block in which #FLUSH was programmed.
- Channel-internal axis swapping is basically possible but the lift axis must not be affected by axis swapping. Additional path smoothing of the LIFT axis (contouring, G61/G261, G151, #SPLINE ON, #HSC ON) is not possible in the lifting range.
- During the lifting motion, tool radius compensation of the LIFT axis is not permitted, i.e. the LIFT axis may not be involved in tool radius compensation.

Limitations during the lifting motion in addition to conventional lifting:

- Path smoothing functions are temporarily suppressed at the start and end of the lifting motion. With Advanced Lifting path smoothing methods are suppressed if the lift axis is programmed directly before LIFT_START or directly after LIFT_END.
- Axis swapping leads to the end of the lifting motion.

1.2.5 Differences between Advanced Lifting and Lifting

Basically Advanced Lifting is recommended. It is independent of the path motion and a greater lifting height is reached. In exceptional cases it may be necessary to apply conventional lifting.

The table below provides a short comparison:

	1. Advanced Lifting	2. Lifting
Maximum lifting height (is reached faster)	high	medium
Collision protection	high	lower
Computing time (real-time task)	high	very low
Path override changes	Limited increase possible	Z axis overload (=lift axis) possible
Feed rate change	No limitation	Z axis overload (=lift axis) possible
HSC slope (Type 3)	not possible	can call an implicitly called subroutine at program end.
Maximum lift profile length	unlimited	Number of NC blocks is limited

With Advanced Lifting profile planning must be executed in the real-time task of the controller. This method therefore requires much more real-time computing time than the lifting method calculated in the path preparation task.

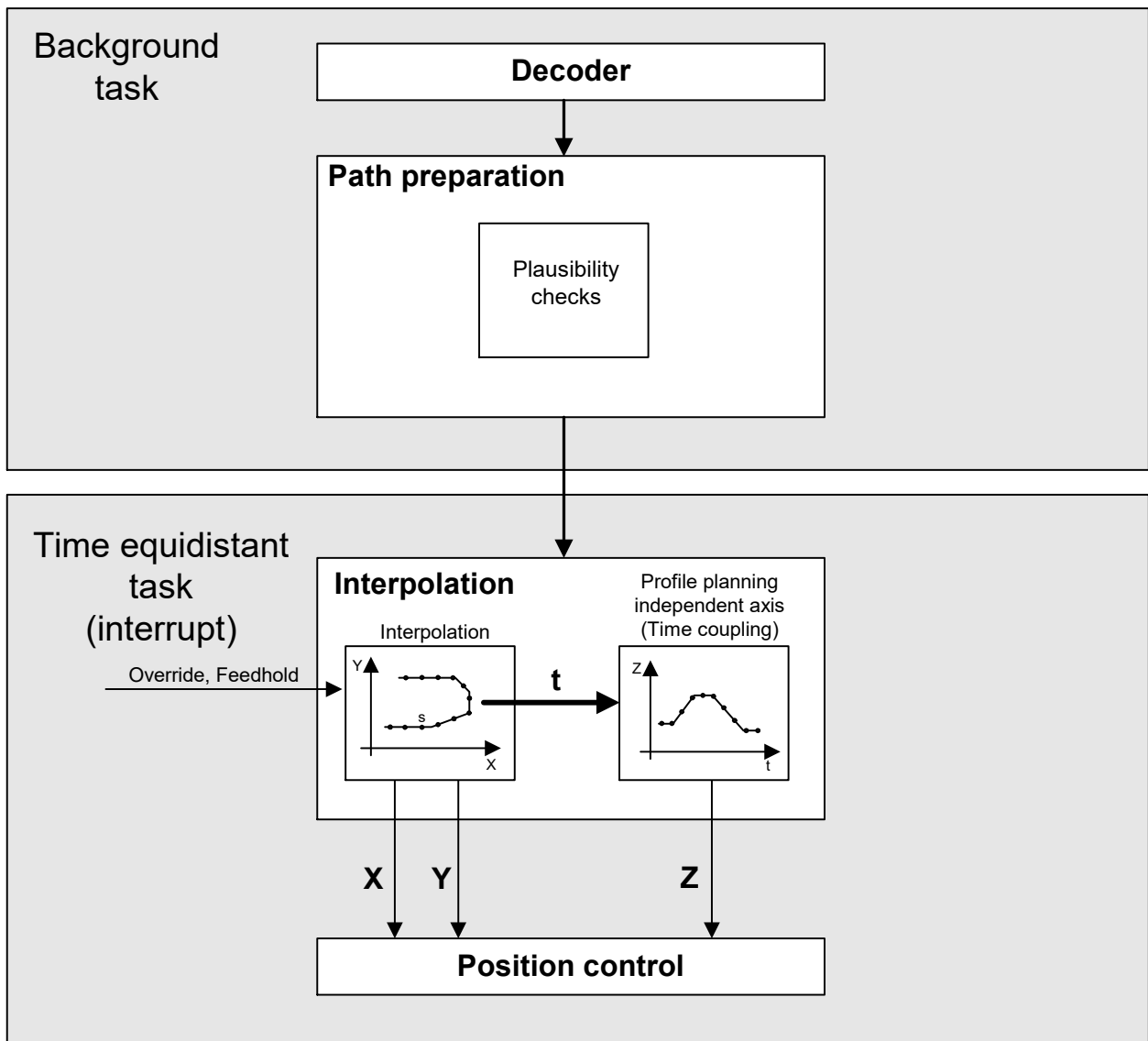


Fig. 8: Structure of the planning and processing of the lifting motion with time-based coupling

Compared with Lifting, Advanced Lifting achieves greater lifting heights:

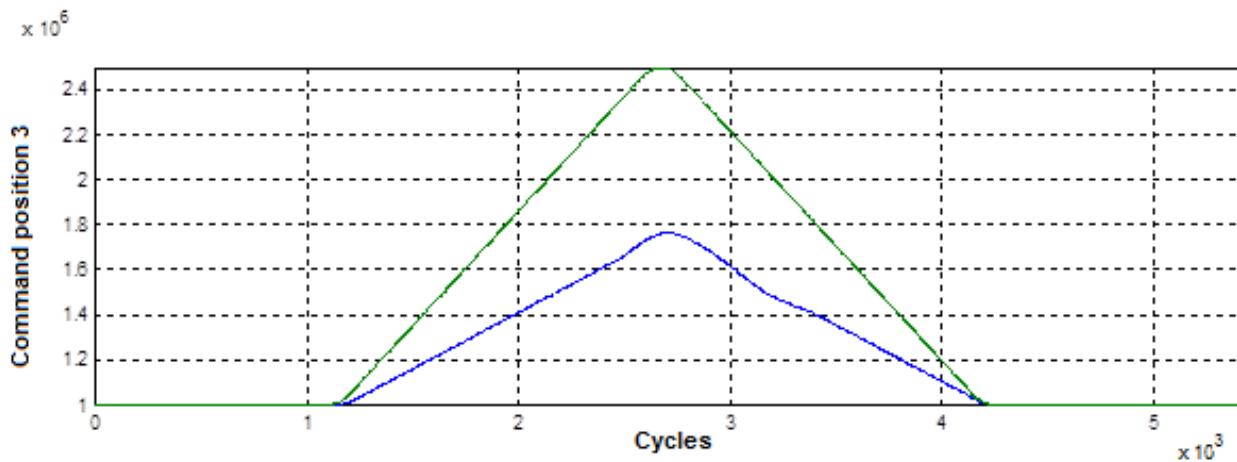


Fig. 9: Comparison of lifting heights reachable with Advanced Lifting (green curve) vs Lifting (blue curve)

In the lowering motion the path velocity override is limited to the value which was active at the start of the lowering motion.

In the upward motion of the lift axis a higher path override may no longer be accepted, otherwise the lift axis would not be able to reach the target position at the end of the lowering motion any more.

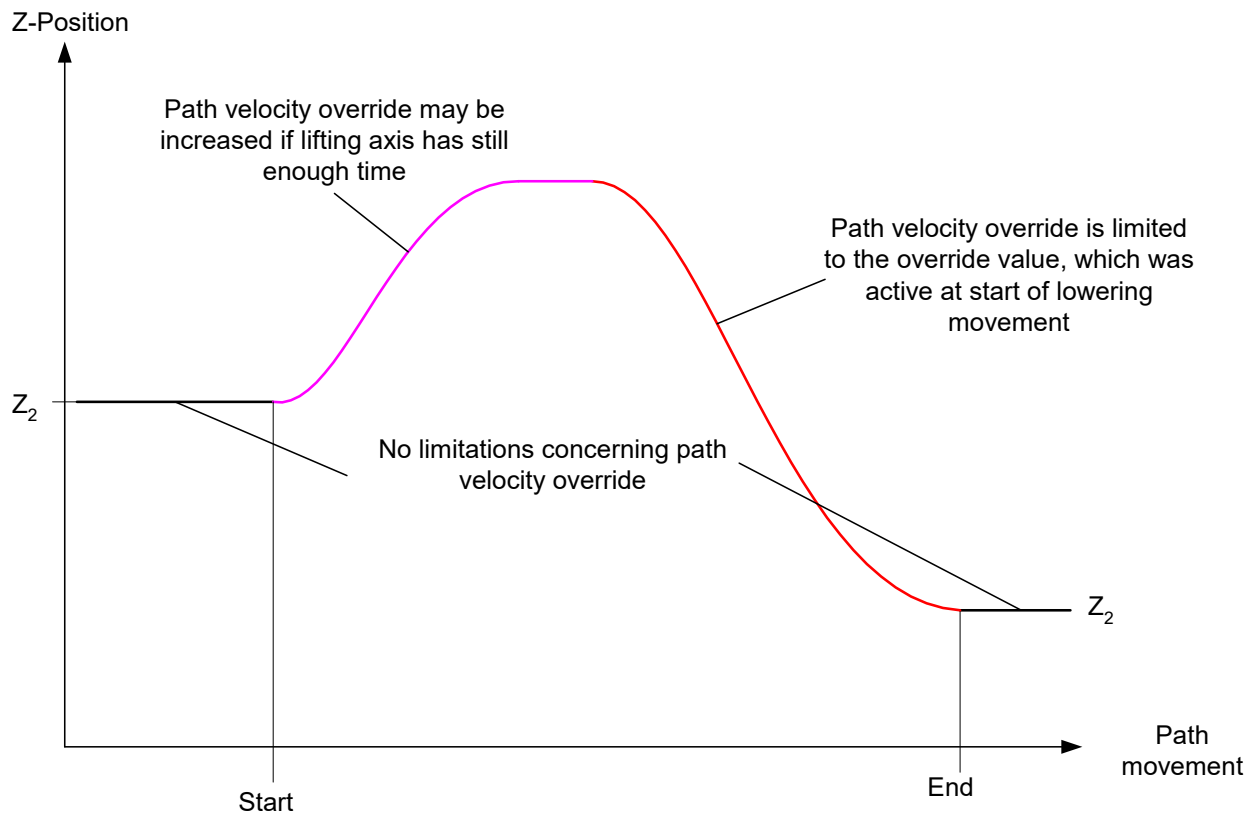


Fig. 10: Path velocity override with Advanced Lifting

1.2.6 Display data - status display

As of CNC Build V2.11.2810.01 it is possible to display the status of the lift function.

This is possible via CNC objects as well as via the HLI. The following data is available:

- HLI:
 - [lift active \[► 35\]](#)
 - [lift suppressed \[► 35\]](#)
- or as associated CNC objects
 - [lift_active \[► 34\]](#)
 - [lift_suppressed \[► 34\]](#)

A distinction is made between the status "Lift function is active" and the status "Lift movement is suppressed". Suppression of the lift movement always occurs when the programmed minimum path distance [P-CHAN-00244 \[► 32\]](#) is not reached. An active lift function is associated with execution of a lift movement.

Advanced Lifting is a special case where both the status for an active lift function and the status for suppressing a lift movement are set at the same time.

This case occurs when the actual lifting of the axis is suppressed because the path distance is too small, but at the same time a target position of the Z axis is programmed. To reach the target position, the lift function is still active in the background.

1.3 Programming

Cross-block lifting/lowering

Programming is based on the syntax for independent axes. The corresponding parameters can be programmed at the start of lifting/lowering. These are non-modal parameters, i.e. if required they are reset for every start.

Syntax:

```
<axis_name> [ LIFT_START [ DOWN ] [ G90 | G91 ] [ POS=.. ] POS_LIMIT=.. ]
```

<axis_name>	Lift axis name
LIFT_START	Identifier for the start of the (cross-block) independent lifting motion of the axis. Must always be programmed as the <u>first</u> keyword.
DOWN	The axis motion direction can be inverted via DOWN, i.e. the motion is in the direction of the negative software limit switch. If nothing is specified, the default direction is in the direction of the positive software limit switch.
G90 / G91	Absolute/relative dimension; the default dimension is G90. G91 is non-modal and is only active for the lifting/lowering motion.
POS=..	Target position of the lift axis after the lifting motion in [mm, inch]. The current command position of the axis (see V.A.ABS.<axis name>) is the default.
POS_LIMIT=..	Maximum lifting height or lowering depth in [mm, inch]

Syntax:

```
<axis_name> [ LIFT_END ]
```

<axis_name>	Lift axis name
LIFT_END	Identifier for the end of the (cross-block) independent lifting motion of the axis.

Cross-block lifting/lowering

```

N10 X10 Y20 Z30 ;Cut with laser
N20 M5 ;Laser off
N30 Z[LIFT_START POS=12 POS_LIMIT=100] ;Lift Z axis
N30 G01 X.. Y..
N40 G02 X.. Y..
N50 G03 X.. Y..
N60 G01 X.. Y..
N70 Z[LIFT_END] ;Absolutely lower Z axis to target 12 mm
N80 M4 ;Laser on
N90 X20 Y20 ...

N10 X10 Y20 Z30
N30 Z[LIFT_START POS=12 POS_LIMIT=100] ;Lift Z axis
N40 G01 X.. Y..
N50 G01 X.. Y..
N60 Z[LIFT_END] ;Absolutely lower Z axis to target 12 mm
N70 X100

alternative programming
N110 X10 Y20 Z30
N140 G01 X.. Y.. Z[LIFT_START POS=12 POS_LIMIT=100]
N150 G01 X.. Y.. Z[LIFT_END]
N170 X100
    
```

Lifting/lowering in an NC block

Programming is based on the syntax for independent axes. The corresponding parameters can be programmed at the start of lifting/lowering. These are non-modal parameters, i.e. if required they are reset for every start.

Syntax:

<axis.name> [LIFT [DOWN] [G90 | G91] [POS=..] POS_LIMIT=..]

<axis_name>	Lift axis name
LIFT	Identifier for the start and end of the independent lifting motion of the axis in the current NC block Must always be programmed as the <u>first</u> keyword.
DOWN	The axis motion direction can be inverted via DOWN, i.e. the motion is in the direction of the negative software limit switch. If nothing is specified, the default direction is in the direction of the positive software limit switch (option not available as at 10/2011).
G90 / G91	Absolute/relative dimension. The default dimension is G90. G91 is non-modal and is only active for the lifting/lowering motion.
POS=..	Target position of the lift axis after the lifting motion in [mm, inch]. The current command position of the axis (see V.A.ABS.<axis name>) is the default.
POS_LIMIT=..	Maximum lifting height or lowering depth in [mm, inch]

Lifting/lowering in an NC block

```

; single-row programming
N200 Z40
N240 X10 Y.. Z[LIFT POS=30 POS_LIMIT=300]
N250 X20 Y.. Z[LIFT POS=20 POS_LIMIT=300]
N260 X30 Y.. Z[LIFT POS=25 POS_LIMIT=300]
N270 X.. Y.. Z[LIFT POS=30 POS_LIMIT=300]
N280 X.. Y.. Z[LIFT POS=30 POS_LIMIT=300]

```

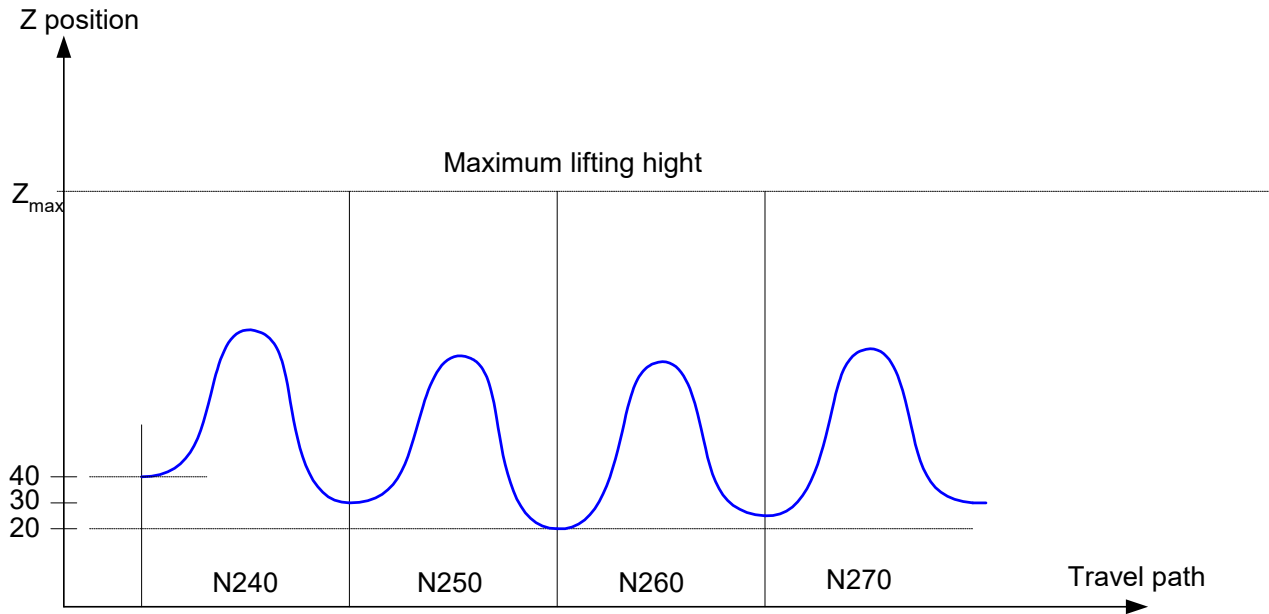


Fig. 11: Single-row lifting

Status query: Lifting/lowering active

In the NC program, the V.G. variable...

V.G.LIFT_ACTIVE

... of the Boolean type can determine whether lifting/lowering is active.

1.4 Parameter

1.4.1 Overview

ID	Parameter	Description
P-STUP-00060	function	Define functionalities in path preparation
P-STUP-00070	function	Define functionalities for decoding
P-CHAN-00244	lift_min_dist	Minimum path length for lifting motion
P-CHAN-00345	enable_time_based_lift	Switch to time-based approach for automatic lifting/lowering of an axis.
P-AXIS-00441	dyn_monitoring_a_war n	Output a warning in the event of a percentage excess in maximum axis acceleration Not necessary for Lifting (only for Advanced Lifting).

ID	Parameter	Description
P-AXIS-00442	dyn_monitoring_a_err	<p>Output an error message in the event of a percentage excess in maximum axis acceleration</p> <p>This maximum value is used to plan lift acceleration. This means that the following applies to the axis:</p> $a_{act,Lift} \leftarrow a_{max,Lift} = a_{max} * \frac{dyn_monitor_a_err}{1000}$ <p>Not necessary for Lifting (only for Advanced Lifting).</p>

1.4.2 Description

1.4.2.1 Activate lift function

P-STUP-00060	Defining functionalities for path preparation.
Description	This parameter defines the individual functionalities for path preparation. The individual functions can be enabled or disabled for testing or for performance reasons.
Parameter	configuration.channel[i].path_preparation.function
Data type	STRING
Data range	See Activate lift function [► 30]
Dimension	----
Default value	FCT_DEFAULT
Remarks	

Path preparation function table

Flag	Description
FCT_DEFAULT	The functions FCT_FFM FCT_PRESEGMENTATION FCT_SPLINE FCT_POLY FCT_CAX FCT_CAX_TRACK FCT_SEGMENTATION are available.
FCT_FFM	Free-form surface mode, #HSC [OPMODE 1 CONTERR 0.01], #HSC [OPMODE 2]
FCT_PRESEGMENTATION	Linear pre-segmentation in HSC mode
FCT_SPLINE	#HSC[], AKIMA, B-Spline, G150/G151
FCT_POLY	#CONTOUR MODE[], G61, G261/G260
FCT_CAX	C axis processing, i.e. the spindle is embedded in the NC channel.
FCT_CAX_TRACK	#CAX TRACK, tracking an axis according to the contour angle
FCT_SEGMENTATION	For dynamic segmentation of the path contour, e.g. if the curvature of a polynomial segment varies significantly.

The following functions must also be enabled:

FCT_LIFT_UP	Automatic lifting/lowering of an axis (path-based coupling). Example: FCT_DEFAULT FCT_LIFT_UP
FCT_EMF	Edge machining (sharp angle contours). Example: FCT_DEFAULT FCT_EMF
FCT_EMF_POLY_OFF	Edge machining inactive with polynomials. Contrary to the setting with FCT_EMF, edge signal generation is masked when path polynomial generation is active in the channel. Polynomials are generated for smoothing G261 or when B Spline is active. The resulting geometry is then tangential. Example: FCT_DEFAULT FCT_EMF_POLY_OFF
FCT_SYNC	Synchronisation of an axis on a path group. Example: FCT_DEFAULT FCT_SYNC
FCT_PRECON	Optimised planning using #HSC[BSPLINE]. Example: FCT_DEFAULT FCT_PRECON
FCT_LIFT_UP_TIME	Automatic lifting/lowering of an axis (time-based coupling). Example: FCT_DEFAULT FCT_LIFT_UP_TIME
FCT_PTP	Dynamically optimised contouring of the complete contour. Example: FCT_DEFAULT FCT_PTP
FCT_M_PRE_OUTPUT	Pre-output of M/H functions (microjoints). Example: FCT_DEFAULT FCT_M_PRE_OUTPUT
FCT_SURFACE	HSC machining with Surface Optimiser Example: FCT_DEFAULT FCT_SURFACE
FCT_SEG_CHECK	Block segmentation in combination with path-controlled offset of M functions (dwell time), see P-CHAN-00650 and Activate lift function ► 30 Example: FCT_DEFAULT FCT_SEG_CHECK
FCT_NIBBLING	Activate the nibbling function Example: FCT_DEFAULT FCT_NIBBLING
FCT_PUNCHING	Activate the punching function Example: FCT_DEFAULT FCT_PUNCHING
FCT_VSM	Activate the velocity smoothing function Example: FCT_DEFAULT FCT_VSM as of V3.1.3079.21

P-STUP-00070	Definition of interpolator functionalities
Description	This parameter defines individual functionalities and the size of the look-ahead buffer in the interpolator, i.e. it defines the number of blocks to calculate deceleration distance and dynamic planning.

Parameter	configuration.channel[i].interpolator.function
Data type	STRING
Data range	See Activate lift function [► 32] .
Dimension	----
Default value	FCT_IPO_DEFAULT
Remarks	

Interpolation function table

Identifier	Description
FCT_IPO_DEFAULT	FCT_LOOK_AHEAD_STANDARD
FCT_LOOK_AHEAD_LOW	30 blocks
FCT_LOOK_AHEAD_STANDARD	120 blocks
FCT_LOOK_AHEAD_HIGH	190 blocks
FCT_LOOK_AHEAD_CUSTOM	Any number of look-ahead blocks in the interval [0; 200]. Specification by parameter P-CHAN-00653.
FCT_SYNC	Synchronisation of an axis on a path group. Example: FCT_IPO_DEFAULT FCT_SYNC
FCT_LOOK_AHEAD_OPT	The path velocity curve can be further improved for HSC machining by additional calculations. This generally reduces machining time. The additional calculations place greater demands on the controller hardware.
FCT_LIFT_UP_TIME	Automatic lifting/lowering of an axis (time-based coupling). Example: FCT_IPO_DEFAULT FCT_LIFT_UP_TIME
FCT_SHIFT_NCBL	Path-controlled offset of M functions (dwell time). Example: FCT_IPO_DEFAULT FCT_SHIFT_NCBL
FCT_CALC_STATE_AT_T	Calculation of path velocity at a time in the future. Function only available in combination with HSC slope and only as of V3.1.3057.0 Example: FCT_IPO_DEFAULT FCT_CALC_STATE_AT_T
FCT_CALC_TIME	Calculation of interpolation time to next feed block (G01,G02,G03). Example: FCT_IPO_DEFAULT FCT_CALC_TIME
FCT_CONTOUR_LAH	Contour look-ahead: advance output of motion blocks to the PLC as of V3.1.3104.07
FCT_DYN_POS_LIMIT	Dynamic limitation of axis positions

The look-ahead buffer size specified above applies as of CNC Build V2.11.2800 and higher. The following values apply as of CNC Build V2.11.20xx:

FCT_LOOK_AHEAD_LOW	30 blocks
FCT_LOOK_AHEAD_STANDARD	70 blocks
FCT_LOOK_AHEAD_HIGH	120 blocks

1.4.2.2 Parameters for the Lift function

P-CHAN-00244	Minimum path length for lift movements
Description	This parameter defines a minimum path distance for lift movement. If the main axis motion is shorter than the parameter value, no lift movement is executed.
Parameter	lift_min_dist
Data type	UNS32
Data range	0: Inactive (default). 1: Lift movements are suppressed if the main path motion is below the limit value.
Dimension	0.1µm
Default value	0
Remarks	

P-CHAN-00345	Switch-over to time-based calculation when an axis is lifted
---------------------	---

Description	When an axis is lifted (see [FCT-A11 [▶ 9]]), it can be lifted or lowered automatically independent of the path motion. The CNC limits the maximum lift height so that the axis can reach the target point of the lowering movement and not influence the path motion. Normally this takes place during path preparation with a path-based coupling of the axis to the main motion path. Instead the 'enable_time_base_lift' parameter can enable a time-based consideration in the real-time GEO task of the controller. As a result, greater lifting height can be reached afterwards. However, time-based coupling requires considerably more computing power in the real-time task of the controller. The HSC slope profile and the time-based approach cannot be used at the same time.
Parameter	enable_time_based_lift
Data type	BOOLEAN
Data range	0: Path-based approach (default). 1: Time-based approach.
Dimension	----
Default value	0
Remarks	<p>The time-based approach must also be included in the configuration data of the path preparation and interpolation function in the controller. Here, set the key word FCT_LIFT_UP_TIME in the parameters P-CHAN-00600 and P-CHAN-00650 (alternatively: P-STUP-00060 and P-STUP-00070).</p> <p>Parameterisation example with P-CHAN-00600 / P-CHAN-00650</p> <pre>configuration.path_preparation.function FCT_DEFAULT FCT_LIFT_UP_TIME .interpolator.function FCT_DEFAULT FCT_LIFT_UP_TIME</pre> <p>Alternatively, the function can be parameterised in the start-up list (P-STUP-00060 / P-STUP-00070).</p> <p>Example of the 1st CNC channel:</p> <pre>configuration.channel[0].path_preparation.function. FCT_DEFAULT FCT_LIFT_UP_TIME configuration.channel[0].interpolator.function. FCT_DEFAULT FCT_LIFT_UP_TIME</pre>

1.4.2.3 CNC objects

For further information on addressing CNC objects, see [FCT-C13//Description].

Name	lift_active		
Description	This object checks the status of the lift function. It signals whether the lift function is activated.		
Task	GEO (Port 551)		
Index group	0x12130<C _{ID} >	Index offset	0x<A _{ID} >0095
Data type	BOOLEAN	Length	1
Attributes	read	Unit	-
Remarks			

Name	lift_suppressed		
Description	This object indicates whether a lift movement is suppressed. This is always the case when the programmed minimum path distance <u>P-CHAN-00244</u> [► 32] is not reached.		
Task	GEO (Port 551)		
Index group	0x12130<C _{ID} >	Index offset	0x<A _{ID} >0094
Data type	BOOLEAN	Length	1
Attributes	read	Unit	-
Remarks	<p>The following special case of the status display occurs when you use Advanced Lifting.</p> <p>If the lift movement is suppressed due to insufficient travel distance and a target position of the Z axis is programmed at the same time, the lift function is active in order to be able to approach the target position of the Z-axis.</p> <p>In this case, the status of the lift function <u>lift_active</u> [► 34] = TRUE and <u>lift_suppressed</u> = TRUE are displayed simultaneously.</p>		

1.4.2.4 HLI parameters

Lift function is active	
Description	This data item indicates whether a lift function is active or not. An active lift function is associated with execution of a lift movement.
Signal flow	CNC->PLC
ST path	gpAx[axis_idx]^ .ipo_state.lift_active
Data type	BOOL
Value range	TRUE = Lift function is active FALSE = Lift function is not active
Access	PLC is reading

Lift movement is suppressed	
Description	This data item indicates whether a lift movement is suppressed. This is always the case when the programmed minimum path distance P-CHAN-00244 [► 32] is not reached.
Signal flow	CNC->PLC
ST path	gpAx[axis_idx]^ .ipo_state.lift_suppressed
Data type	BOOL
Value range	TRUE = Lift movement is suppressed FALSE = Lift movement is not suppressed.
Access	PLC is reading
Special feature	The following special case of the status display occurs when you use “Advanced Lifting”: If the lift movement is suppressed due to insufficient travel distance and a target position of the Z axis is programmed at the same time, the lift function is active in order to be able to approach the target position of the Z-axis. In this case, the status of the lift function is simultaneously displayed as “active” and “suppressed”.

2 MicroJoints

2.1 Pre-output of M functions (MicroJoint)



Use of this function requires a license for the “Cutting” option. It is not included in the scope of the standard license.

Requirements to use the MicroJoints function:

The pre-output function must be enabled in each channel in P-CHAN-00600, or in the start-up list in P-STUP-00060.

```
configuration.path_preparation.function
FCT_DEFAULT | FCT_M_PRE_OUTPUT ( P-CHAN-00600 )
```



The MicroJoint function only supports the pre-output of channel-specific M functions; axis-specific M functions are not supported.



With the MicroJoint function, M functions can be pre-output by specifying a path. No timed pre-output is possible. This can only be implemented with M functions of synchronisation type MET_SVS.

When the MicroJoints function is inactive, a path-based pre-output of M/H functions is only possible with the synchronisation type MEP_SVS.

Activating and enabling the function

Pre-output of an M/H function is executed if:

a pre-output path is specified in P-CHAN-00070 or P-CHAN-00107

Path-related pre-output of M functions

A pre-output can automatically output an M function in advance at a specific point along the path.

For example, in the case of M functions with a time stamp MOS_TS, this can be used for advanced deactivation of a laser to briefly interrupt the cutting process. This leaves so-called MicroJoints.

Output of the advanced M function is not tied to the originally programmed block limits. The motion block is opened automatically by the CNC at the corresponding positions and the M function is inserted.

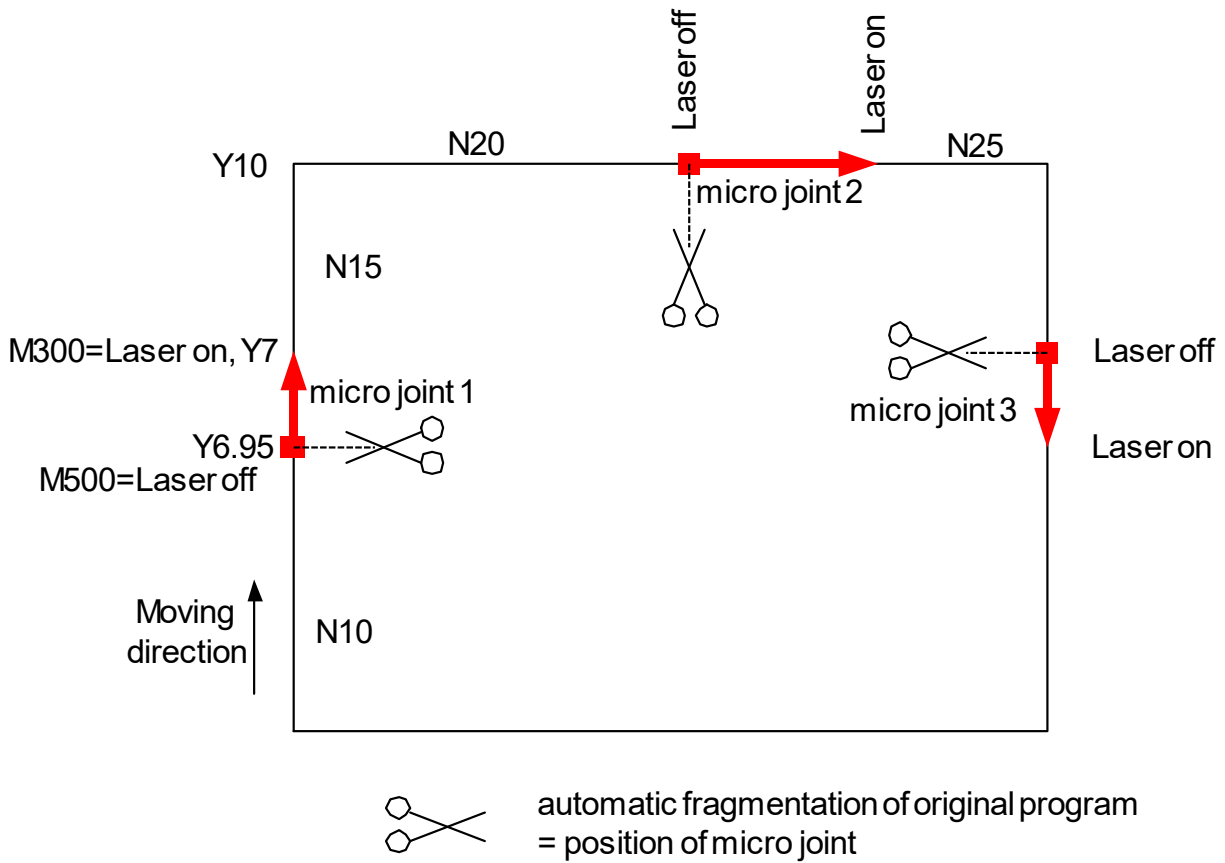


Fig. 12: Programmed MicroJoints in the part

Pre-output of M functions

```

; M300 - Laser on, M500 - Laser off
N05 V.G.M_FCT[500].PRE_OUTP_PATH = 0.05
N10 G00 G90 X0 Y0
N15 L Laser_on.sub
N20 G01 F5000
N25 Y7
N30 M500 M300 ;Microjoint 1
N35 Y10
N40 X14
N45 M500 M300 ;Microjoint 2
N50 X20
N55 L Laser_off.sub
N99 M30
    
```

Equivalent example with explicit programming

```

; M300 - Laser on, M500 - Laser off
N05 G00 G90 X0 Y0
N10 L Laser_on.sub
N15 G01 F5000
N20     Y6.95
N25 M500           ;Microjoint 1
N30     Y7
N35 M300
N40     Y10
N45 X13.95
N50 M500           ;Microjoint 2
N55 X14
N60 M300
N65 X20
...
N70 L Laser_off.sub
N99 M30

```

M/H functions for pre-output

In addition to the actual use of pre-output with high-resolution MOS_TS, output is basically also possible for other M or H functions.

The following synchronisation methods of the M and H functions are evaluated at pre-output:

MOS, MVS_SVS, MVS_SNS, MNS_SNS, MOS_TS

reference position of the pre-output

If the M/H function is programmed together with a motion, then:

the path of the pre-output is determined for its output time relative to the block.

MOS, MOS_TS, MVS_SVS and MVS_SNS are determined relative to the block start position

MNS_SNS is positioned relative to the block end position.



Due to pre-output, however, it is basically no longer required to separate the output and synchronisation points.

In other words, if the M/H function is synchronised (MVS_SVS, MVS_SNS, MNS_SNS), output and synchronisation take place at the same point. This corresponds to programming the M/H function in a separate NC line.

With synchronisation type MCS_SNS: if it is necessary to split blocks due to the pre-output since the pre-output fails to occur at an existing block limit, the split block is synchronised at the end and not at the output point.

Parametrisation using lists

M functions with pre-output are parameterised in the channel list by P-CHAN-00041 (m_synch[.]) and P-CHAN-00070 (m_pre_outp[.]):

```
m_synch[100]    MOS_TS
m_pre_outp[100] 500                ;in 0.1 µm
```

H functions with pre-output are parameterised in the channel list by P-CHAN-00027 (h_synch[.]) and P-CHAN-00107 (h_pre_outp[.]):

```
h_synch[50]     MVS_SVS
h_pre_outp[50]  400                ;in 0.1 µm
```

Parametrisation by programming

As an alternative to the parametrisation of M/H functions, the synchronisation method and the path also can be specified directly in NC program.

```
V.G.M_FCT[11].SYNCH = 1
V.G.M_FCT[11].PRE_OUTP_PATH = 14      ;in [mm]

V.G.H_FCT[200].SYNCH = 4
V.G.H_FCT[200].PRE_OUTP_PATH = 40    ;in [mm]
```

Synchronisation types as macro

```
%MicroJoint
; Synchronisation types as macro
"MOS" = "1"
"MVS_SVS" = "2"
"MVS_SNS" = "4"
"MNS_SNS" = "8"
"MOS_TS" = "262144" ;0x40000

V.G.M_FCT[11].SYNCH = "MOS_TS"
V.G.M_FCT[11].PRE_OUTP_PATH = 11      ;in [mm]
V.G.M_FCT[13].SYNCH = "MNS_SNS"
V.G.M_FCT[13].PRE_OUTP_PATH = 23      ;in [mm]

V.G.H_FCT[12].PRE_OUTP_PATH = 12      ;in [mm]
V.G.H_FCT[12].SYNCH = "MVS_SVS"

N01 X0 G01 F500
N10 X100
N20 X200 M11 H12 M13
N30 X300
M30
```

2.1.1 Limitations, special cases

Limitation of the look-ahead range

The described look-ahead range is limited due to resource limitation and the requirement for the NC program to run up as soon as possible after start.

The default limits the maximum number of blocks considered for pre-output to 10 blocks; this can be set in P-CHAN-00603 (or in P-STUP-00061). Depending on the block length, this results in a maximum joint width.

If an M/H function is brought forward beyond the look-ahead range, the M/H function is only brought forward automatically as far as the look-ahead range permits.

Limitation of the look-ahead range

```
%microjoint4
N01 G00 G90 X0 Y0
N02 G01 F10000
```

```

N03 V.G.M_FCT[100].PRE_OUTP_PATH = 28.6 ;in mm
N20 G91 Y1
N21 Y1 ; -> planned MicroJoint at Y1.4 mm
N22 Y1
N23 Y1
N24 Y1
N25 Y1
...
N37 Y1
N38 Y1
N39 Y1 ; -> real MicroJoint caused by block number limitation
N40 Y1
N41 Y1
N42 Y1
N43 Y1
N44 Y1
N45 Y1
N46 Y1
N47 Y1
N48 Y1
N49 Y1
N50 M100 M26
N99 M30

```

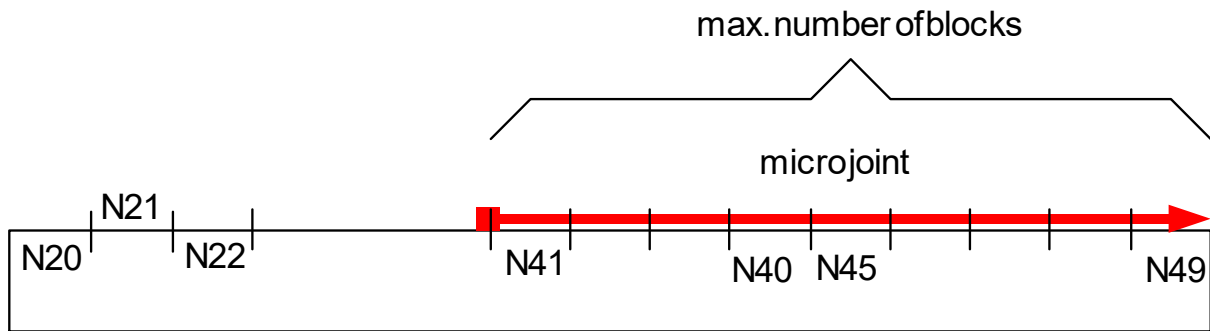


Fig. 13: Limitation of the pre-output path of the M function to 10 blocks

Explicit cancellation of the look-ahead range, #FLUSH, Read synchronous V.E. variable

The look-ahead range of M functions is reset by flushing the channel (#FLUSH or #FLUSH WAIT). In other words, the pre-output of M functions cannot be reversed beyond the #FLUSH point.

An implicit #FLUSH WAIT, i.e. the channel is flushed, can also be executed when a synchronous V.E variable (see [EXTV]) is read. A pre-output via the read access of a synchronous V.E. variable is therefore not possible either.

If an M/H function is brought forward beyond the look-ahead range, the M/H function is only brought forward automatically as far as the look-ahead range permits.

Explicit cancellation of the look-ahead range, #FLUSH, Read synchronous V.E. variable

```

%microjoint6
N01 G00 G90 X0 Y0
N02 G01 F10000

N10 V.G.M_FCT[100].PRE_OUTP_PATH = 28.6 ; in mm
N20 G91 Y1
N21 Y1 ; -> planned MicroJoint at Y1.4 mm
N22 Y1
N23 Y1
...
N38 Y1
N39 Y1
N40 Y1
N41 Y1
N42 Y1
N43 Y1
N44 Y1

```



```
N400#FLUSH ; -> MicroJoint inserted at Y24
N45 Y1
N46 Y1
N47 Y1
N48 Y1
N49 Y1
N50 M100 M26
N99 M30
```

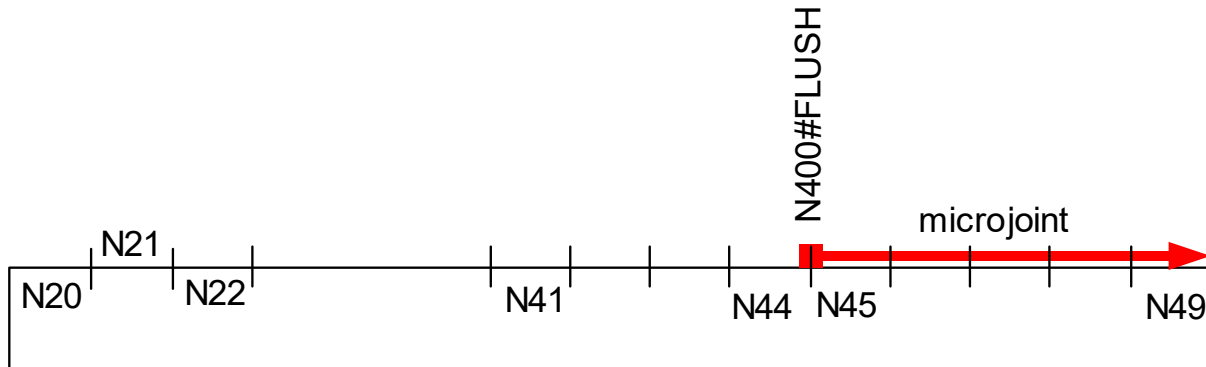


Fig. 14: Explicit limitation of the lead distance of the M function

"Overlapping" path-related pre-output

After a path-related pre-output of the M function is detected, all previously stored motion blocks are output. This corresponds to explicit flushing of the channel (see #FLUSH), thus avoiding delayed processing of the motion blocks.

As a result, it is not possible to overlap the path range of several M functions.

If pre-outputs of M/H functions overlap, the individual M/H functions are only brought forward automatically up to the originally programmed position.

"Overlapping" path-related pre-output

```
%microjoint5
(* M100 - Laser off, M26 - Laser on *)
N01 G00 G90 X0 Y0
N02 G01 F10000
N03 V.G.M_FCT[101].PRE_OUTP_PATH = 5 ;in mm
N04 V.G.M_FCT[102].PRE_OUTP_PATH = 23
N05 V.G.M_FCT[103].PRE_OUTP_PATH = 31
N20 X10
N30 M101 M26
N40 X30
N50 M102 M26
N60 X40
N70 M103 M26
N80 M30
```

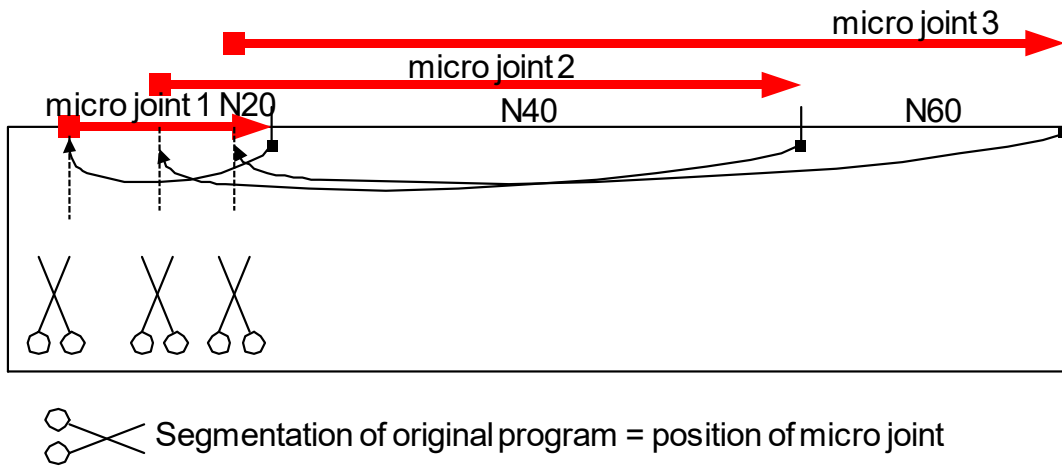


Fig. 15: Theoretical overlapping of MicroJoints in the part

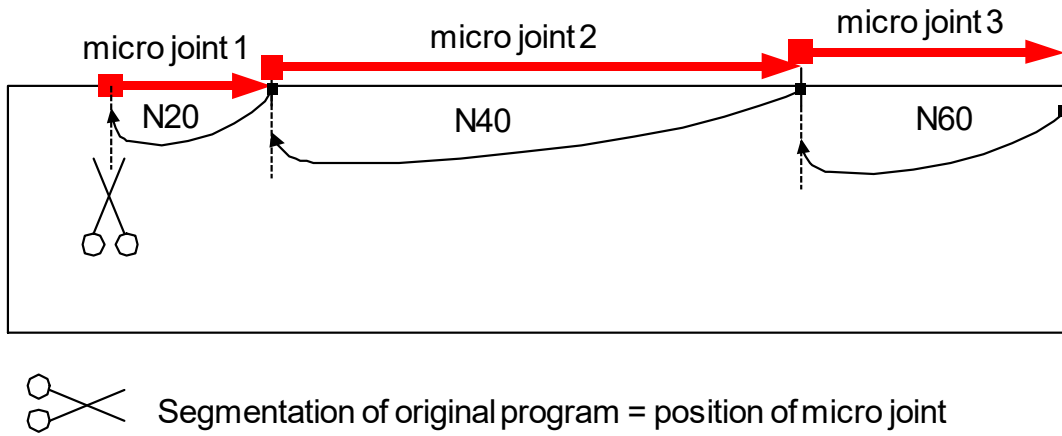


Fig. 16: Limitation of overlapping of MicroJoints in the part

Combination of MNS_SNS with and without pre-output path

It is not permitted to execute the simultaneous programming of MNS_SNS M functions with and without pre-output path in the same NC block including an axis motion.

Combination of MNS_SNS with and without pre-output path

```
%microjoint9
N01 G01 G90 X0 Y0 F10000

N02 V.G.M_FCT[100].PRE_OUTP_PATH = 35.6; in mm

N04 V.G.M_FCT[100].SYNCH = 8 ;MNS_SNS
N04 V.G.M_FCT[200].SYNCH = 8 ;MNS_SNS

N20 X10
N40 X30 M100 M200
N60 X40

N99 M30
```

Pre-output between output and synchronisation points of an MVS_SNS

It is not possible to insert an M/H function of synchronisation type MVS_SNS between output and synchronisation points. The pre-output of the M/H function is then only brought forward up to synchronisation point of the MCS_SNS at the most.

Pre-output of another M/H function of the MVS_SNS type

The example below shows an attempt to move M100 between the output and synchronisation points of the M200 (an MVS_SNS with motion). In this case, M100 is not output as required at X9 but at the end of N10, i.e. at X10.

```
N01 G01 G90 X0 Y0 F1000
(Definitions of M functions)
N02 V.G.M_FCT[100].PRE_OUTP_PATH = 21.0
N03 V.G.M_FCT[100].SYNCH = 2 ; MVS_SVS
N04 V.G.M_FCT[200].SYNCH = 4 ; MVS_SNS

N10 X10 M200
N20 X30
N30 X40 M100
N40 X0 Y0
N50 M30
```

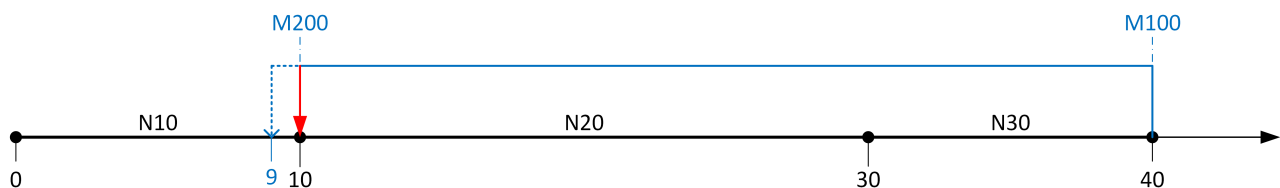


Fig. 17: Attempted pre-output with another M/H function of the MVS_SNS type

2.1.2 Tolerance parameters for the permitted deviation between real and planned pre-output positions of an M/H function

The [Limitations and special cases](#) [► 39] described in the section can result in an M/H function with pre-output not being output at the required position, but possibly at a significantly less advanced position.

However, the channel parameter P-CHAN-00760 (pre_output_tolerance) is used to check how far the pre-output of an M/H function may deviate from the planned position.

If the deviation exceeds the specified tolerance value, the program is aborted and a corresponding error message is output. Otherwise, the M/H function is automatically without a warning output and offset by this deviation from the expected position.

2.1.3 Explicit feed programming for MicroJoints (#CHANNEL SET)

Feed at / behind a MicroJoint

For technical process reasons, it may be necessary to limit the path velocity for a MicroJoint (in particular with an M function MOS which requires no acknowledgement). In addition, the path after the advanced M function (MicroJoint path) is completely traversed to the end at a change in velocity.

This can be defined by the following feed settings in the NC command #CHANNEL SET (see figure below "Feed definition with MicroJoints").

#CHANNEL SET [M_PRE_OUTPUT [E=..] [F=..] [VECTOR_LIMIT_OFF]]	non-modal
E=..	Block end velocity E of the previous MicroJoint (start of MicroJoint)
F=..	Feed velocity within the MicroJoint (path between the position of the advanced M function and the originally programmed position of the M function)
VECTOR_LIMIT_OFF	Deselecting a possible dynamic limitation. If one of the previously programmed dynamic influences is active via #VECTOR LIMIT (VEL, ACC, DEC), it is suppressed within the MicroJoint range.

Explicit feed programming for MicroJoints

```
%microjoint16
N01 G00 G90 X0 Y0
N02 G01 F100

N05 #CHANNEL SET [M_PRE_OUTPUT E=20 F=5000]

N10 V.G.M_FCT[100].PRE_OUTP_PATH = 8; in mm
N20 G91 Y1
...
N40 Y10
N50 M100 M26
N99 M30
```



Fig. 18: Feed definition with MicroJoints



If the F or E word is not specified, the feed for the advanced M function and subsequent motion blocks is not changed.

MicroJoint feed across multiple blocks

When the pre-output of the M function is advanced across multiple blocks, the feed of all MicroJoint motion blocks is also changed to the specified value.

A possibly explicitly programmed feed is replaced by the specific MicroJoint feed.

MicroJoint feed across multiple blocks

```
%microjoint17
```

```
N01 G01 G90 X0 Y0 F100
N05 #CHANNEL SET [M_PRE_OUTPUT E=20 F=5000]
N10 V.G.M_FCT[100].PRE_OUTP_PATH = 15; in mm
...
N40 G91 Y10 F7500
N50 M100 M26
N99 M30
```

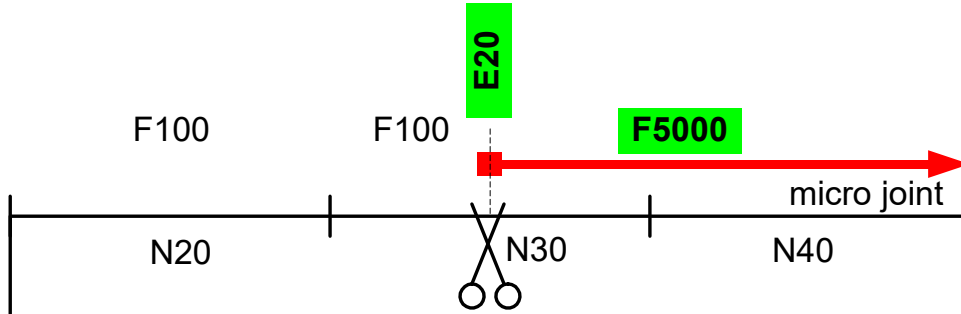


Fig. 19: Feed with block global MicroJoints



Specifying a MicroJoint specific feed replaces the possible explicitly programmed feed of the NC block.

See example above:

F7500 in N40 is replaced by F5000.

Increased feed with M11, decreased feed with M12

```
%microjoint16
V.G.M_FCT[11].SYNCH = "MOS"
V.G.M_FCT[11].PRE_OUTP_PATH = 125
V.G.M_FCT[12].SYNCH = "MOS"
V.G.M_FCT[12].PRE_OUTP_PATH = 325

N300 #CHANNEL SET [M_PRE_OUTPUT E=250 F=1500]
N01 X-222 G01 F1000

N10      X10
N20      X100
N30      X200 M11 (125mm)

N32 #VECTOR LIMIT ON[VEL=500]

N35 #CHANNEL SET [M_PRE_OUTPUT E=150 F=750]

N40      X300
N41      X310
N42      X320
N43      X330
N44      X340
N45      X350
N46      X360
N47      X370
N48      X380
N49      X390
N50      X500
N60      M12 (325mm)
N70      X600
N80      X700
M30
```

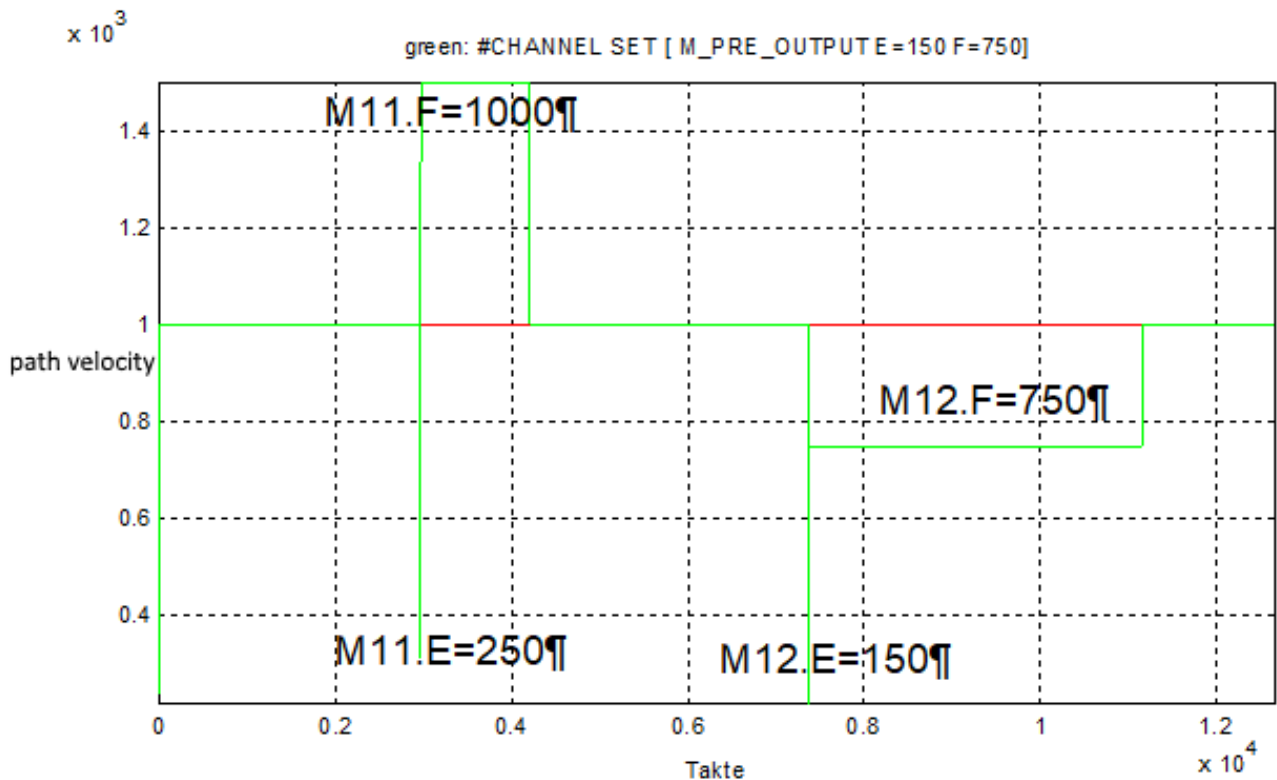


Fig. 20: Increased feed with M11, decreased feed with M12

Suppress VECTOR_LIMIT during MicroJoint

```

%microjoint18
V.G.M_FCT[11].SYNCH = "MOS"
V.G.M_FCT[11].PRE_OUTP_PATH = 125
V.G.M_FCT[12].SYNCH = "MOS"
V.G.M_FCT[12].PRE_OUTP_PATH = 325

N300 #CHANNEL SET [M_PRE_OUTPUT E=250 F=1500]
N01 X-222 G01 F1000

N10 X10
N20 X100
N30 X200 M11 (125mm)

N32 #VECTOR LIMIT ON[VEL=500]

N35 #CHANNEL SET [M_PRE_OUTPUT E=150 F=750 VECTOR_LIMIT_OFF]

N40 X300
N41 X310
N42 X320
N43 X330
N44 X340
N45 X350
N46 X360
N47 X370
N48 X380
N49 X390
N50 X500
N60 M12 (325mm)
N70 X600
N80 X700
M30
    
```

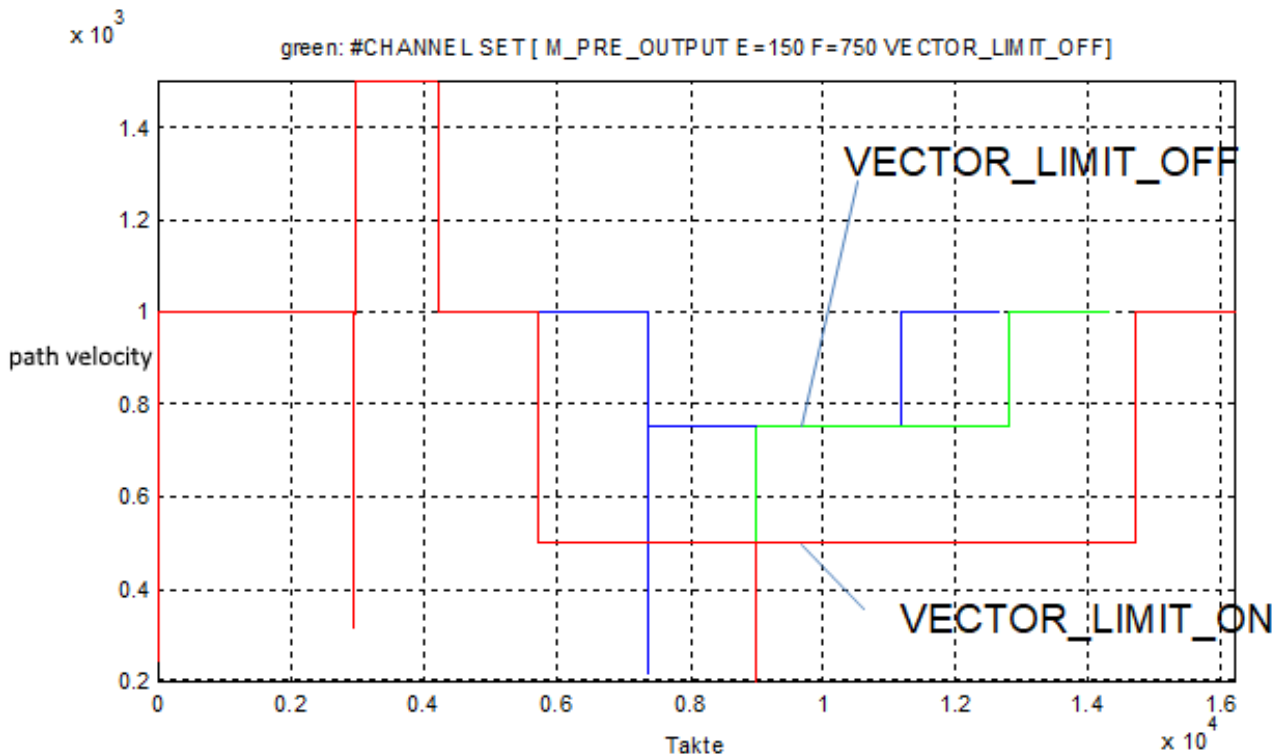


Fig. 21: Suppress VECTOR_LIMIT during MicroJoint

3 Tube processing

3.1 Overview

Task

The functions permit a simplified programming for the surface machining of:

- round tubes,
- polygonal tubes (profiled tubes) and
- open polygonal tubes (L/U profiles)

Depending on the application, the geometry is specified as Cartesian either on the lateral surface projection or as a parallel projection onto the workpiece. Different machining variants are possible here on 3/4-axis or 5/6-axis machines.

Characteristics

The function can only be enabled exclusively for Cartesian and kinematic transformations.

Parametrisation

Specific kinematics with corresponding parameter sets are required for machining variants (see chapter [Parameters \[► 115\]](#)).

Programming

A kinematic transformation is actually selected by specific variants of the #CYL command. In this case, a kinematic is implicitly selected (#KIN ID [..]).



Transformations are additional options and subject to the purchase of a license.

Mandatory note on references to other documents

For the sake of clarity, links to other documents and parameters are abbreviated, e.g. [PROG] for the Programming Manual or P-AXIS-00001 for an axis parameter.

For technical reasons, these links only function in the Online Help (HTML5, CHM) but not in pdf files since pdfs do not support cross-linking.

3.2 Description

Classic lateral surface machining

Classic lateral surface machining of cylindrical workpieces typically takes place on machine structures that are designed and conceived for pure turning work. These machines have only 2 translatory tool axes Z, X and one rotary workpiece axis C.

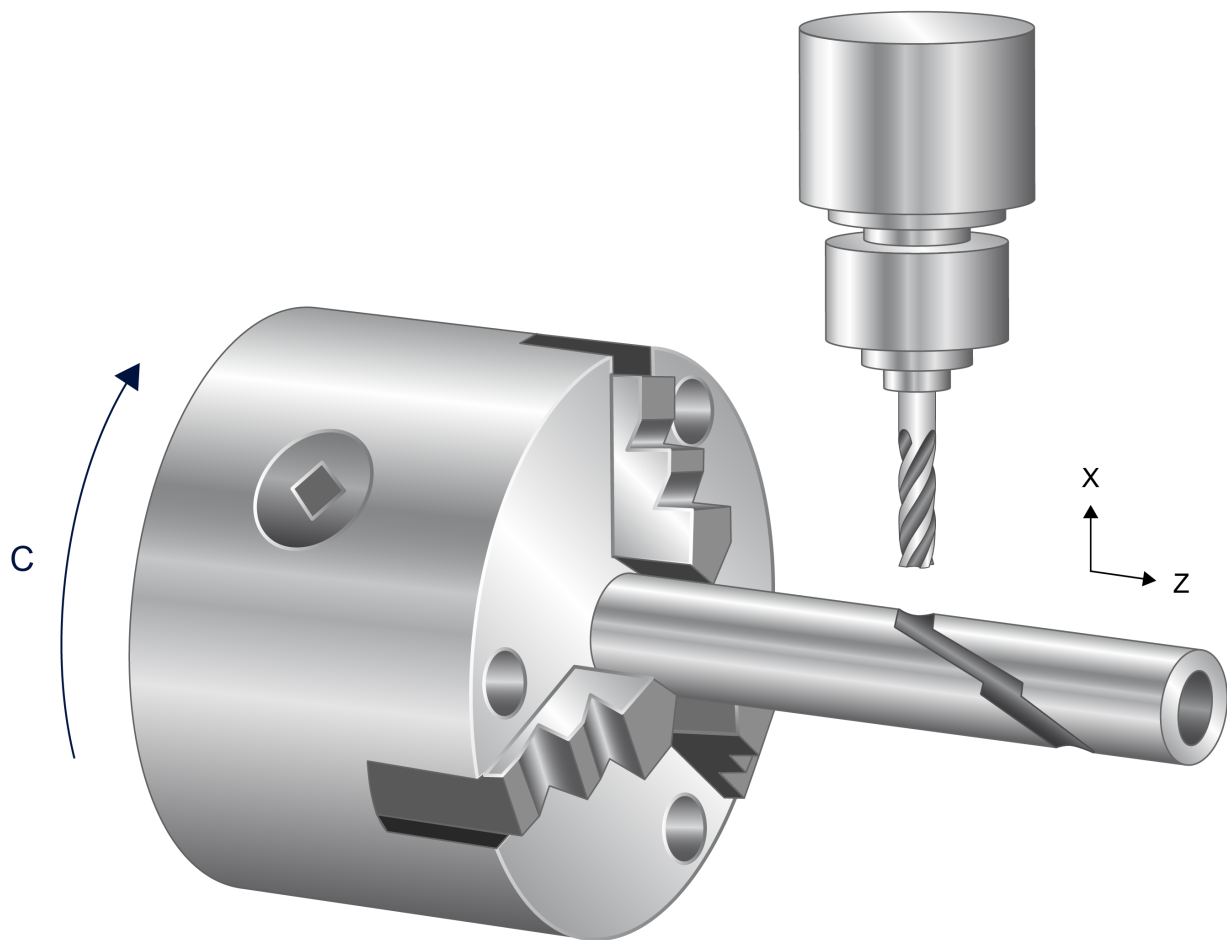


Fig. 22: Round tube lateral surface machining

Rotation-symmetrical workpiece

Besides its use in machining centres, this function is also used on other machine structures with 3 Cartesian axes X, Y, Z. With the aid of an additionally arranged rotary axis, e.g. A, these machines can also be used to machine rotation-symmetrical workpieces.

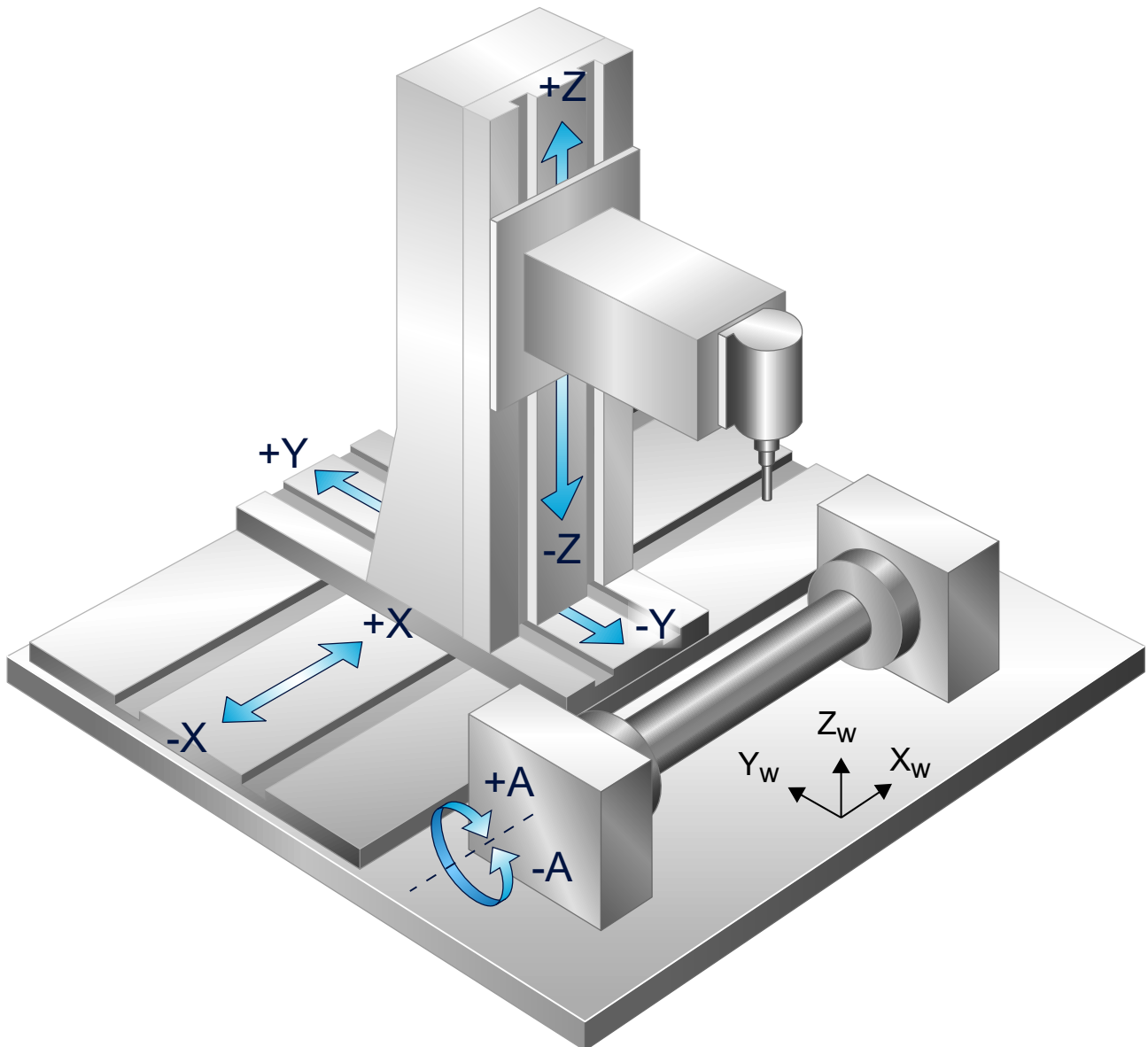


Fig. 23: Tube machining with Cartesian 3-axis machine

Besides round tube machining on the lateral surface, the functions for tube projection and profiled tube machining are described below.

Programming kinematic parameters

The kinematic parameters can be set in the channel parameters (kinematik[*].param[*] or trafo[*].*) or in the NC program by suitable V.G variables.

i Note on CNC Build up to V2.11.28xx and as of V3.00 and higher

Up to Build 2.11.28xx, parameterising the kinematics was only possible in the NC program. As of V3.00 the associated kinematic ID must be set in the channel parameters in P-CHAN-00262: e.g. trafo[0].id 15

As of Builds V3.00 and higher, the parameter P-CHAN-00262 is required for all subsequent transformations in pipe and profile tube machining operations.

Transformation ID	Description
15	Round tube, lateral surface (3/4-axis) [▶ 53]
78	Round tube, projection (3/4-axis) [▶ 58]
79	Polygonal tube, profiled tube (3/4-axis) [▶ 62]
90	Round tube, lateral surface (5/6-axis) [▶ 81]
93	Polygonal tube, profiled tube (5/6-axis) [▶ 111]

Channel parameter

Setting example (for CNC Builds up to V2.11.28xx):

```
...
# Parameterisation takes place in P-CHAN-00094
kinematik[15].param[0] 1230000 # P-CHAN-00094
kinematik[15].param[1] 0      # P-CHAN-00094
kinematik[15].param[2] 0
kinematik[15].param[3] 0
kinematik[15].param[4] 0
kinematik[15].param[5] 0
kinematik[15].param[6] 0
kinematik[15].param[7] 0
kinematik[15].param[8] 0
kinematik[15].param[9] 0
...
```

OR

Setting example (for CNC Builds as of V3.00 and higher):

```
...
# Parameterisation takes place in P-CHAN-00262 and P-CHAN-00263
trafo[0].id 15 # P-CHAN-00262
trafo[0].param[0] 1230000 # P-CHAN-00263
trafo[0].param[1] 0      # P-CHAN-00263
trafo[0].param[2] 0
trafo[0].param[3] 0
trafo[0].param[4] 0
trafo[0].param[5] 0
trafo[0].param[6] 0
trafo[0].param[7] 0
trafo[0].param[8] 0
trafo[0].param[9] 0
...
```

NC program

Setting example in the NC program:

```
...
V.G.KIN[15].PARAM[0] = 123000
V.G.KIN[15].PARAM[1] = 0
V.G.KIN[15].PARAM[2] = 0
V.G.KIN[15].PARAM[3] = 0
V.G.KIN[15].PARAM[4] = 0
V.G.KIN[15].PARAM[5] = 0
V.G.KIN[15].PARAM[6] = 0
V.G.KIN[15].PARAM[7] = 0
V.G.KIN[15].PARAM[8] = 0
V.G.KIN[15].PARAM[9] = 0
...
```

3.3 Machining variants (3/4-axis)

A distinction is made between 4 different machining variants:

- [Round tube, lateral surface \[► 53\]](#)
- [Round tube, projection \[► 58\]](#)
- [Polygonal tube, profiled tube \[► 62\]](#)
- [Open polygonal tube / profiled tube \(L/U profiles\) \[► 72\]](#)

3.3.1 Round tube, lateral surface

3.3.1.1 Programming #CYL [..]

The path is programmed in Cartesian coordinates on the lateral surface projection in X and U where U is the rotary axis identifier. When selected, the reference radius R on the cylindrical workpiece must also be programmed.

The tool must be located above the centre of rotation when selected.

If required, PCS (Programming Coordinate System) modulo calculation can be activated by a kinematic parameter (see below Parameter HD10 in section [Description](#) [116]). In this case, the PCS U axis is treated as a rotary modulo axis. After it crosses the modulo limit of the rotary axis, the circumferential position is also corrected.

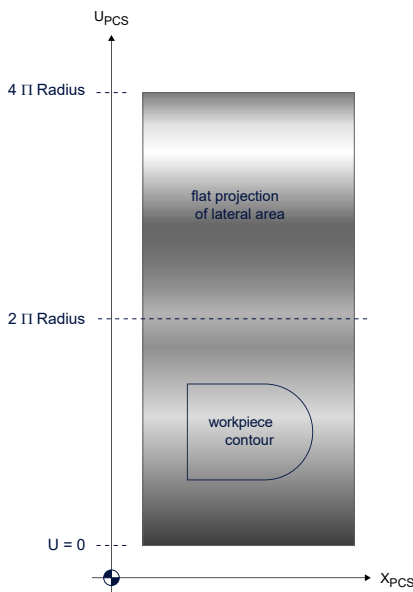


Fig. 24: Path programming on the lateral surface

i In the case of absolute programming, a position on the tube's circumference is always moved to over the shortest distance. The section "Programming modulo axes" in [PROG] must be observed when programming the sign. This must also be taken into account for circular motion blocks (G02, G03) with absolute target point programming.

i The kinematic parameters in [ID 15](#) [116] must be set for this machining type.

Syntax to select lateral surface machining with round tube:

Syntax:

#CYL [*<1st_main_axis_name>*, *<2nd_main_axis_name>*, *<3rd_main_axis_name>* etc.] modal

<1st_main_axis_name Name of the first main axis according to the current main plane.
>

<2nd_main_axis_name Name of the second main axis according to the current main plane (virtual linear axis, development).
>

<3rd_main_axis_name Axis name of the third main axis according to the current main plane with specification of the reference radius in [mm, inch].
>

Syntax to deselect lateral surface machining with round tube

Syntax:

#CYL OFF

modal

#CYL [..]

```
(* Example with axis identifier U for 2nd main axis *)
N05 G00 Y0 (tool over centre of rotation)
N10 G01 X60 U45 F5000
N20 #CYL [X, U, Z60] (Select lateral surface, radius 60 mm)
N30 G00 G90 X0 U0 (X: 0mm U:0mm!)
N40 G01 U100 F500
N50 G02 X100 R50
N60 G01 U0
N70 Z0
N80 #CYL OFF
```

3.3.1.2 Axis configuration

The following axis configuration must be set in the NC channel.

Axis configuration in the NC channel		
Axis identifier	X, Y, Z, U	
Axis index	0, 1, 2, 3	
Kinematic structure (ID 15)		
	Tool axes	Workpiece axes
NC axes	X, Y, Z	U

Axis structure

The Z tool axis must intersect with the rotary axis U, i.e. the tool axis lies at the tube centre point. To achieve this, place the Y axis in the correct position before selecting the transformation.

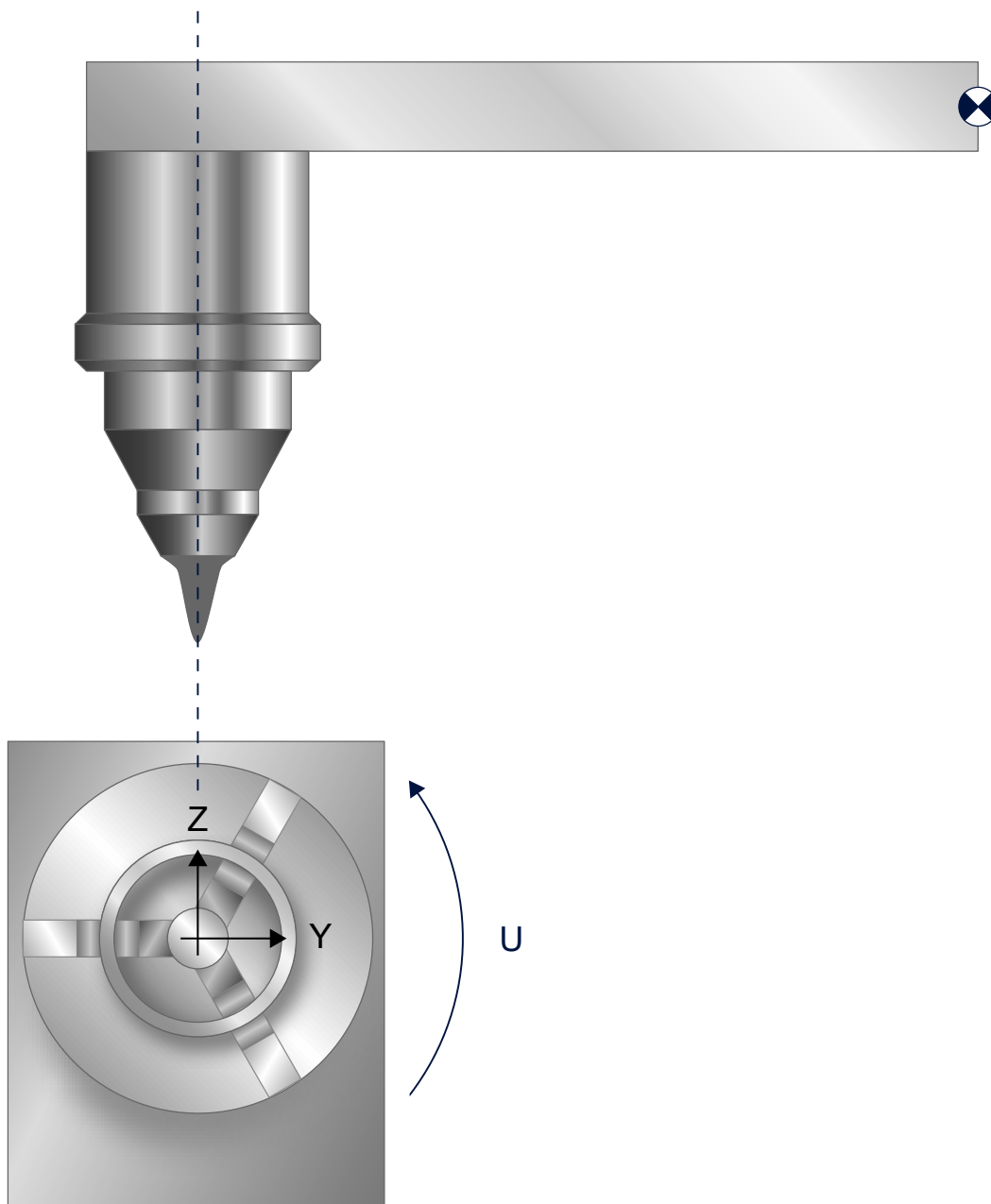


Fig. 25: Axis structure

Parameterisation: [Round tube, lateral surface \(kinematic ID 15\)](#) [[▶ 116](#)]

3.3.1.3 Path example

Lateral surface transformation

```
(* Lateral surface transformation *)

N30 #SLOPE [TYPE=STEP]
N40 G00 X0 Y0 Z100 U0

N50 #CYL [X, U, Z35] (* Select lateral surface machining *)

N70 G01 G90 X0 U0 F5000
N80 G01 Z10 G90 F50000
N90 $FOR P1=1, 4, 1
N100 G00 G90 X0 U[P1*90]
N110 $FOR P2=1, 5, 1
N120 P3=P2*4
N130 P4=P3+2
N140 G01 G91 U-P3
N150 XP3
N160 U[2*P3]
N170 X-P3
N180 G90 U0
N190 G91 XP4
N190 $ENDFOR
N200 $FOR P2=1, 5, 1
N210 P3=P2*4
N220 P4=P3*2+2
N230 G90 G02 IP3
N240 G91 G01 XP4
N250 $ENDFOR
N260 $ENDFOR

N290 #CYL OFF
M30
```

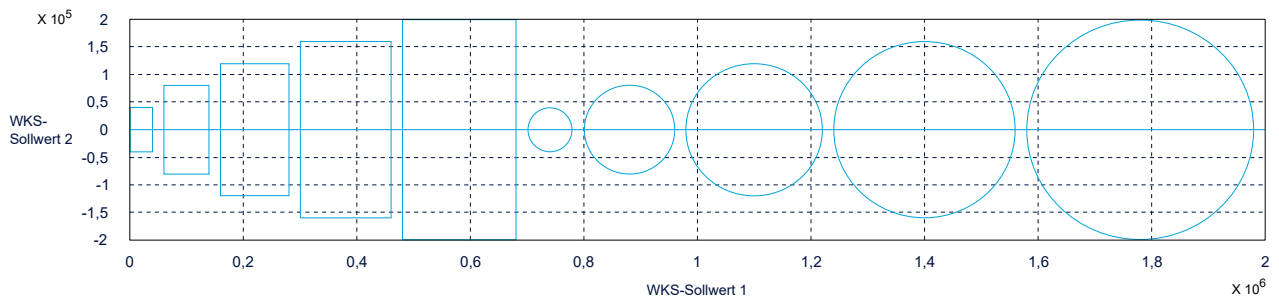


Fig. 26: X-U contour line projection

3.3.2 Round tube, projection

With projected round tube machining, the programmed X/Y path is mapped by parallel projection onto the lateral surface of a tube. The distance from the tube (Z height) is kept constant by transformation on the curved tube. If the distance is changed, a Z height change can be additionally programmed.

Machining is possible up to a programmable radius limit. This value is always less than the tube radius. Machining is aborted if a position outside this limit is programmed. This results in an error message.

Before selecting the transformation, the tube must be positioned so that the Y axis is within the set limit 'LIMIT' (see NC command #CYL [...]).

The specified feed rate refers to the original path programmed. Especially in the edge zone of the tube, the real feed rate of the tool in the round tube is higher.

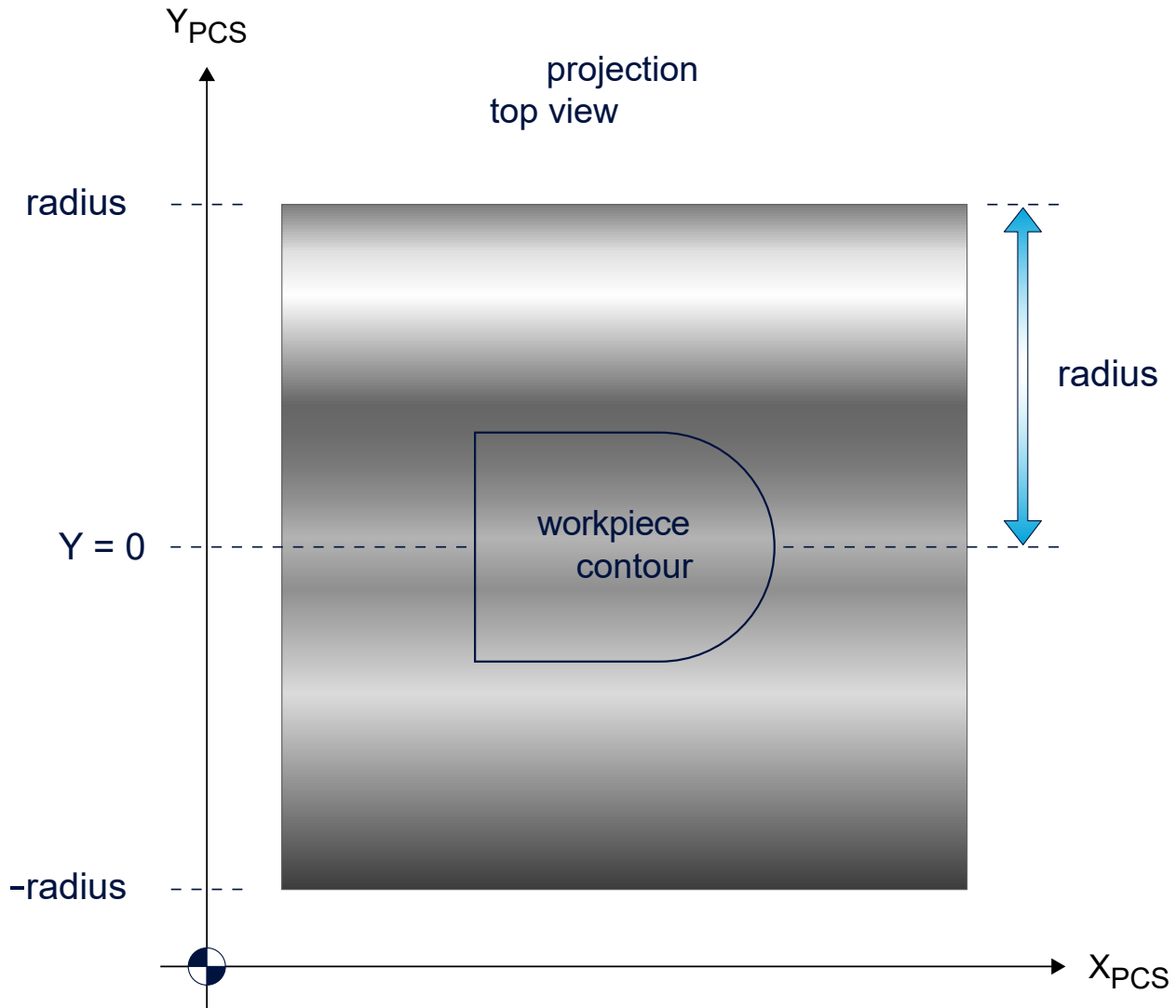


Fig. 27: Programming with path projection

3.3.2.1 Programming #CYL [RADIUS..]

i The kinematic parameters in [ID 78](#) [▶ 118](#) must be set for this machining type.

Syntax to select round tube projection:

Syntax:

#CYL [RADIUS=.. [LIMIT=..] modal

RADIUS=.. Radius of the round tube or of the lateral surface to be machined, [mm, inch]

LIMIT=.. Machining limit, symmetrically relative to the tube centre. [mm, inch]
If no limit is explicitly specified, $LIMIT = 0.25 * RADIUS$ applies.

Syntax to deselect round tube projection:

Syntax:

#CYL OFF modal

#CYL [RADIUS..]

```
N10 X0 Y-1000 Z100 U0
N20 # CYL [RADIUS=35 LIMIT=31] ;Select tube projection
N30 G01 G90 X0 Y0 F5000
N40 G01 Z10
N50 $FOR P1=1, 4, 1
N60 G00 G90 X0 Y0 U[P1*90]
N70 $FOR P2=1, 5, 1
N80 P3=P2*4
N90 P4=P3+2
N100 G01 G91 Y-P3
N110 XP3
N120 Y[2*P3]
N130 X-P3
N140 G90 Y0
N150 G91 XP4
N160 $ENDFOR
N170 $FOR P2=1, 5, 1
N180 P3=P2*4
N190 P4=P3*2+2
N200 G90 G02 IP3
N210 G91 G01 XP4
N220 $ENDFOR
N230 $ENDFOR
N240 #CYL OFF ;Deselect tube projection
```

3.3.2.2 Axis configuration

The kinematic structure consists of three translatory axes in the tool. The rotary workpiece axis is not changed by the transformation.

The following axis configuration must be set in the NC channel.

Axis configuration in the NC channel		
Axis identifier	X, Y, Z, U	
Axis index	0, 1, 2, 3	
Kinematic structure (ID 78)		
	Tool axes	Workpiece axes
NC axes	X, Y, Z	U

Axis structure

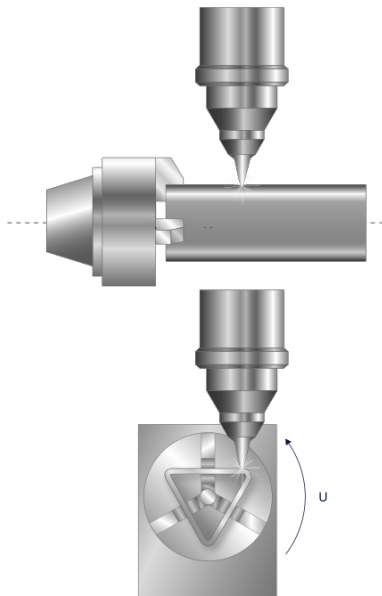


Fig. 28: Axis structure

Parameterisation: [Round tube, projection \(kinematic ID 78\)](#) |▶ 118|

3.3.2.3 Path example

Tube projection

```
(* Tube projection *)

#SLOPE [TYPE=STEP]
X0 Y-1000 Z100 U0

N50 #CYL [RADIUS=35 LIMIT=31] (* Selecting tube projection*)

N70 G01 G90 X0 Y0 F5000
N80 G01 Z10 G90 F50000
N90 $FOR P1=1, 4, 1
N100 G00 G90 X0 Y0 U[P1*90]
N110 $FOR P2=1, 5, 1
N120 P3=P2*4
N130 P4=P3+2
N140 G01 G91 Y-P3
N150 XP3
N160 Y[2*P3]
N170 X-P3
N180 G90 Y0
N190 G91 XP4
N190 $ENDFOR
N200 $FOR P2=1, 5, 1
N210 P3=P2*4
N220 P4=P3*2+2
N230 G90 G02 IP3
N240 G91 G01 XP4
N250 $ENDFOR
N260 $ENDFOR

N290 #CYL OFF
M30
```

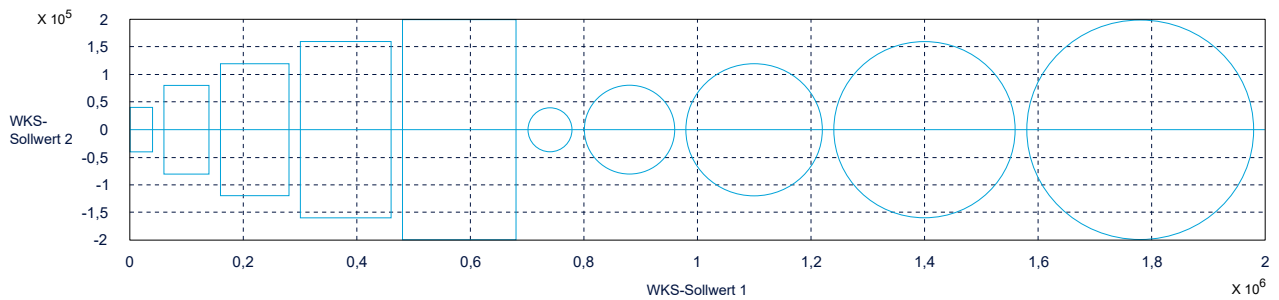


Fig. 29: X-Y contour line projection

3.3.3 Polygonal tube, profiled tube

This function places the programmed contour onto the projected lateral surface of a profiled tube.

The controller guides the workpiece during machining (Y deflection) so that the tool is always perpendicular to the workpiece surface. The distance from the workpiece (Z height) is kept constant without Z programming. A Z height can also be programmed. The programming coordinates of U, X and Z height of the TCP (Tool Centre Point) refers to the lateral surface.

With lateral surface machining, the path feed rate for round tubes refers to the programmed projected path.

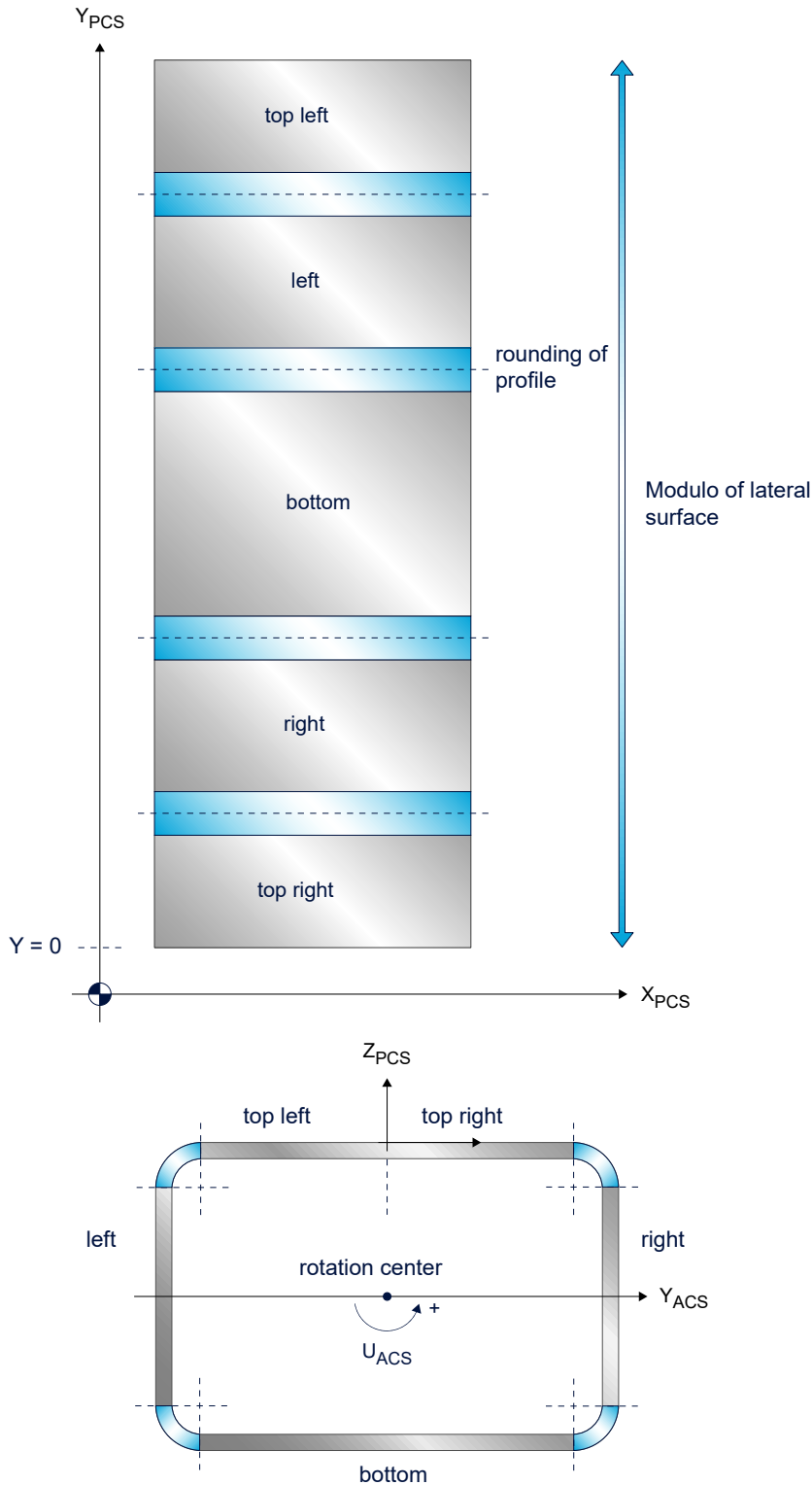


Fig. 30: Programming on the lateral surface

3.3.3.1 Programming #CYL [EDGES..]



The kinematic parameters in [ID 79](#) | [120](#) must be set for this machining type.

Syntax to select profiled tube machining:

Syntax:

```
#CYL [ EDGES=.. ROUNDING=.. LENGTH1=.. [LENGTH2=.. ]          modal
      [ VEL=.. ] [ ACC=.. ] ]
```

EDGES=..	Number of edges (corners) of the profiled tube, positive integer The minimum number of corners on the profile is limited to 3 and the maximum number to 16.
ROUNDING=..	Edge rounding radius (corner radius), [mm, inch].
LENGTH1=..	Side length for symmetrical tubes or first side length for rectangular tubes, [mm, inch]
LENGTH2=..	Second side length for rectangular tubes, [mm, inch]
VEL=..	Path velocity on edge rounding [mm/min]
ACC=..	Path acceleration on edge rounding [mm/min ²]

Syntax to deselect profiled tube machining:

Syntax:

```
#CYL OFF          modal
```

#CYL [EDGES..]

```
(Symmetrical square profile with 100 mm edge length)
(and 10 mm edge rounding radius)
N10 #CYL [EDGES=4 ROUNDING=10 LENGTH1=100]
...
(Asymmetrical square profile with edge lengths of 100 mm)
(and 80 mm and 15 mm edge rounding radius)
N10 #CYL [EDGES=4 ROUNDING=15 LENGTH1=100 LENGTH2=80]
...
(Reduced path dynamics on the profile rounding)
N10 #CYL [EDGES=4 ROUNDING=5 LENGTH1=50 LENGTH2=50
          ACC=1000000]
```

NOTICE

With relative programming, the number of profile rotations is limited for each block due to resources. An error message is generated if the maximum number is exceeded.

Tube profile machining

```
(* Tube profile machining *)
%main
N10 #SLOPE [TYPE=STEP]
N20 G90 X0 Y0 Z100 U0
N30 U0 X0
N40 #CYL[EDGES=4 ROUNDING=5 LENGTH1=20 LENGTH2=20]
N50 G01 G91 X10 F5000
N60 U50
N70 G03 U-100 I300 J-50
N80 #CYL OFF
N90 M30
```

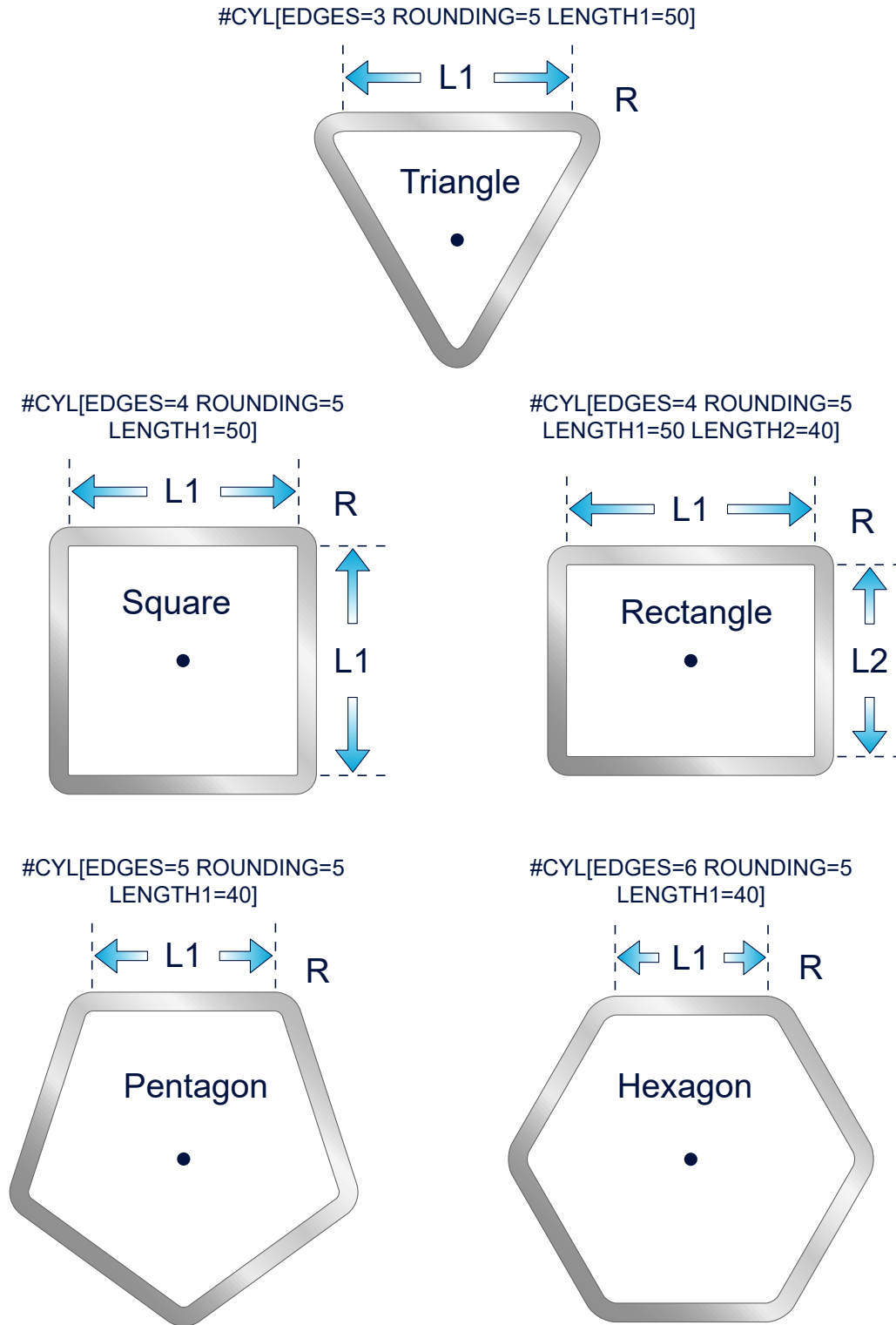


Fig. 31: Parameterisation examples for profiled tubes

Rectangular profile

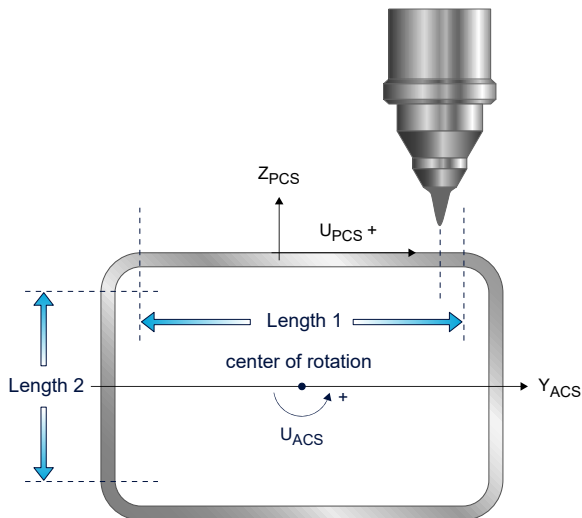


Fig. 32: Lateral surface coordinate system with rectangular profile

Activation condition

Default case: Selecting on plane surface

The transformation is selected when the workpiece is aligned flat. The angle of the U axis then displayed with horizontal workpiece alignment is set by means of a U offset (kinematic parameters).

When #CYL[...] is selected, the Y axis position of the tool is located within the plane surface of the workpiece (side length LENGTH1), otherwise an error message is output.

Special case: Selection on profile rounding

A U angle offset may possibly have to be set in the same way as described before.

The transformation should be selected on the profile rounding. This variant can be used when machining was stopped with active transformation on the profile rounding or a profile rounding position was approached using #PTP ON. The CNC checks whether selection is possible with the current active U and Y axis positions. An error message is generated if an axis position are invalid.



With G90 absolute programming, positioning on the circumference is always based on the "shortest path" without specifying the direction of rotation.

Please note the section "Programming modulo axes" in [PROG] when programming the sign for the direction of rotation.

This must also be taken into account for circular motion blocks (G02, G03) with absolute target point programming.

3.3.3.2 Axis configuration

The kinematic structure consists of 3 translatory axes in the tool and one rotary axis in the workpiece.

The following axis configuration must be set in the NC channel.

Axis configuration in the NC channel		
Axis identifier	X, Y, Z, U	
Axis index	0, 1, 2, 3	
Kinematic structure (ID 79)		
	Tool axes	Workpiece axes
NC axes	X, Y, Z	U

Axis structure

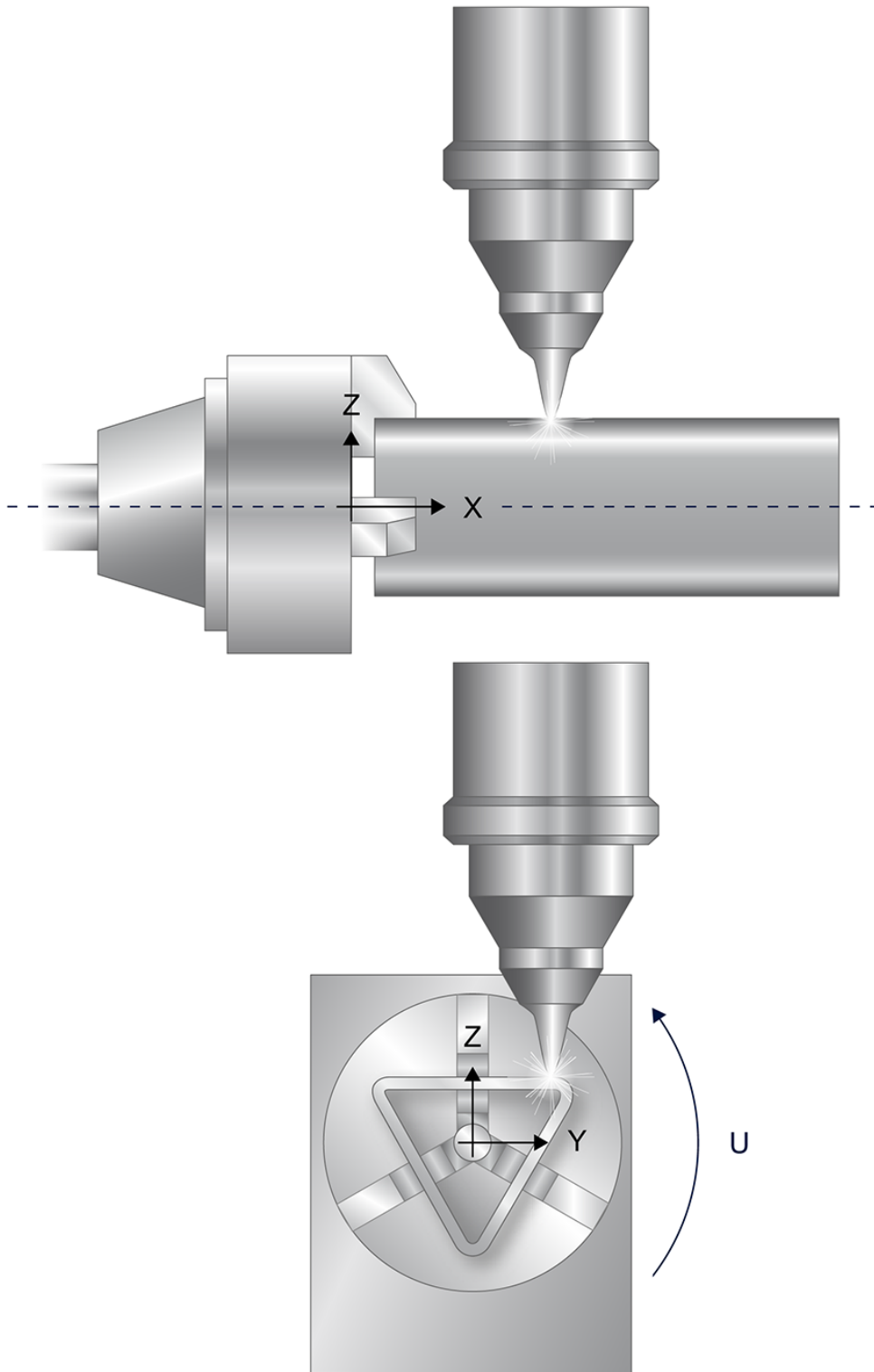


Fig. 33: Axis structure

Parameterisation: [Polygonal tube, profiled tube \(kinematic ID 79\)](#) [[▶ 120](#)]

3.3.3.3 Profile rounding, technology and dynamics during feed motion

Machining on profile roundings

In comparison to straight sections, there may be deviations in material characteristics (e.g. wall thickness) in the area of the profile roundings. When the limits to the profile roundings are crossed, this can be signalled by M/H functions. As a result, the process can be influenced by the PLC. The M/H functions are always of the MOS type (M functions without synchronisation).

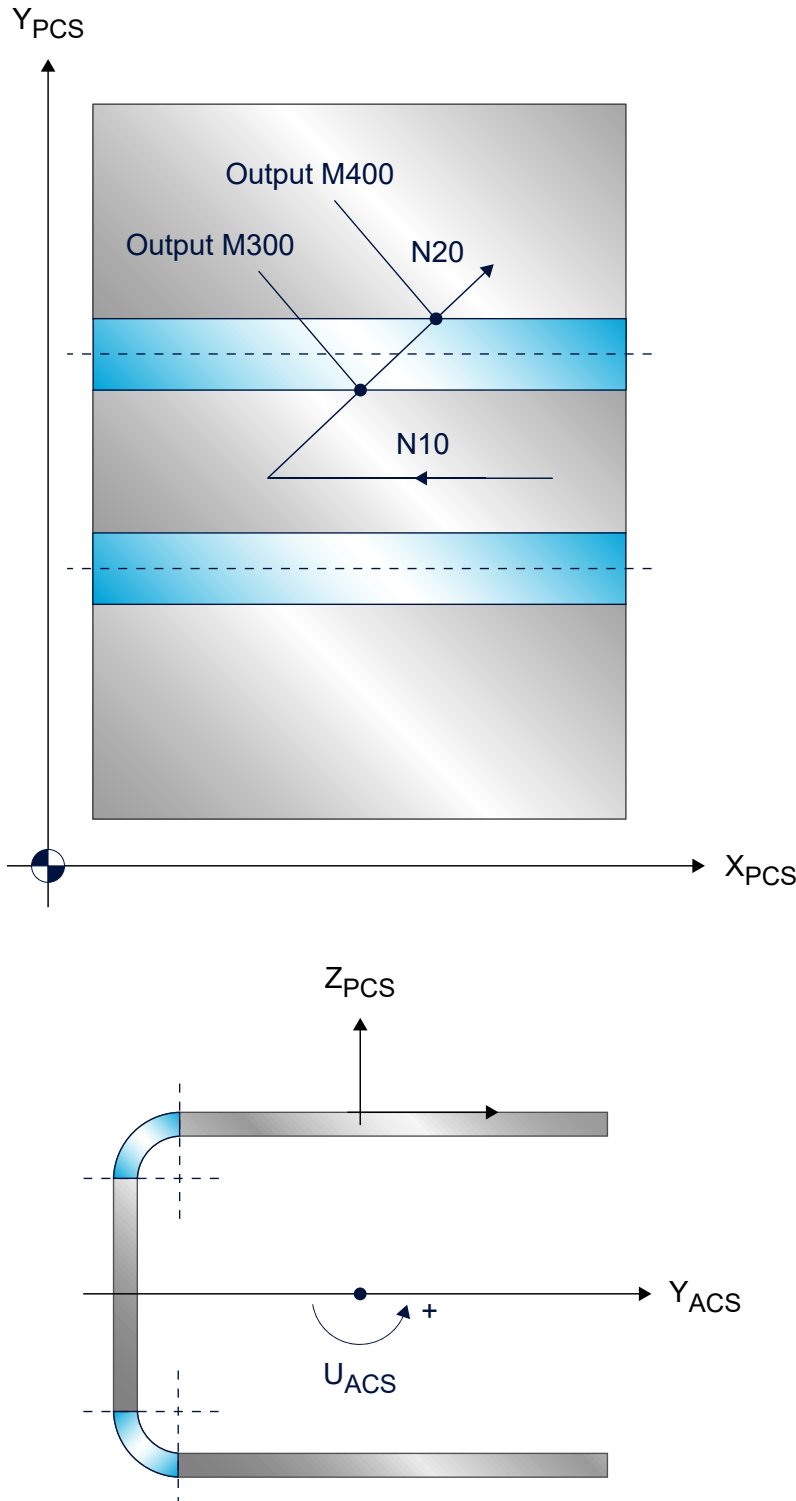


Fig. 34: Output of a technology function at a profile rounding

Dynamics in the profile rounding

At the transition points of the profile roundings, the CNC may possibly reduce the feed rate due to the acceleration of other axes depending on the parameterised axis dynamics of the participating axes.

The dynamics on the profile rounding can be influenced by parameters in the NC command #CYL[...]. In addition to the normal path velocity and acceleration limit (cf. #VECTOR LIMIT[VEL ACC]), the values from the #CYL[...] command are also considered in the profile rounding.

Machining on profile roundings

```
#CYL[EDGES=4 ROUNDING=5 LENGTH1=50 LENGTH2=50
      ACC=500000 VEL=1000]
```

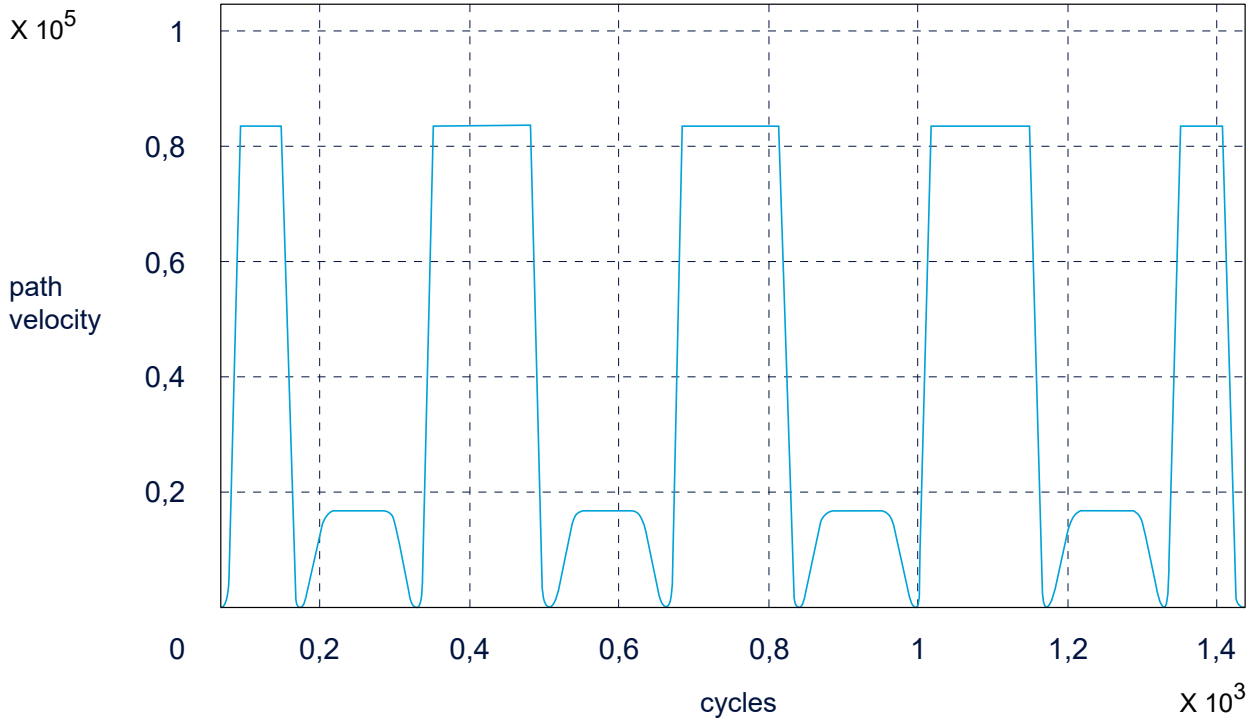


Fig. 35: Path dynamics adjustment on profile rounding

3.3.3.4 Path example

Polygonal tube transformation

```
(* Polygonal tube transformation *)

%L SUB_CONT
N[10+P30] G00 G90 X0 Z100 U0
N[20+P30] G162
P1=5 (* Radius inner circle *)
P2=25 (* Radius outer circle *)
P3=22.5
P4=2*P3
$FOR P10=0, 8, 1
    P6=P10*P4
    P7=SIN[P6]
    P8=COS[P6]
N[40+P10] G01 X[P2*P8] U[P2*P7] F5000
    P20=SIN[P3 + P6]
    P21=COS[P3 + P6]
N[50+P10] G01 X[P1*P21] U[P1*P20] F5000
$ENDFOR
M29
%t_tube_prof.nc
N10 #SLOPE [TYPE=STEP]
N20 G00 X0 Y0 Z100 U0

N70 #CYL[EDGES=4 ROUNDING=5 LENGTH1=20 LENGTH2=20]
(* Profile circumference approx. 111.41592653589793 mm *)

P30=2000
N35 G92 X30 U30
N40 LL SUB_CONT
N45 G92 X-30 U30
N50 LL SUB_CONT
N60 G92 X30 U-[-30]
N70 LL SUB_CONT
N80 G92 X-30 U-[-30]
N90 LL SUB_CONT
N100 G92 X0 U0

N110 #CYL OFF
M30
```

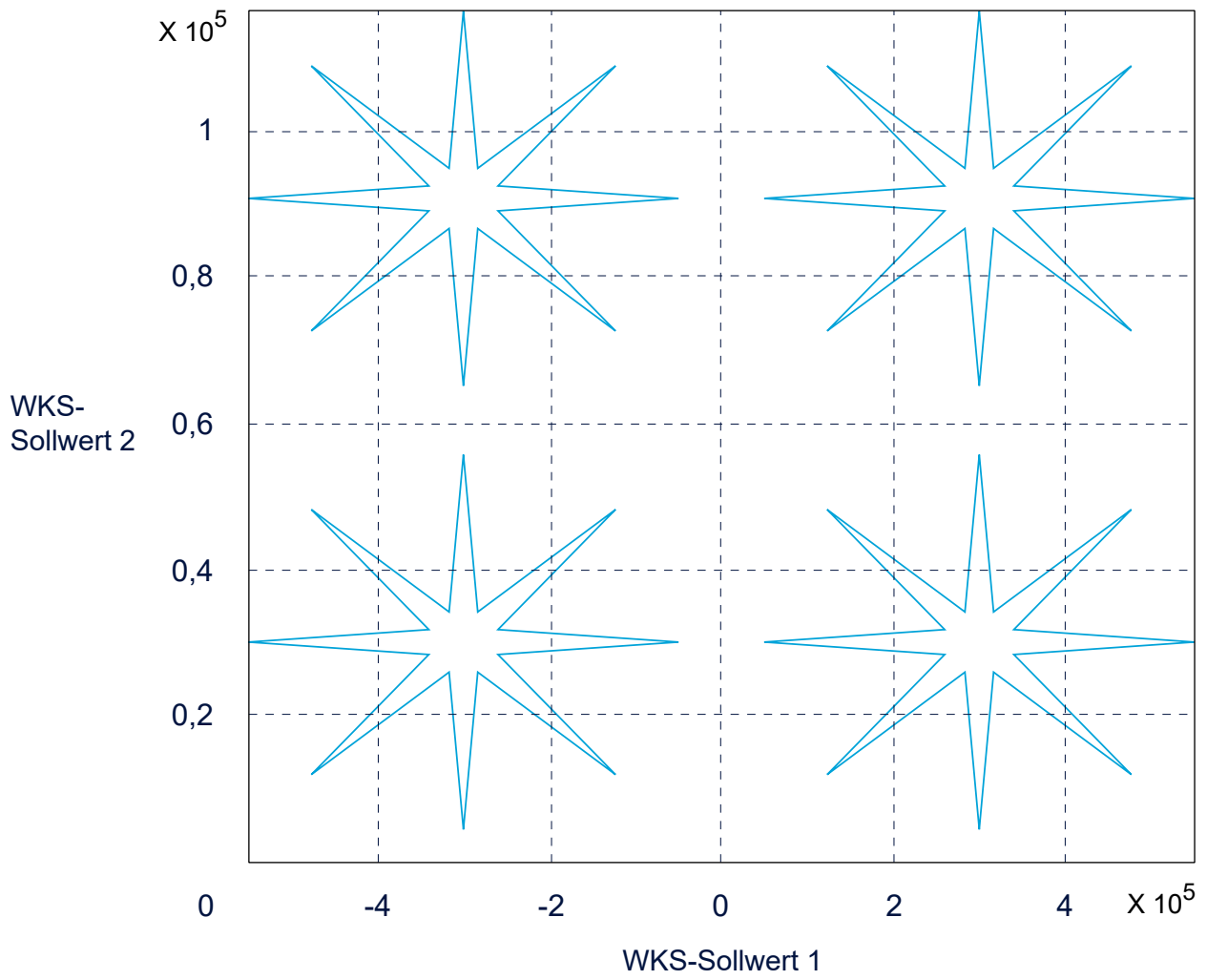


Fig. 36: X-U contour line projection

3.3.4 Open polygonal tube / profiled tube (L/U profiles)



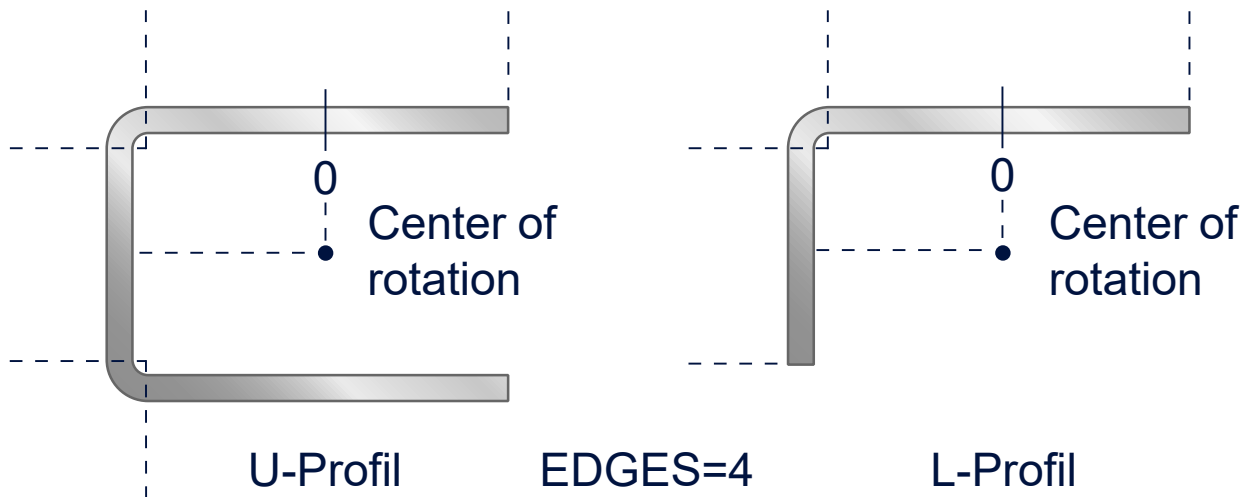
This function is available as of CNC Build
V2.11.2807.01 .

Characteristics

An extension of the definition permits the machining of **non-closed** profiles. An open profiled tube (L/U tube) is detected as a limited lateral surface.

There is no limitation of the path motion or modulo calculation of the PCS coordinate when "virtual edges" are crossed. For this reason, the coordinate system on a lateral surface is linear (see also linear coordinate system for round tube machining). Starting from the zero point, the lateral surface is divided into a positive and a negative direction.

Programming is always related to the closed edges of the tube profile. This means that it is possible to cross virtual edges when profile transformation is active but there is no rotation of the workpiece or Z height adjustment.



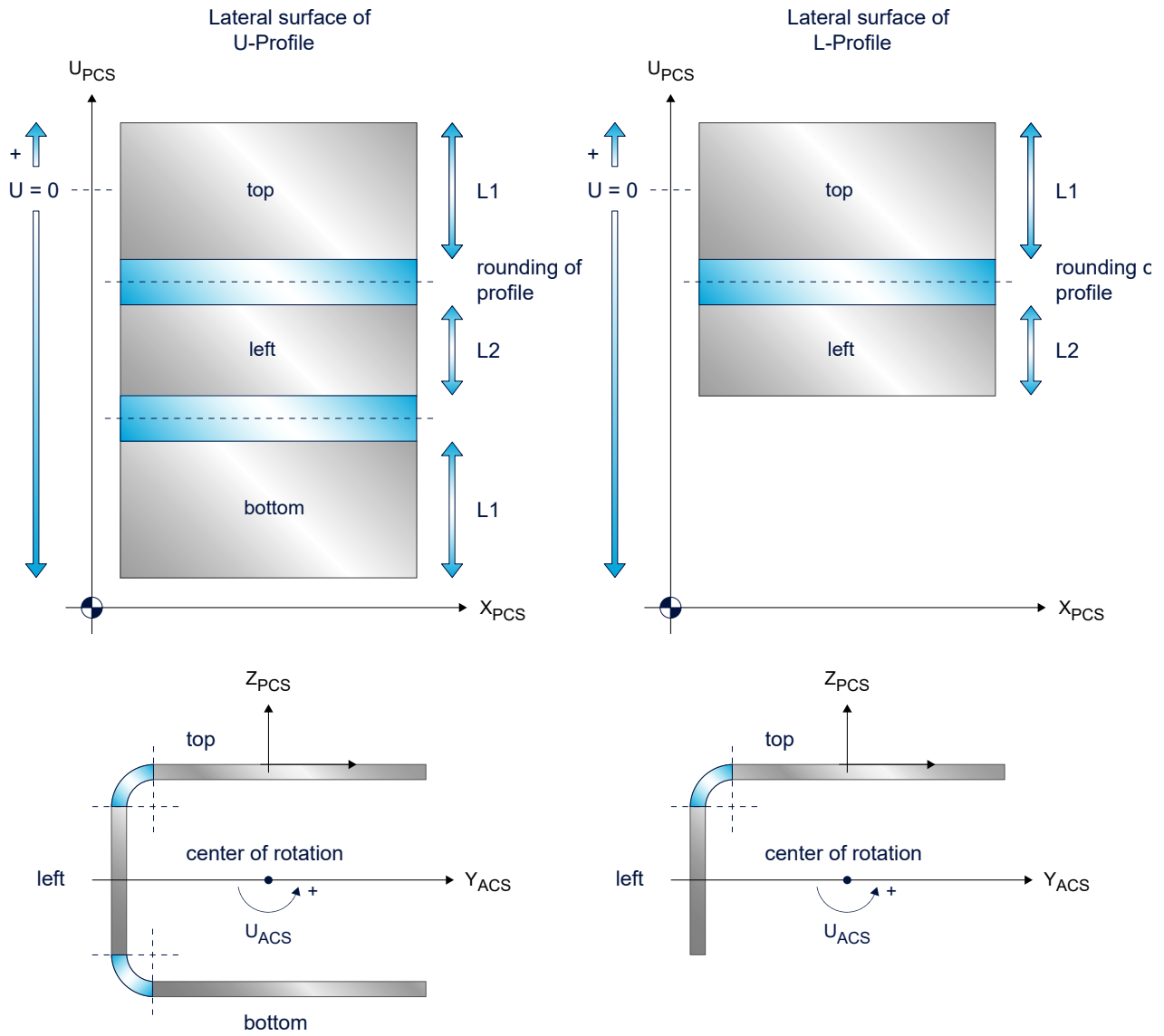


Fig. 37: Examples of open profiles, U and L profile

Clamping examples of open rectangular profiles:

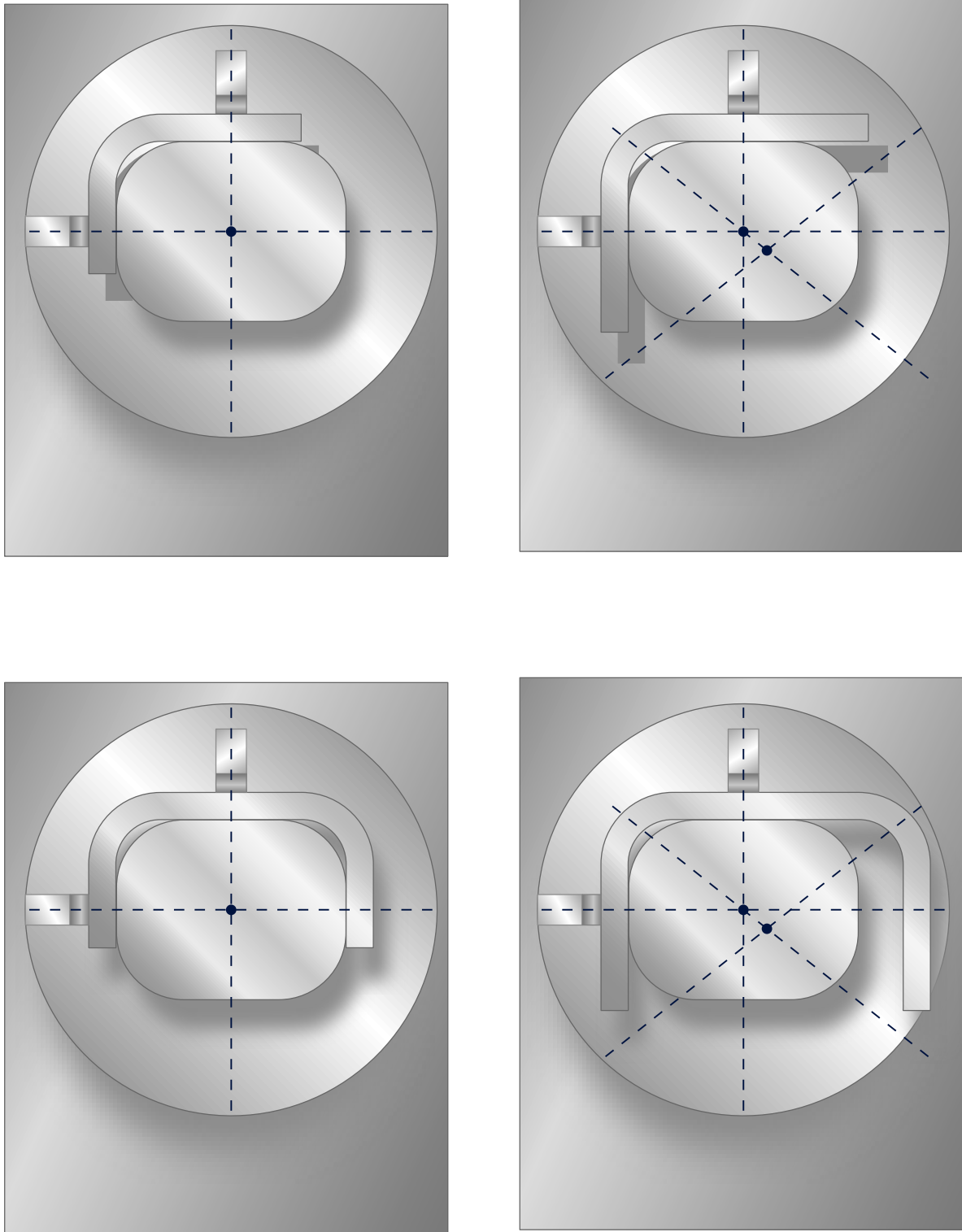


Fig. 38: Clamping examples

3.3.4.1 Programming #CYL [EDGES.. OPEN..]

Open edges

This extension permits the user to define 2 edges between which the profile is opened.

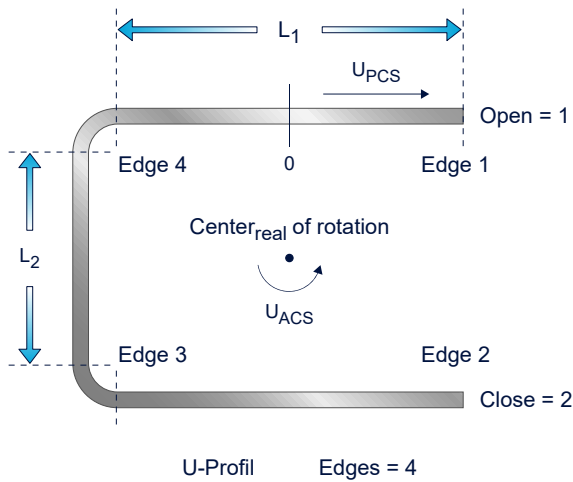


Fig. 39: Defining an open U profile specifying the open edges



The kinematic parameters in [ID 79](#) | [120](#) must be set for this machining type.

Syntax to select open profiled tube machining:

Syntax:

```
#CYL [ EDGES=.. ROUNDING=.. LENGTH1=.. [LENGTH2=.. ] modal
      [ OPEN=.. CLOSE=.. ] ]
```

EDGES=..	Number of edges (corners) of the closed profiled tube, positive integer. The number of profile edges is limited to minimum 3 and maximum 16.
ROUNDING=..	Edge rounding radius (corner radius), [mm, inch].
LENGTH1=..	Side length for symmetrical tubes or first side length for rectangular tubes, [mm, inch]
LENGTH2=..	Second side length for rectangular tubes, [mm, inch]
OPEN=..	Number of the edge [1; <EDGES>] where the workpiece is open. Ascending number in lateral surface projection (positive U_{PCS} direction).
CLOSE=..	Number of the edge [1; <EDGES>] where the workpiece closes again (positive U_{PCS} direction).

Syntax to deselect open profiled tube machining:

Syntax:

#CYL OFF

modal

Programming #CYL [EDGES.. OPEN..]

```
...
N3 U0 X0
N4 #CYL [EDGES=4 ROUNDING=5 LENGTH1=60 LENGTH2=45 OPEN=1 CLOSE=2]
N5 G01 G91 X10 F5000
```

i To determine the edge numbers for 'OPEN' and 'CLOSE', start with '1 PCS' in the positive PCS direction (clockwise, CW) from 'OPEN' to 'CLOSE' across the profile. This ensures that all profiled parts between 'OPEN' and 'CLOSE' are in the open range.

OPEN=1 / CLOSE=2: -> U open right

OPEN=3 / CLOSE=4 -> U open left

OPEN=1 / CLOSE=3: -> L open right

OPEN=2 / CLOSE=4: -> L open left

NOTICE

It is only possible to select profile machining if a closed profile edge is orientated towards the tool when the rotating axis is in zero position.

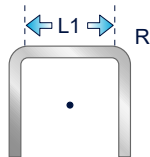
For example the following command is not permitted:

```
#CYL [EDGES=4 ROUNDING=5 LENGTH1=60 OPEN=4 CLOSE=1]
```

i If it is necessary to cross an open profile edge to the adjacent surface (e.g. if the path to the new target position is shorter), deselect the profile transformation (#CYL OFF) or possibly retract the tool, reposition the rotating axis and repeat selection of the profile transformation with #CYL [EDGES...].

Examples of open profiles

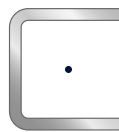
```
#CYL[EDGES=4 ROUNDING=5 LENGTH1=50]
```



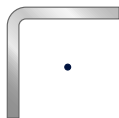
OPEN=2 CLOSE=3



OPEN=3 CLOSE=4



OPEN=1 CLOSE=2



OPEN=1 CLOSE=3



OPEN=2 CLOSE=4

#CYL[EDGES=5 ROUNDING=5 LENGTH1=40]

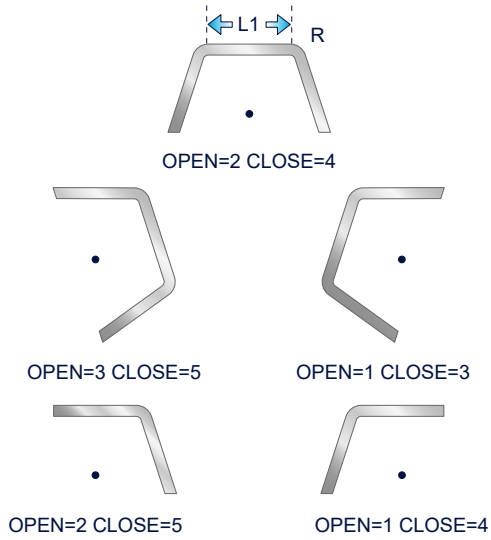


Fig. 40: Examples of programming parameters for open profiles

Profile transformation of square profile

```
(* Polygonal tube transformation, square tube, segmentation at circumference, *)
(* Absolute programming *)
(* Open profile *)

%L SUB_CONT
N[10+P30] G00 G90 X0 Z100 U0
N[20+P30] G162
P1=20 (* inner circle radius *)
P2=50 (* outer circle radius *)
P3=22.5
P4=2*P3
G261
$FOR P10=0, 8, 1
    P6=P10*P4
    P7=SIN[P6]
    P8=COS[P6]
N[40+P10] G01 X[P2*P8] U[P2*P7] F5000
    P20=SIN[P3 + P6]
    P21=COS[P3 + P6]
N[50+P10] G01 X[P1*P21] U[P1*P20] F5000
$ENDFOR
G260
M29

%prof_open_close.nc
N10 #SLOPE [TYPE=STEP]
N20 G00 X0 Y0 Z100 U0
N25 #CONTOUR MODE[DEV PATH_DEV 2]
N65 G00 G90 Y0 U0
N70 #CYL[EDGES=4 ROUNDING=5 LENGTH1=20 LENGTH2=20 OPEN=2 CLOSE=3]
P30=2000
N80 LL SUB_CONT
N90 #CYL OFF
M30
```

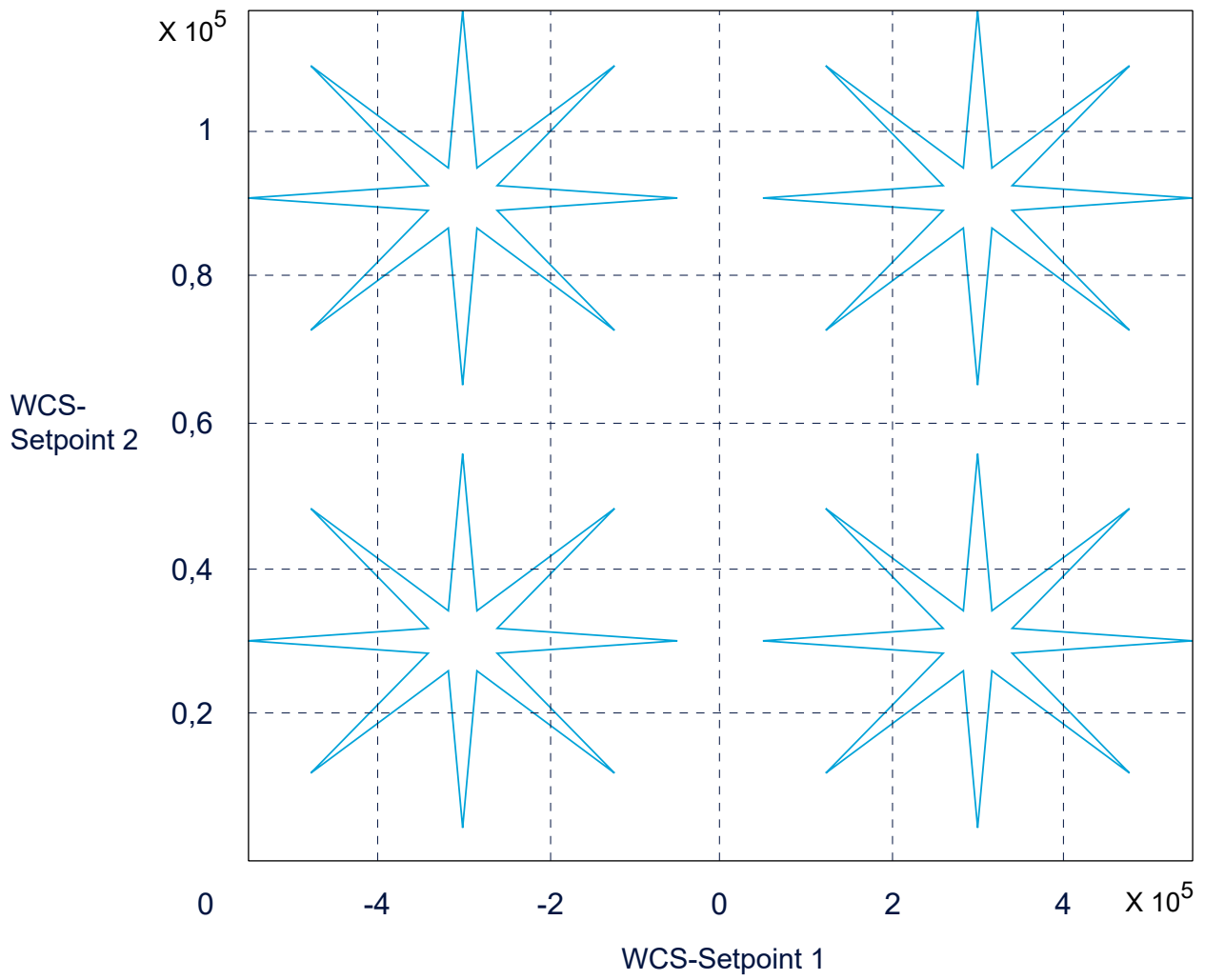


Fig. 41: X-U flat projection of geometry

3.3.4.2 Eccentric rotation centre point

Open edges

When the workpiece is not clamped centrally, it results in an offset between the workpiece centre point and the rotation centre. This offset can be additionally specified when it is selected.

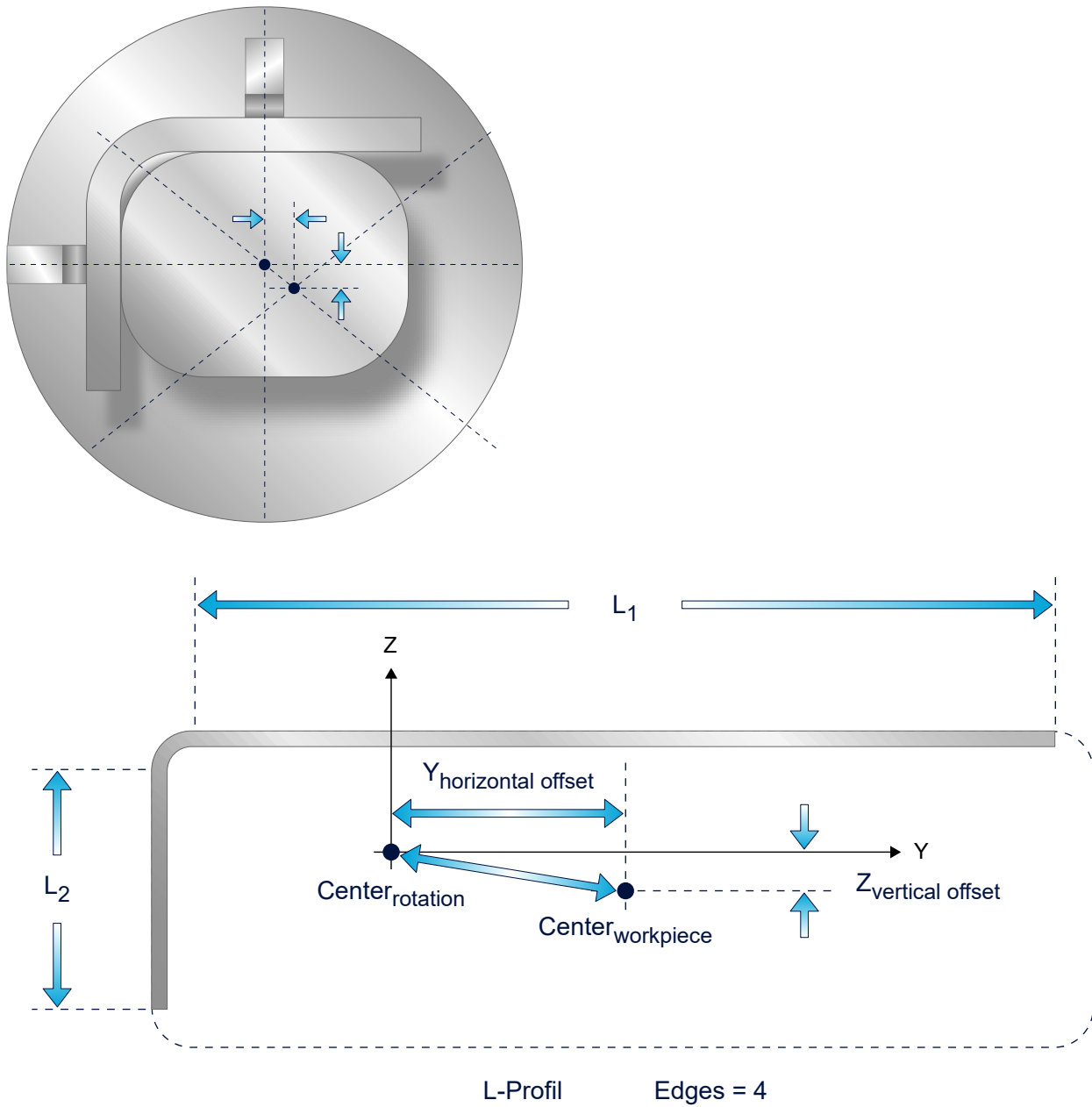


Fig. 42: Defining an open L profile with rotation centre point offset

Syntax to select open profiled tube machining with offset of rotation centre point:

```
#CYL [ EDGES=.. ... CLOSE=.. [ HOR_OFFSET=.. VERT_OFFSET=.. ] ]
```

- EDGES=.. ... Syntax of profile description
- CLOSE=..
- HOR_OFFSET=.. Offset of the workpiece centre point in horizontal direction (Y here) towards the actual rotation centre point in [mm, inch].
- VERT_OFFSET=.. Offset of the workpiece centre point in vertical direction (Y here) towards the actual rotation centre point in [mm, inch].

3.3.4.3 Axis configuration

The kinematic structure consists of 3 translatory axes in the tool and one rotary axis in the workpiece.

The following axis configuration must be set in the NC channel.

Axis configuration in the NC channel		
Axis identifier	X, Y, Z, U	
Axis index	0, 1, 2, 3	
Kinematic structure (ID 79)		
	Tool axes	Workpiece axes
NC axes	X, Y, Z	U

Parameterisation: [Polygonal tube, profiled tube \(kinematic ID 79\) \[▶ 120\]](#)

3.4 Machining variants (5/6-axis)

A distinction is made between 2 different machining variants:

- [Round tube, lateral surface \[▶ 81\]](#)
- [Polygonal tube, profiled tube \[▶ 111\]](#)

3.4.1 Round tube, lateral surface

3.4.1.1 6-axis, 2 orientation axes in the tool head available



This function is available as of CNC Build V2.11.2019.00.

Combined machining of plate/round tube

The kinematics here consist of 6 axes and are intended for use on machine tools which have an optional tube axis in addition to the 5 axes of a classic plate machining machine.

The machining orientation is defined by the 2 rotation axes in the tool. To machine the tube, the TCP (tool centre point) and the X/Y axis remain positioned above the tube rotation axis. The X/Y position of the TCP remains at the top point of the tube during machining. The contour is programmed on the lateral surface by the axes U, Y and X, V. Orientation is programmed dependent on the axis structure present in the tool head:

- With the structure with machine angle A-B or B-A directly with the assigned angle values, or with the virtual angles C and A.

- With the head structure CA, CB, the programmings takes place directly using the angle values CA, CB. In these cases (virtual or real C axis) the bevel angle can be kept constant to the contour using the function "tangential tracking".

Set one of the following 6-axis configurations. Depending on the machine configuration, the tube axis lies parallel to the X or Y machine axis. This is controlled by the command **#CYL ORI LATERAL[.].**

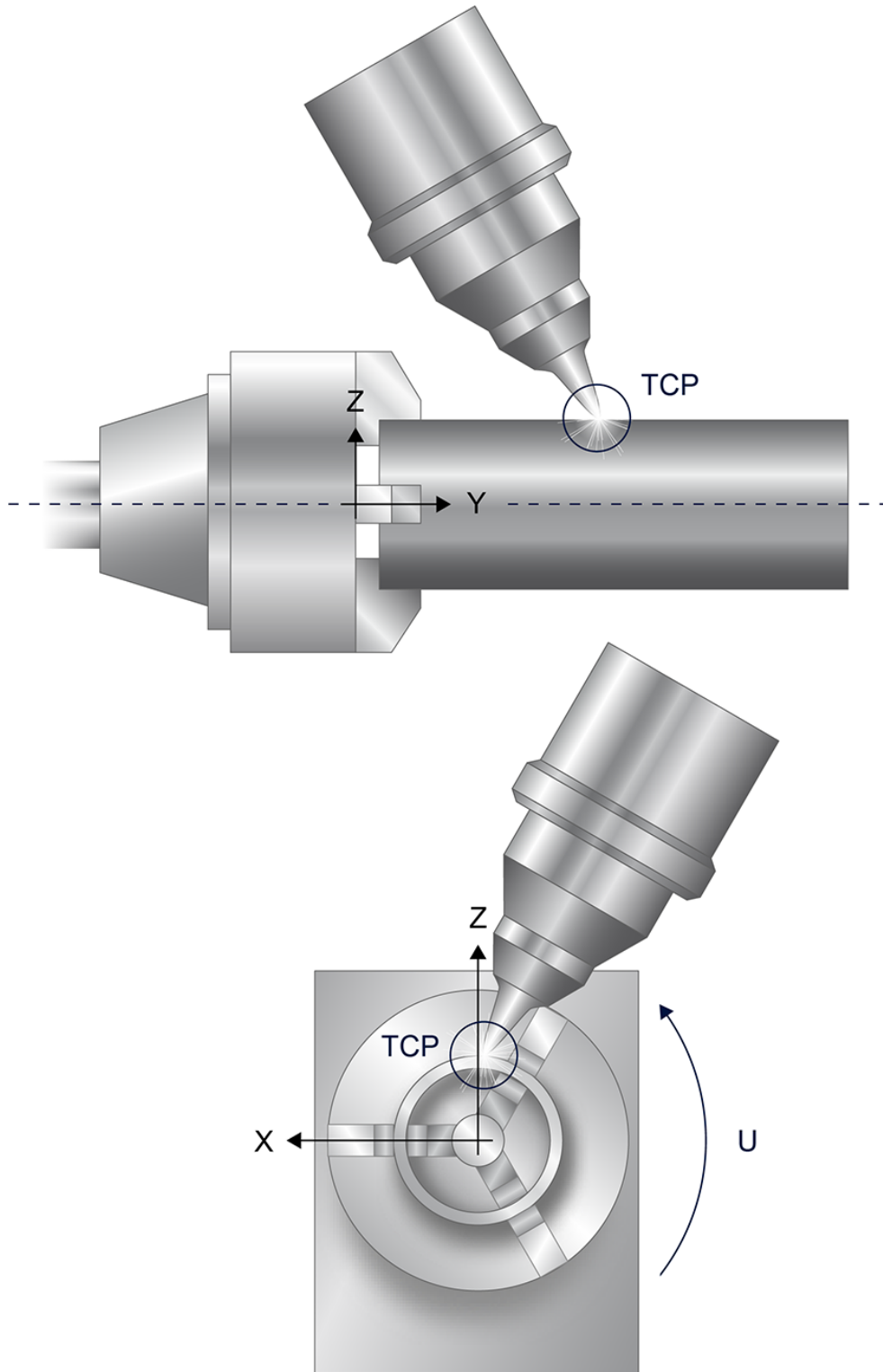


Fig. 43: TCP rotates about the tube centre axis, tube top point

3.4.1.1.1 Tube machining with AB orientation head

Axis configuration in the NC channel		
Axis identifier	X, Y, Z, A/(C), B/(A), U/V	
Axis index	0, 1, 2, 3, 4, 5	
Kinematic structure (ID 90)		
	Tool axes	Workpiece axes
NC axes	X, Y, Z, A/(C), B/(A)	U/V

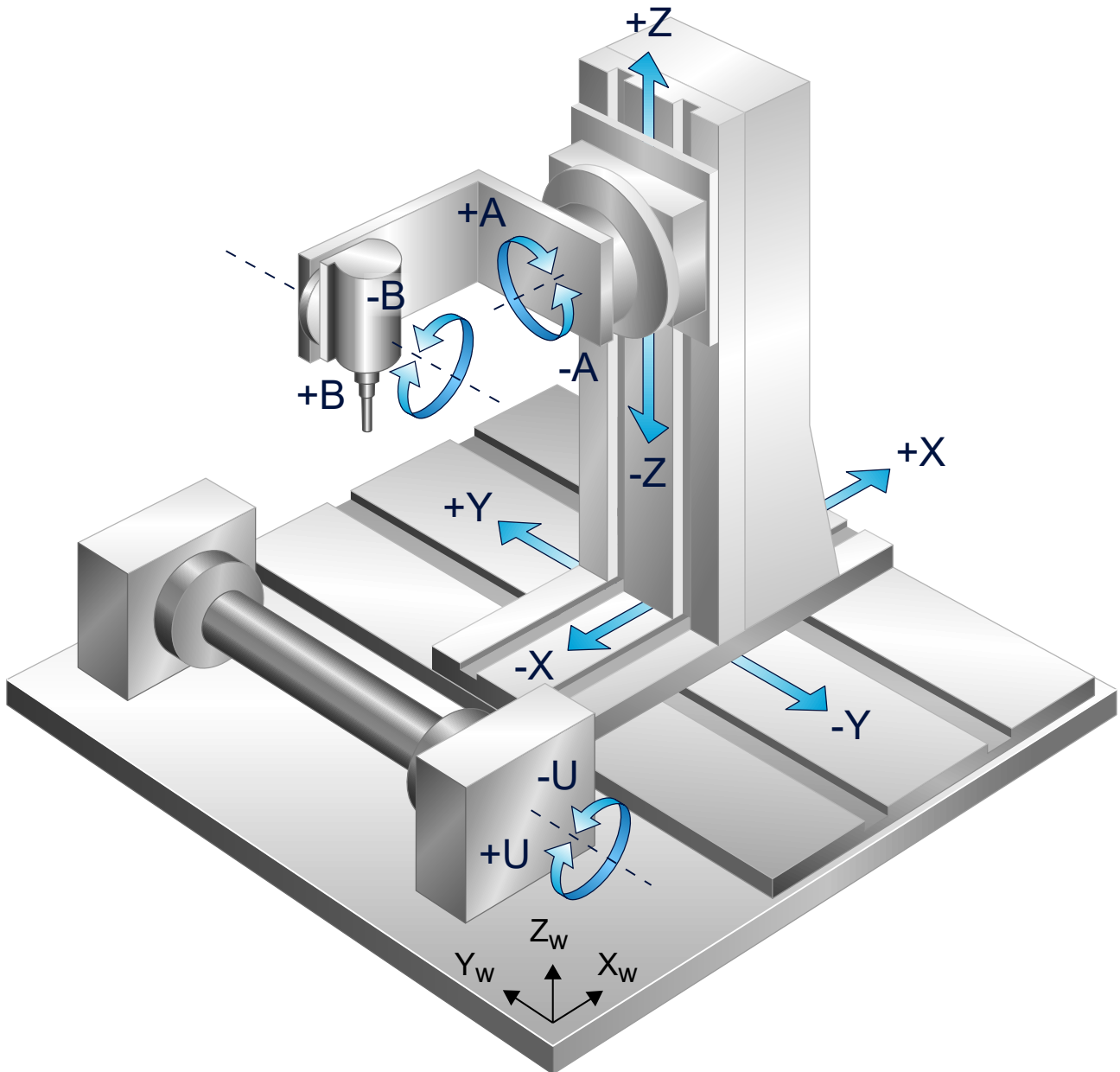


Fig. 44: Lateral surface machining with tube axis parallel to Y

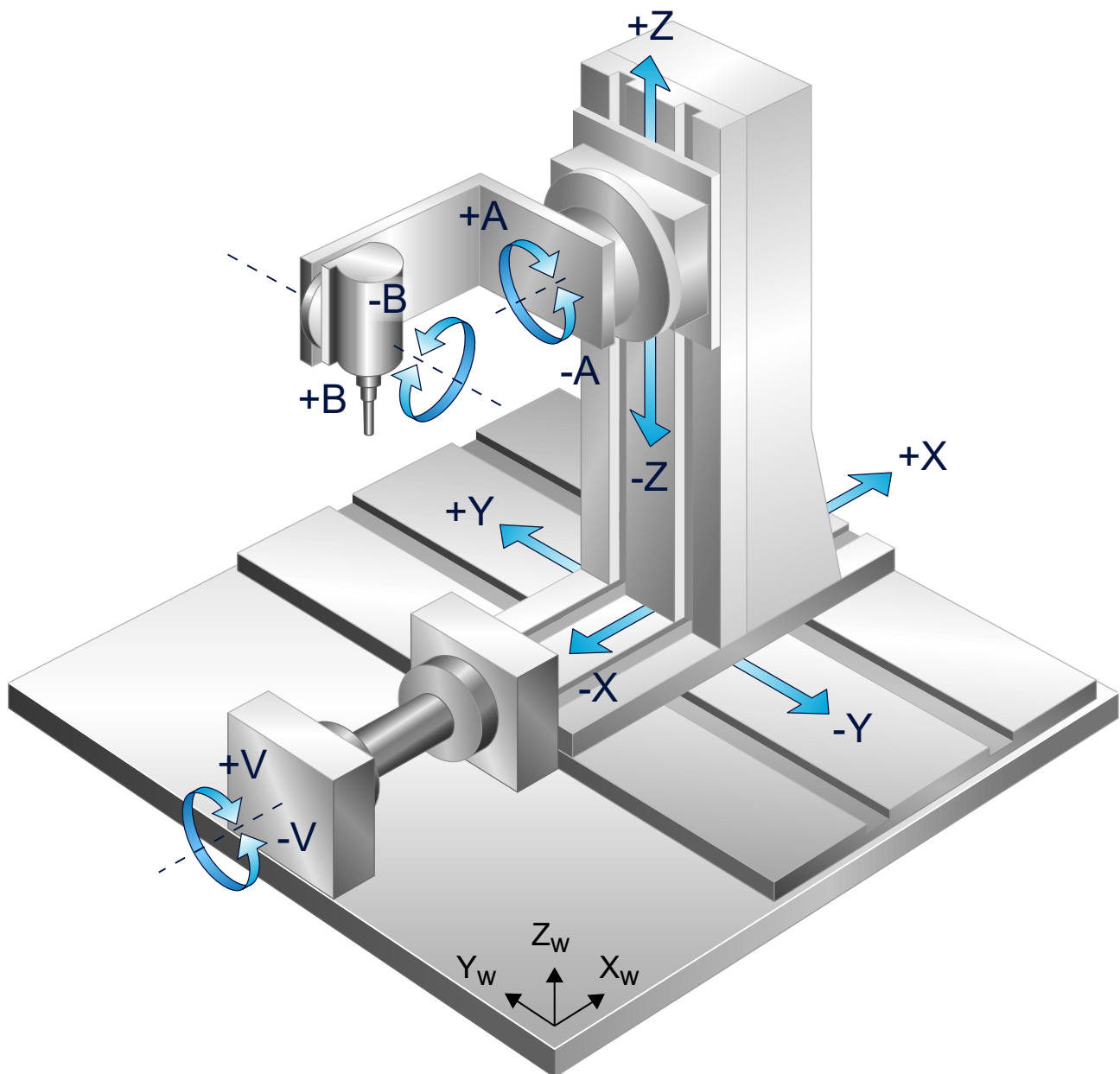


Fig. 45: Lateral surface machining with tube axis parallel to X

Parameterisation: [Parameters for AB orientation head](#) [▶ 125]

3.4.1.1.2 Tube machining with BA orientation head

Axis configuration in the NC channel		
Axis identifier	X, Y, Z, B/(C), A/(A), U/V	
Axis index	0, 1, 2, 3, 4, 5	
Kinematic structure (ID 90)		
	Tool axes	Workpiece axes
NC axes	X, Y, Z, B/(C), A/(A)	U/V

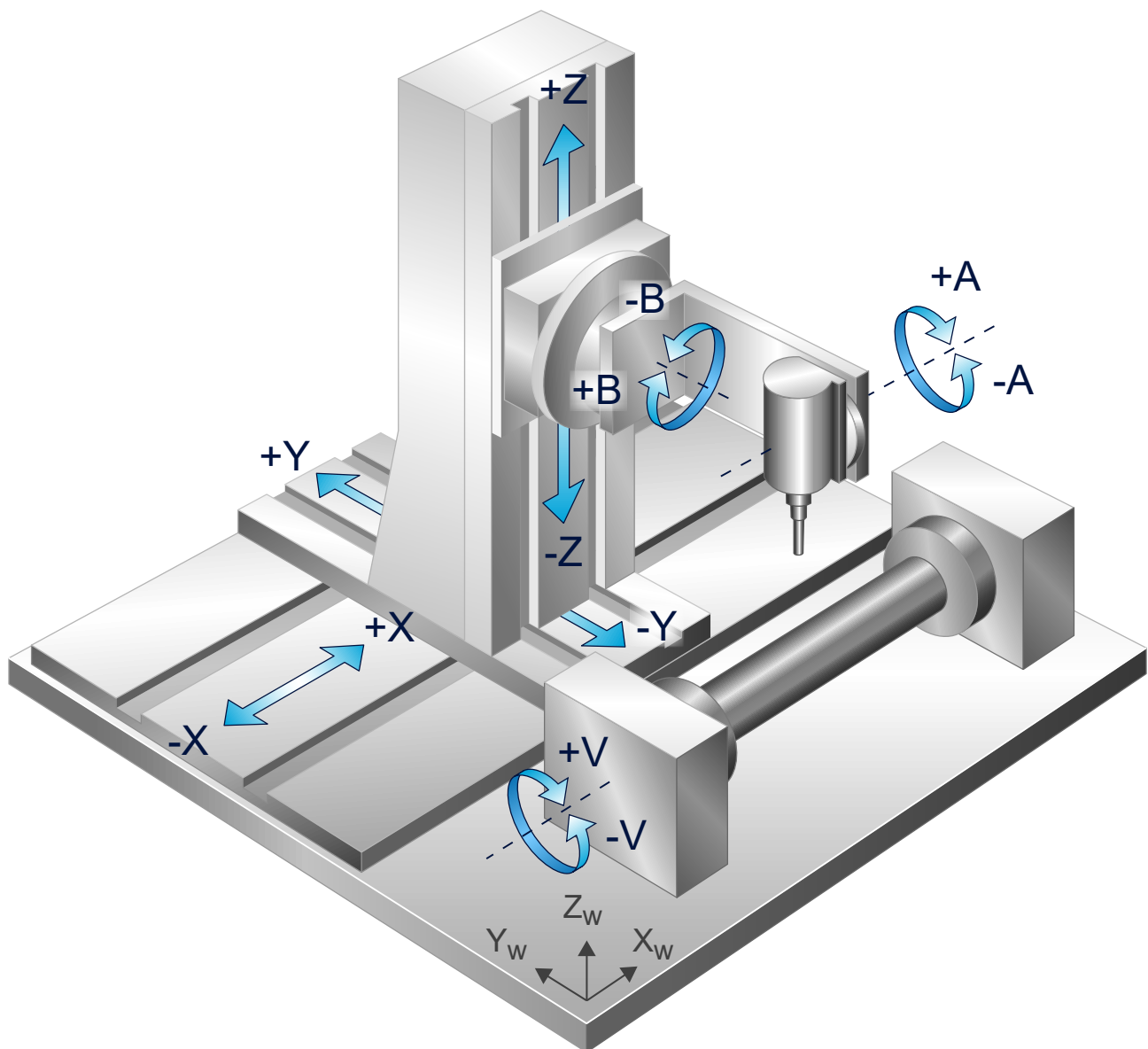


Fig. 46: Lateral surface machining with tube axis parallel to X

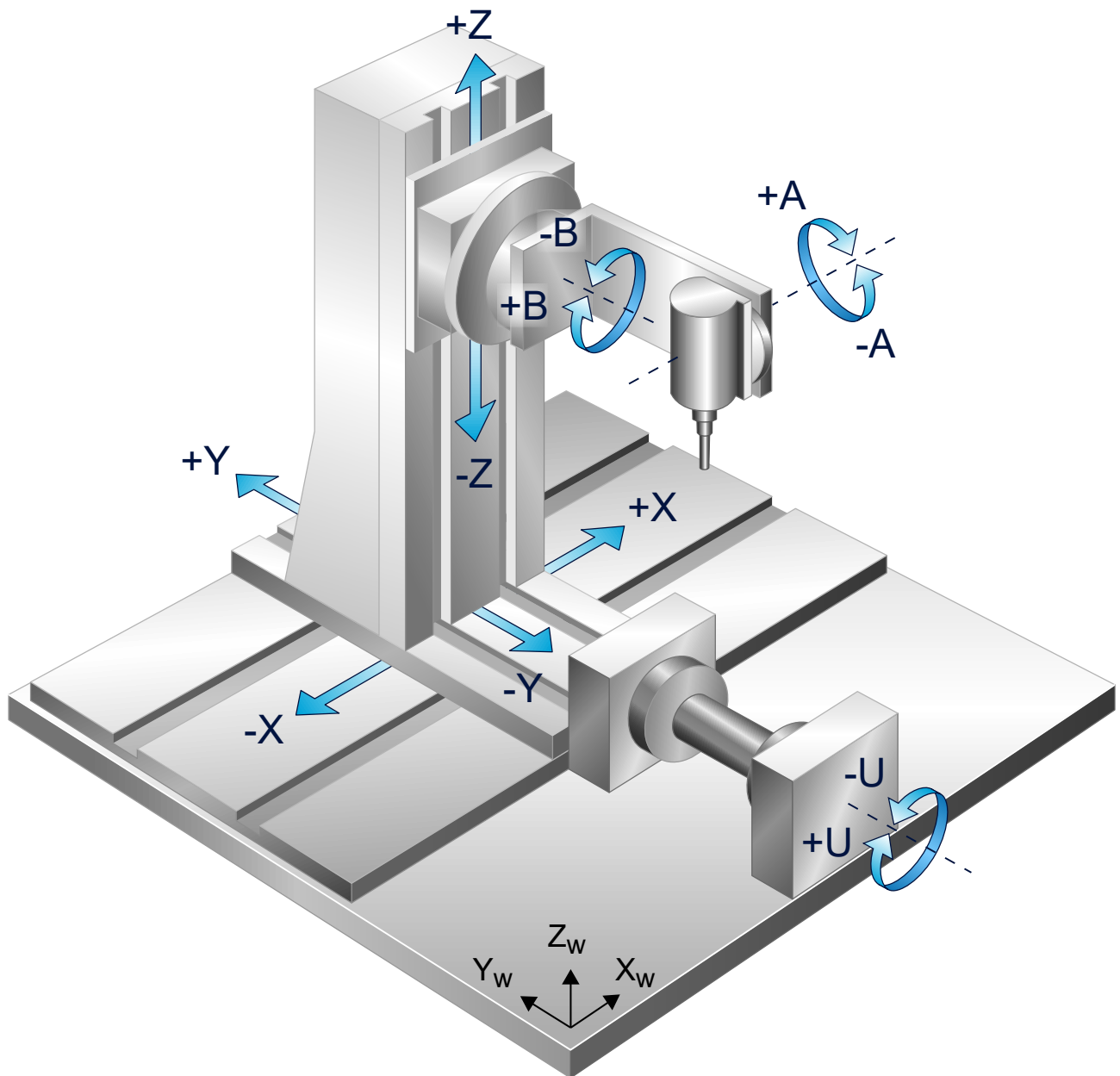


Fig. 47: Lateral surface machining with tube axis parallel to Y

Parameterisation: [Parameters for BA orientation head | 127](#)

3.4.1.1.3 Tube machining with CA orientation head

Axis configuration in the NC channel		
Axis identifier	X, Y, Z, C, A, U/V	
Axis index	0, 1, 2, 3, 4, 5	
Kinematic structure (ID 90)		
	Tool axes	Workpiece axes
NC axes	X, Y, Z, C, A	U/V

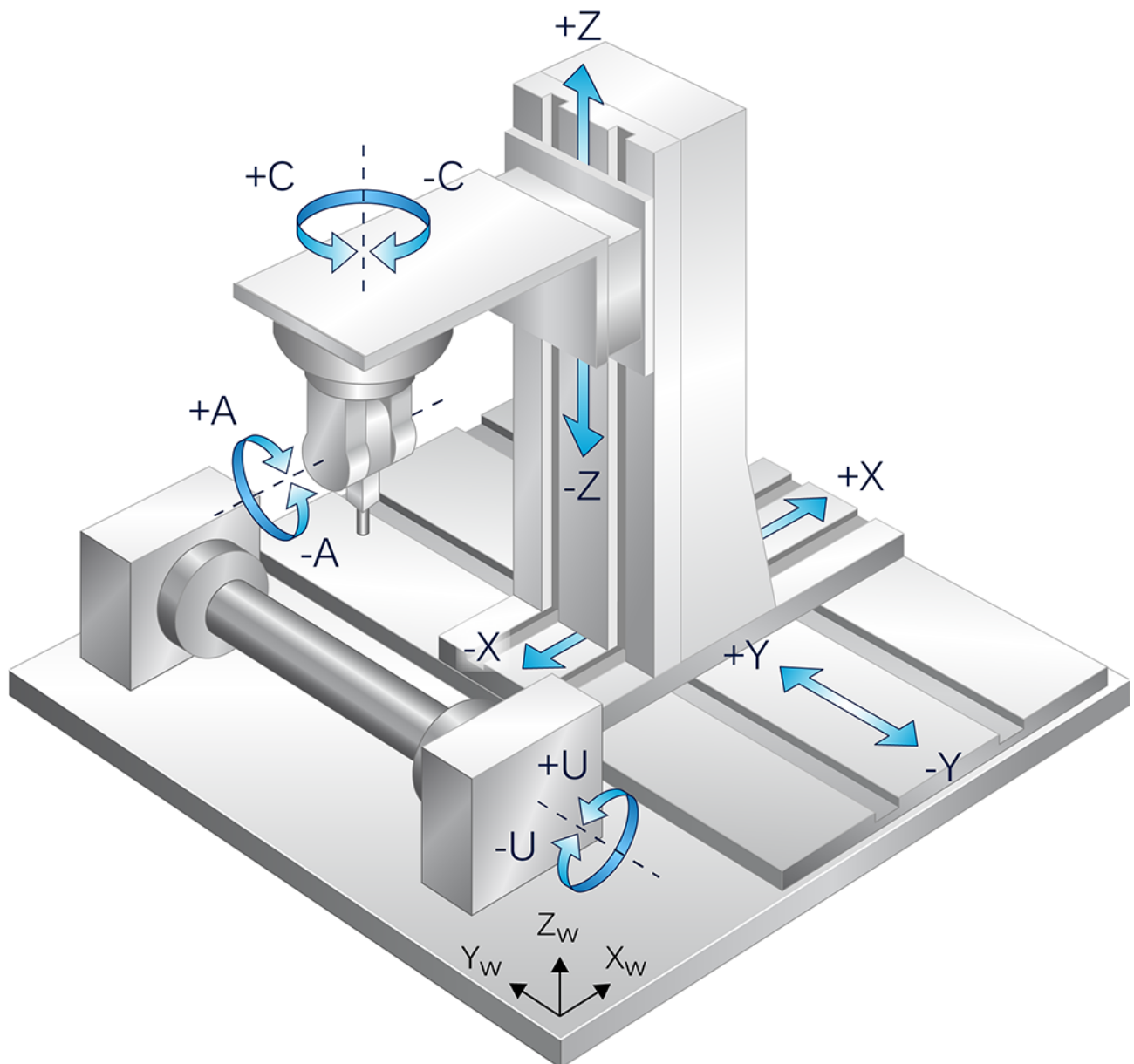


Fig. 48: Lateral surface machining with tube axis parallel to Y

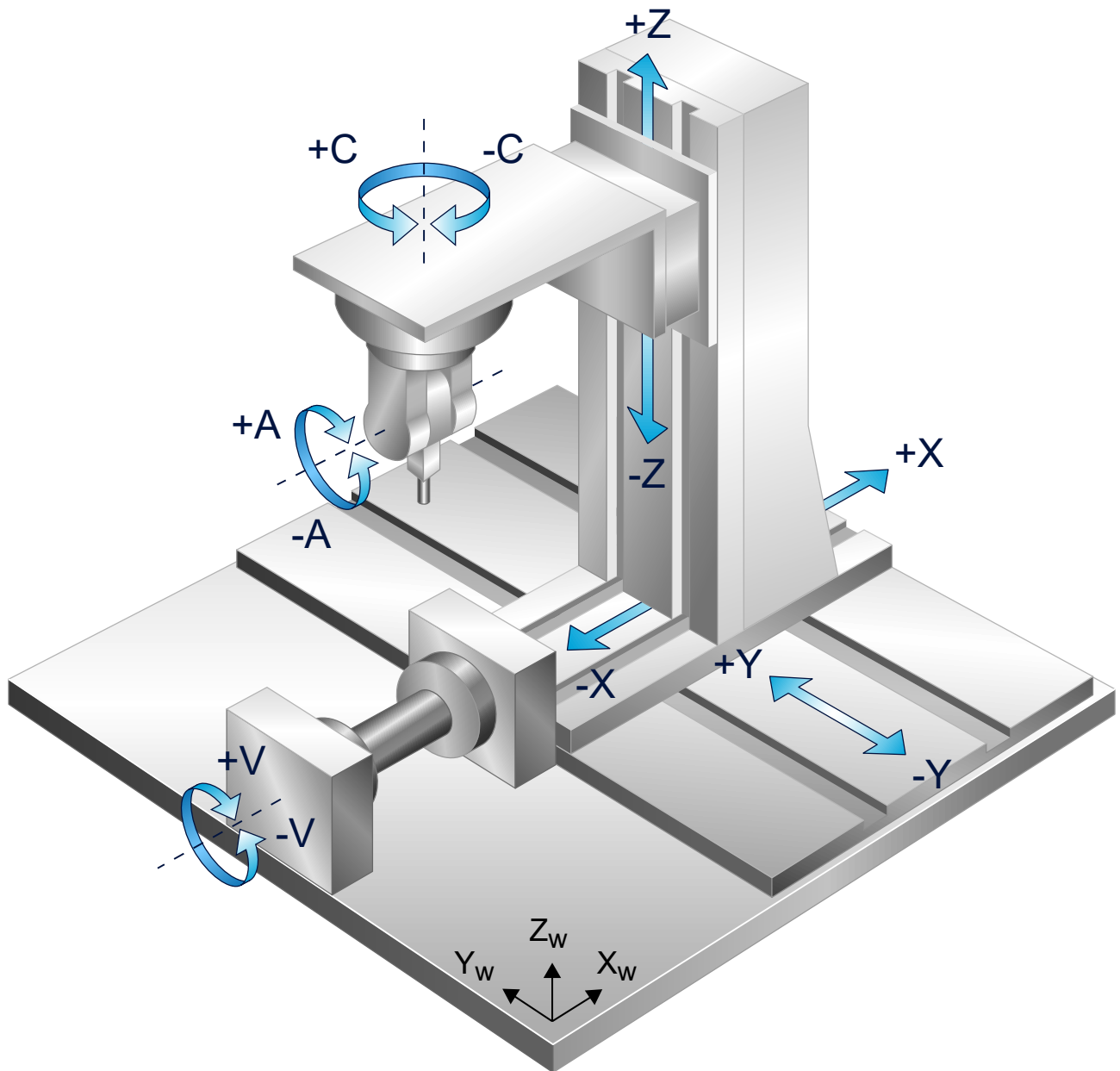


Fig. 49: Lateral surface machining with tube axis parallel to X

Parameterisation: [Parameters for CA orientation head \[► 129\]](#)

3.4.1.1.4 Tube machining with CB orientation head

Axis configuration in the NC channel		
Axis identifier	X, Y, Z, C, B, U/V	
Axis index	0, 1, 2, 3, 4, 5	
Kinematic structure (ID 90)		
	Tool axes	Workpiece axes
NC axes	X, Y, Z, C, B	U/V

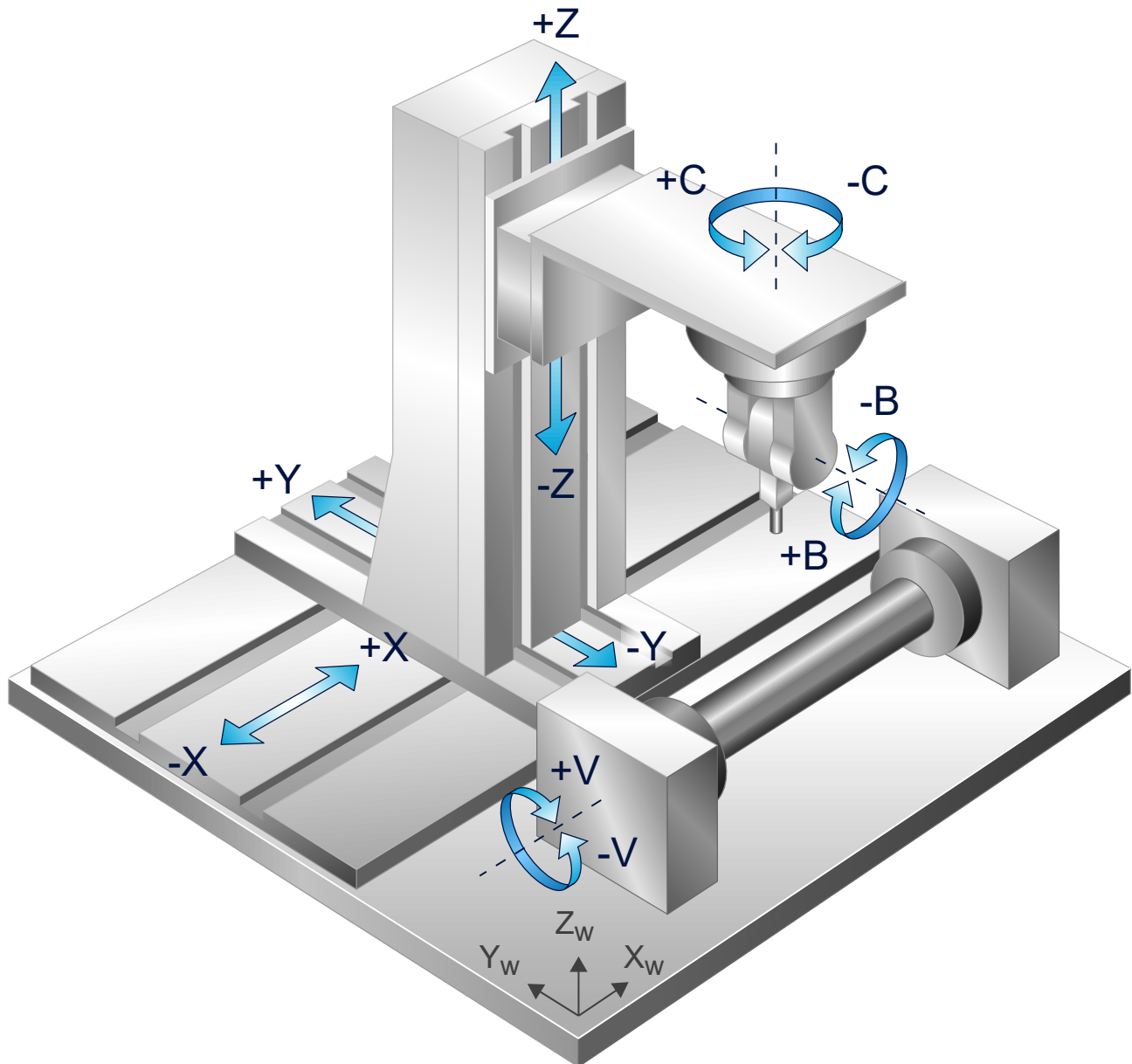


Fig. 50: Lateral surface machining with tube axis parallel to X

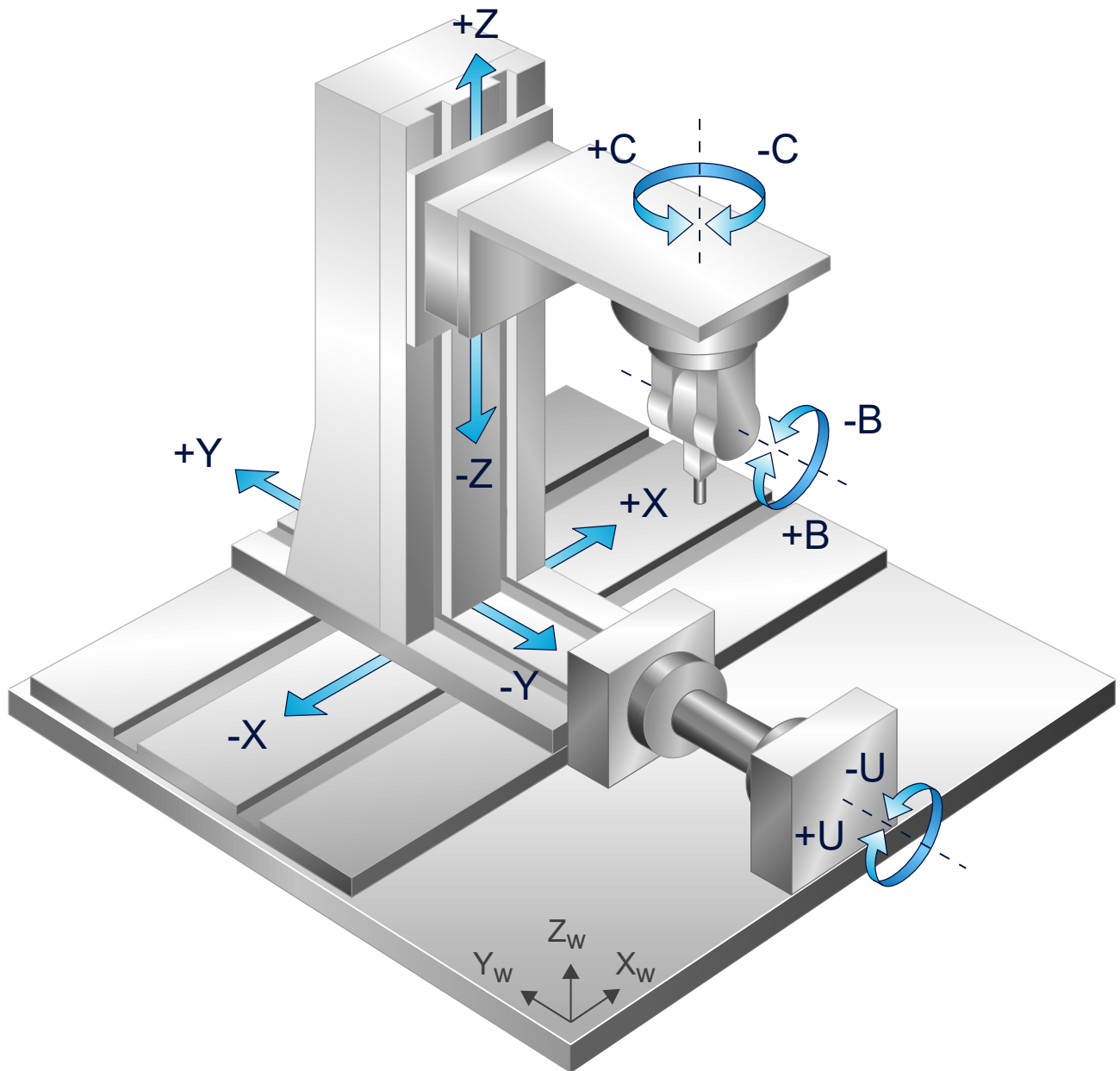


Fig. 51: Lateral surface machining with tube axis parallel to Y

Parameterisation: [Parameters for CB orientation head](#) | 1311

3.4.1.1.5 Tube machining with CA cardanic orientation head

Axis configuration in the NC channel		
Axis identifier	X, Y, Z, C, A, U/V	
Axis index	0, 1, 2, 3, 4, 5	
Kinematic structure (ID 90)		
	Tool axes	Workpiece axes
NC axes	X, Y, Z, C, A	U/V

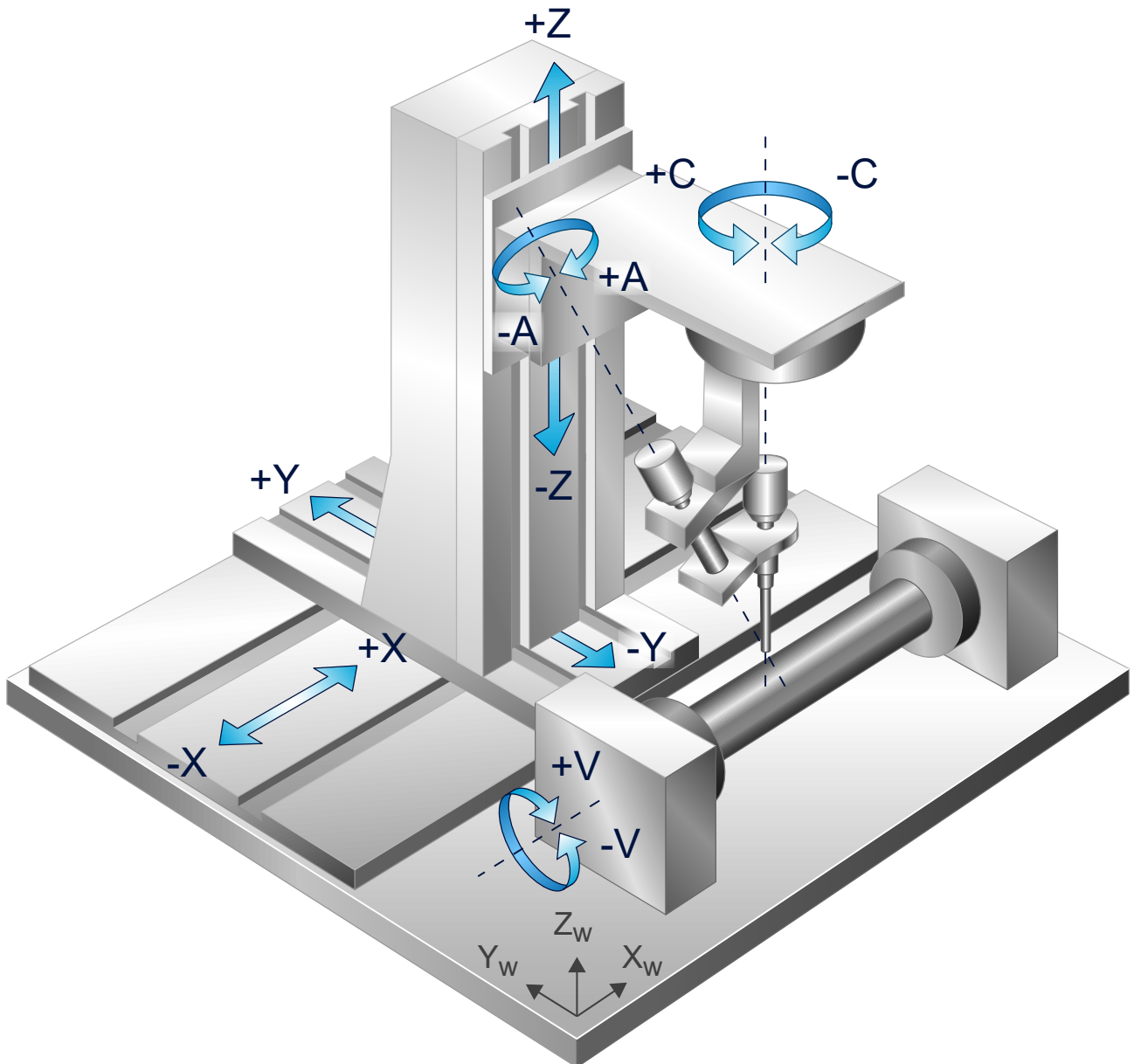


Fig. 52: Lateral surface machining with tube axis parallel to X

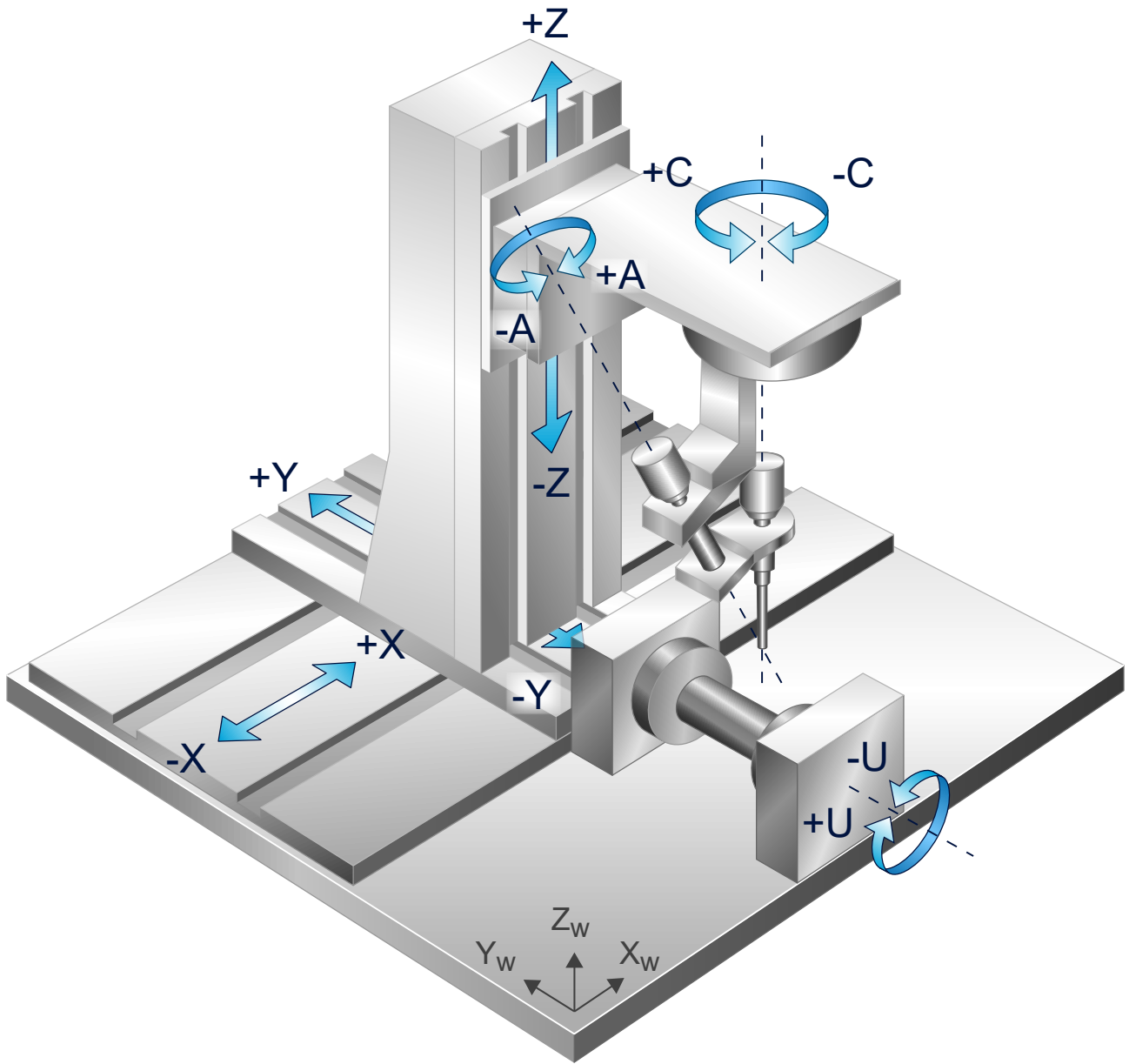


Fig. 53: Lateral surface machining with tube axis parallel to Y

Parameterisation: [Parameters for CA cardanic orientation head \[► 133\]](#)

3.4.1.2 5-axis, one orientation axis in both workpiece and tool



This functionality has been available since CNC Build V2.11.2807.20.

Round tube machining

These kinematics are intended for machine tools with 5 machine axes which are specialised for tube machining only.

This requires a configuration of 5 real machine axes and one virtual axis or one simulation axis. The machining orientation is defined by one rotation axis in the tool and one in the workpiece.

The TCP is positioned for tube machining with the X/Y axis above the top point of the tube. As opposed to 6-axis kinematics [▶ 81] the TCP does not remain at the top point of the tube when there is a change in orientation but drifts along the surface of the cylinder. This must be considered to avoid collisions between the workpiece and the tool holder.

The path is programmed on the lateral surface by the axes U, Y and X, V. Orientation is programmed dependent on the existing kinematics.

- A-U or B-V structures are programmed directly using the assigned angle values A-B or B-A.
- When virtual axes CA are used for parametrisation, these angles are used for programming.

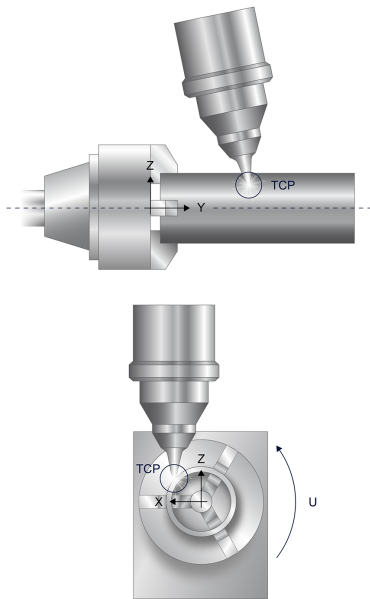


Fig. 54: TCP drifts along the XZ, YZ plane

3.4.1.2.1 Tube machining with AU kinematics

Axis configuration in the NC channel		
Axis identifier	X, Y, Z, B*, A, U	
Axis index	0, 1, 2, 3, 4, 5	
Kinematic structure (ID 90)		
	Tool axes	Workpiece axes
NC axes	X, Y, Z, B*, A	U

(*) Virtual axis or simulation axis

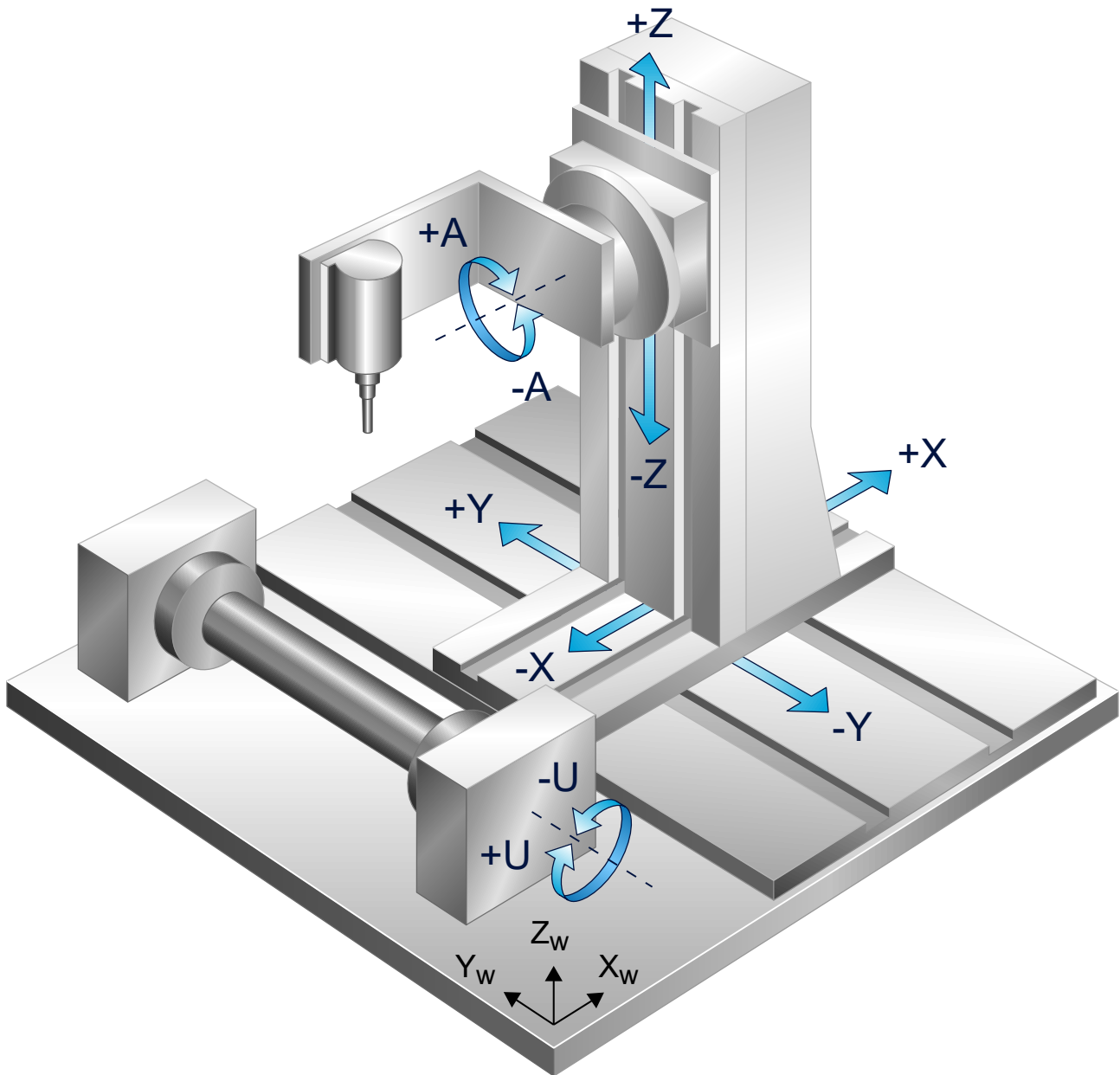


Fig. 55: Lateral surface machining with AU kinematics

Parameterisation: [Parameters for AU kinematics](#) [► 135]

3.4.1.2.2 Tube machining with BV kinematics

Axis configuration in the NC channel		
Axis identifier	X, Y, Z, A*, B, V	
Axis index	0, 1, 2, 3, 4, 5	
Kinematic structure (ID 90)		
	Tool axes	Workpiece axes
NC axes	X, Y, Z, A*, B	V

(*) Virtual axis or simulation axis

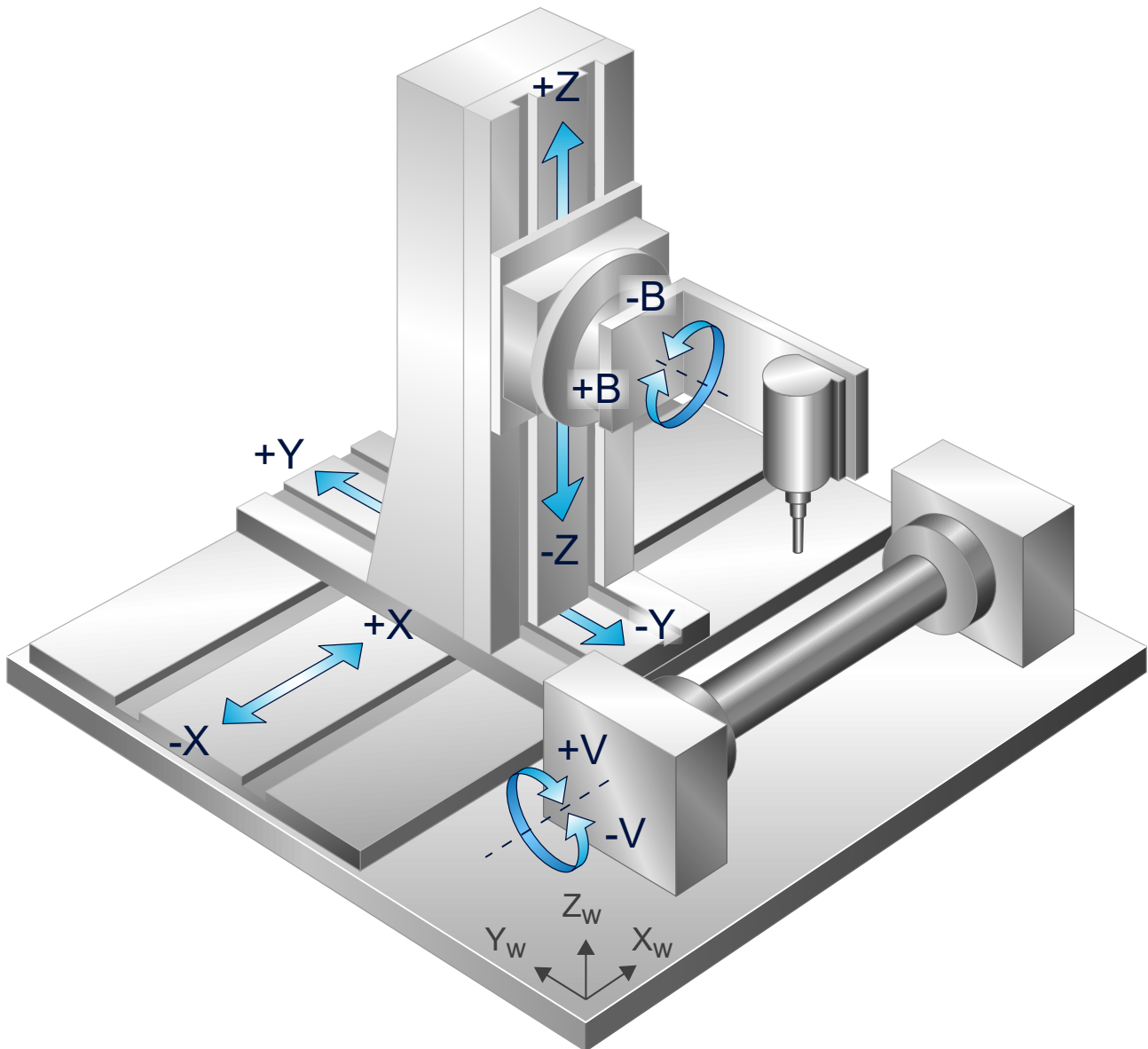


Fig. 56: Lateral surface machining with BV kinematics

Parameterisation: [Parameters for BV kinematics \[► 137\]](#)

3.4.1.3 Programming

Kinematic structure and axis identifiers

The U machine axis is normally an axis that rotates about the X axis, the V axis about Y and the W axis about Z. The configurations and programming examples deviate from this definition. The axis identifiers for the tube system are selected to achieve logical programming in a virtual right-handed **G17** lateral surface system. Therefore, tube machining is dependent on the orientation of the tube axis in the U-Y or X-V plane.

Of course, identifiers used in the NC program may also be the name of the rotary axis in **both** cases, e.g. U.

For tube machining the function is selected by the command **#CYL ORI LATERAL** [...]. The kinematic structure is then selected implicitly. A kinematic parameter defines which kinematic structure is activated in the tool head on selection. The sequence of axes during selection defines whether it is a U projection (tube axis is in Y direction) or a V projection (tube axis is in X direction).

The same kinematic can be used for plate machining. Selection takes place with the command **#KIN ID[90]**; the kinematic is activated by **#TRAFO ON**. The tube axis U can be programmed as tracking axis.

The programming variant with virtual C-A axis is only required for AB, BA head configurations if the application requires machining at a bevel angle to the path. In this case the tangential tracking function can be activated. For all other head configurations there is a real C machine axis.

3.4.1.3.1 Tube machining (#CYL ORI LATERAL)



The kinematic parameters in [ID 90](#) | [125](#) must be set for this machining type.

Syntax for selecting and parameterising, active as of the next motion block:

Syntax:

```
#CYL ORI LATERAL [ AX1<axis_name> | AXNR1=.. AX2<axis_name> | AXNR2=..  
RADIUS=.. ]
```

AX1 <axis_name>	Axis identifier of the first main axis (X or virtual linear axis U, flat projection)
AXNR1 =..	Logical axis number of first main axis (X or virtual linear axis U, flat projection), positive integer
AX2 <axis_name>	Axis identifier of the second main axis (Y or virtual linear axis V, flat projection)
AXNR2 =..	Logical axis number of the second main axis (Y or virtual linear axis V, flat projection), positive integer
RADIUS =..	Tube (bending) radius, [mm, inch]

Syntax for deselection:

```
#CYL OFF
```


3.4.1.3.2 Plate machining

A general description is contained in the programming manual in Section *5-axis functionality* [PROG]:

N10 #KIN ID[90] (* Select kinematics *)

N20 #TRAFO ON (* Select kinematics *)

N30 G00 X100 Y100 Z10 (* Path sessions *)

.....
N100 #TRAFO OFF (* Deselection *)



For plate machining the tube rotary axis (e.g. U) must be located on index 5 in the axis configuration.



The tube rotary axis (e.g. U) is configured for C axis mode as a rotary modulo axis (operation mode 0x204, see P-AXIS-00015).

All kinematics with 2 rotary axes in the tool can be selected as listed under the 6-axis head structures. (AB, BA, CA, CB, CA cardanic head). The head structure is selected by the kinematic parameter HD13 as for tube machining.

3.4.1.4 Examples of tube machining (6-axis)

3.4.1.4.1 AB head, AB programming

```
%L SUB_1
N100 G01 G90 U50 F2000
N150          B15
N200        Y40
N250          B0   A-15
N300 G01          U[-40]
N350          B-15 A0
N400 G01 Y-40
N450          B0 A15
N500 G01          U40
N550          B15 A0
N600 G01 Y0
N700 G01 G90 U20 F2000
N1040 M29
```

```
%tube_5ax
V.G.KIN[90].PARAM[0] = 1000000
V.G.KIN[90].PARAM[1] = 0
V.G.KIN[90].PARAM[2] = 0
V.G.KIN[90].PARAM[3] = 0
V.G.KIN[90].PARAM[4] = 0
V.G.KIN[90].PARAM[5] = 0
V.G.KIN[90].PARAM[6] = 0
V.G.KIN[90].PARAM[7] = 0
V.G.KIN[90].PARAM[8] = 0
V.G.KIN[90].PARAM[9] = 0
V.G.KIN[90].PARAM[10] = 0
V.G.KIN[90].PARAM[11] = 0
V.G.KIN[90].PARAM[12] = 0 (* AB head *)
V.G.KIN[90].PARAM[13] = 0 (* AB programming *)
V.G.KIN[90].PARAM[14] = 0
V.G.KIN[90].PARAM[15] = 0
V.G.KIN[90].PARAM[16] = 0
V.G.KIN[90].PARAM[17] = 0

N05 #SLOPE [TYPE=TRAPEZ]
N20 #KIN ID[90]
N40 G01 X500 Y0 Z50 A0 B0 F2000
N50 #CYL ORI LATERAL[AX1=U AX2=Y RADIUS=30]
N40 G01 U0 Y0 Z30 A0 B0 F2000
N80 LL SUB_1
N110 #CYL OFF

M30
```

3.4.1.4.2 BA head, BA programming

```
%L SUB_1
N100 G01 G90 U50 F2000
N150      A15
N200      Y40
N250      A0 B-15
N300 G01      U[-40]
N350      A-15 B0
N400 G01 Y-40
N450      A0 B0
N500 G01      U40
N550      A15 B0
N600 G01 Y0
N700 G01 G90 U20 F2000
N1040 M29

%tube_5ax
V.G.KIN[90].PARAM[0] = 1000000
V.G.KIN[90].PARAM[1] = 0
V.G.KIN[90].PARAM[2] = 0
V.G.KIN[90].PARAM[3] = 0
V.G.KIN[90].PARAM[4] = 0
V.G.KIN[90].PARAM[5] = 0
V.G.KIN[90].PARAM[6] = 0
V.G.KIN[90].PARAM[7] = 0
V.G.KIN[90].PARAM[8] = 0
V.G.KIN[90].PARAM[9] = 0
V.G.KIN[90].PARAM[10] = 0
V.G.KIN[90].PARAM[11] = 0
V.G.KIN[90].PARAM[12] = 1 (* BA head *)
V.G.KIN[90].PARAM[13] = 0 (* BA programming *)
V.G.KIN[90].PARAM[14] = 0
V.G.KIN[90].PARAM[15] = 0
V.G.KIN[90].PARAM[16] = 0
V.G.KIN[90].PARAM[17] = 0

N05 #SLOPE [TYPE=TRAPEZ]
N20 #KIN ID[90]
N40 G01 X500 Y0 Z50 B0 A0 F2000
N50 #CYL ORI LATERAL[AX1=U AX2=Y RADIUS=30]
N40 G01 U0 Y0 Z30 B0 A0 F2000
N80 LL SUB_1
N110 #CYL OFF

M30
```

3.4.1.4.3 AB head, CA programming

```

%L SUB_1
N100 G01 G90 U50 F2000
N200     Y40
N300 G03 Y50 U40 I-10
N500 G01     U[-40]
N700 G03 Y40 U[-50] J-10
N900 G01 Y-40
N1100 G03 Y-50 U[-40] I10
N1300 G01     U40
N1500 G03 Y-40 U50 J10
N1700 G01 Y0
N1900 G01 G90 U20 F2000

N1040 M29

%tube_5ax

V.G.KIN[90].PARAM[0] = 1000000
V.G.KIN[90].PARAM[1] = 0
V.G.KIN[90].PARAM[2] = 0
V.G.KIN[90].PARAM[3] = 0
V.G.KIN[90].PARAM[4] = 0
V.G.KIN[90].PARAM[5] = 0
V.G.KIN[90].PARAM[6] = 0
V.G.KIN[90].PARAM[7] = 0
V.G.KIN[90].PARAM[8] = 0
V.G.KIN[90].PARAM[9] = 0
V.G.KIN[90].PARAM[10] = 0
V.G.KIN[90].PARAM[11] = 0
V.G.KIN[90].PARAM[12] = 0 (* AB head *)
V.G.KIN[90].PARAM[13] = 1 (* CA programming *)
V.G.KIN[90].PARAM[14] = 0
V.G.KIN[90].PARAM[15] = 0
V.G.KIN[90].PARAM[16] = 0
V.G.KIN[90].PARAM[17] = 0

N05 #SLOPE [TYPE=TRAPEZ]
N40 G01 X500 Y0 Z50 A0 B0 F2000
N45 #SET AX[X,1,0][Y,2,1][Z,3,2][C,4,3][A,5,4][U,6,5]
N50 #CYL ORI LATERAL[AX1=U AX2=Y RADIUS=30]
N40 G01 U0 Y0 Z30 C0 A15 F2000
N70 #CAXTRACK ON[ANGLIMIT 0.1]
N80 LL SUB_1
N90 #CAXTRACK OFF
N110 #CYL OFF

M30

```

3.4.1.4.4 BA head, CA programming

```

%L SUB_1
N100 G01 G90 U50 F2000
N200 Y40
N300 G03 Y50 U40 I-10
N500 G01 U[-40]
N700 G03 Y40 U[-50] J-10
N900 G01 Y-40
N1100 G03 Y-50 U[-40] I10
N1300 G01 U40
N1500 G03 Y-40 U50 J10
N1700 G01 Y0
N1900 G01 G90 U20 F2000

N1040 M29

%tube_5ax

V.G.KIN[90].PARAM[0] = 1000000
V.G.KIN[90].PARAM[1] = 0
V.G.KIN[90].PARAM[2] = 0
V.G.KIN[90].PARAM[3] = 0
V.G.KIN[90].PARAM[4] = 0
V.G.KIN[90].PARAM[5] = 0
V.G.KIN[90].PARAM[6] = 0
V.G.KIN[90].PARAM[7] = 0
V.G.KIN[90].PARAM[8] = 0
V.G.KIN[90].PARAM[9] = 0
V.G.KIN[90].PARAM[10] = 0
V.G.KIN[90].PARAM[11] = 0
V.G.KIN[90].PARAM[12] = 1 (* AB head *)
V.G.KIN[90].PARAM[13] = 1 (* CA programming *)
V.G.KIN[90].PARAM[14] = 0
V.G.KIN[90].PARAM[15] = 0
V.G.KIN[90].PARAM[16] = 0
V.G.KIN[90].PARAM[17] = 0

N05 #SLOPE [TYPE=TRAPEZ]
N40 G01 X500 Y0 Z50 A0 B0 F2000
N45 #SET AX[X,1,0][Y,2,1][Z,3,2][C,4,3][A,5,4][U,6,5]
N50 #CYL ORI LATERAL[AX1=U AX2=Y RADIUS=30]
N40 G01 U0 Y0 Z30 C0 A15 F2000
N70 #CAXTRACK ON[ANGLIMIT 0.1]
N80 LL SUB_1
N90 #CAXTRACK OFF
N110 #CYL OFF

M30

```

3.4.1.4.5 CA head, CA programming

```

%L SUB_1
N100 G01 G90 U50 F2000
N200 Y40
N300 G03 Y50 U40 I-10
N500 G01 U[-40]
N700 G03 Y40 U[-50] J-10
N900 G01 Y-40
N1100 G03 Y-50 U[-40] I10
N1300 G01 U40
N1500 G03 Y-40 U50 J10
N1700 G01 Y0
N1900 G01 G90 U20 F2000

N1040 M29

%tube_5ax

V.G.KIN[90].PARAM[0] = 1000000
V.G.KIN[90].PARAM[1] = 0
V.G.KIN[90].PARAM[2] = 0
V.G.KIN[90].PARAM[3] = 0
V.G.KIN[90].PARAM[4] = 0
V.G.KIN[90].PARAM[5] = 0
V.G.KIN[90].PARAM[6] = 0
V.G.KIN[90].PARAM[7] = 0
V.G.KIN[90].PARAM[8] = 0
V.G.KIN[90].PARAM[9] = 0
V.G.KIN[90].PARAM[10] = 0
V.G.KIN[90].PARAM[11] = 0
V.G.KIN[90].PARAM[12] = 2 (* CA head *)
V.G.KIN[90].PARAM[13] = 0
V.G.KIN[90].PARAM[14] = 0
V.G.KIN[90].PARAM[15] = 0
V.G.KIN[90].PARAM[16] = 0
V.G.KIN[90].PARAM[17] = 0

N05 #SLOPE [TYPE=TRAPEZ]
N40 G01 X500 Y0 Z50 C0 A0 F2000
N45 #SET AX[X,1,0][Y,2,1][Z,3,2][C,4,3][A,5,4][U,6,5]
N50 #CYL ORI LATERAL[AX1=U AX2=Y RADIUS=30]
N40 G01 U0 Y0 Z30 C0 A15 F2000
N60 #CAXTRACK ON[ANGLIMIT 0.1]
N70 LL SUB_1
N80 #CAXTRACK OFF
N90 #CYL OFF

M30

```

3.4.1.4.6 CB Kopf, CB Programmierung

```

%L SUB_1
N100 G01 G90      U50 F2000
N200             Y40
N300 G03 Y50     U40   I-10
N500 G01         U[-40]
N700 G03 Y40     U[-50] J-10
N900 G01 Y-40
N1100 G03 Y-50   U[-40] I10
N1300 G01        U40
N1500 G03 Y-40   U50   J10
N1700 G01 Y0
N1900 G01 G90    U20 F2000

N1040 M29

%tube_5ax

V.G.KIN[90].PARAM[0] = 1000000
V.G.KIN[90].PARAM[1] = 0
V.G.KIN[90].PARAM[2] = 0
V.G.KIN[90].PARAM[3] = 0
V.G.KIN[90].PARAM[4] = 0
V.G.KIN[90].PARAM[5] = 0
V.G.KIN[90].PARAM[6] = 0
V.G.KIN[90].PARAM[7] = 0
V.G.KIN[90].PARAM[8] = 0
V.G.KIN[90].PARAM[9] = 0
V.G.KIN[90].PARAM[10] = 0
V.G.KIN[90].PARAM[11] = 0
V.G.KIN[90].PARAM[12] = 4   (* CA head *)
V.G.KIN[90].PARAM[13] = 0
V.G.KIN[90].PARAM[14] = 0
V.G.KIN[90].PARAM[15] = 0
V.G.KIN[90].PARAM[16] = 0
V.G.KIN[90].PARAM[17] = 0

N05 #SLOPE [TYPE=TRAPEZ]
N40 G01 X500 Y0 Z50 C0 B0 F2000
N45 #SET AX[X,1,0][Y,2,1][Z,3,2][C,4,3][B,5,4][U,6,5]
N50 #CYL ORI LATERAL[AX1=U AX2=Y RADIUS=30]
N40 G01 U0 Y0 Z30 C0 B15 F2000
N60 #CAXTRACK ON[ANGLIMIT 0.1]
N70 LL SUB_1
N80 #CAXTRACK OFF
N90 #CYL OFF

M30

```

3.4.1.4.7 CA cardanic head, CA programming

```

%L SUB_1
N100 G01 G90 U50 F2000
N200 Y40
N300 G03 Y50 U40 I-10
N500 G01 U[-40]
N700 G03 Y40 U[-50] J-10
N900 G01 Y-40
N1100 G03 Y-50 U[-40] I10
N1300 G01 U40
N1500 G03 Y-40 U50 J10
N1700 G01 Y0
N1900 G01 G90 U20 F2000

N1040 M29

%tube_5ax

V.G.KIN[90].PARAM[0] = 0
V.G.KIN[90].PARAM[1] = 0
V.G.KIN[90].PARAM[2] = 450000
V.G.KIN[90].PARAM[3] = 0
V.G.KIN[90].PARAM[4] = 0
V.G.KIN[90].PARAM[5] = 0
V.G.KIN[90].PARAM[6] = 0
V.G.KIN[90].PARAM[7] = 0
V.G.KIN[90].PARAM[8] = 0
V.G.KIN[90].PARAM[9] = 0
V.G.KIN[90].PARAM[10] = 0
V.G.KIN[90].PARAM[11] = 0
V.G.KIN[90].PARAM[12] = 8 (* CA cardan head *)
V.G.KIN[90].PARAM[13] = 0
V.G.KIN[90].PARAM[14] = 0
V.G.KIN[90].PARAM[15] = 0
V.G.KIN[90].PARAM[16] = 0
V.G.KIN[90].PARAM[17] = 0

N05 #SLOPE [TYPE=TRAPEZ]
N40 G01 X500 Y0 Z50 C0 B0 F2000
N45 #SET AX[X,1,0][Y,2,1][Z,3,2][C,4,3][A,5,4][U,6,5]
N50 #CYL ORI LATERAL[AX1=U AX2=Y RADIUS=30]
N40 G01 U0 Y0 Z30 C0 B15 F2000
N60 #CAXTRACK ON[ANGLIMIT 0.1]
N70 LL SUB_1
N80 #CAXTRACK OFF
N90 #CYL OFF

M30

```


3.4.1.5 Examples of plate machining (6-axis)

3.4.1.5.1 AB Kopf, CA Programming

```
%t_tube
V.G.KIN[90].PARAM[0] = 1000000
V.G.KIN[90].PARAM[1] = 0
V.G.KIN[90].PARAM[2] = 0
V.G.KIN[90].PARAM[3] = 0
V.G.KIN[90].PARAM[4] = 0
V.G.KIN[90].PARAM[5] = 0
V.G.KIN[90].PARAM[6] = 0
V.G.KIN[90].PARAM[7] = 0
V.G.KIN[90].PARAM[8] = 0
V.G.KIN[90].PARAM[9] = 0
V.G.KIN[90].PARAM[10] = 0
V.G.KIN[90].PARAM[11] = 0
V.G.KIN[90].PARAM[12] = 0   AB Kopf
V.G.KIN[90].PARAM[13] = 1   (* CA programming *)
V.G.KIN[90].PARAM[14] = 0
V.G.KIN[90].PARAM[15] = 0
V.G.KIN[90].PARAM[16] = 0
V.G.KIN[90].PARAM[17] = 0

N10 #SLOPE [TYPE=TRAPEZ]
N20 #KIN ID[90]
N30 G01 X0 Y0 Z0 A0 C0 U0 F2000
N40 #SET AX[X,1,0][Y,2,1][Z,3,2][C,4,3][A,5,4][U,7,5]
N45 #CONTOUR MODE[DEV PATH_DEV 0.1 TRACK_DEV 1]

N50 #TRAFO ON
N55 G01 U0 X0 Y0 Z0 C0 A45
N56 #CAXTRACK ON[ANGLIMIT 1]

N57 G261
N58 G01 G91 X50
N60 G90 G02 J-30
N61 G01 G91 X50
N62 G260
N63 #CAXTRACK OFF

N80 #TRAFO OFF
N90 M30
```

3.4.1.5.2 AB Kopf, AB Programming

```
%t_tube
V.G.KIN[90].PARAM[0] = 1000000
V.G.KIN[90].PARAM[1] = 0
V.G.KIN[90].PARAM[2] = 0
V.G.KIN[90].PARAM[3] = 0
V.G.KIN[90].PARAM[4] = 0
V.G.KIN[90].PARAM[5] = 0
V.G.KIN[90].PARAM[6] = 0
V.G.KIN[90].PARAM[7] = 0
V.G.KIN[90].PARAM[8] = 0
V.G.KIN[90].PARAM[9] = 0
V.G.KIN[90].PARAM[10] = 0
V.G.KIN[90].PARAM[11] = 0
V.G.KIN[90].PARAM[12] = 0    AB Kopf
V.G.KIN[90].PARAM[13] = 0    (* AB programming *)
V.G.KIN[90].PARAM[14] = 0
V.G.KIN[90].PARAM[15] = 0
V.G.KIN[90].PARAM[16] = 0
V.G.KIN[90].PARAM[17] = 0

N10 #SLOPE [TYPE=TRAPEZ]
N20 #KIN ID[90]
N30 G01 X0 Y0 Z0 A0 C0 U0 F2000
N40 #SET AX[X,1,0][Y,2,1][Z,3,2][A,4,3][B,5,4][U,7,5]
N45 #CONTOUR MODE[DEV PATH_DEV 0.1 TRACK_DEV 1]

N50 #TRAFO ON
N55 G01 U0 X0 Y0 Z0 A0 B45

N57 G261
N58 G01 G91 X50
N60 G90 G02 J-30
N61 G01 G91 X50
N62 G260

N80 #TRAFO OFF
N90 M30
```

3.4.1.6 Examples of tube machining (5-axis)

3.4.1.6.1 AU kinematics, BA programming

```
(* B is simulation axis *)

%L SUB_1
N570 G261
N580 G01 G90 Y50 B15
N600 G90 G02 J-30
N610 G01 G90 Y-50 B-15
N620 G90 G02 J-30
N630 G01 G91 Y50 B0
N640 G260
M29

%t_tube
V.G.KIN[90].PARAM[0] = 1000000
V.G.KIN[90].PARAM[1] = 0
V.G.KIN[90].PARAM[2] = 0
V.G.KIN[90].PARAM[3] = 0
V.G.KIN[90].PARAM[4] = 0
V.G.KIN[90].PARAM[5] = 0
V.G.KIN[90].PARAM[6] = 0
V.G.KIN[90].PARAM[7] = 0
V.G.KIN[90].PARAM[8] = 0
V.G.KIN[90].PARAM[9] = 0
V.G.KIN[90].PARAM[10] = 0
V.G.KIN[90].PARAM[11] = 0
V.G.KIN[90].PARAM[12] = 9 (* Kinematic 9: A WZ, U 10: B WZ, V *)
V.G.KIN[90].PARAM[13] = 0 (* Progr. orientation 0: same as Kin. 1: CA *)
V.G.KIN[90].PARAM[14] = 0
V.G.KIN[90].PARAM[15] = 0
V.G.KIN[90].PARAM[16] = 0
V.G.KIN[90].PARAM[17] = 0

N05 #SLOPE [TYPE=STEP]
N10 #SET AX[X,1,0] [Y,2,1] [Z,3,2] [B,4,3] [A,5,4] [U,6,5]

N20 G01 X0 Y0 Z150 A0 B0 U0 F2000
N30 #CONTOUR MODE[DEV PATH_DEV 0.1 TRACK_DEV 1]
N40 #CYL ORI LATERAL[AX1=U AX2=Y RADIUS=25]
N50 G01 U0 X0 Y0 Z30 A0 B0
N60 LL SUB_1
N120 #CYL OFF

M30
```

3.4.1.6.2 BV kinematics, AB programming

```
(* A is simulation axis *)

%L SUB 1
N570 G261
N580 G90 G01 X50 A15
N600 G02 J-30
N610 G01 X-50 A-15
N600 G02 J-30
N610 G01 X50 A0
N620 G260
M29

%t_tube
V.G.KIN[90].PARAM[0] = 1000000
V.G.KIN[90].PARAM[1] = 0
V.G.KIN[90].PARAM[2] = 0
V.G.KIN[90].PARAM[3] = 0
V.G.KIN[90].PARAM[4] = 0
V.G.KIN[90].PARAM[5] = 0
V.G.KIN[90].PARAM[6] = 0
V.G.KIN[90].PARAM[7] = 0
V.G.KIN[90].PARAM[8] = 0
V.G.KIN[90].PARAM[9] = 0
V.G.KIN[90].PARAM[10] = 0
V.G.KIN[90].PARAM[11] = 0
V.G.KIN[90].PARAM[12] = 10 (* Kinematic 9: A-U 10: B-V *)
V.G.KIN[90].PARAM[13] = 0 (* Progr. orientation 0: same as Kin 1: CA *)
V.G.KIN[90].PARAM[14] = 0
V.G.KIN[90].PARAM[15] = 0
V.G.KIN[90].PARAM[16] = 0
V.G.KIN[90].PARAM[17] = 0

N05 #SLOPE [TYPE=STEP]
N10 #SET AX[X,1,0][Y,2,1][Z,3,2][A,4,3][B,5,4][V,6,5]
N20 G01 X0 Y0 Z150 A0 B0 V0 F2000
N30 #CONTOUR MODE[DEV PATH_DEV 0.1 TRACK_DEV 1]

N40 #CYL ORI LATERAL[AX1=X AX2=V RADIUS=25]
N50 G01 V0 X0 Y0 Z30 A0 B0
N60 LL SUB 1
N120 #CYL OFF

M30
```

3.4.1.6.3 AU kinematics, CA programming

```
(* C is simulation axis *)

%L SUB_1
N570 G261
N575           A15
N580 G01 G90 U50
N590           Y50
N600           U0
N610           Y0
N620           U[-50]
N630           Y-50
N640           U0
N650           Y0
N620 G260
M29

%t_tube
V.G.KIN[90].PARAM[0] = 1000000
V.G.KIN[90].PARAM[1] = 0
V.G.KIN[90].PARAM[2] = 0
V.G.KIN[90].PARAM[3] = 0
V.G.KIN[90].PARAM[4] = 0
V.G.KIN[90].PARAM[5] = 0
V.G.KIN[90].PARAM[6] = 0
V.G.KIN[90].PARAM[7] = 0
V.G.KIN[90].PARAM[8] = 0
V.G.KIN[90].PARAM[9] = 0
V.G.KIN[90].PARAM[10] = 0
V.G.KIN[90].PARAM[11] = 0
V.G.KIN[90].PARAM[12] = 9 (* Kinematic 9: A-U 10: B-V *)
V.G.KIN[90].PARAM[13] = 1 (* Progr. orientation 0: same as Kin. 1: CA *)
V.G.KIN[90].PARAM[14] = 0
V.G.KIN[90].PARAM[15] = 0
V.G.KIN[90].PARAM[16] = 0
V.G.KIN[90].PARAM[17] = 0

N05 #SLOPE [TYPE=STEP]
N10 #SET AX[X,1,0][Y,2,1][Z,3,2][C,4,3][A,5,4][U,6,5]
N20 G01 X0 Y0 Z150 C0 A0 U0 F2000
N30 #CONTOUR MODE[DEV PATH_DEV 0.1 TRACK_DEV 1]

N40 #CYL ORI LATERAL[AX1=U AX2=Y RADIUS=25]
N50 G01 U0 X0 Y0 Z30 C0 A0
N56 #CAXTRACK ON[AX=C ANGLIMIT 0.1]
N60 LL SUB_1
N70 #CAXTRACK OFF
N110 #CYL OFF

M30
```

3.4.1.6.4 BV kinematics, CA programming

```
(* C is simulation axis *)

%L SUB_1
N570 G261
N575           A15
N580 G01 G90 X50
N590           V50
N600           X0
N610           V0
N620           X-50
N630           V[-50]
N640           V0
N650           X0
N620 G260
M29

%t_tube
V.G.KIN[90].PARAM[0] = 1000000
V.G.KIN[90].PARAM[1] = 0
V.G.KIN[90].PARAM[2] = 0
V.G.KIN[90].PARAM[3] = 0
V.G.KIN[90].PARAM[4] = 0
V.G.KIN[90].PARAM[5] = 0
V.G.KIN[90].PARAM[6] = 0
V.G.KIN[90].PARAM[7] = 0
V.G.KIN[90].PARAM[8] = 0
V.G.KIN[90].PARAM[9] = 0
V.G.KIN[90].PARAM[10] = 0
V.G.KIN[90].PARAM[11] = 0
V.G.KIN[90].PARAM[12] = 10 (* Kinematic 9: A-U 10: B-V *)
V.G.KIN[90].PARAM[13] = 1 (* Progr. orientation 0: same as Kin 1: CA *)
V.G.KIN[90].PARAM[14] = 0
V.G.KIN[90].PARAM[15] = 0
V.G.KIN[90].PARAM[16] = 0
V.G.KIN[90].PARAM[17] = 0

N05 #SLOPE [TYPE=STEP]
N10 #SET AX[X,1,0] [Y,2,1] [Z,3,2] [C,4,3] [A,8,4] [V,7,5]

N20 G01 X0 Y0 Z150 C0 A0 V0 F2000
N30 #CONTOUR MODE[DEV PATH_DEV 0.1 TRACK_DEV 1]

N40 #CYL ORI LATERAL[AX1=X AX2=V RADIUS=25]
N50 G01 V0 X0 Y0 Z30 C0 A0

N56 #CAXTRACK ON[AX=C ANGLIMIT 1]
N60 LL SUB_1
N70 #CAXTRACK OFF

N80 #CYL OFF

M30
```

3.4.2 Polygonal tube, profiled tube

Machining with 5-axis head

The [Kinematic 93 \[▶ 139\]](#) is provided for profiled tube machining with 5-axis heads. It is activated implicitly when tube machining is selected. Its configuration is described in the section "[Polygonal tube, profiled tube \(5/6-axis\) \[▶ 139\]](#)".

5-axis heads supported

The [Kinematic 93 \[▶ 139\]](#) also supports all 5-axis heads described in the section "[Round tube, lateral surface \[▶ 81\]](#)".



One restriction is that the tube axis must always be parallel to the X axis. This explains why the command `#CYL ORI PROFILE [...]` has no options to specify the axes.

Parameterisation example: [Parameters for AB and BV orientation head \[▶ 139\]](#)

3.4.2.1 Programming (#CYL ORI PROFILE)



The kinematic parameters in [ID 93 \[▶ 139\]](#) must be set for this machining type.

Syntax for selecting and parameterising, active as of the next motion block:

Syntax:

```
#CYL ORI PROFILE [ EDGES=.. ROUNDING=.. LENGTH1=.. [ LENGTH2=.. ]          modal
                  [ VEL=.. ] [ ACC=.. ] ]
```

EDGES=..	Number of edges (corners) of the profiled tube, positive integer The minimum number of corners on the profile is limited to 3 and the maximum number to 16.
ROUNDING=..	Edge rounding radius (corner radius), [mm, inch].
LENGTH1=..	Side length for symmetrical tubes or first side length for rectangular tubes, [mm, inch]
LENGTH2=..	Second side length for rectangular tubes, [mm, inch]
VEL=..	Path velocity on edge rounding [mm/min]
ACC=..	Path acceleration on edge rounding [mm/min ²]

Syntax for deselection:

Syntax:

```
#CYL OFF          modal
```

#CYL ORI PROFILE [..]

```
(Symmetrical square profile with 100 mm edge length)
(and 10 mm edge rounding radius)
N10 #CYL ORI PROFILE [EDGES=4 ROUNDING=10 LENGTH1=100]
...

(Rectangular tube with edge lengths of 100 mm)
(and 80 mm and 15 mm edge rounding radius)
N10 #CYL ORI PROFILE [EDGES=4 ROUNDING=15 LENGTH1=100 LENGTH2=80]
...

(Reduced path dynamics on the profile rounding)
N10 #CYL ORI PROFILE [EDGES=4 ... LENGTH2=50 ACC=1000000]
```


3.4.2.2 Program example with AB tool head configuration

This configuration contains 6 real axes.

```
N010 ; configuration of AB orientation head
N020 V.G.KIN[93].PARAM[0] = 1000000 ; Z offset to the tool fixing point
N030 V.G.KIN[93].PARAM[1] = 10000 ; X offset to the tool fixing point
N040 V.G.KIN[93].PARAM[2] = 20000 ; Y offset to the tool fixing point
N050 V.G.KIN[93].PARAM[3] = 30000 ; X offset rotation point A axis - rotation point B axis
N060 V.G.KIN[93].PARAM[4] = 31415 ; Y offset rotation point A axis - rotation point B axis
N070 V.G.KIN[93].PARAM[5] = 27181 ; Z offset rotation point A axis - rotation point B axis
N080 V.G.KIN[93].PARAM[6] = -1234 ; X offset zero point - rotation point A axis
N090 V.G.KIN[93].PARAM[7] = 17 ; Y offset zero point - rotation point A axis
N100 V.G.KIN[93].PARAM[8] = 100 ; Z offset zero point - rotation point A axis
N110 V.G.KIN[93].PARAM[11] = 1000 ; angle offset U/V axis
N120 V.G.KIN[93].PARAM[12] = 0 ; 0 = AB head
N130 V.G.KIN[93].PARAM[13] = 0 ; 0 = PCS programming same as head
N140 V.G.KIN[93].PARAM[14] = 0 ; rotation direction AM positive
N150 V.G.KIN[93].PARAM[15] = 0 ; rotation direction BM positive
N160 V.G.KIN[93].PARAM[16] = 200 ; angle offset AM
N170 V.G.KIN[93].PARAM[17] = 100 ; angle offset BM
N200 ; configuration of profile tube
N230 V.G.KIN[93].PARAM[23] = 513 ; Z offset rotary axis U to machine zero point
N240 V.G.KIN[93].PARAM[24] = 1000 ; X offset rotary axis U to machine zero point
N250 V.G.KIN[93].PARAM[25] = -5000 ; Y offset rotary axis U to machine zero point
N260
N270 ; sort axes
N280 #SET AX [X, 1, 0][Y, 2, 1][Z, 3, 2][A, 4, 3][B, 5, 4][U, 6, 5]
N290
N300 ; move to zero
N310 G00 G90 X0 Y0 Z0 A0 B0 U0
N320
N330 ; select kinematic 93
N340 #KIN ID[93]
N350

N360 ; start processing
N370 G01 X500 Y0 Z50 A0 B0 F2000
N380 #CYL ORI PROFILE [EDGES = 4 ROUNDING = 10 LENGTH1 = 50]
N390 G01 X0 U0 Z30 A0 B0 F2000
N400 G01 G90 U50 F2000
N410 B15
N420 X40
N430 B0 A-15
N440 G01 U-40
N450 B-15 A0
N460 G01 X-40
N470 A15 B0
N480 G01 U40
N490 B15 A0
N500 G01 X0
N510 G01 G90 U20 F2000
N520 #CYL OFF
N530
N540 ; end program
N550 M30
```

3.4.2.3 Program example with BV configuration:

This configuration contains 5 real axes. The A axis included is a virtual simulation axis.

```
%L SUB_GEOM
N570 G261
N575      B=15 F200
N580 G01 G90 X50 F5000
N590      G91 U100
N600      G90 X0
N610      G91 U-100
N620      G90 X-100
N630      G91 U-100
N640      G91 U100
N650      G90 X0
N660      G90 B=0
N620 G260
M29

%t_edge_prof_5ax_BV.nc
N9 ;
N10 V.G.KIN[93].PARAM[0] = 1000000
N11 V.G.KIN[93].PARAM[1] = 0
N12 V.G.KIN[93].PARAM[2] = 0
N13 V.G.KIN[93].PARAM[3] = 0
N14 V.G.KIN[93].PARAM[4] = 0
N15 V.G.KIN[93].PARAM[5] = 0
N16 V.G.KIN[93].PARAM[6] = 0
N17 V.G.KIN[93].PARAM[7] = -942000
N18 V.G.KIN[93].PARAM[8] = 0
N21 V.G.KIN[93].PARAM[11] = 0
N22 V.G.KIN[93].PARAM[12] = 10 (* 10: B WZ, V *)
N23 V.G.KIN[93].PARAM[13] = 0
N24 V.G.KIN[93].PARAM[14] = 0
N25 V.G.KIN[93].PARAM[15] = 0
N26 V.G.KIN[93].PARAM[16] = 0
N27 V.G.KIN[93].PARAM[17] = 0
N33 V.G.KIN[93].PARAM[23] = 0
N34 V.G.KIN[93].PARAM[24] = 0
N35 V.G.KIN[93].PARAM[25] = 0

N10 #SET SLOPE PROFIL[1]
N20 G00 X0 Y0 Z250
N30 #CONTOUR MODE[DEV PATH_DEV 0.1 TRACK_DEV 1]

N40 #SET AX[X,1,0][Y,2,1][Z,3,2][A,4,3][B,5,4][U,6,5]
N50 G00 X0 Y94.2 Z250 A0 B0 U0
N60 #CYL ORI PROFILE[EDGES=4 ROUNDING=5 LENGTH1=50 LENGTH2=50]
(* Profile circumference approx. 231.41592 mm *)

N70 LL SUB_GEOM
N90 #CYL OFF
M30
```

3.5 Parameter

Parameterisation

The workpiece parameters are defined in the NC program. The following parameters are offset values of the kinematic structure, parameters for the rotary axis and optionally applicable M/H codes.

3.5.1 Overview

3.5.1.1 Channel parameters

The following kinematic parameters must be assigned function-specific for machining variants.

ID	Parameter	Description
P-CHAN-00094	kinematik[i].param[j]	Kinematic offsets of the corresponding kinematics, CNC Build as of V3.00
P-CHAN-00262	trafo[i].id	Kinematics ID
P-CHAN-00263	trafo[i].param[j]	Kinematic offsets of the corresponding kinematics, CNC Build as of V3.00

The following parameters are optional for profiled tube machining. The M/H numbers are defined for output at the rounding transition of the profiled tube.

ID	Parameter	Description
P-CHAN-00249	tube_profile.techno_nr_rnd_on	M/H number, entering edge rounding
P-CHAN-00250	tube_profile.techno_nr_rnd_off	M/H number, leaving edge rounding
P-CHAN-00251	tube_profile.techno_type	0 = M, 1 = H

3.5.1.2 Axis parameters

The U rotary axis must be set by the following parameters.

ID	Parameter	Value	Description
P-AXIS-00015	axis mode	0x0000 0204	Axis defined as U rotary axis for lateral surface, projection and profiled tube machining.
P-AXIS-00126	moduloo	3600000	Definition of upper modulo limit
P-AXIS-00127	modulou	0	Definition of lower modulo limit

3.5.2 Description

3.5.2.1 Round tube, lateral surface (kinematic ID 15)

Parameters are defined under the ID 15 of the kinematic offsets (P-CHAN-00263 and P-CHAN-00094).

If required, PCS modulo calculation can be enabled by the parameter HD10.

HD offset	param[i]	Description	Unit
HD1	0	Z offset tool clamping point tool carrier reference point (WZBP)	1.0 E-4 mm
HD2	1	Angle offset of rotary axis	1.0 E-4°
HD3	2	X offset tool clamping point tool carrier reference point (WZBP)	1.0 E-4 mm
HD4	3	-	
HD5	4	Z offset of rotary axis U to machine zero point (MNP)	1.0 E-4 mm
HD6	5	X offset of rotary axis U to machine zero point (MNP)	1.0 E-4 mm
HD10	9	PCS modulo calculation 0: inactive 1: active	[-]

The general description is contained in the channel parameter list under P-CHAN-00263 and P-CHAN-00094.

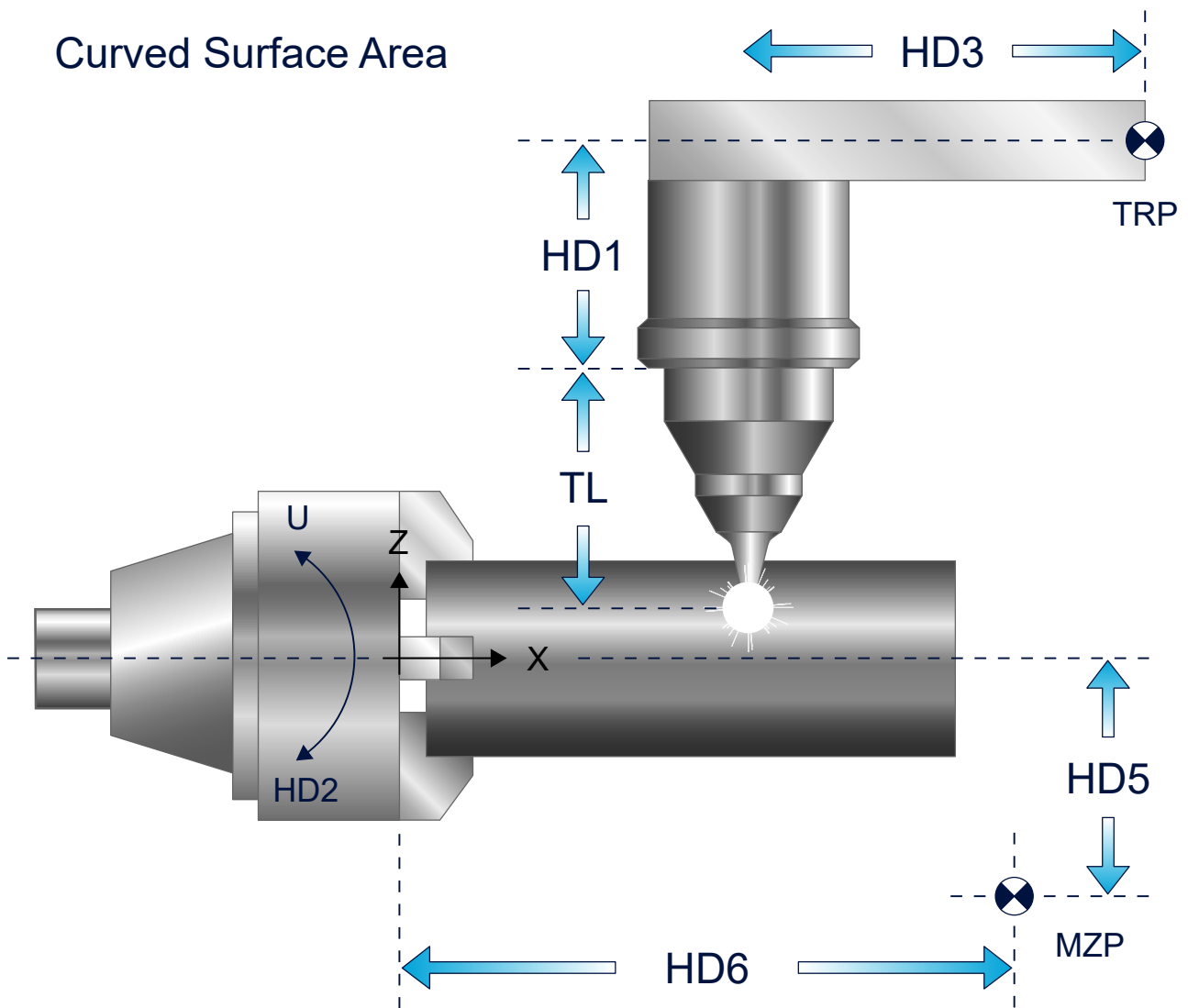


Fig. 57: Kinematic offsets for lateral surface machining

3.5.2.2 Round tube, projection (kinematic ID 78)

Parameters are defined under the ID 78 of the kinematic offsets (P-CHAN-00263 and P-CHAN-00094).

HD offset	param[i]	Description	Unit
HD1	0	Z offset tool clamping point tool carrier reference point (WZBP)	1.0 E-4 mm
HD2	1	X offset tool clamping point tool carrier reference point	1.0 E-4 mm
HD3	2	Y offset tool clamping point tool carrier reference point	1.0 E-4 mm
HD4	3	-	
HD5	4	Z offset of rotary axis U to machine zero point (MNP)	1.0 E-4 mm
HD6	5	X offset of rotary axis U to machine zero point	1.0 E-4 mm
HD7	6	Y offset of rotary axis U to machine zero point	1.0 E-4 mm

With regard to modulo calculation, the U axis is handled depending on the MDS setting in the axis.

The general description is contained in the channel parameter list under P-CHAN-00263 and P-CHAN-00094.

Projection Tube Processing

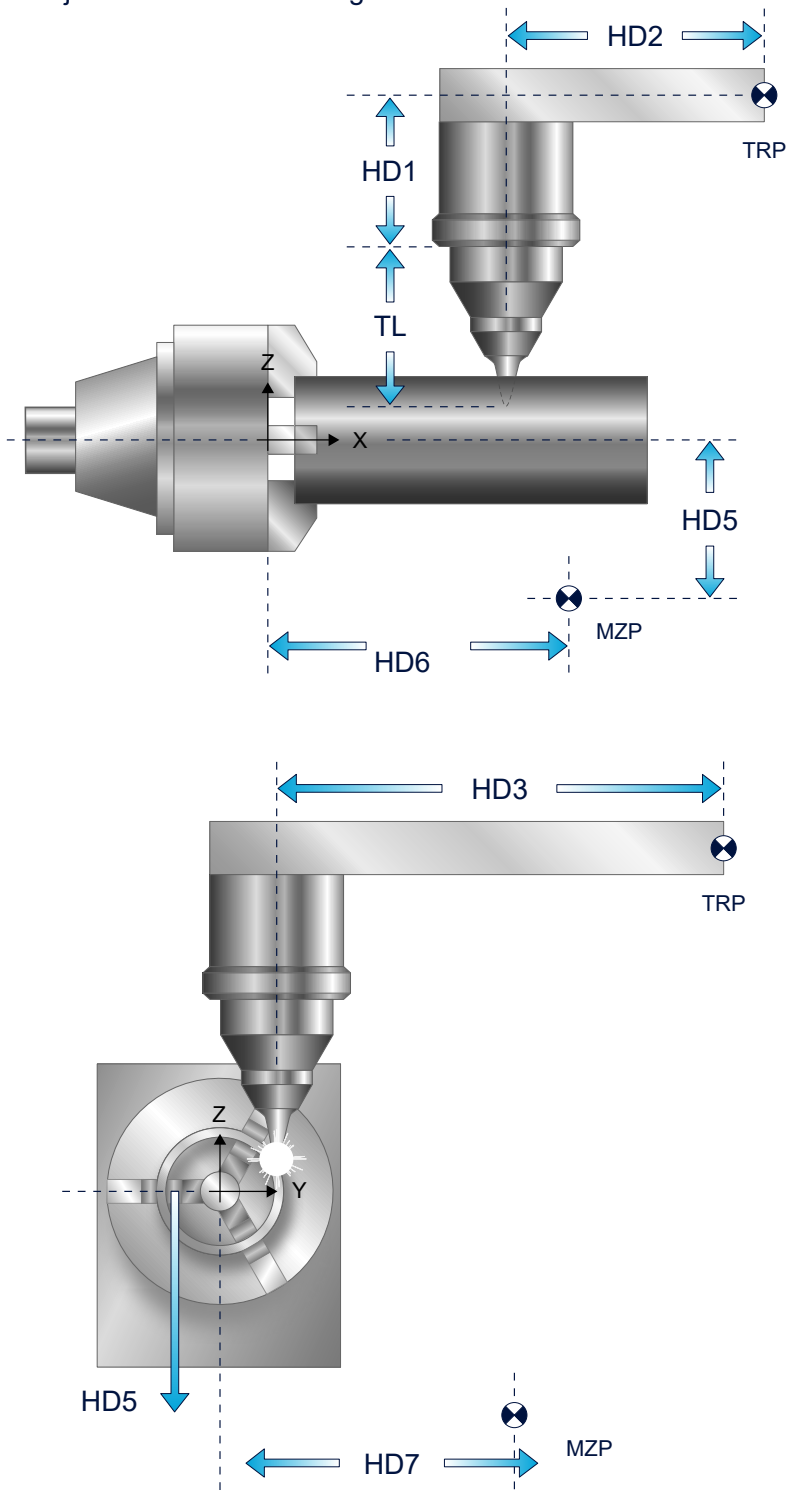


Fig. 58: Tube projection transformation kinematic offsets

3.5.2.3 Polygonal tube, profiled tube (kinematic ID 79)

Parameters are defined under the ID 79 of the kinematic offsets (P-CHAN-00263 and P-CHAN-00094).

HD offset	param[i]	Description	Unit
HD1	0	Z offset tool clamping point tool carrier reference point (WZBP)	1.0 E-4 mm
HD2	1	X offset tool clamping point tool carrier reference point	1.0 E-4 mm
HD3	2	Y offset tool clamping point tool carrier reference point	1.0 E-4 mm
HD4	3	Z offset of rotary axis U to machine zero point (MNP)	1.0 E-4 mm
HD5	4	X offset of rotary axis U to machine zero point	1.0 E-4 mm
HD6	5	Y offset of rotary axis U to machine zero point	1.0 E-4 mm
HD7	6	-	
HD8	7	Angle offset of workpiece clamp position	1.0 E-4°

A modulo compensation is always executed for the U axis.

The general description is contained in the channel parameter list under P-CHAN-00263 and P-CHAN-00094.

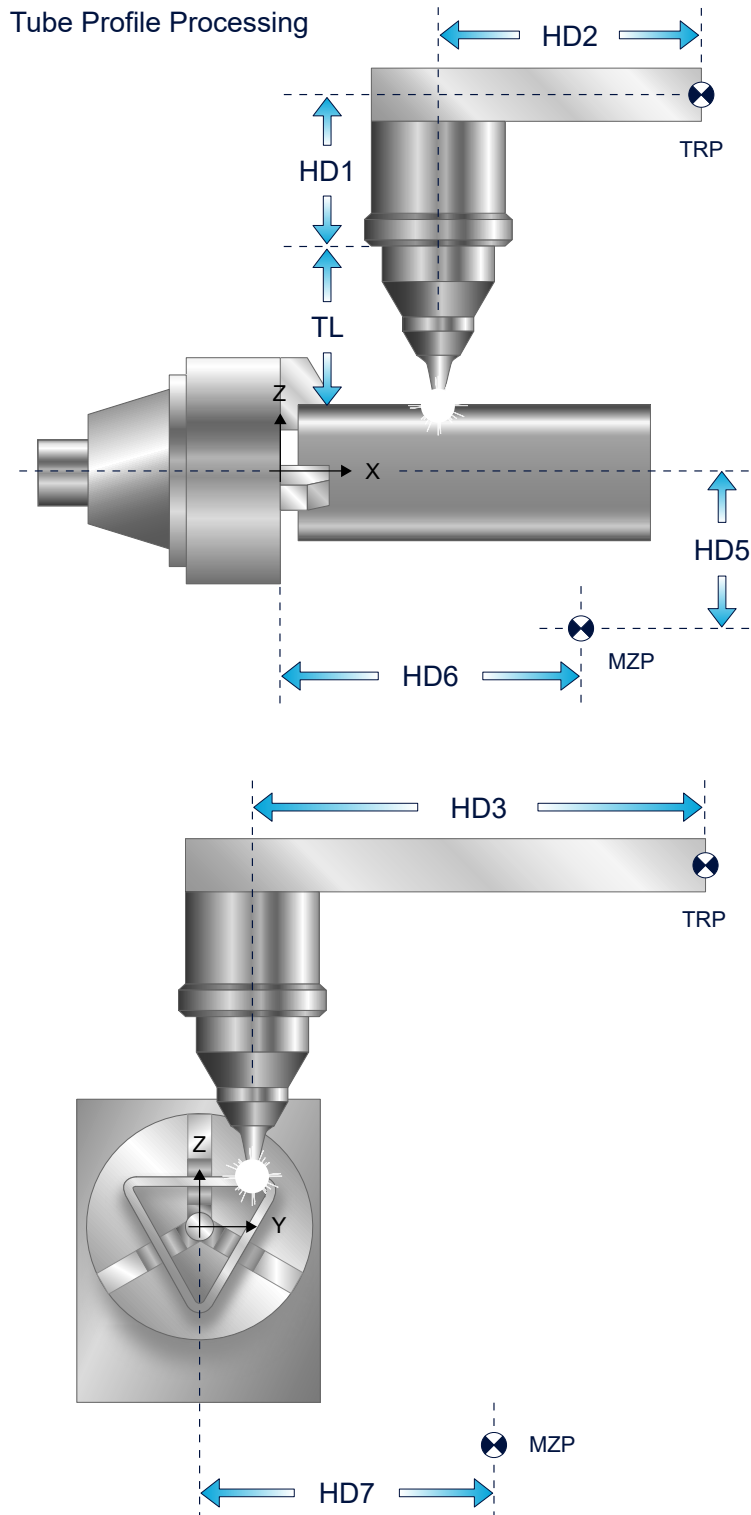


Fig. 59: Profiled tube transformation kinematic offsets

Tube Profile Processing

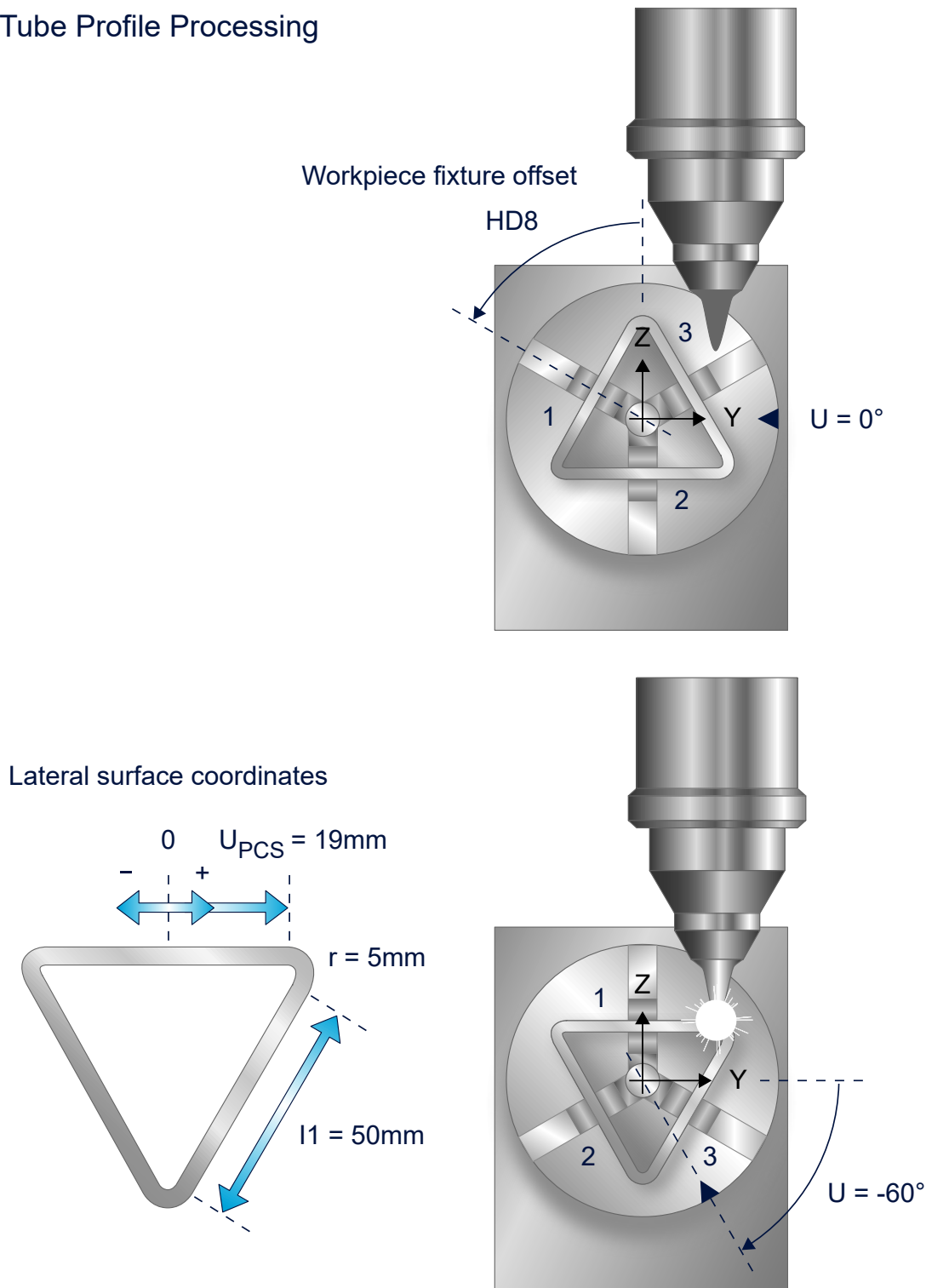


Fig. 60: Offset for workpiece clamp position

When the rotary workpiece axis is in zero position, the clamped workpiece is normally not in the specified basic orientation where the workpiece axis is perpendicular to the profile section. The kinematic parameter HD8 considers the clamp position of the profiled tube. In this case, the workpiece must be oriented above the rotary axis so that a plane surface of the profile is perpendicular to the tool. In the current example the U axis is moved to -60°; the required offset setting is then +60°.

In the above figure, the lateral surface system is then obtained after the transformation is selected according to following parameters #CYL[EDGES=3 ROUNDING=5 LENGTH1=50]. The zero point of the lateral surface system is located in the middle of lateral plane 1; the PCS start position of the TCP is U_{PCS} = +19mm.

Tube Profile Processing

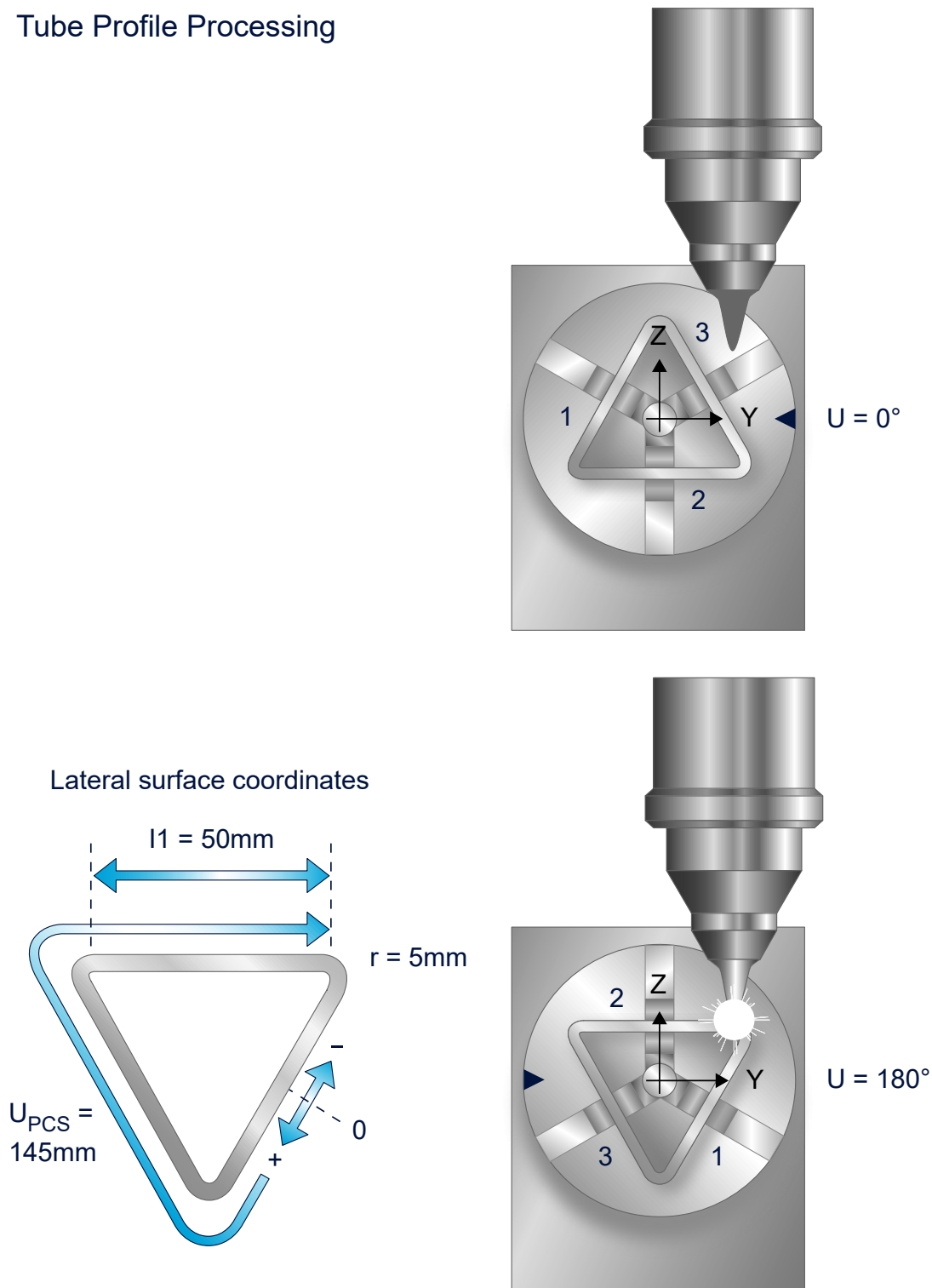


Fig. 61: Selection on the plane lateral surface

In the following case the transformation should be activated on the lateral surface 2. The clamping position and kinematic parameter HD8 correspond to the above example. The U axis is positioned at 180° before the transformation is selected so that the tool is perpendicular to the required plane surface.

In the above figure, the lateral surface system is then obtained after transformation is selected according to the following parameters #CYL[EDGES=3 ROUNDING=5 LENGTH1=50]. The zero point of the lateral surface system is located in the middle of lateral plane 1; in the lateral surface system, it is located at the start position $U_{PCS}=145\text{mm}$.

Tube Profile Processing

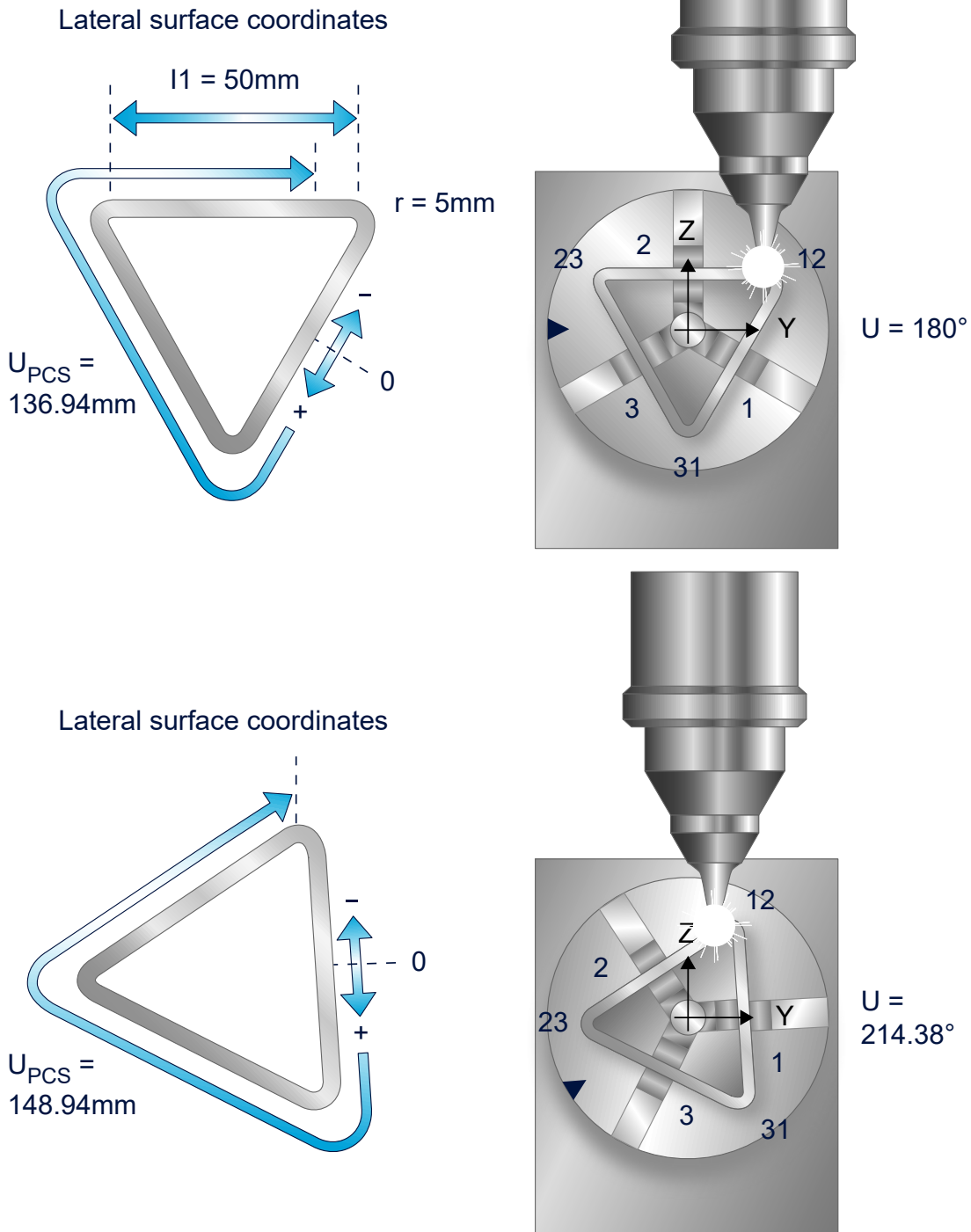


Fig. 62: Selection on profile rounding

In this case the transformation should be activated on the profile rounding 12. The clamping position and kinematic parameter HD8 correspond to the above example. The lateral surface system is obtained after transformation is selected as shown in above figure. The system is located at the start position $U_{PCS}=136.94\text{mm}$. The approach to the profile rounding at position $U_{PCS}=148.94\text{mm}$ is executed by positioning with the command #PTP ON.

Polygonal tube, profiled tube (kinematic ID 79)

N30 ...

```
N40 G0 G90 X0 Y=20 U=0 Z50
N50 #CYL [EDGES=3, ROUNDING=5, LENGTH1=50]
N60 #PTP ON
N70 G0 G90 U148.94 Z40
N80 #PTP OFF
N90 Z0
N100 G01 U150 X5
...
```

3.5.2.3.1 M / H Steuercodes

The M/H functions described below can be used for process control on the profile rounding.

Variable name	Type	Permitted range	Dimension
tube_profile.techno_nr_rnd_on	SGN16	-1 ... [M/H_FKT_ANZ-1] Default: -1 = not used	---
tube_profile.techno_nr_rnd_off	SGN16	-1 ... [M/H_FKT_ANZ-1] Default: -1 = not used	---
tube_profile.techno_type	SGN16	0 : M numbers 1 : H numbers	----

Value M/H_FKT_ANZ	Meaning
application-specific	Maximum number of M/H functions

NOTICE

To activate the function, the M/H numbers of the two parameters must be ≥ 0 .
M/H numbers may not already be assigned by an application in P-CHAN-00041 (m_synch[...]) or P-CHAN-00027 (h_synch[...]).

Excerpt from the channel parameter list:

```
# Definition of M/H functions for profiled tube rounding technology
# =====
:
tube_profile.techno_type           1           Use of H numbers
tube_profile.techno_nr_rnd_on     300      H number, engage in rounding
tube_profile.techno_nr_rnd_off    400      H number, retract from rounding
#
```

3.5.2.4 Round tube, lateral surface (5/6-axis) (kinematic ID 90)

3.5.2.4.1 Parameters for AB orientation head

Parameters are defined under the ID 90 of the kinematic offsets (P-CHAN-00263 and P-CHAN-00094).

HD offset	param[i]	Description	Unit
HD1	0	Z axis offset to the tool fixing point	1.0 E-4 mm
HD2	1	X axis offset to the tool fixing point	1.0 E-4 mm
HD3	2	Y axis offset to the tool fixing point	1.0 E-4 mm
HD4	3	X axis offset rotation point A axis to rotation point B axis	1.0 E-4 mm
HD5	4	Y axis offset rotation point A axis to rotation point B axis	1.0 E-4 mm
HD6	5	Z axis offset rotation point A axis to rotation point B axis	1.0 E-4 mm
HD7	6	X axis offset zero point to rotation point A axis	1.0 E-4 mm
HD8	7	Y axis offset zero point to rotation point A axis	1.0 E-4 mm
HD9	8	Z axis offset zero point to rotation point A axis	1.0 E-4 mm
HD10	9	n.a.	

HD11	10	n.a.	
HD12	11	Angle offset U/V axis	1.0 E-4°
HD13	12	Orientation head, sequence of rotary axes 0: AB 1: BA	[-]
HD14	13	PCS angle programming 0: same as orientation head 1: CA	[-]
HD15	14	Rotation direction AM 0: math positive 1: math negative	[-]
HD16	15	Rotation direction BM 0: math positive 1: math negative	[-]
HD17	16	Angle offset AM	1.0 E-4°
HD18	17	Angle offset BM	1.0 E-4°

The general description is contained in the channel parameter list under P-CHAN-00263 and P-CHAN-00094.

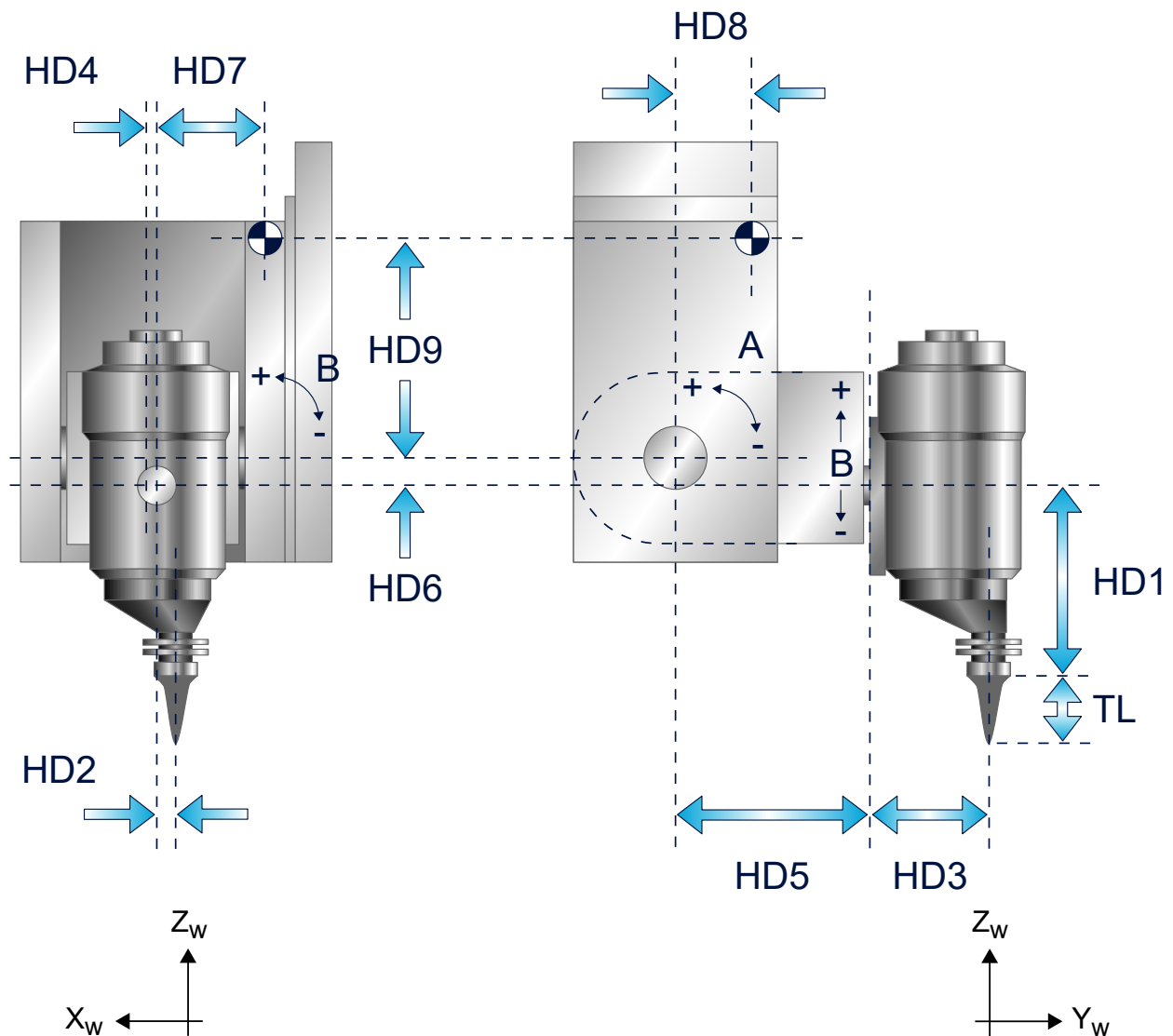


Fig. 63: Parameters of AB tool head

3.5.2.4.2 Parameters for BA orientation head

Parameters are defined under the ID 90 of the kinematic offsets (P-CHAN-00263 and P-CHAN-00094).

HD offset	param[i]	Description	Unit
HD1	0	Z axis offset to the tool fixing point	1.0 E-4 mm
HD2	1	X axis offset to the tool fixing point	1.0 E-4 mm
HD3	2	Y axis offset to the tool fixing point	1.0 E-4 mm
HD4	3	X axis offset rotation point B axis to rotation point A axis	1.0 E-4 mm
HD5	4	Y axis offset rotation point B axis to rotation point A axis	1.0 E-4 mm
HD6	5	Z axis offset rotation point B axis to rotation point A axis	1.0 E-4 mm
HD7	6	X axis offset zero point to rotation point B axis	1.0 E-4 mm
HD8	7	Y axis offset zero point to rotation point B axis	1.0 E-4 mm
HD9	8	Z axis offset zero point to rotation point B axis	1.0 E-4 mm
HD10	9	n.a.	
HD11	10	n.a.	
HD12	11	Angle offset U/V axis	1.0 E-4°
HD13	12	Orientation head, sequence of rotary axes 0: AB 1: BA	[-]
HD14	13	PCS angle programming 0: same as orientation head 1: CA	[-]
HD15	14	Rotation direction AM 0: math positive 1: math negative	[-]
HD16	15	Rotation direction BM 0: math positive 1: math negative	[-]
HD17	16	Angle offset AM	1.0 E-4°
HD18	17	Angle offset BM	1.0 E-4°

The general description is contained in the channel parameter list under P-CHAN-00263 and P-CHAN-00094.

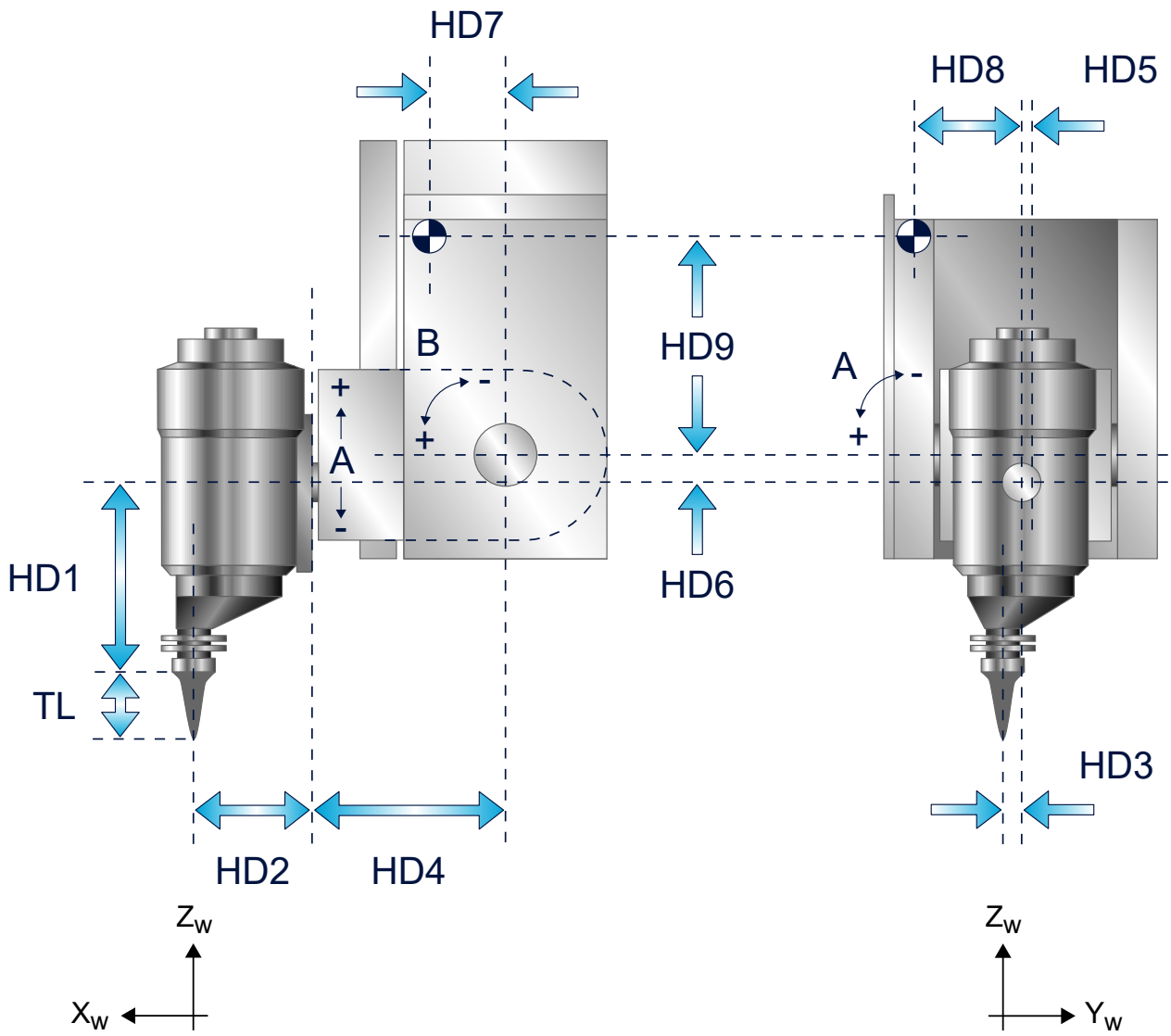


Fig. 64: Parameters for BA orientation head

3.5.2.4.3 Parameters for CA orientation head

Parameters are defined under the ID 90 of the kinematic offsets (P-CHAN-00263 and P-CHAN-00094).

HD offset	param[i]	Description	Unit
HD1	0	Z axis offset to the tool fixing point	1.0 E-4 mm
HD2	1	X axis offset to the tool fixing point	1.0 E-4 mm
HD3	2	Y axis offset to the tool fixing point	1.0 E-4 mm
HD4	3	X axis offset rotation point C axis to rotation point A axis	1.0 E-4 mm
HD5	4	Y axis offset rotation point C axis to rotation point A axis	1.0 E-4 mm
HD6	5	Z axis offset rotation point C axis to rotation point A axis	1.0 E-4 mm
HD7	6	X offset reference point to rotation point C axis	1.0 E-4 mm
HD8	7	Y offset reference point to rotation point C axis	1.0 E-4 mm
HD9	8	Z offset reference point to rotation point C axis	1.0 E-4 mm
HD10	9	n.a.	
HD11	10	n.a.	
HD12	11	Angle offset U/V axis	1.0 E-4°
HD13	12	Orientation head, sequence of rotary axes 2: CA 4: CB	[-]
HD14	13	-	
HD15	14	Rotation direction CM 0: math positive 1: math negative	[-]
HD16	15	Rotation direction AM 0: math positive 1: math negative	[-]
HD17	16	Angle offset CM	1.0 E-4°
HD18	17	Angle offset AM	1.0 E-4°

The general description is contained in the channel parameter list under P-CHAN-00263 and P-CHAN-00094.

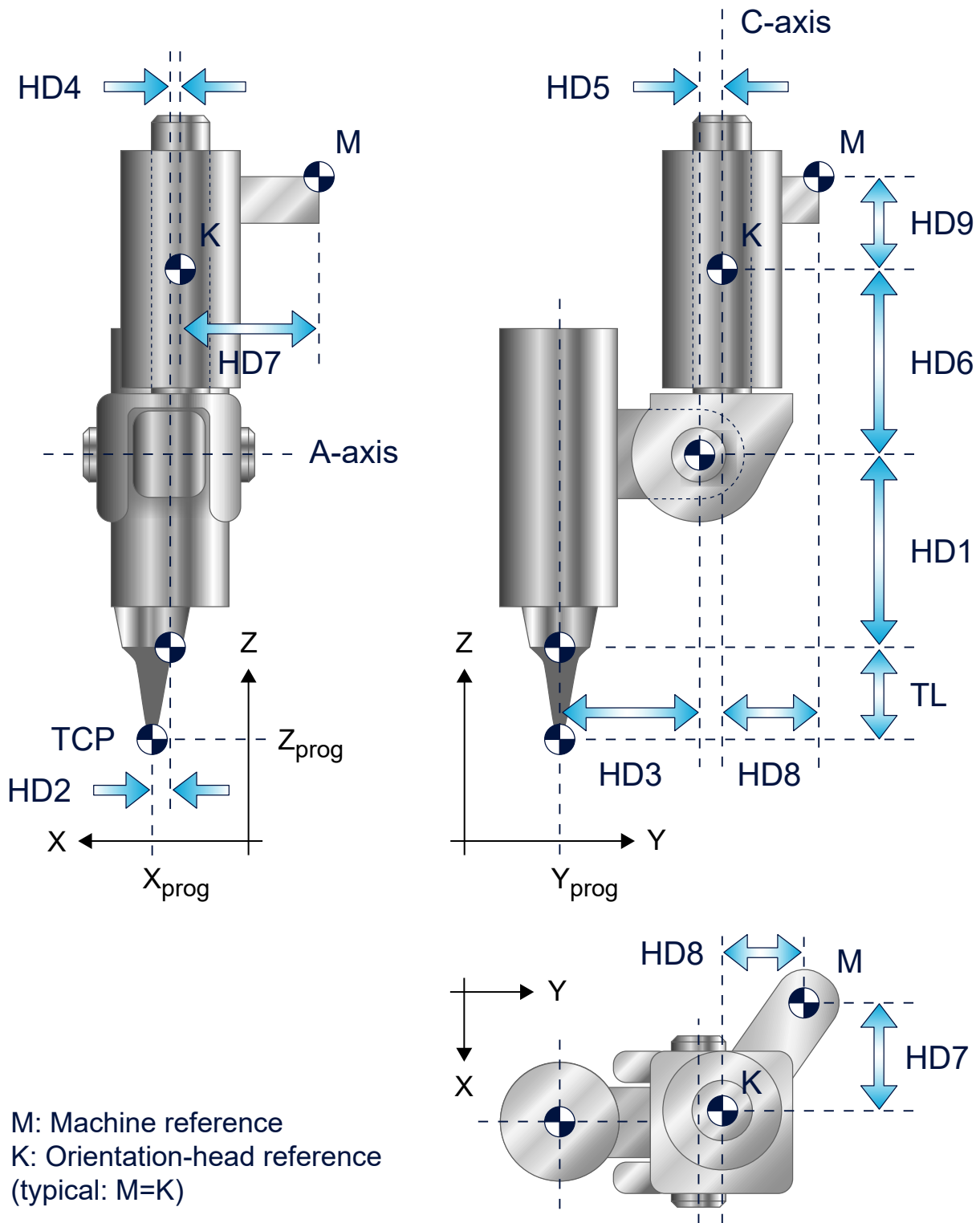


Fig. 65: Parameters for CA orientation head

3.5.2.4.4 Parameters for CB orientation head

Parameters are defined under the ID 90 of the kinematic offsets (P-CHAN-00263 and P-CHAN-00094).

HD offset	param[i]	Description	Unit
HD1	0	Z axis offset to the tool fixing point	1.0 E-4 mm
HD2	1	X axis offset to the tool fixing point	1.0 E-4 mm
HD3	2	Y axis offset to the tool fixing point	1.0 E-4 mm
HD4	3	X axis offset rotation point C axis to rotation point B axis	1.0 E-4 mm
HD5	4	Y axis offset rotation point C axis to rotation point B axis	1.0 E-4 mm
HD6	5	Z axis offset rotation point C axis to rotation point B axis	1.0 E-4 mm
HD7	6	X axis offset zero point to rotation point B axis	1.0 E-4 mm
HD8	7	Y axis offset zero point to rotation point B axis	1.0 E-4 mm
HD9	8	Z axis offset zero point to rotation point B axis	1.0 E-4 mm
HD10	9	n.a.	
HD11	10	n.a.	
HD12	11	Angle offset U/V axis	1.0 E-4°
HD13	12	Orientation head, sequence of rotary axes 2: CA 4: CB	[-]
HD14	13	-	
HD15	14	Rotation direction CM 0: math positive 1: math negative	[-]
HD16	15	Rotation direction BM 0: math positive 1: math negative	[-]
HD17	16	Angle offset CM	1.0 E-4°
HD18	17	Angle offset BM	1.0 E-4°

The general description is contained in the channel parameter list under P-CHAN-00263 and P-CHAN-00094.

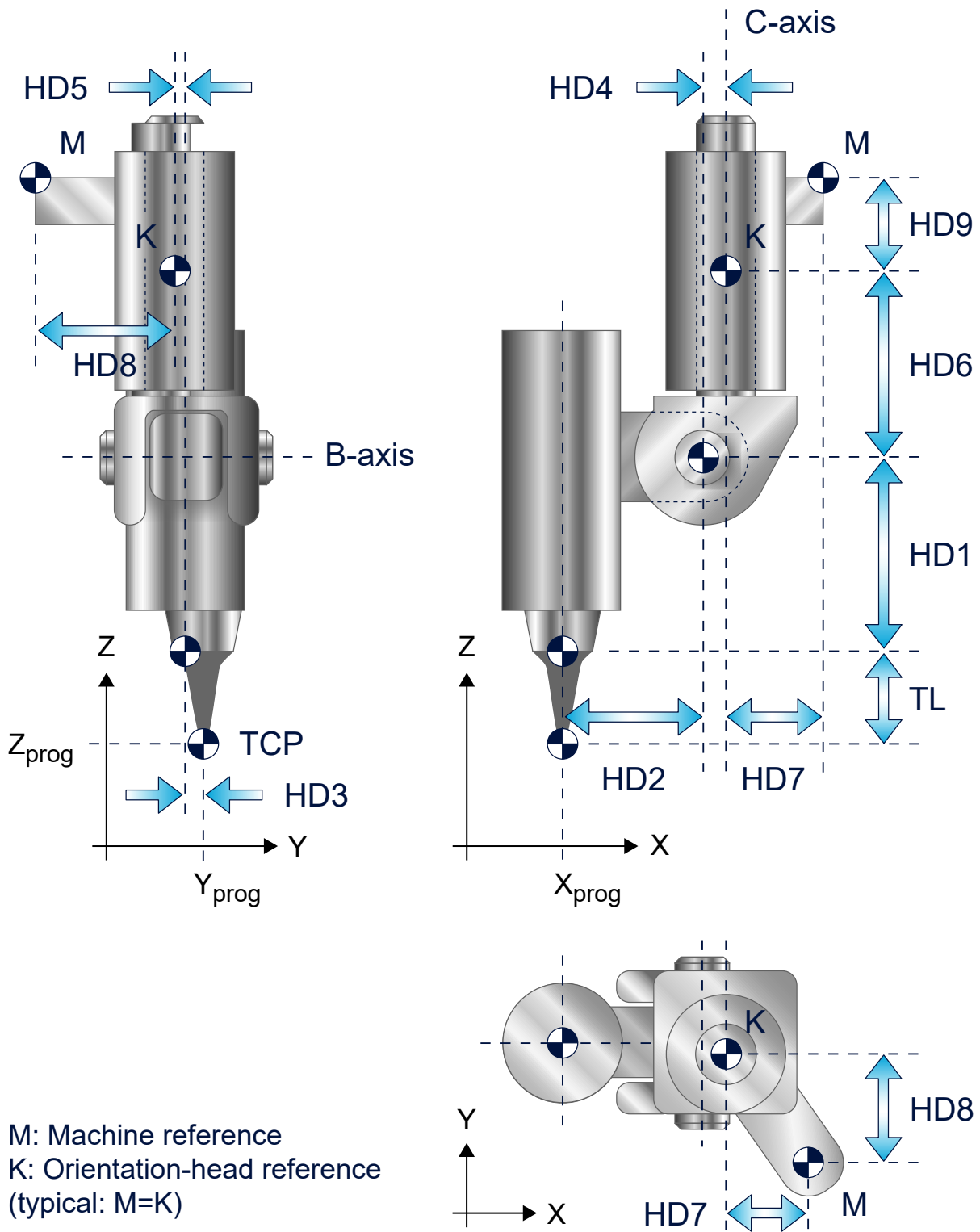


Fig. 66: Parameters for CB orientation head

3.5.2.4.5 Parameters for CA cardanic orientation head

Parameters are defined under the ID 90 of the kinematic offsets (P-CHAN-00263 and P-CHAN-00094).

HD offset	param[i]	Description	Unit
HD1	0	n.a.	
HD2	1	n.a.	
HD3	2	Head angle	1.0 E-4°
HD4	3	n.a.	
HD5	4	n.a.	
HD6	5	Orientation C axis head; required if head has a 180° offset in zero position. 0: Default 1: 180 degree offset	[-]
HD7	6	X offset reference point to rotation point C axis	1.0 E-4 mm
HD8	7	Y offset reference point to rotation point C axis	1.0 E-4 mm
HD9	8	Z offset reference point to rotation point C axis	1.0 E-4 mm
HD10	9	n.a.	
HD11	10	n.a.	
HD12	11	Angle offset U/V axis	1.0 E-4°
HD13	12	Orientation head, sequence of rotary axes: 2: CA 8: CA cardanic	[-]
HD14	13	n.a.	
HD15	14	X offset to tool holding device	1.0 E-4 mm
HD16	15	Y offset to tool holding device	1.0 E-4 mm
HD17	16	Z offset to tool holding device	1.0 E-4 mm
HD18	17	X offset A axis to C axis	1.0 E-4 mm
HD19	18	Y offset A axis to C axis	1.0 E-4 mm
HD20	19	Z offset A axis to C axis	1.0 E-4 mm

The general description is contained in the channel parameter list under P-CHAN-00263 and P-CHAN-00094.

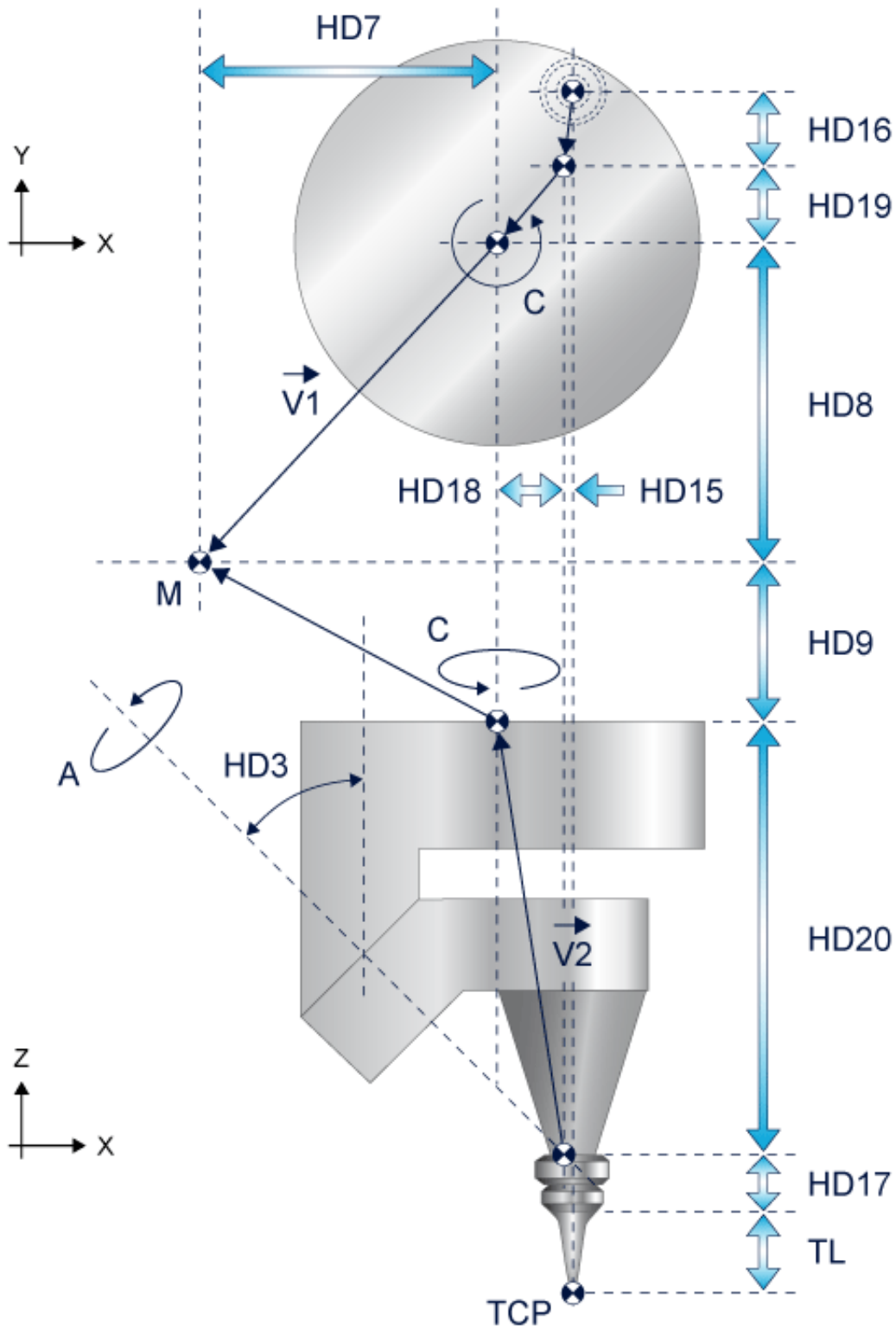


Fig. 67: Cardanic head in zero position, HD6=0

3.5.2.4.6 Parameters for AU kinematics

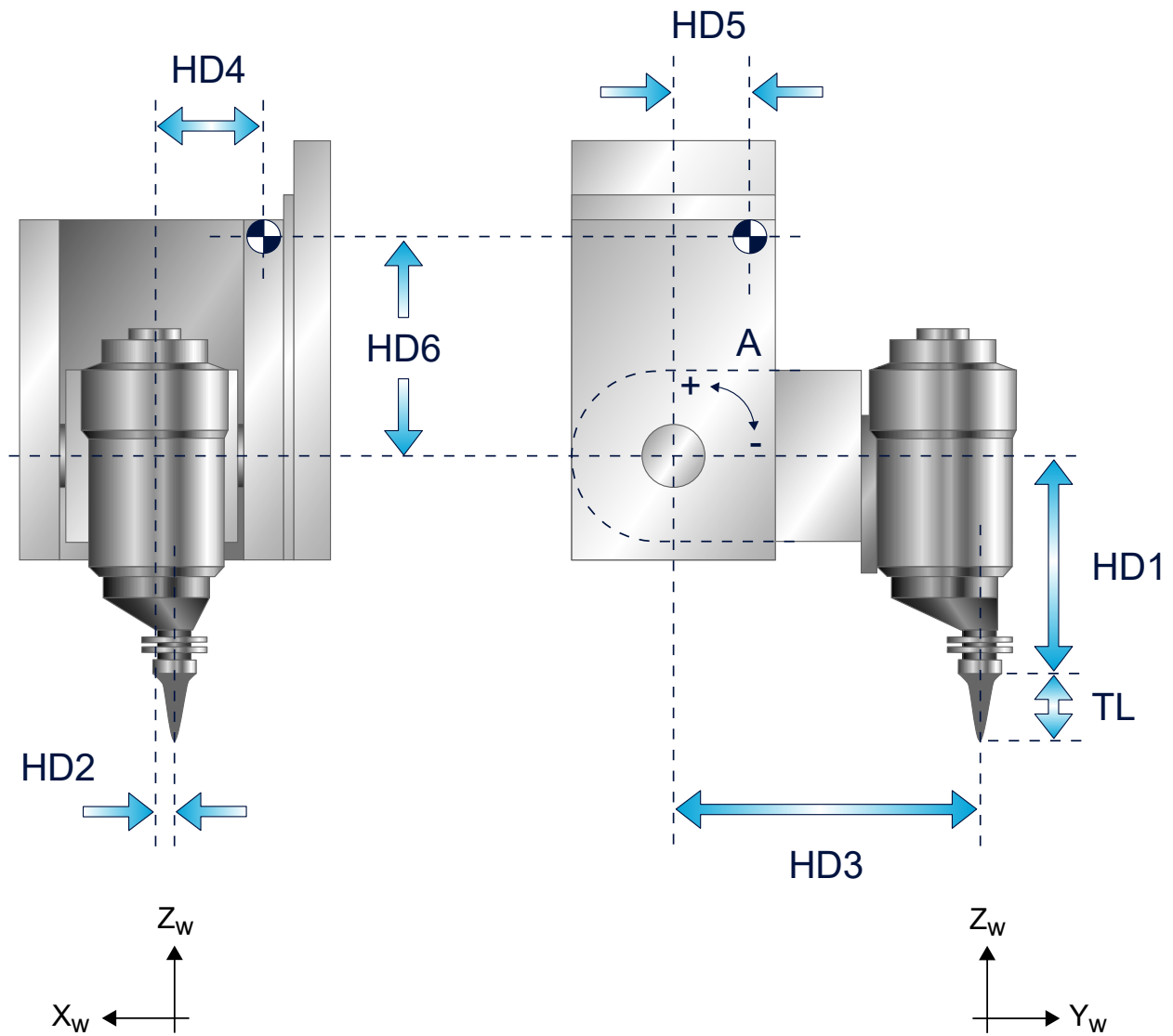


Fig. 68: Parameters of AU tool head

Parameters are defined under the ID 90 of the kinematic offsets (P-CHAN-00263 and P-CHAN-00094).

HD offset	param[i]	Description	Unit
HD1	0	Z axis offset to the tool fixing point	1.0 E-4 mm
HD2	1	X axis offset to the tool fixing point	1.0 E-4 mm
HD3	2	Y axis offset to the tool fixing point	1.0 E-4 mm
HD4	3	X offset rotation point A axis to reference point tool slide	1.0 E-4 mm
HD5	4	Y offset rotation point A axis to reference point tool slide	1.0 E-4 mm
HD6	5	Z offset rotation point A axis to reference point tool slide	1.0 E-4 mm
HD7	6	X offset to machine origin	1.0 E-4 mm
HD8	7	Y offset to machine origin	1.0 E-4 mm
HD9	8	Z offset to machine origin	1.0 E-4 mm
HD10	9	n.a.	
HD11	10	n.a.	
HD12	11	Angle offset U/V axis	1.0 E-4°
HD13	12	Machine structure 9 : A U 10: B V	[-]
HD14	13	PCS angle programming 0: same as kinematic 1: CA	[-]
HD15	14	Rotation direction AM 0: math positive 1: math negative	[-]
HD16	15	Rotation direction BM 0: math positive 1: math negative	[-]
HD17	16	Angle offset AM	1.0 E-4°
HD18	17	Angle offset BM	1.0 E-4°

The general description is contained in the channel parameter list under P-CHAN-00263 and P-CHAN-00094.

3.5.2.4.7 Parameters for BV kinematics

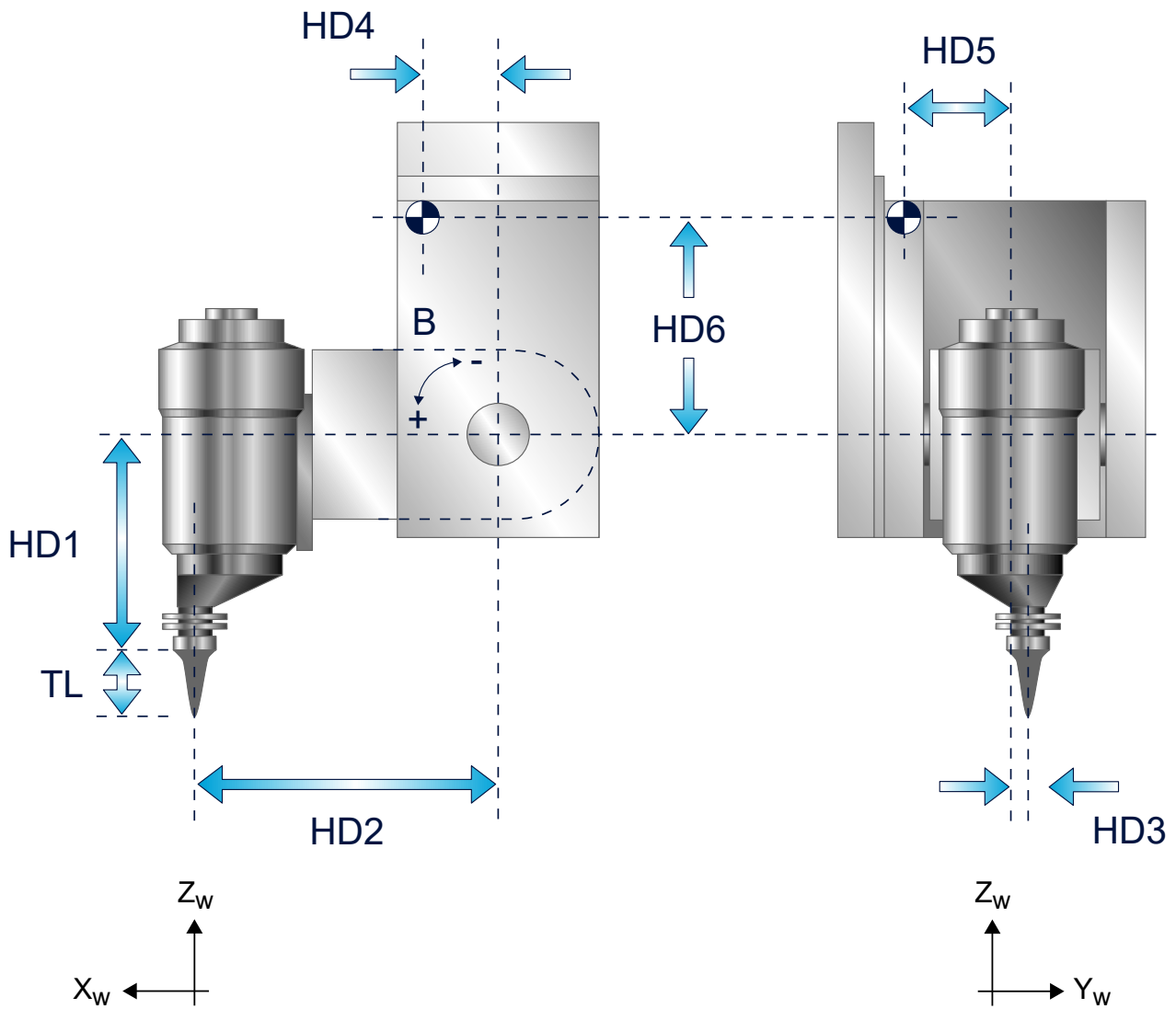


Fig. 69: Parameters of BV tool head

Parameters are defined under the ID 90 of the kinematic offsets (P-CHAN-00263 and P-CHAN-00094).

HD offset	param[i]	Description	Unit
HD1	0	Z axis offset to the tool fixing point	1.0 E-4 mm
HD2	1	X axis offset to the tool fixing point	1.0 E-4 mm
HD3	2	Y axis offset to the tool fixing point	1.0 E-4 mm
HD4	3	X offset rotation point B axis to reference point tool slide	1.0 E-4 mm
HD5	4	Y offset rotation point B axis to reference point tool slide	1.0 E-4 mm
HD6	5	Z offset rotation point B-axis to reference point tool slide	1.0 E-4 mm
HD7	6	X offset to machine origin	1.0 E-4 mm
HD8	7	Y offset to machine origin	1.0 E-4 mm
HD9	8	Z offset to machine origin	1.0 E-4 mm
HD10	9	n.a.	
HD11	10	n.a.	
HD12	11	Angle offset U/V axis	1.0 E-4°
HD13	12	Machine structure 9 : A U 10: B V	[-]
HD14	13	PCS angle programming 0: same as kinematic 1: CA	[-]
HD15	14	Rotation direction AM 0: math positive 1: math negative	[-]
HD16	15	Rotation direction BM 0: math positive 1: math negative	[-]
HD17	16	Angle offset AM	1.0 E-4°
HD18	17	Angle offset BM	1.0 E-4°

The general description is contained in the channel parameter list under P-CHAN-00263 and P-CHAN-00094.

3.5.2.5 Polygonal tube, profiled tube (5/6-axis) (kinematic ID 93)

Configuration

Kinematic 93 is configured in analogy to kinematic 90 in section "Round tube, lateral surface (5/6-axis) [► 125]". In addition the user can specify kinematic parameters as of index 23. The parameters correspond to kinematic 79 described in section "Polygonal tube, profiled tube [► 120]" (i.e. Index 23 in kinematic 93 corresponds to Index 3 in kinematic 79 etc.).

As an example the configuration her is shown of an AB orientation head. Parameterisation is analogous for all other orientation heads.

Note: All offsets starting from Index 20 act as static offsets, i.e. they are not influenced by rotations within the head.

3.5.2.5.1 Parameters for AB and BV orientation head

Parameters are defined under the ID 93 of the kinematic offsets (P-CHAN-00263 and P-CHAN-00094).

The parameters in the AB and BV configurations only differ in the assignment of HD13.

HD offset	param[i]	Description	Unit
HD1	0	Z axis offset to the tool fixing point	1.0 E-4 mm
HD2	1	X axis offset to the tool fixing point	1.0 E-4 mm
HD3	2	Y axis offset to the tool fixing point	1.0 E-4 mm
HD4	3	X offset rotation point A axis to. rotation point B axis	1.0 E-4 mm
HD5	4	Y axis offset rotation point A axis to rotation point B axis	1.0 E-4 mm
HD6	5	Z axis offset rotation point A axis to rotation point B axis	1.0 E-4 mm
HD7	6	X axis offset zero point to rotation point A axis	1.0 E-4 mm
HD8	7	Y axis offset zero point to rotation point A axis	1.0 E-4 mm
HD9	8	Z axis offset zero point to rotation point A axis	1.0 E-4 mm
HD10	9	n.a.	
HD11	10	n.a.	
HD12	11	Angle offset U/V axis	1.0 E-4°
HD13	12	Orientation head, sequence of rotary axes 0 : AB 10: BV	[-]
HD14	13	PCS angle programming 0: same as orientation head 1: CA	[-]
HD15	14	Rotation direction AM, , 0: math positive 1: math negative	[-]
HD16	15	Rotation direction BM 0: math positive 1: math negative	[-]
HD17	16	Angle offset AM	1.0 E-4°
HD18	17	Angle offset BM	1.0 E-4°
HD19	18	n.a.	
HD20	19	n.a.	
HD21	20	n.a.	
HD22	21	n.a.	
HD23	22	n.a.	
HD24	23	Z offset of rotary axis U to machine zero point (MNP)	1.0 E-4 mm
HD25	24	X offset of rotary axis U to machine zero point	1.0 E-4 mm

HD26	25	Y offset of rotary axis U to machine zero point	1.0 E-4 mm
HD27	26	-	
HD28	27	Angle offset of workpiece clamp position	1.0 E-4°

The general description is contained in the channel parameter list under P-CHAN-00263 and P-CHAN-00094.

3.6 Block search and profiled tube machining

Resuming path approach

Please note the following when path motion is resumed on profiled tubes with the block search function:

- The approach motion in an area with an active #CYL [EDGES..] or #CYL ORI PROFILE [EDGES=...] takes place on the **ACS plane**. To prevent any collision between tool and workpiece, position the tool at a sufficient safety height (U axis rotates without compensation motion of Z).
- The tool must be perpendicular to the profile surface and within the capture range of the profile (see figure below).
- The approach motion is executed in two steps:
 1. Approach motions without Z axis (e.g. U, Y, X)
 2. Approach motion of the Z axis

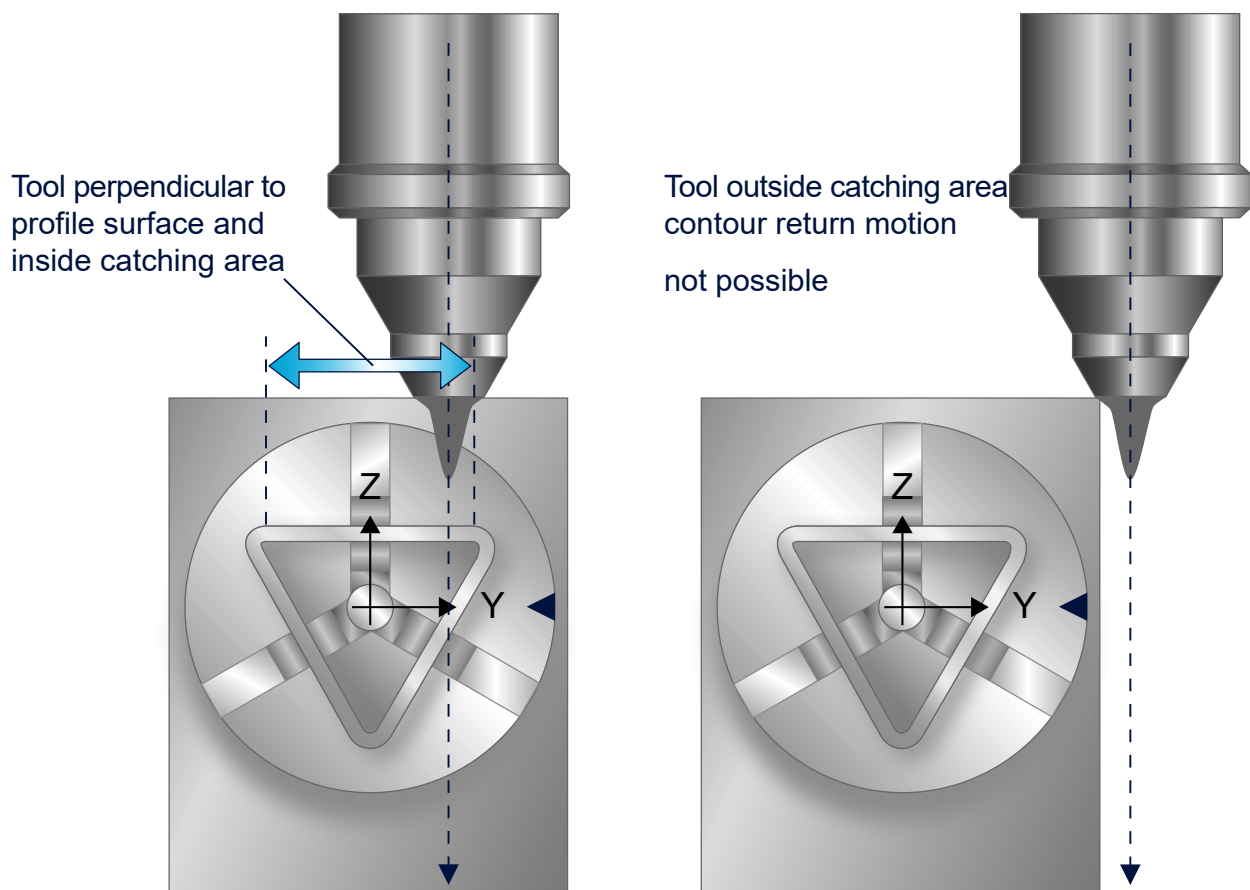


Fig. 70: Starting position for motion resumption

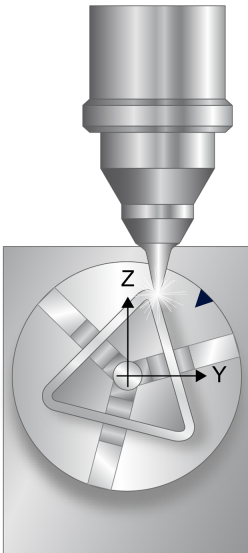


Fig. 71: Axis position after motion resumption

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