Exploring

SmartCAM® V11.5

Advanced Wire EDM™

Doc SC007-MRS

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SmartCAMcnc

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Welcome

Welcome to the exploration of SmartCAM Advanced Wire EDM. Before you begin this exploration, take a few minutes to read through this introduction.

Overview

SmartCAM Advanced Wire EDM provides extremely accurate wirepath for both 2- and 4-axis wire EDM machines. It offers the flexibility and functionality that you need today plus a long-term growth path for your future needs. Like all SmartCAM applications, Advanced Wire EDM does more than reduce your programming time, it helps you improve your machining processes and move your products to market faster.

Using Your Exploring Manual

This manual is designed to be used, not simply read. It is yours to keep. It is organized into units that cover different parts of the system. The individual lessons in each unit contain the following material:

- Lesson Objectives
- Feature Overviews
- Points to Remember
- Challenge Projects

Exploring Prerequisites

While SmartCAM is easy to understand and operate, you will benefit from having some experience with computers and machine tools. You will find it helpful to be familiar with Microsoft Windows and its corresponding commands.

You should also be familiar with these topics:

- Hard disk organization
- Computer Numerical Control (CNC) programming practices
- Basic machine tool terminology

Following SmartCAM Advanced Wire EDM Exploring Program

SmartCAM Advanced Wire EDM exploring sessions are intended to give you a broad introduction to the SmartCAM Advanced Wire EDM software features while helping you build a solid foundation of skills.

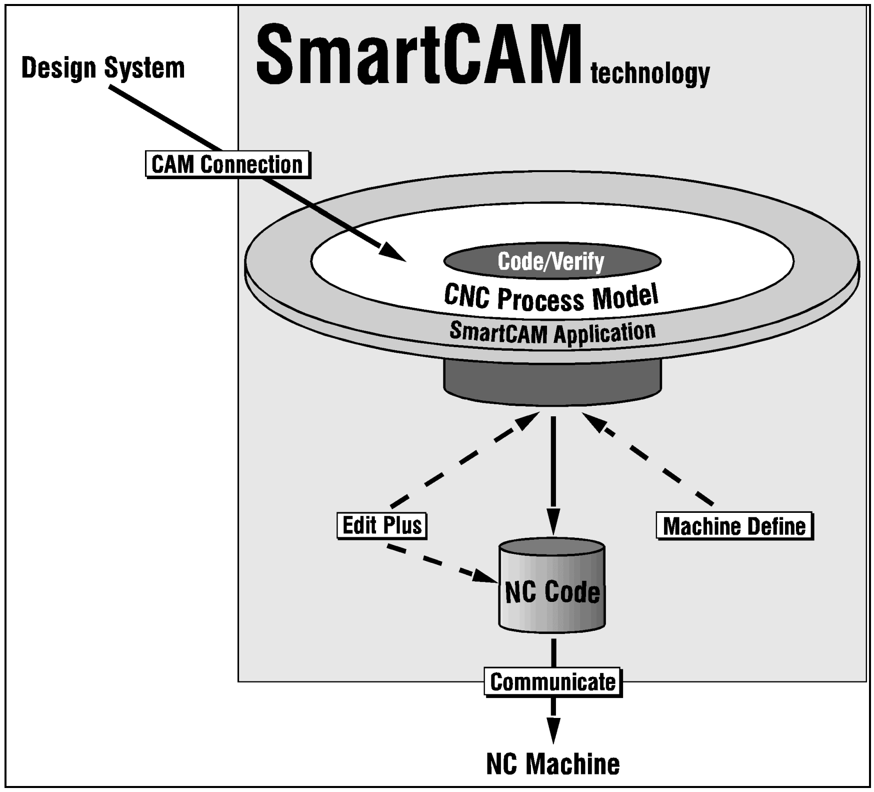
This will enable you to easily learn more advanced skills as you use SmartCAM, on your own, to accomplish specific work requirements.

Exploring Advanced Wire EDM Objectives

- Become acquainted with SmartCAM.
- Work with SmartCAM.
- Use job operations.
- Work with elements.
- Generate and verify 4-axis toolpath.
- Generate code.
- Apply advanced techniques.

Learning SmartCAM Technology

SmartCAM consists of several modules that work together to provide a single method for changing a design into machine code. These modules are shown in the following figure and are described in the next section.



SmartCAM CNC Process Modeling

The SmartCAM approach to CNC machining captures the mental model you have when you create a part and display it on your computer screen as a graphic model. This enables you to create, change, and interact with the model of the manufacturing process. This model is called the *CNC Process Model*. The part geometry and toolpath are incorporated as you build the model, and you can view the toolpath at any time. When the machining process is correct, you generate code directly from the model.

Considerations such as feeds and speeds, tool availability, fixtures, and machine idiosyncrasies are part of the model. When changes are required, you can easily revise the model and generate code again.

When you add a new machine, you simply select the new machine and template files and regenerate the code.

SmartCAM's Components

Each SmartCAM application is composed of two pieces that work together: a CNC Process Model and a job operations setup.

CNC Process Model

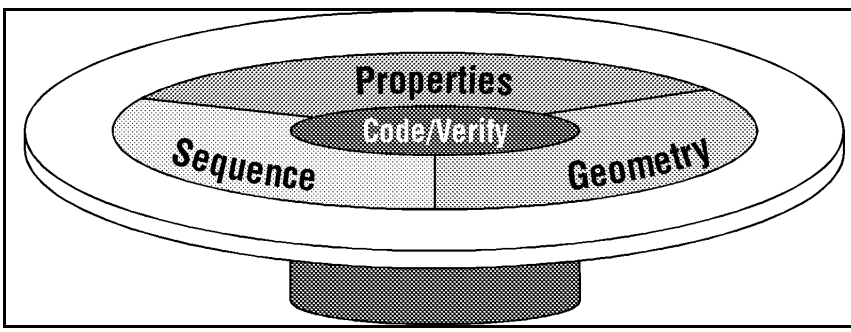
A SmartCAM CNC Process Model is a dynamic, sequential toolpath database. Part geometry is immediately converted into toolpath, sequenced in the way the machine will cut the part. Any changes you make to the model immediately update the database.

Because there is no separation of part geometry and toolpath, you do not need to wait until you finish creating the geometry to specify its sequence and properties. You can make changes at any time and instantly view the resulting tool motion.

As you build a CNC Process Model, you incorporate the following:

- **Sequence** (when the operation should occur)—the order that machining operations and toolpath become part of the model.
- **Properties** (how the operation should occur)—machining parameters, such as tool selection, depths, tool offset direction, and machine-control behavior, are assigned to the toolpath.
- **Geometry** (where the operation should occur)—elements defining the toolpath, such as linear or circular cutting, rapid traverses, and lead-in moves, are added to the model.

As you build and save a model, it is stored in a process model file. All process model files have a `.pm4` extension.



Job Operations Setup

An important part of the CNC Process Model is the information about the tools and operations you use to machine the part. This information, known as the *job operations setup,* is stored in the job operations file. All job operations files have a `.jof` extension. Each process model is linked to a `.jof` file.

The job operations setup links tools and operations together as *process steps*. As you develop a process model, you assign steps to the toolpath elements. Each step contains all the parameters for a specific tool and a specific operation. When you generate NC code, SmartCAM accesses the `.jof` file and uses the tool and operation parameters. This information can be printed and used by the machine operator to set up the machine.

Applications

Your SmartCAM application provides the graphic environment for creating a CNC Process Model and NC code. Use the various tools available in the application to define the process for machining the part. Change the sequence, properties, or geometry as needed, and view the results before you create code. When the model is complete, select the Code option from the Process menu to generate machine-ready NC code from the process model.

Edit Plus

Edit Plus is an ASCII text editor that you can use for a variety of editing tasks. Edit Plus's features include search and replace, repeat with axis increments, and absolute-to-incremental conversion. These features speed up the editing process.

Communicate

For Windows users, Communicate provides various ways to communicate with your CNC machine using RS-232 or parallel communication formats. You can punch a tape, read a tape, or send code directly to or from a machine's controller.

CAM Connection

CAM Connection translates files from CAD systems into information SmartCAM can use to create geometry for a CNC Process Model.

Machine Define

Machine Define specifies and configures a machine file that sets the parameters relating to your machine's code requirements. Machine (`.smf`) files for several popular CNC machines come with your SmartCAM system. If these do not fit your needs, you can easily modify them to do the job.

SmartCAM Visual CTK

SmartCAM Visual CTK is a drag-and-drop WYSIWYG (what you see is what you get) development environment that enables you to create dialog boxes and control panels for your macros. This helps you to integrate your customized productivity solutions into the SmartCAM interface.

Using the Documentation

Your SmartCAM documentation package also includes these documents:

- *Installation Guide for All SmartCAM Products* contains instructions on how to install the SmartCAM software and customize your SmartCAM display.

These documents can now be found online:

- *User Guide* provides information about the tools you use to create a CNC Process Model.
- *SmartCAM Edit Plus User Guide* describes how to use the SmartCAM text editor.
- S*martCAM Communicate User Guide* provides an overview of RS-232 communications and an explanation of how to use the Communicate utility.
- *SmartCAM CAM Connections* shows how to convert both CAD-prepared drawing files into SmartCAM CNC Process Model files and SmartCAM CNC Process Model files into CAD files.
- *SmartCAM CAM Connection Reference Manual* provides information about how the CAM Connection application translates CAD input files into CAM output files. It also contains information about customizing the CAM Connection environment and running the application non-graphically.
- *SmartCAM Code Generation Guide* provides in-depth information about generating NC code from your CNC Process Model, reference sections for machine files and template files, and an explanation of how to use the Machine Define utility.
- *SmartCAM Customization Manual* contains information on how to customize SmartCAM windows, hot keys, icons, and macro commands.

Using Online SmartCAM Manuals

SmartCAM manuals are available for use online. You can search for a specific term, see graphics that explain advanced applications, look for an explanation of a specific error message, and more. Online documentation is quick and easy to use, and it answers your questions as they come up while you are working at the computer. The online reader provides an opportunity to search all or any of the manuals at one time for words, phrases, even wild card expressions.

Using Online Help

You can find more information about a topic or an input field using these methods:

- Use context-sensitive Help by performing these tasks:
  a. Press **Shift +F1** to display a cursor. Place the cursor anywhere, and click the left mouse button. A Help topic is displayed with an overview.
  b. To learn more about the topic you chose, select the underlined text for this topic in Help. A Help topic is displayed that has an overview and buttons for **Fields** and **How To**. Each input field is described in Fields. The How To provides operational information about how to perform a process.

- Use Search to find information about specific input fields. You enable Search when you press **F1**, select **Search**, and then enter the word to learn about.
- Use Glossary to find a word and how it is used. You can also press **F1** and select the title *Glossary*. The Glossary contains conceptual information.

Documentation Conventions

Information in SmartCAM manuals is presented in a consistent way, using the following conventions:

- Inch and metric formats are both given where appropriate. The metric measurement is enclosed in square brackets ([ ]) following the inch measurement, for example, 4.700 [120].
- Sample files are provided in both inch and metric formats. File names for metric models are similar to the corresponding inch file names except that they begin with the letter *m*. Metric files are stored in directories named with an `_m`. The metric parts are not exact conversions; they are similar parts with appropriate metric tooling.
- Points to Remember are at the end of every lesson. This provides an opportunity for you to review the important parts of each lesson.
- Self-Tests are at the end of Advanced Wire EDM units. These tests enable you to check your understanding of the *Points to Remember*. Some self-tests contain *Challenge Projects*, which enable you to apply your new skills in a challenging and practical project.
- Commands are presented exactly as you should enter them. Be sure to include all spaces.
- If your keyboard has a Return key, press that key whenever instructed to press Enter.
- Combinations of keys appear with a plus (+) between the keys; for example, **Alt+4** or **META+4** means you should hold down the ALT or META key and press the **4** key at the same time.
- On some keyboards, the META key is labeled EXTENDED CHAR.
- Selections you should make to move through a procedure appear in **bold typeface**.
- A series of selections used in directions will appear as in the following example:

  Select **Edit—Geo Edit—Blend**.

  This tells you to select **Edit** from the top menu bar, **Geo Edit** from the Edit menu, and then **Blend** from the list of Geo Edit modeling tools.

1

Becoming Acquainted with SmartCAM

Overview

It is important for you to become acquainted with the SmartCAM environment before you performWire EDM operations. This unit introduces you to the basic SmartCAM workplace, terms, files, and view manipulation techniques.

Lessons for This Unit

- Learning the SmartCAM Workplace
- Working with Files
- Manipulating the View

Learning the SmartCAM Workplace

Objectives

This lesson shows you how to perform these tasks:

- Start SmartCAM.
- Identify and define SmartCAM workplace areas.
- Identify and define SmartCAM controls.

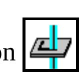
Overview

You can use the menu bar to access most of the tools in SmartCAM. You can select items in the menu bar to open pull-down menus. When you select an item, a list of items is displayed that enables you to open toolboxes, dialog boxes, and submenus. When you choose a toolbox, its title is displayed on the workbench. Depending upon your screen resolution, the last three to five toolboxes you used are displayed on the workbench. A list of tools is displayed in the toolbox, which is below the workbench.

Starting SmartCAM

If SmartCAM is not installed on your computer, see the *Installation Guide for All SmartCAM Products* for directions on installing the software.

Perform these tasks to start SmartCAM:

1. Locate the **SmartCAM Advanced Wire EDM** icon  in the SmartCAM program group.

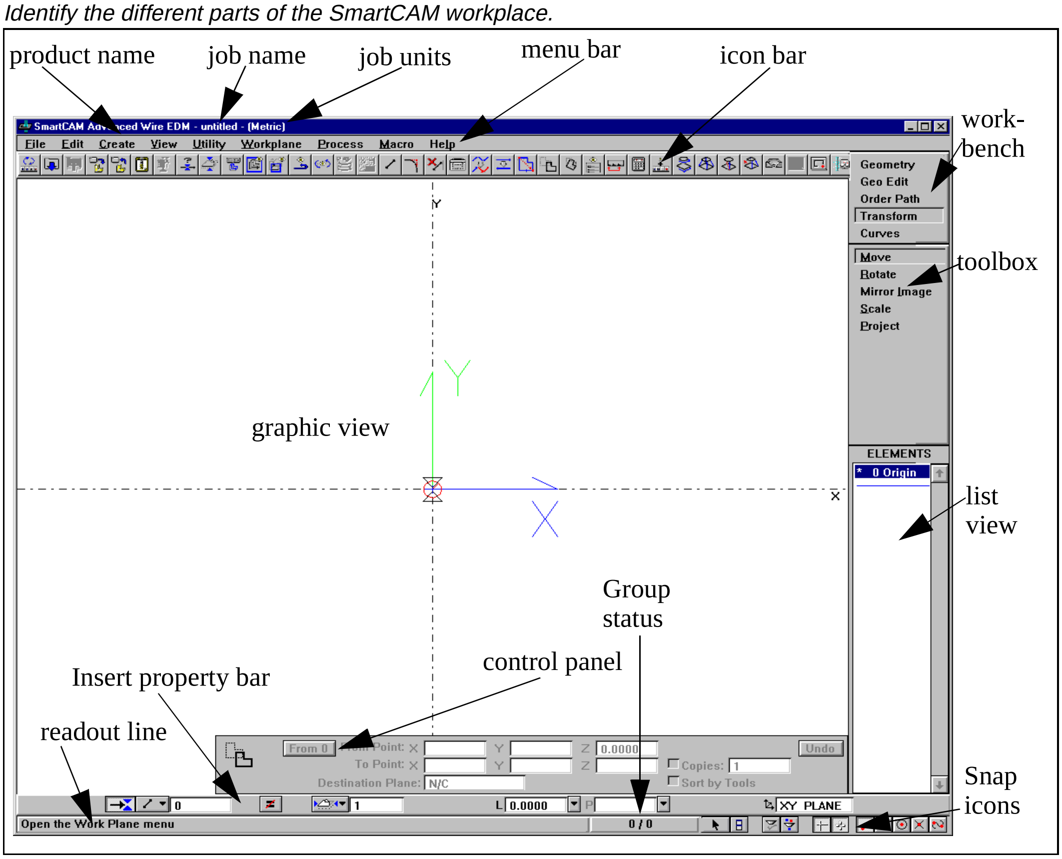
2. Use the left mouse button to select the icon (double-click in Windows NT 3.5.1 or single-click in Windows NT 4 or Windows 95).

The SmartCAM application window is displayed on the screen.

Using Workplace Areas

Many of the terms used to describe the SmartCAM workplace are based on common terms and procedures used in the CNC machining world.

Figure 1-1
Identify the different parts of the SmartCAM workplace.

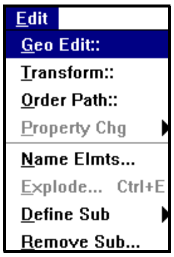


Menu Bar

The menu bar is displayed across the top of the SmartCAM workplace. Select items from the menu bar to open pull-down menus, from which you can open toolboxes, dialog boxes, or submenus. Take a few minutes to get acquainted with the layout of each pull-down menu.

Some menu choices are dimmed (a light shade of gray) and cannot be selected for one or more of these reasons:

- The job operations file is not active.
- The function requires an active group.
- The process model is empty (no geometry).
- The function requires a layer or a step to be active.



Pull-Down Menus

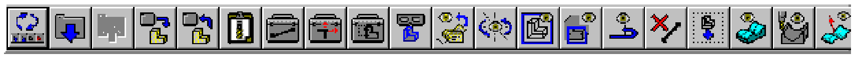
Pull-down menus are accessed through the menu bar. Perform these tasks to select from the Edit pull-down menu:

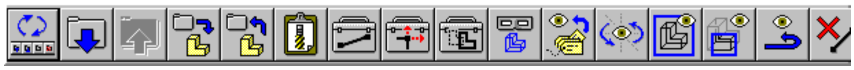
1. Use one of these methods to open the Edit pull-down menu:
   - Use the mouse to position the cursor over the Edit topic in the menu bar and press the left mouse button.
   - Use the keyboard by pressing the Alt key and the underlined letter (E) in the name of the menu item.
2. Slide the cursor down the list of items, and select the one you want. For example, select **Geo Edit** from the **Edit** pull-down menu. Notice that **Geo Edit** is displayed on the workbench, the tools for editing geometry are displayed in the toolbox, and the control panel for the highlighted tool is displayed at the bottom of the screen.

You can access these elements from pull-down menus.

- **Toolboxes** are indicated by a square made of four dots after the item name. When this item is selected, a list of tools is displayed below the workbench. If you select Geo Edit, a new list of tools is displayed on the side of the screen.
- **Dialog boxes** are indicated by an ellipsis (...) after the item name. When this type of item is selected, a dialog box is displayed. You can move the dialog box anywhere on the screen by placing the cursor on its title bar, pressing and holding the left mouse button, and moving the mouse. If you select a menu option, such as Edit—Name Elmts, a dialog box is displayed at the bottom of the screen.
- **Submenus** are indicated by a triangle after the item name. When a submenu item is selected, another menu is displayed. You can then select an item from this second menu. For example, if you select Edit—Property Chg, a submenu is displayed on the side.

Icon Bar





The icon bar provides shortcuts for accessing SmartCAM menus, macros, toolboxes, modeling tools, and functions. You can position it at different locations in the SmartCAM workplace, add icons to it, and size it to meet your needs. You have three size choices: small, medium, and large (represented above, respectively).

Selecting an Icon Bar

You can choose to display a different icon bar on the screen. Perform these tasks to select an icon bar to display:

1. Select **Utility—Icon Bar—Choose**. The **Choose Icon Bar** dialog box is displayed.

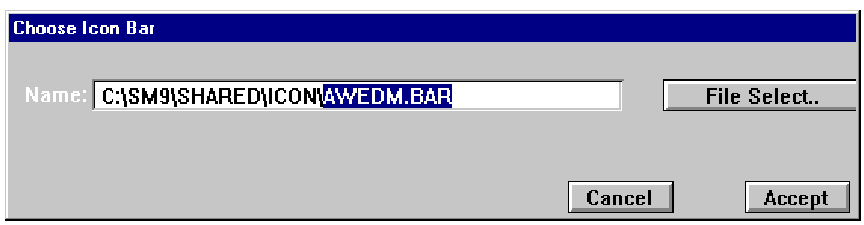


Figure 1-2 *Set the values on the Choose Icon Bar dialog box.*

2. Select the **File Select** button to choose the icon bar to work with. The **Open** dialog box is displayed.

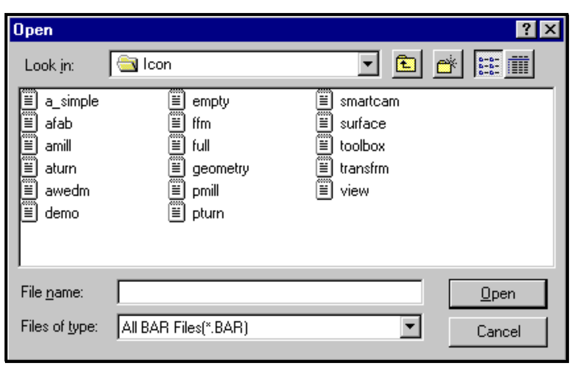


Figure 1-3 *Set the values on the Open dialog box.*

3. Select an icon bar file.
4. Select the **Open** button. The **Choose Icon Bar** dialog box becomes active.
5. Select the **Accept** button.

Adding an Icon to the Icon Bar

Perform these tasks to add an icon to the icon bar:

1. Select **Utility—Icon Bar—Button Add**. The **Add Bar Button** dialog box is displayed.

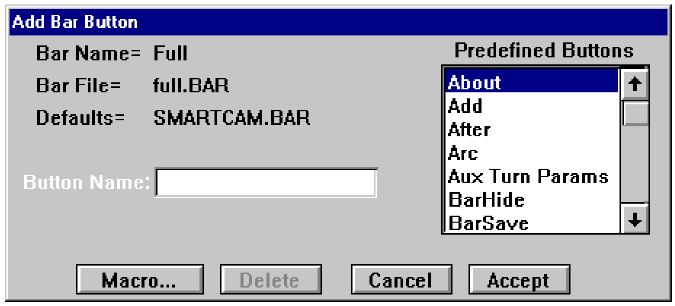


Figure 1-4
Set the values on the Add Bar Button dialog box.

2. Select the icon to add from the **Predefined Buttons** list.

3. Select the **Accept** button.

Note Shift-clicking an existing or blank icon also enables you to add or replace an icon.

Configuring an Icon Bar

Perform these tasks to set the position and size of the icon bar:

1. Select **Utility—Icon Bar—Configure**. The **Configure Icon Bar** dialog box is displayed.

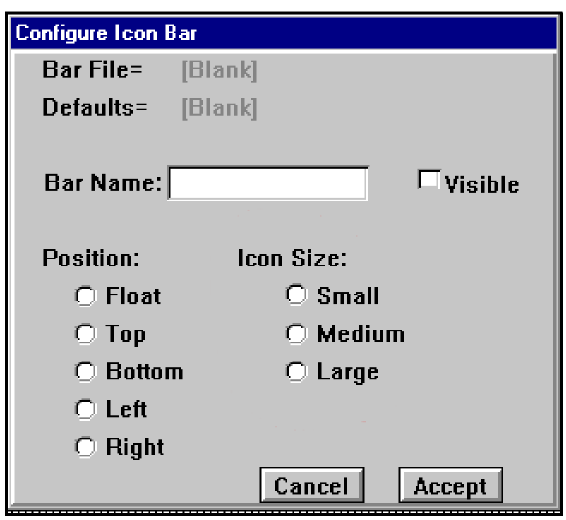


Figure 1-5
Set the values on the Configure Icon Bar dialog box.

2. Turn on a **Position** option switch to specify where on the screen to display the icon bar.

3. Turn on an **Icon Size** option switch to specify the size of the icons. The smaller the icon size, the more graphic view space is available.
4. Turn on the **Visible** on/off switch to make the icon visible.
5. Select the **Accept** button.

Viewing Large Icon Bars

The `.bar` files supplied with SmartCAM may contain more icons than you can display at certain combinations of screen resolution, bar position, and icon size. Perform these tasks to view the entire icon bar:

1. Select **Utility—Icon Bar—Configure**. The **Configure Icon Bar** dialog box is displayed.
2. Set the **Position** option switch to **Float**.
3. Select the **Accept** button.

   Note If you have not used the floating icon bar before, it will appear with only six icons visible.
4. Move your cursor over the edge of the icon bar.
5. When your cursor changes to a double arrow shape, click with your left mouse button and drag the icon bar box out until all the icons are displayed.

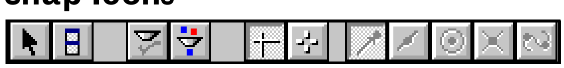
Editing an Icon Bar

You can change any of the icons that are displayed on the icon bar. One way is to open your `.bar` file in a text editor and edit it in that way. However, you can perform these tasks to edit your icon bar from within SmartCAM:

1. Shift-click an icon. The **Edit Icon Bar** dialog box appears.

   Note This procedure replaces the selected icon with the newly selected icon. The original icon will not be shifted over, it will be replaced.
2. Select the name of the icon you want to display in its place.
3. Select the **Accept** button.

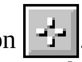
Snap Icons



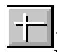
Snap icons enable you to use selection modes and point settings to enter coordinate values in input fields and snap to existing geometry.

Snap Selection Modes

Snap uses these selection modes:

- **Snap mode** requires that you activate the Snap Mode icon . When Snap mode is on, the pointer is displayed as a short cross hairs. Use the Snap Point Settings icons, which are on the readout line, to set the active point settings and then snap to an element.

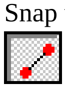
  Note If no snap points are found within the element picking distance, Snap returns the coordinates of the last point that you selected.

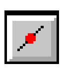
- **Free Coordinate mode** requires that you activate the Free Coordinates Mode icon . When Free Coordinate mode is on, the pointer is displayed as a large cross hairs. As you move the cross hairs across the graphic view, the coordinates are displayed on the readout line. The Linear Increment setting in the Increment dialog box determines the interval at which coordinates are updated.

- **Automatic mode** requires that you activate the Snap Mode icon and the Free Coordinates Mode icon. The system switches between the modes depending on the distance of the pointer from the nearest available point. When the pointer is within the pick limit from an existing point, the Snap mode is in effect. You are able to snap only to those element types that are indicated by the Snap Point Settings icons.

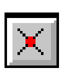
Snap Point Settings

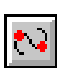
Snap uses these point settings, any or all of which can be active at one time:


Endpoint uses the snap points at the start and end points of all elements in the process model.


Midpoint uses the snap points at the midpoint of all elements in the process model, except for polylines and splines.


Center Point uses the snap points at the center point of all arc elements in the process model.


Intersection uses the snap points at each intersection of lines or arcs in the process model. Intersection does not recognize the intersection of polylines and splines.

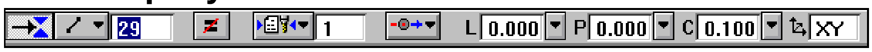

Control Point uses the snap points at each control point on a spline or polyline element in the process model.

Readout Line

The readout line is always visible below the graphic view. The information displayed to the left depends on the task in progress. As you move the cursor over any menu, icon, toolbox, or tool, the readout line displays a short statement identifying its use. The readout line displays information about the selected element when you use Snap mode.

The information displayed to the right is the group status. The number to the left of the slash reflects the quantity of entities in the active group. The number to the right of the slash reflects the total number of entities in the model.

Insert Property Bar



The Insert property bar is positioned either below or above the graphics view. It displays information about the insert position, assignment, association, and properties.

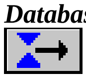
Its appearance changes somewhat between inserting with a step or on a layer because not all fields apply to both conditions.

Chapter 2 presents detailed information about the Insert property bar.

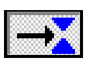
Insert Positions

These icons control where the new geometry resides:

Database Location

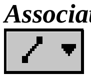


The **Before** icon inserts geometry into the database before the current position.



The **After** icon inserts geometry into the database after the current position.

Association



The **Element** icon specifies that the insert position is relative to an element.

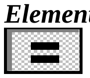
The **Profile** icon specifies that the insert position is relative to a profile.

The **Layer** icon specifies that the insert position is relative to a layer.

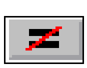
The **Step** icon specifies that the insert position is relative to a step.

The **Tool** icon specifies that the insert position is relative to a tool.

Element Property

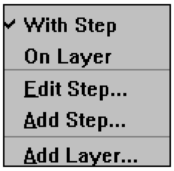


The **Match Element** icon updates the properties of an inserted element to match those of an element that you select.



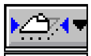
The **Don’t Match Element** icon does not match the properties of an inserted element to another element.

Insert Assignments



Assignment

These icons control what the new geometry will be assigned to:


The **On Layer** icon assigns the new geometry to a layer.


The **With Step** icon assigns the new geometry to the chosen step, but it does not match the properties of an inserted element to another element.

Edit/Add

These menu items enable you to manipulate step and layer information from the Insert property bar:

The **Edit Step...** item opens the Edit Process Step dialog box, which enables you to view or change step properties.

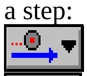
The **Add Step...** item opens the Add Process Step dialog box, which enables you to create new process steps.

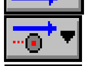
The **Add Layer...** item opens the Add Layer dialog box, which enables you to create a new layer with full control over layer properties.

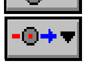
Insert Properties

Offset

Offset is relative to the direction of the geometry. These icons control the properties of the new geometry, and they are available only when you insert with a step:


The **Offset Left** icon sets the tool to the left of the geometry.


The **Offset Right** icon sets the tool to the right of the geometry.


The **No Offset** icon centers the tool on the geometry.

Level

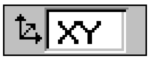
The **L** selector switch accepts a value for the level of the geometry on a specific workplane. You can enter a value in the input field, snap to a level in the graphic view, use the default level, or select one of the five different most recently used levels.

Profile Top

The **P** selector switch accepts a value for the top of the material. You can turn it on or off. If you turn it on, you can select one of the five different most recently used profile top settings, or enter a value in the input field.

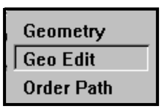
Clear

The **C** selector switch accepts a value for the height the tool retracts between profiles. If you turn it on, you can select one of the five different most recently used profile top settings, or enter a value in the input field. This is available only if you are inserting with a step.



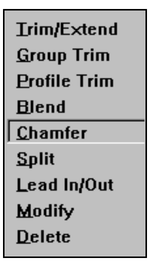
Work Plane

This input field accepts a value for the workplane to which the insert will correspond. The list view displays defined workplanes when you select this input field. This field accepts both keyboard input or an input made by selecting from the defined workplanes displayed in the list view.



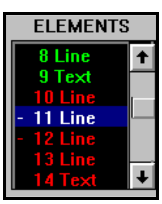
Workbench

The workbench provides quick access to frequently used sets of procedures, called *toolboxes*. Depending upon your screen resolution, the three to five most recently used toolbox titles are resident on the workbench. To add a new toolbox title to the workbench, select it from a menu. You can select any of the five last used toolboxes by pressing the **Alt** key and numbers **1**, **2**, **3**, **4**, or **5**.



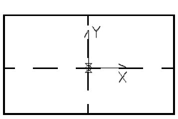
Toolbox

The toolbox that is displayed corresponds to the active workbench selection (toolbox title). The toolbox contains sets of modeling tools that you can use to create and change the model that you are building. When you select a tool from the toolbox, the list view and the control panel that correspond to it are displayed.



List View

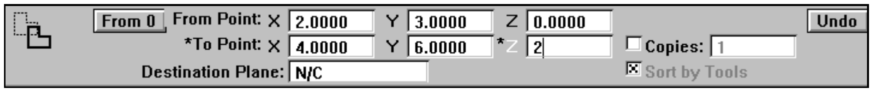
The list view displays information for the tool that you select from the open toolbox. For example, Element Seq is the selected tool, so element information is displayed sequentially in the list view.



Graphic View

The graphic view provides a visual representation of the process model. Additions or changes you make to the graphic view are reflected immediately. The displayed model may be viewed from any angle, and rotated, moved, enlarged, or panned. You can also view the toolpath and make changes quickly and easily.

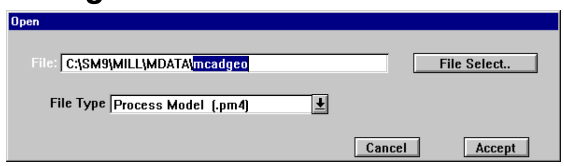
Control Panel



Control panels are displayed at the bottom of the screen. Each tool has its own control panel. In the upper left corner of each control panel is a copy of the tool's icon image.

An asterisk (*) in the control panel indicates that after you set that switch or field, SmartCAM has enough information to complete the action.

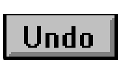
Dialog Box



Dialog boxes open temporarily to enable you to select or control specific events. A dialog box can be displayed anywhere on the screen. It is closed when its action is complete or is cancelled. If a dialog box is open, you must complete it or cancel it to do anything else with the model. For example, this dialog box is opened when you select Open from the File menu. It remains open until you press the Accept button or the Cancel button.

Using Controls

Controls interact with SmartCAM control panels and dialog boxes.



Action Buttons

Action buttons initiate a specific action or function.

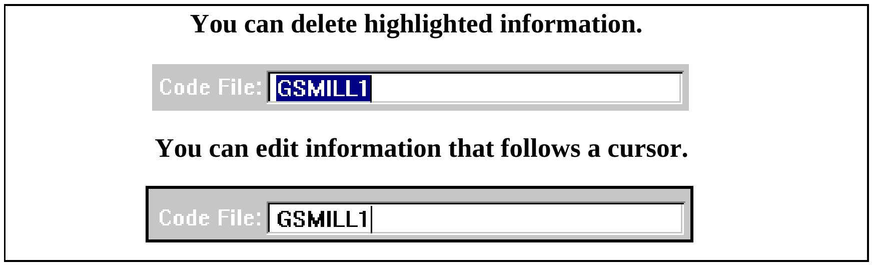
Select a button by placing the cursor over it and pressing the left mouse button or by pressing the Tab key until the button is highlighted and then pressing the Enter key.

Input Fields

Use input fields to enter information, such as names and numbers. Select the field by placing the cursor over it and pressing the left mouse button. Then enter the desired name or number. You can switch between input fields by pressing the Tab key.

Selecting the name of the input field highlights its contents. If the current information in the input field is highlighted, it is deleted when you enter a new value.

Figure 1-6
Delete or edit information in input fields.

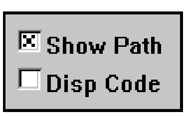


Selecting in the input field places the cursor to the right of the last character in the input field. If only a flashing bar (cursor) is visible, the current value can be appended to or edited by using the arrow and Backspace keys.

Most of the input fields accept expressions in place of direct input. SmartCAM solves the expression and uses the solution. For example, to specify a Z coordinate location that is one inch from the end point of an existing element, perform these tasks:

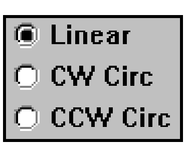
1. Select the Z input field label to make the input field active.
2. Select the end of the existing element (with Snap on) to enter the Z coordinate of the existing element end point.
3. Enter **+1** in the input field after the element input coordinate.

When you accept the coordinates, SmartCAM solves the expression and uses the resulting Z coordinate.



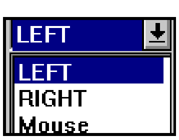
On/Off Switches

On/Off switches turn a function or an input field on or off. The switch has an X in the box when it is turned on, and the box is empty when the switch is turned off. Use the mouse to place the cursor over the switch, and press the left mouse button to turn the switch on or off. In this example, Show Path is on and Disp Code is off. You can have both on/off switches on at the same time.



Option Switches

Option switches turn on one option from a group. Place the cursor over the option switch, and press the left mouse button to toggle the switch on or off. Unlike on/off switches, only one option switch can be on at a time. In this example, With Step is on and On Layer is off.



Selector Switches

Selector switches contain a short list of options or choices for a field. Selector switches are displayed in many control panels and dialog boxes. Choosing the selector switch causes the option list to be displayed.

Use these methods to set selector switches:

- Move the cursor over the name of the selector switch, and then press the mouse button to cycle through the different options.
- Move the cursor over the selector switch option, and then press the mouse button to display the list of options. Select the option you want. If there are many options, use the scroll bar to display all the options.
- Press the Tab key until the selector switch is highlighted, and then press the Up or Down arrow key to set the correct option.

Using Hot Keys

Many SmartCAM tasks are assigned to hot keys that provide a quick way of performing a task or setting a mode of operation. **[Alt]+[Letter]** selects a pull-down menu from the menu bar. **[Letter]** should be the first letter of the pull-down menu you want to display. Press **[Alt]** and the appropriate letter key at the same time.

For information about customizing hot key assignments, refer to the *shortcut key* topic in the online Help.

Points to Remember

- ❑ You cannot select dimmed menu items.
- ❑ There are several types of controls that you can use to interact with control panels and dialog boxes: action buttons, input fields, on/off switches, option switches, and selector switches.
- ❑ The icon bar can be thoroughly customized to meet your needs. It can be resized, moved, reorganized, and changed.
- ❑ An asterisk (*) in the control panel indicates that after you set that switch or field, SmartCAM has enough information to complete the action.
- ❑ Each tool has its own control panel.
- ❑ To enter information in an input field, you must first select it.

Working with Files

Objectives

This lesson shows you how to perform these tasks:

- Identify SmartCAM file types.
- Open a file.
- Save a file.
- Create a new file.

Overview

Now that you are familiar with the SmartCAM workplace, you are ready to experiment with SmartCAM files using the model files provided with SmartCAM Advanced Wire EDM.

Learning SmartCAM File Types

SmartCAM creates and uses process model and job operations files.

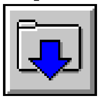
Process Model

The process model file graphically represents the part, material block, clamps, and fixtures. It also contains the sequence of machine operations.

Job Operations File

The job operations file contains all of the step information used in a job: tool information, feeds, and speeds.

Opening a File



Model File: AWFORM.PM4

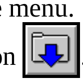
When you first open your application, most of the options on the menu bar and the icon bar are dimmed, and you cannot select them. This is because you have not yet opened a model file.

The files referenced in this manual are in the `\train` directory of your SmartCAM CD. If your CD drive is labeled drive `d`, the files with English unit data are in `d:\train\wire_e`, and metric data files are in `d:\train\wire_m`.

Note The model file references in this book are to English unit files. Although the metric unit files are not directly referenced, the metric file naming convention is such that a metric file name can easily be derived from the name of the referenced English unit file. An "m" has been added as the last character before the period in the metric file name. For example, where the English unit file name is `AWFORM.PM4`, the metric file name would be `AWFORMM.PM4`. If the English file name already uses the limit of 8 characters and needs to be truncated to add the "m," the metric name has been altered some to maintain its mnemonic significance.

If your CD drive is labeled differently, insert that letter in place of "d." If you have copied these files to a local or network drive, it is necessary to know that path to use the files referenced in this book.

Open a file by performing these tasks:

1. Access the **Open** dialog box by performing one of these tasks:
   - Select **Open** from the **File** menu.
   - Select the **File—Open** icon .
2. Select the **Process Model** (`.pm4`) selector switch. The 2-D (`.sh2`) and 3-D (`.sh3`) options are used for converting files created in previous versions of SmartCAM.
3. Select **File Select** to display a list of available files in the **Open** dialog box.
4. Select model file **`AWFORM.PM4`**.
5. Select the **Accept** button.

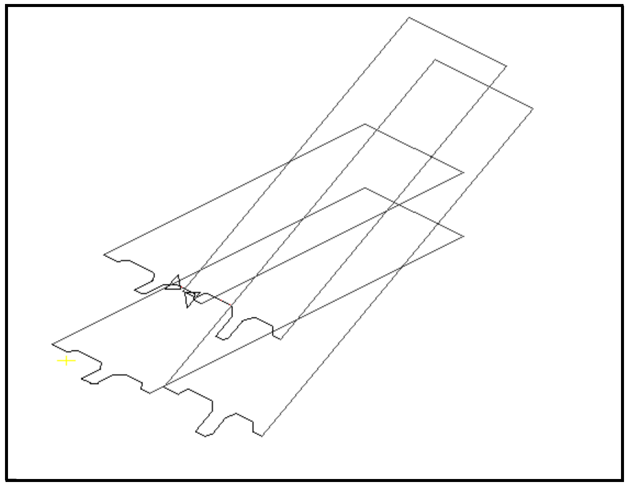


Figure 1-7
Open AWFORM.

Saving a File

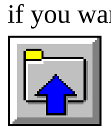
To avoid losing your work, save your model frequently while you are working on it. Avoid saving model files that are shipped with the software because they are often used for multiple lessons. However, if you do save changes to one of these files on your local drive, you can return to the `\train` directory of your SmartCAM CD for a clean copy of the file.

There are two ways to save files: File—Save and File—Save As.

Using File—Save 

When you select Save from the File menu, the open process model file and job operations setup file are saved immediately with the current filenames, which overwrites the existing file.

Note Use File—Save As if you want to save the file with a different name.

Using File—Save As 

When you select Save As from the File menu, a dialog box opens, enabling you to save the process model file, the job operations file, or both with a new file name. This enables you to create a new file without changing the file already on disk. The new file and path you assigned in the Save As dialog box become the active file and path for SmartCAM.

Creating a New File

Use New to create a new CNC Process Model. When you select New, the existing process model closes, and SmartCAM opens a new, untitled process model. Perform these tasks to create and save a new file:

1. Select **File—New**.
2. Select **File—Save As**.

Points to Remember

- ❑ Process model files graphically represent the part.
- ❑ Job operation files contain step information.
- ❑ Use File—Save to overwrite the existing file.
- ❑ Use File—Save As to save a file with a new name.
- ❑ A clean copy of each training file is in the `\train` directory of your CD.

Manipulating the View

Objectives

This lesson shows you how to perform these tasks:

- Window in.
- Name views.
- Get views.
- Change the orientation of the view.
- Change the display of the view.

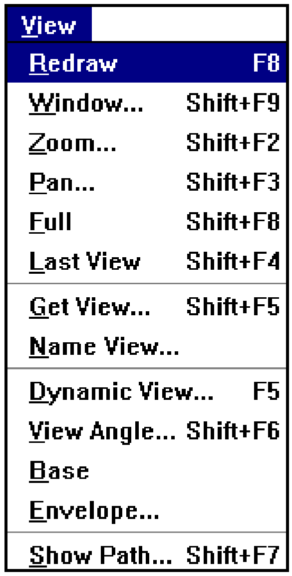
Overview

Use the View menu to change the view of the model.

Using the View Menu

Use the View menu to change the graphic view of your model.

Figure 1-8
Specify options from the View menu.



Using Window

Model File: AWFORM.PM4

Use Window to magnify part of the graphic view to show more detail. Perform these tasks to practice using Window:

1. Open the model file **`AWFORM.PM4`**.

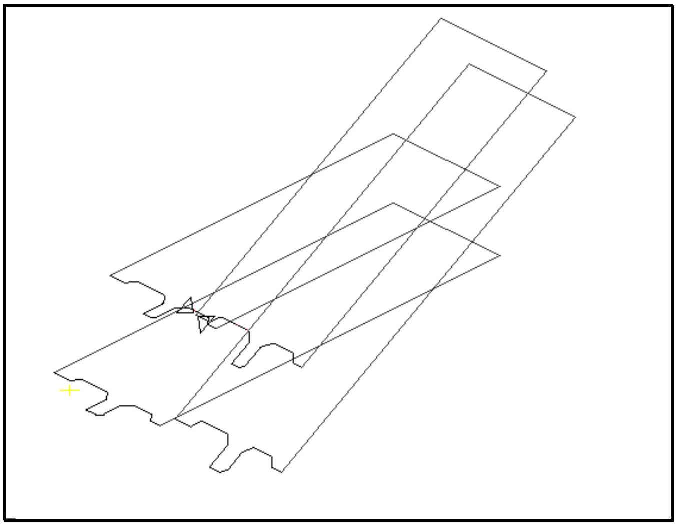


Figure 1-9
Open AWFORM.

2. Select **View—Window**. The **Window** dialog box is displayed.

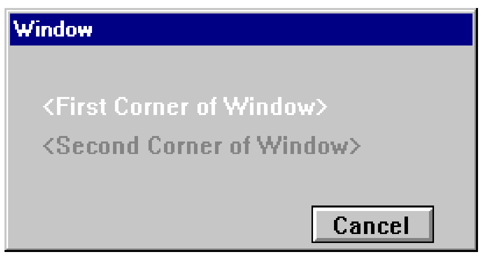
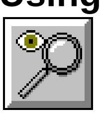


Figure 1-10
Specify the first and second corners of a window.

3. Use the mouse to select the first corner of the window, and then drag the mouse, stretching a box around the area to magnify.

Using Zoom



Model File: AWFORM.PM4

Use Zoom to magnify a specific area. Perform these tasks to use Zoom:

1. Select **View—Zoom**. The **Zoom** dialog box is displayed.

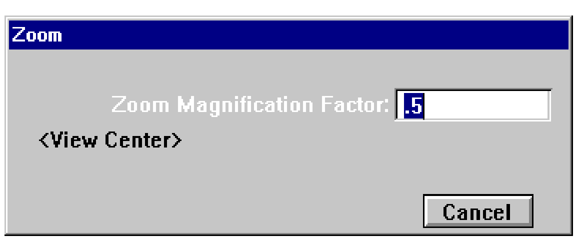
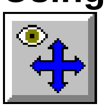


Figure 1-11
Specify a zoom magnification factor in the Zoom dialog box.

2. Set the **Zoom Magnification Factor** input field. The **<View Center>** prompt is highlighted.

3. Select a point in the graphic view. The graphic view is zoomed around this point.

Using Pan



Model File: AWFORM.PM4

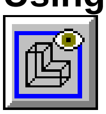
Use Pan to move the view along the distance between two points you specify. Perform these tasks to use Pan:

1. Select **View—Pan**. The **Pan** dialog box is displayed.

Figure 1-12
Specify a point to pan from and a point to pan to.

2. Select a point in the graphic view to pan from.
3. Select a point in the graphic view to pan to. The graphic view pans from the first point to the second point.

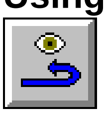
Using Full



Model File: AWFORM.PM4

Select **View—Full**. SmartCAM fits all of the non-hidden geometry into the graphic view.

Using Last View



Model File: AWFORM.PM4

Select **View—Last View**. The previous view is displayed. You can use this option to alternate between two convenient views.

Using Get View

Model File: AWVIEWS1.PM4

Use the Get View feature to view different orientations that you saved. By default, four different views are available (Top, Right, Front, Isometric). You can use the Get View dialog box or these hot keys to view your model from different orientations:

- F9—Change the graphic view to the full Top view of the part.
- F10—Change the graphic view to the full Front view of the part.
- F11—Change the graphic view to the full Right view of the part.
- F12—Change the graphic view to the full Iso view of the part.

Perform these tasks to use the Get View dialog box:

1. Open the model file **`AWVIEWS1.PM4`**.

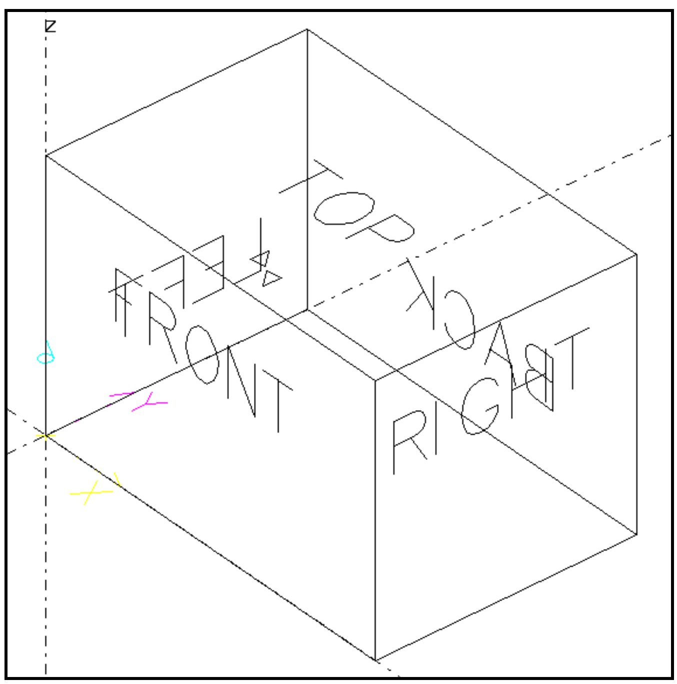
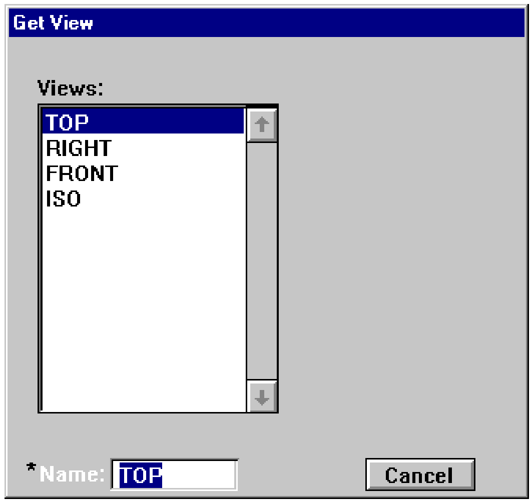


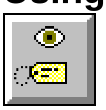
Figure 1-13
Open AWVIEWS1.

2. Select **View—Get View**. The **Get View** dialog box is displayed.
3. Select the view you want.

Figure 1-14
Specify the view that you want.



Using Name View

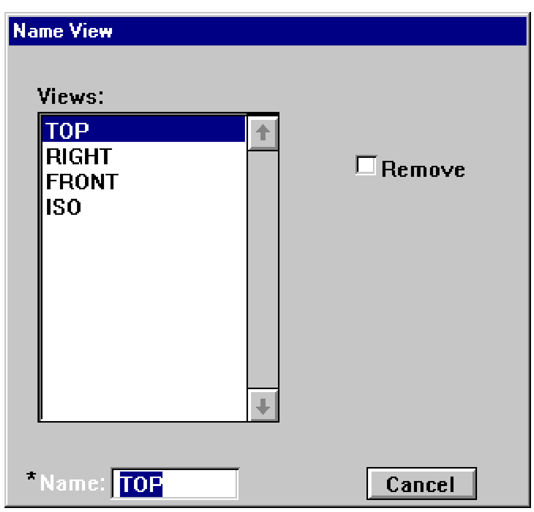


Model File: AWVIEWS1.PM4

Use the Name View feature to save different orientations by assigning them names. You can access these views later using Get View. Perform these tasks to use Name View:

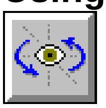
1. Create the view for your current display.
2. Select **View—Name View**. The **Name View** dialog box is displayed.

Figure 1-15
Set the Name input field to save the new view.



3. Set the **Name** input field to save the new view.

Using Dynamic View



Model File: AWVIEWS1.PM4

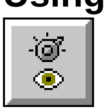
Use the Dynamic View feature to change the orientation of the view in the active window. You can rotate, spin, pan, or zoom using the mouse. Perform these tasks to use Dynamic View:

1. Select **View—Dynamic View**. The **Dynamic View** dialog box is displayed.

Figure 1-16 *Specify a way to move the view in the Dynamic View dialog box.*

2. Select **Rotate**, **Flat Spin**, **Pan**, or **Zoom**:
   - **Rotate** moves the view as a three-dimensional object around a center point.
   - **Flat Spin** moves the view as a two-dimensional object around its visual center point.
   - **Pan** shifts the view on the screen.
   - **Zoom** magnifies or shrinks the view.
3. Select and hold the left mouse button while moving the mouse. The dynamic view changes.
4. Select the **Accept** button when you are satisfied with the view.

Using Display Modes



Model File: ELECTRODE.PM4

Use the Display Modes dialog box (Utility—Display Modes) to control how geometry is displayed in the graphic view.

Perform these tasks to use Display Modes:

1. Open the model file **`ELECTRODE.PM4`**.

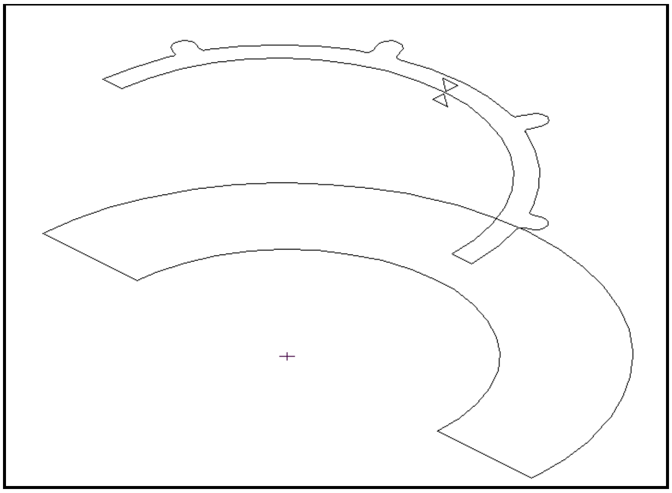


Figure 1-17
Open ELECTRODE.

2. Select **Utility—Display Modes**. The **Display Modes** dialog box is displayed.

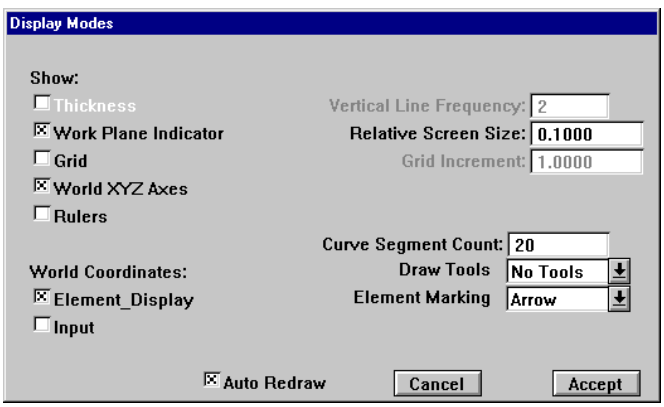


Figure 1-18
Set the values on the Display Modes dialog box.

3. Set the values on the dialog box. Although you typically accept most default settings, the following list contains commonly changed settings:

- **Thickness** displays the distance between the Z level and the Prof Top values when turned on.
- **Work Plane Indicator** displays the work plane indicator when turned on.
- **World XYZ Axes** displays the World Coordinate System when turned on.
- **Element Marking** displays elements in the active group with one of these options: **Arrow**, **Dotted**, or **Both**.

Points to Remember

- ❑ Use the View menu to access options for manipulating the view.
- ❑ Window and Zoom magnify specific areas of the view.
- ❑ Pan and Dynamic View manipulate the orientation of the view.
- ❑ Save a view with Name View.
- ❑ Use the Display Modes feature to control how the geometry is displayed in the graphic view.
- ❑ You can show thickness, work plane, grid, world area, and rulers.

Self-Test

Directions

Test your understanding of the concepts and procedures in this section by answering the following questions. The answers for each self-test are in *Appendix A* of this manual.

_______________ **1. It is possible to select dimmed menu items.**

a) true
b) false

_______________ **2. What does an asterisk (*) in the control panel indicate?**

a) SmartCAM enters a system default for that switch or field.
b) SmartCAM requires one more digit for that switch or field.
c) SmartCAM completes the action after you set that switch or field.
d) SmartCAM completes the action after you enter one more value and set that switch or field.

_______________ **3. Which of these workplace items does each control panel correspond to?**

a) workbench
b) toolbox
c) tool
d) dialog box

_______________ **4. What do process model files graphically represent?**

a) part
b) feed
c) machine code
d) b and c

_______________ **5. What do job operation files contain?**

a) layer information
b) step information
c) both a and b
d) neither a nor b

_______________ **6. Which View features magnify specific areas of the view?**

a) Window
b) Zoom
c) both a and b
d) neither a nor b

_______________ **7. Which View features manipulate the orientation of the view?**

a) Window
b) Zoom
c) both a and b
d) neither a nor b

_______________ **8. What feature do you use to control how the geometry is displayed in the graphic view?**

a) Show/Mask
b) Display Modes
c) Increment
d) Status

2

Working with SmartCAM

Overview

After you become acquainted with SmartCAM and can perform basic tasks such as navigating in the workplace, opening files, and manipulating the view, you are ready to work with SmartCAM. This entails manipulating elements, which represent toolpath or boundary definitions and element properties.

Lessons for This Unit

- Inserting Elements and Setting the Active Step/Layer
- Using Levels, Clearance, and Profile Top
- Working with Work Planes and Tool Planes
- Using Snap
- Grouping Elements
- Using Edit Filters

Inserting Elements and Setting the Active Step/ Layer

Objectives

This lesson shows you how to perform these tasks:

- Using the Insert property bar to set the insert position.
- Using the Insert property bar to set the insert assignment.

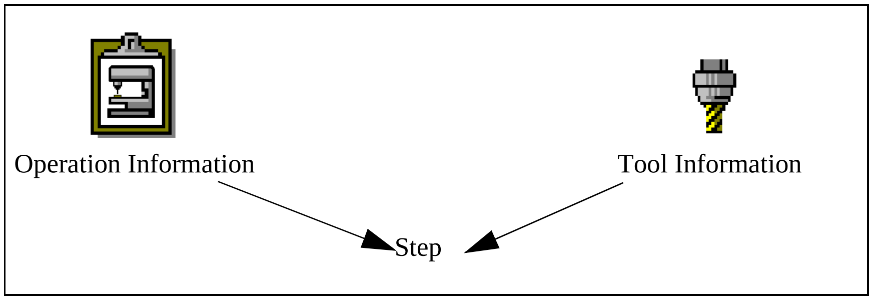
Overview

Elements represent toolpath or boundary definitions within the model database. If a process step is assigned to an element, it is toolpath.

A process step is a combination of tool information and an operation. Any geometry created with a process step represents toolpath. Tool information includes these qualities:

- Tool (wire electrode or hole electrode)
- Type)
- Diameter
- Optional custom tool graphics
- Operation information, which includes the following:
  - Feed rate
  - Spindle speed

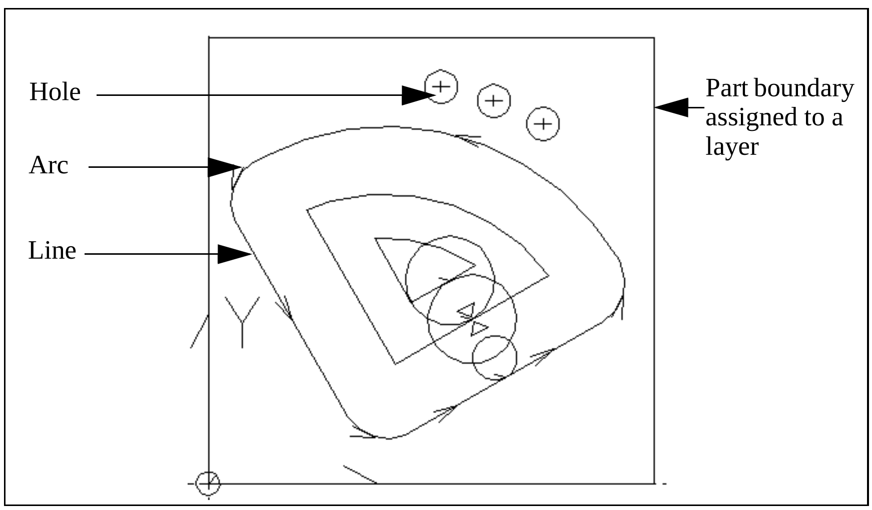
Figure 2-1
A step is made of operation and tool information.



When you need to model part boundaries, fixtures, or other details that are not toolpath, assign elements to different layers. Layer information is CAD geometry. Each layer in a model has one of 16 colors, and the maximum number of layers is 99. Items such as clamps, fixtures, and material boundaries are examples of geometry to draw on layers because they do not represent toolpath. In addition, no tool or operation information is associated with layer geometry.

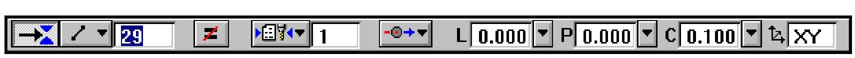
Elements are displayed in the following figure.

Figure 2-2
These are element samples.



Use the Insert property bar to add new elements to the database at a specified insert location with the specified properties.

Figure 2-3
The Insert property bar is very important for creating elements.



You can set insert locations with either a process step or a layer. Just remember that geometry associated with a process step represents toolpath and geometry associated with a layer does not. Use one of the methods in the Insert property bar to set the insert location. A horizontal line in the list view indicates the insert location. You can use the Insert property bar to set the active process step or layer, and the offset, work plane, level, prof_top, and clear values.

The active settings on the Insert property bar affect only element creation. To change the insert sequence for existing elements, use Edit—Order Path. To change other insert properties for existing elements, use Edit—Property Change.

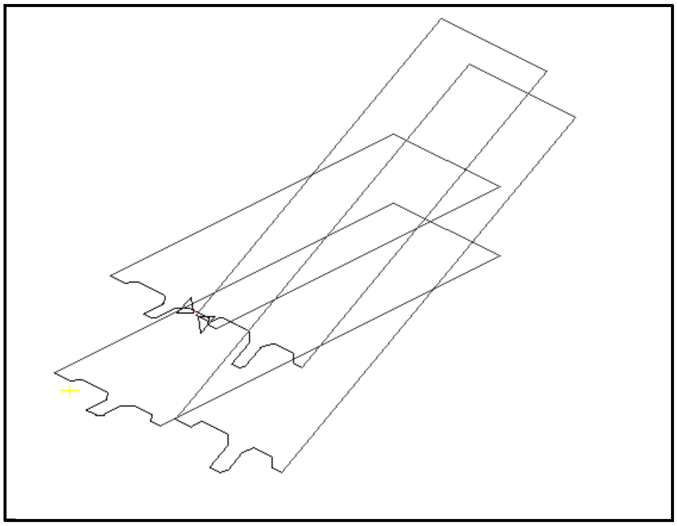
Inserting Geometry

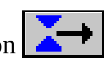
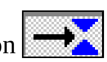
Model File: AWFORM.PM4

Perform these tasks to insert geometry:

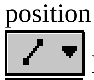
1. Open the model file **`AWFORM.PM4`**.

Figure 2-4
Open AWFORM.



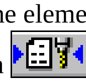
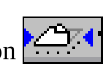
2. Set the **Before** icon  or **After** icon  on the **Insert** property bar to indicate if the insert point is to be before or after the selected element, process step, tool, layer, or profile.

3. Specify with an Association icon on the **Insert** property bar, the insert position that is relative to a tool. These icons are valid options:

    Element
    Profile
    Layer
    Step
    Tool

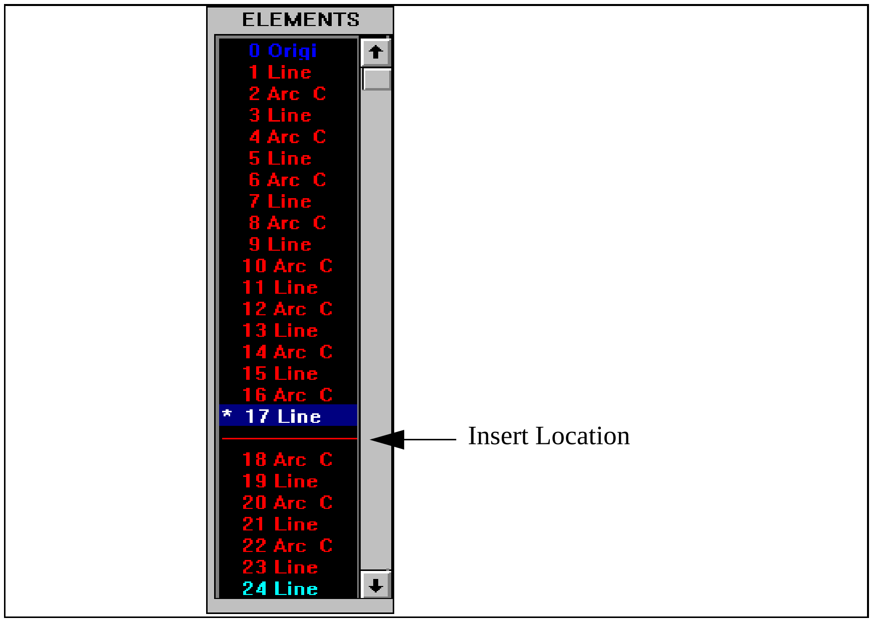
   Notice that the list view is updated to correspond to the icon you select.

4. Select from the list view or graphic view the element, profile, layer, process step, or tool to insert the element before or after.

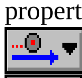
5. Set the **With Step** icon  or the **On Layer** icon  on the **Insert** property bar.

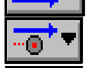
6. Select the step or layer to use from the list view or graphic view.

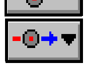
Figure 2-5
Identify the insert location in the list view.



7. Set the **L (Level)** input field on the **Insert** property bar. This is the Z-axis position for the geometry.
8. Set the **C (Clear)** input field on the **Insert** property bar. This is the primary retract plane for the tool. You can set this value only when you insert with a step. Setting a clearance value for a step ensures that subsequent uses of inserting on a layer use this data for layer geometry.
9. Set the **P (Profile Top)** input field on the Insert property bar. This identifies the material top level for geometry.
10. Set one of the **Offset** icons on the Insert property bar to indicate the offset property for the new geometry along its direction:

     The **Offset Left** icon sets the tool to the left of the geometry.

     The **Offset Right** icon sets the tool to the right of the geometry.

     The **No Offset** icon centers the tool on the geometry.

    Note Offset icons are available only if you are inserting with a step.

11. Use the **Create** menu to build the geometry, see *Creating Elements*, on page 4-3.

Points to Remember

- Layer geometry is not associated with a step and cannot generate code.
- Toolpath geometry is created with a step and can generate code.
- The Offset and Clear selector switches are available only when you insert with a step.
- To input the number of a profile, step, layer, or an element, use the Before or After icons with step and layer input fields.

Using Levels, Clearance, and Profile Top

Objectives

This lesson shows you how to perform these tasks:

- Use levels.
- Define the clearance height.
- Define the profile top.
- Set the Insert property bar.

Overview

Use levels to set the Z-height of the geometric elements you draw. When you draw an element with a step, SmartCAM sets the Z-height for the tip of the tool to the level you set in the Level input field.

When you draw an element with a step, you use the C (Clear) selector switch to set the Z-height for how far the tool retracts after making a cut. You use the P (Profile Top) selector switch to identify the material top for geometry.

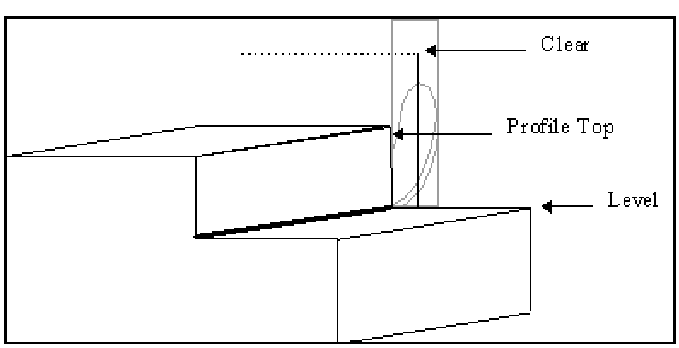


Figure 2-6
Notice the Clear, Profile Top, and Level of a simple operation.

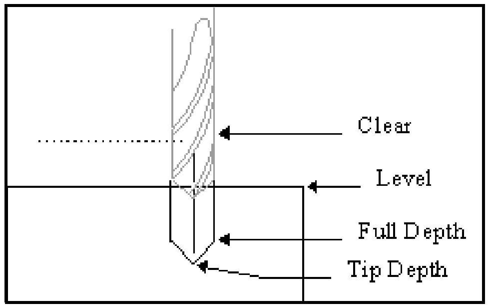


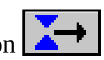
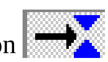
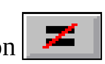
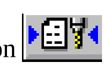
Figure 2-7
Notice the Clear, Level, Full Depth, and Tip Depth of a simple drilling operation.

Setting the Insert Property Bar

When you set level, clearance, and profile top on the Insert property bar, you must turn on the on/off option for the Clear and Prof_Top fields to be active.

Setting Levels, Clearance, and Profile Top

Perform these tasks to set levels,clearance, and profile top:

1. Activate the **Before** icon  or **After** icon  on the **Insert** property bar to indicate if the insert point is to be before or after the selected element, process step, tool, profile, or layer.
2. Select the **Element** icon  on the **Insert** property bar.
3. From the list view or graphic view, select the element that you want to place the new element before or after.
4. Make sure the **Don't Match Element** icon  is active on the **Insert** property bar. This prevents the new element from adopting the properties of the preceding element.
5. Activate the **With Step** icon  on the **Insert** property bar, and select a wire tool from the list view.
6. Set the **L (Level)** selector switch on the **Insert** property bar. It specifies the Z-level at which the tip of the tool cuts.
7. Turn on **C (Clear)**, and set the selector switch on the **Insert** property bar. It specifies how far the tool retracts after making a cut.
8. Turn on **P (Profile Top)**, and set the selector switch on the **Insert** property bar. It specifies the top edge of the element.

Checking Levels, Clearance, and Profile Top

Model File: AWFORM.PM4

When you insert on a layer, SmartCAM uses the levels, clearance, and profile top values that you set in a step to create geometry. You can verify this by performing these tasks:

1. Open the model file **AWFORM.PM4**.

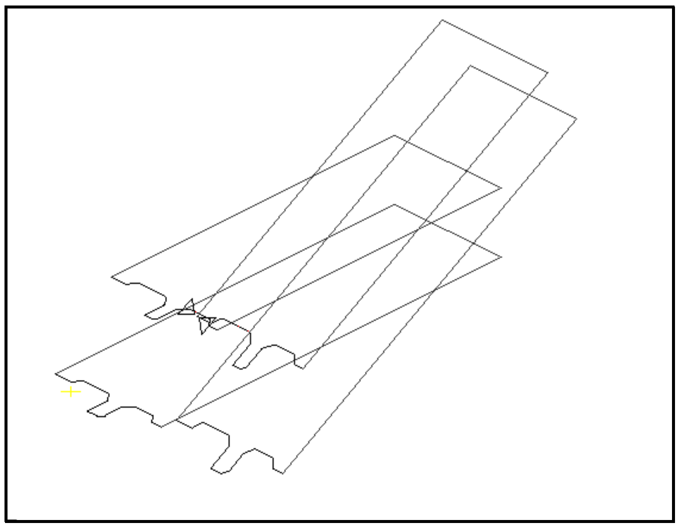
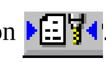


Figure 2-8 *Open AWFORM.*

2. Set the **With Step** icon .
3. Select the step for which to set the levels, clearance, and profile top.
4. Select **Utility—Element Data**. The **Element Data** dialog box is displayed.
5. Notice that the level, clearance, and profile values are the same as the values that you entered when you inserted with a step.

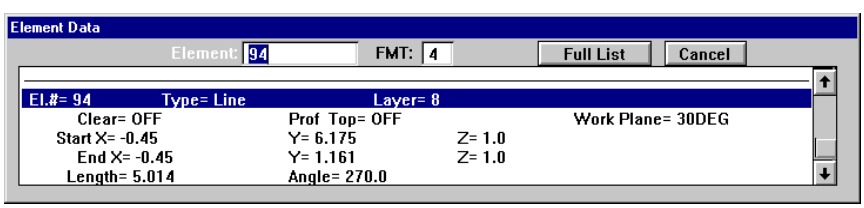
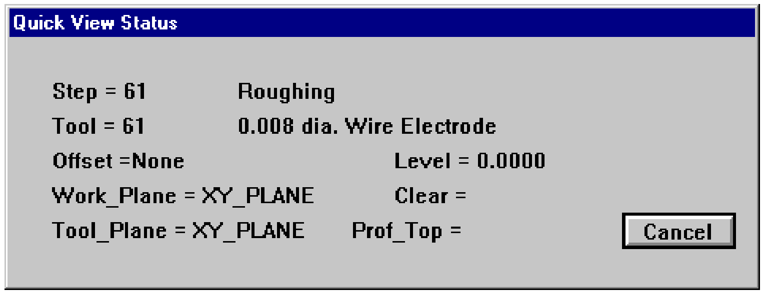


Figure 2-9 *Verify your data with the Element Data dialog box.*

6. Select **Utility—Status**. The **Quick View Status** dialog box is displayed.

   This dialog box lets you view the operation's status during SmartCAM operation without interrupting the current task or losing control panel inputs.

Figure 2-10
View the status of the current operation with the Quick View Status dialog box.



7. Select the **Cancel** button when you finish viewing the status.

Points to Remember

- Clear defines the height to which the tool retracts after making a cut.
- Level defines the Z-level at which the tip of the tool cuts.
- Profile Top defines the Z-height of the top of your part.
- Use Status to view the operation's status.
- Using Status does not interrupt the current task or lose control panel inputs.

Working with Work Planes and Tool Planes

Objectives

This lesson shows you how to perform these tasks:

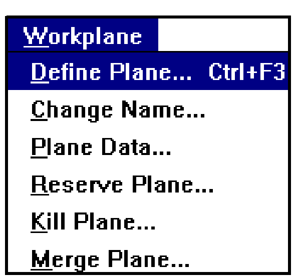
- Understand work plane and tool plane terminology.
- Create work planes.
- Delete work planes.

Overview

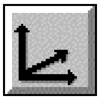
Work planes determine the plane orientation of planar elements such as lines, arcs, and ellipses. SmartCAM has three pre-defined work planes that are reserved: XY, YZ, and XZ. You cannot modify these pre-defined work planes. You can assign any work plane the reserved status. You can also define work planes that are not reserved by defining the position and orientation of the Local Coordinate System (LCS). An LCS has a red Z axis, a blue X axis, and a green Y axis. SmartCAM also has a World Coordinate System (WCS), which is the system origin point.

Use the Workplane menu to create or manipulate work planes.

Figure 2-11 *Use the Workplane menu.*



Creating Work Planes



Model File: AWWKPLANE.PM4

You can create work planes when you transform elements and have the Suppress Planes option turned off. You can also create work planes in one of these ways: three points, line and angle, and rotation.

Use Define Plane to create a new work plane for the model. When you define and accept a work plane, it becomes the active work plane. To make an existing work plane active, use the Insert property bar.

Defining a Work Plane from Three Points

Perform these tasks to define a work plane from three points:

1. Open the model file **`AWWKPLANE.PM4`**.

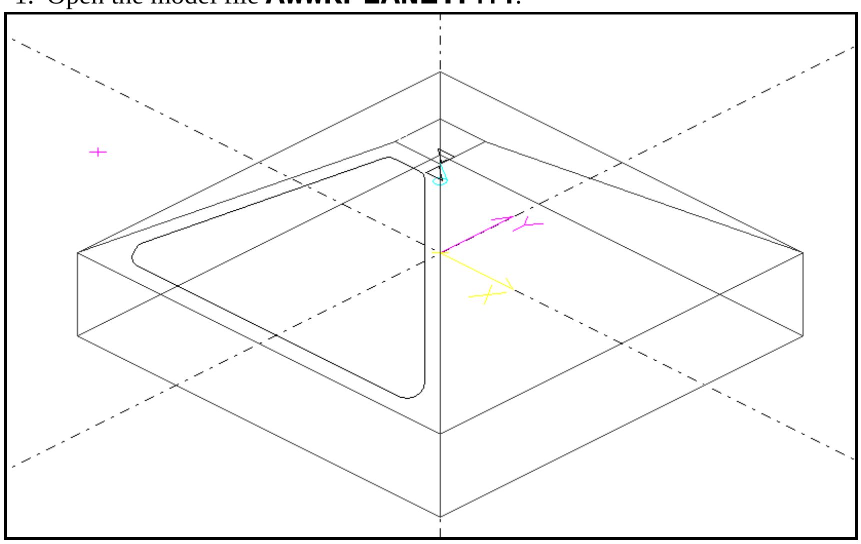


Figure 2-12
Open AWWKPLANE.

2. Select **Workplane—Define Plane**. The **Define Plane** dialog box is displayed.

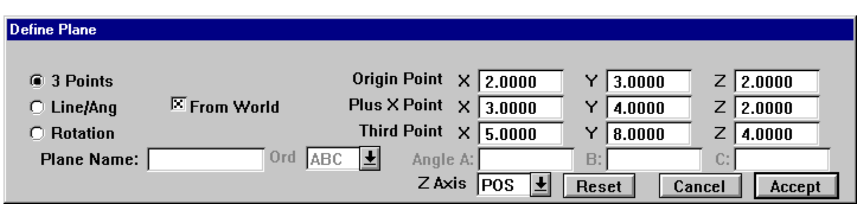


Figure 2-13
Set the values on the Define Plane dialog box.

3. Turn on the **3 Points** option switch.
4. Turn on the **From World** on/off switch to use the WCS as the reference for setting the new work plane toolpaths. When this on/off switch is turned off, the points are positioned using the active work plane as a reference.

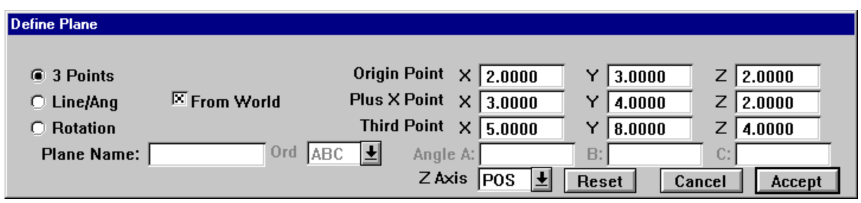
5. **Set the Origin Point**, **Plus X Point**, and **Third Point** input fields.
6. Toggle the **Z Axis** selector switch to change the orientation of the Z-axis work plane (POS or NEG).
7. Turn on the **Match Plane** on/off switch. This ensures that the work plane has the same plane as the tool plane.
8. Enter a name for the plane in the **Plane Name** input field. Notice that the **Tool Plane** input field has the same plane name when you press the Enter key.
9. Select the **Accept** button.

Defining a Work Plane from a Line/Angle

Perform these tasks to define a work plane from a line and an angle:

1. Select **Workplane—Define Plane**. The **Define Plane** dialog box is displayed.

Figure 2-14
Set the values on the Define Plane dialog box.



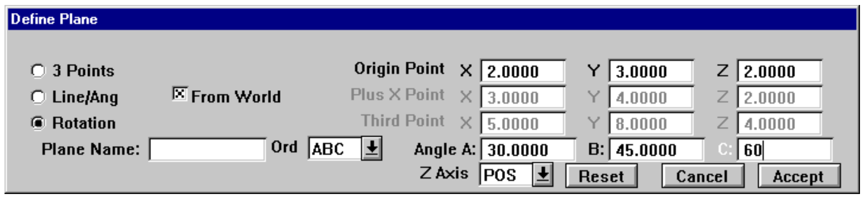
2. Select **Line/Ang**.
3. Turn on the **From World** on/off switch to use the WCS as the reference for setting the new work plane's **Origin Point** input fields. When this switch is toggled off, the points are positioned using the active work plane as a reference.
4. Set the **Origin Point** by using the **X**, **Y**, and **Z** input fields.
5. Set the **Plus X Point** by using the **X**, **Y**, and **Z** input fields.
6. Set the **Angle A** input field to indicate the angle of rotation for the work plane. The angle A is rotated around the X axis.
7. Toggle the **Z Axis** selector switch to change the orientation of the work plane.
8. Turn on the **Match Plane** on/off switch to enable the work plane to have the same plane as the tool plane.
9. Enter a name in the **Plane Name** input field.
10. Select the **Accept** button.

Defining a Work Plane for a Rotation

Perform these tasks to define a work plane for a rotation:

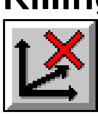
1. Select **Workplane—Define Plane**. The **Define Plane** dialog box is displayed.

Figure 2-15 Set the values on the Define Plane dialog box.



2. Turn on the **Rotation** option switch.
3. Turn on the **From World** on/off switch to use the WCS as the reference for setting the new work plane toolpath's **Origin Point**, **Plus X Point**, and **Third Point** input fields. When this switch is turned off, the points are positioned using the active work plane as a reference.
4. Use the **Origin Point** input fields to indicate the Origin Point.
5. Use the **Angle A**, **B**, and **C** input fields to indicate the angles of rotation for the work plane. The angles A, B, and C are rotated around the X, Y, and Z axes, respectively.
6. Toggle the **Ord** selector switch if you want to change the order in which the angles are rotated.
7. Toggle the **Z Axis** selector switch to change the orientation of the work.
8. Turn on the **Match Plane** on/off switch to ensure that the work plane has the same plane as the tool plane.
9. Enter a name in the **Plane Name** input field.
10. Select the **Accept** button.

Killing a Plane



Use Kill Plane to delete work planes that have no elements associated with them. This frees computer memory so you can add more elements to the model. Only unused work planes are shown in the dialog box list. You cannot kill reserved work planes. Perform these tasks to kill a plane:

1. Select **Workplane—Kill Plane**. The **Kill Plane** dialog box is displayed.

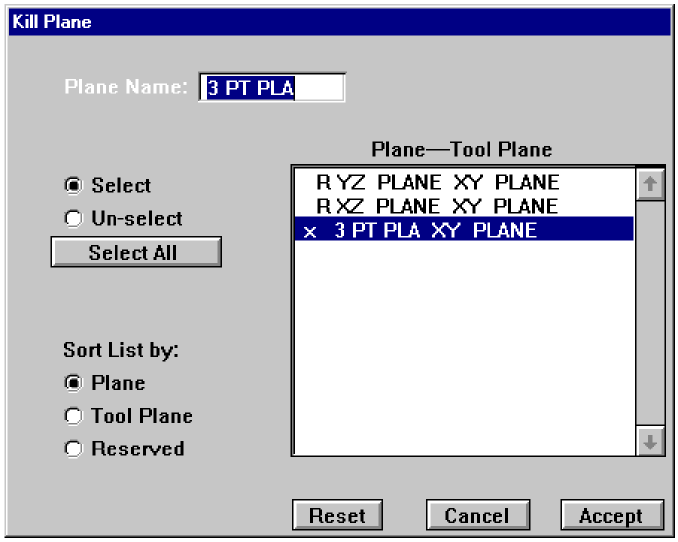


Figure 2-16
Select the plane to delete on the Kill Plane dialog box.

2. Select the name of the tool plane to delete from the **Plane—Tool Plane** list.
3. Press the Enter key.
4. Select the **Accept** button.

Points to Remember

- ❑ Work planes determine the orientation of geometry.
- ❑ Delete unused work planes using Kill Plane.

Using Snap

Objectives

This lesson shows you how to perform these tasks:

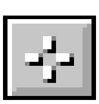
- Learn Snap selection modes.
- Use Snap.

Overview

Snap enables you to use points and other element properties from existing geometry to enter coordinate values in input fields. When you use it, the cursor snaps to the place identified by the active point setting. Use the Snap Mode icons, which are on the readout line, to set the mode and the active point settings.

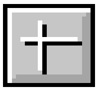
Snap Selection Modes

Snap controls whether the system uses points on elements or specific coordinates when you select coordinate values from the graphic view. Snap uses these selection modes:

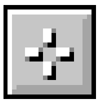


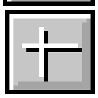
- **Snap mode** requires that you activate the Snap Mode icon. When Snap mode is on, the pointer is displayed as a short cross hairs. Use any of the snap point settings icons (End Point, Midpoint, Center Point, and so forth), which are on the readout line, to set the active point settings and then snap to an element.

  Note If no snap points are found within the element selection distance, Snap returns the coordinates of the last point you selected.



- **Free Coordinates mode** requires that you activate the Free Coordinates Mode icon in a feature that permits it, such as Create Geometry. When Free Coordinates mode is on, the pointer is displayed as a large cross hairs. As you move the cross hairs across the graphic view, the coordinates are displayed in the readout line. The Linear Increment setting in the Increment dialog box determines the interval at which coordinates are updated.





- **Automatic mode** requires that you activate the Snap Mode icon and the Free Coordinates Mode icon. The system switches between modes depending on the distance of the pointer from the nearest available point. When the pointer is within the selection limit of an existing point, Snap mode is in effect. You are able to snap only to those element types that are indicated by the Snap Point Settings icons.

Operating Snap

Model File: AWSNPGRP.PM4

Snap point settings control which element points are used for snap points. You can use any combination of the snap point settings, but you must always have at least one setting turned on. Practice using Snap mode and the Snap point settings by performing these tasks:

1. Open the model file **AWSNPGRP.PM4**.

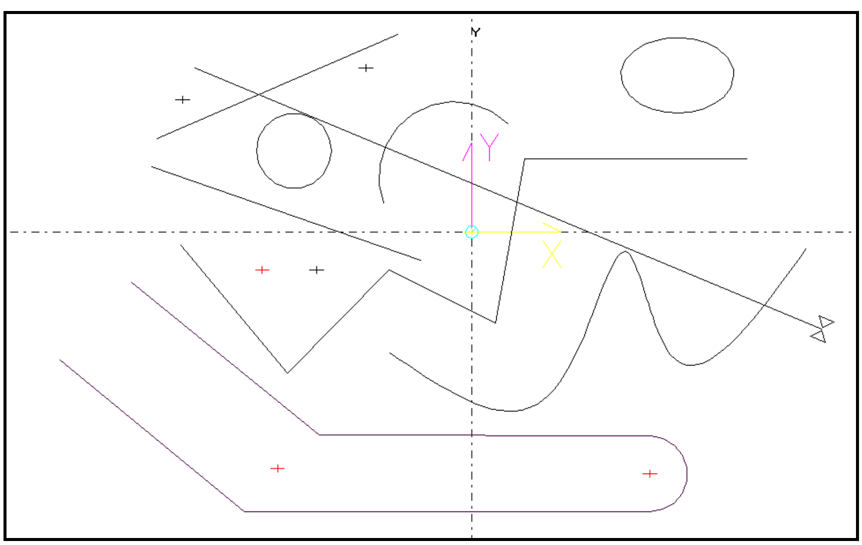
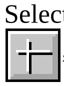
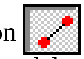
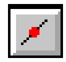
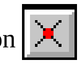
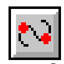
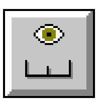


Figure 2-17 *Open AWSNPGRP.*

2. Select the **Snap Mode** icon  and the **Free Coordinates Mode** icon , so that you are in Automatic Mode.
3. Select **Create—Geometry—Line**, and select an input field. Notice that large cross hairs are displayed in the graphic view.

4. Select the **End Point** icon  and snap to the start and end points of all elements in the process model.
5. Select the **Midpoint** icon  to snap to the midpoint of all elements in the process model, except for polylines and splines.
6. Select the **Center Point** icon  to snap to the center point of all arc elements in the process model.
7. Select the **Intersection** icon  and snap to the intersection of lines or arcs in the process model. Intersection does not recognize the intersection of polylines and splines.
8. Select the **Control Point** icon  and snap to points at each control point on a spline or polyline element in the process model.
9. Keep the model file open.

Incrementing with Snap



Model File: AWSNPGRP.PM4

Use Increment, which is on the Utility menu to set the precision of coordinates and pointer movement in the graphic view, the pick distance for Snap, and the default behavior for Z-level settings on the Create control panels.

You increment the pointer coordinates and angles in the graphic view when you adjust the Linear Increment and Angular Increment values on the Increment dialog box. To increment coordinates and angles in the graphic view with Snap, perform these tasks:

1. Open the model file **AWSNPGRP.PM4**.
2. Select **Utility—Increment**. The **Increment** dialog box is displayed.

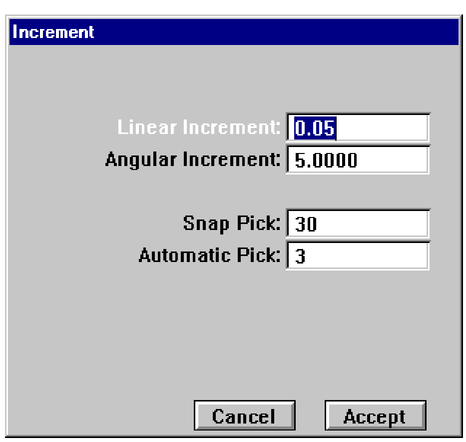


Figure 2-18
Set the values on the Increment dialog box.

3. Set **Linear Increment** to the minimum distance for pointer movement between coordinate display updates when you are using Snap Free Coordinate mode. Set this distance to the smallest value necessary for the precision required by the part geometry.
4. Set **Angular Increment** to the minimum degrees for pointer movement between angle display updates. Set this distance to the smallest value necessary for the precision required by the part geometry.
5. Set **Snap Pick** to the maximum distance in pixels that the pointer can be from an element to select it when you use Snap in Snap mode. This value is also used by the Group arrow and it is normally about 30 pixels.
6. Set **Automatic Pick** to the distance in pixels that the pointer must be from existing elements to switch from Snap mode to Free Coordinate mode when you use Snap in automatic mode. This value is normally between three and five pixels.

   Note The acceptability of the **Snap Pick** and **Automatic Pick** values is affected by your monitor resolution.

Points to Remember

- ❑ Snap enables you to use points and other element properties from existing geometry to enter coordinate values in input fields when you create or edit geometry.
- ❑ If no snap points are found within the element picking distance, Snap returns the coordinates of the last point that you selected.
- ❑ You can use any combination of the snap point settings, but you must always have at least one setting turned on.
- ❑ You increment the pointer coordinates and angles in the graphic view when you adjust the Linear Increment and Angle Increment values on the Increment dialog box.
- ❑ Select Snap Pick or Automatic Pick to set the Snap mode distance.
- ❑ The acceptability of the Snap Pick and Automatic Pick values is affected by your monitor resolution.

Grouping Elements

Objectives

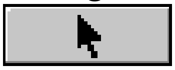
This lesson shows you how to practice these tasks:

- Group elements using the Group Arrow icon.
- Group elements using the Group tool palette.
- Include and restrict the types of elements that you group using the Group tool palette.

Overview

Use the Group icon or the Group tool palette to create an active group of elements.

Using the Group Arrow Icon



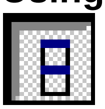
Use the Group Arrow icon to add, edit, or delete elements from the active group or to create a new active group if you operate without the Group tool palette showing.

Select the Group Arrow icon in the readout line below the graphic view. The arrow stays active until you initiate a different function by selecting a control panel or clicking an input field in the active control panel.

Elements in the active group are marked with arrowheads or as dotted lines. To change the active group indicator, change the Element Marking setting in the Utility—Display Modes dialog box; see *Using Display Modes,* on page 1-27.

Note You cannot group hidden or filtered elements. To add hidden elements to a group, first use Utility—Show/Mask to make them visible; see *Using Show/Mask,* on page 4-52. To change the filtering criteria, select the Edit Filter icon  from the readout line or the Group tool palette to open the Edit Filter dialog box.

Using the Group Tool Palette



Model File: AWGROUP.PM4

Use the Group tool palette anytime to group elements, profiles, boxes, steps, layers, or tools. You can activate the Group tool palette by selecting the Group Tool Palette icon that is on the readout line. You can place the Group tool palette anywhere on the screen, and it remains open until you close it.

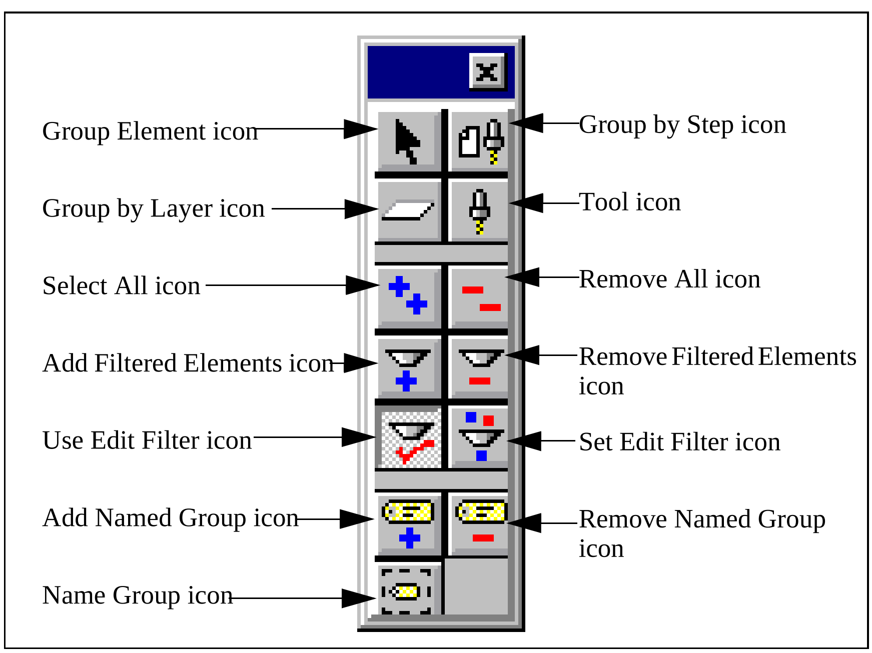


Figure 2-19
Learn to identify the icons in the Group tool palette.

This is the basic procedure for using the Group tool palette:

1. Open the model file **AWGROUP.PM4**.

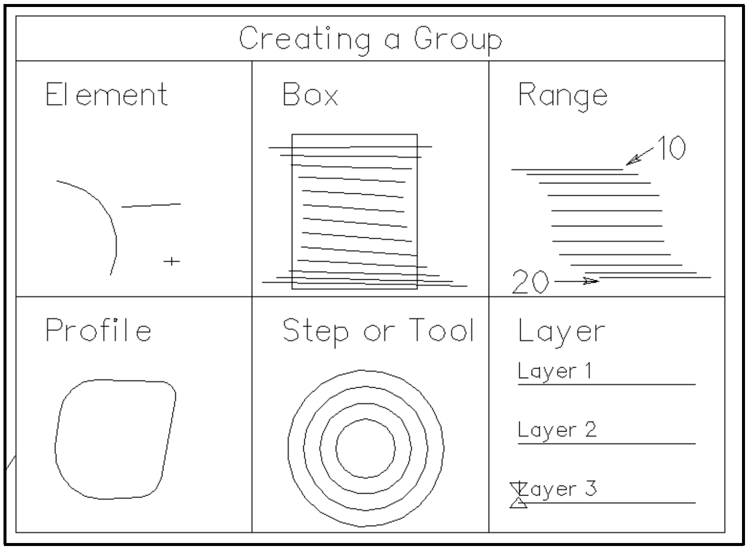


Figure 2-20 *Open AWGROUP.*

2. Select the **Group Tool Palette** icon, which is on the readout line.
3. Select the **Group Element**, **Group by Step**, **Tool**, or **Group by Layer** icon to group elements. Use the **Group by Step**, **Tool**, or **Group by Layer** icon to indicate the step, tool, or layer to work with from either the graphic view or the list view.

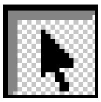
   Note Press the Control (Ctrl) key while performing any of the following selection methods to remove elements from the active group. Each selection method behaves the same for ungrouping as as it does for grouping.

   - **Element—**Single-click an element to add it to the group.
   - **Profile—**Double-click an element in a profile to add it to the group.
   - **Layer** or **Step—**Triple-click any element associated with the desired layer or step to add it to the group.
   - **Range—**Single-click the first element in the range, and Shift-click the last element in the range to add it to the group.
   - **All Visible Geometry—**Double-click in an area that does not contain geometry.
   - **Elements Partially in a Box—**Click and drag from one corner of the box to the opposite corner. All elements at least partially in the box are added to the active group.

- **Elements Completely in a Box—**Shift-click and drag from one corner of the box to the opposite corner. All elements completely within the box are added to the active group.

4. Use the **Remove All** icon  to remove all elements from the active group.

Grouping Geometry by Element



Model File: AWGROUP.PM4

Grouping by element enables you to group or ungroup single elements from the screen as you use the mouse. Perform these tasks to group geometry by element:

1. Open the model file **`AWGROUP.PM4`**.

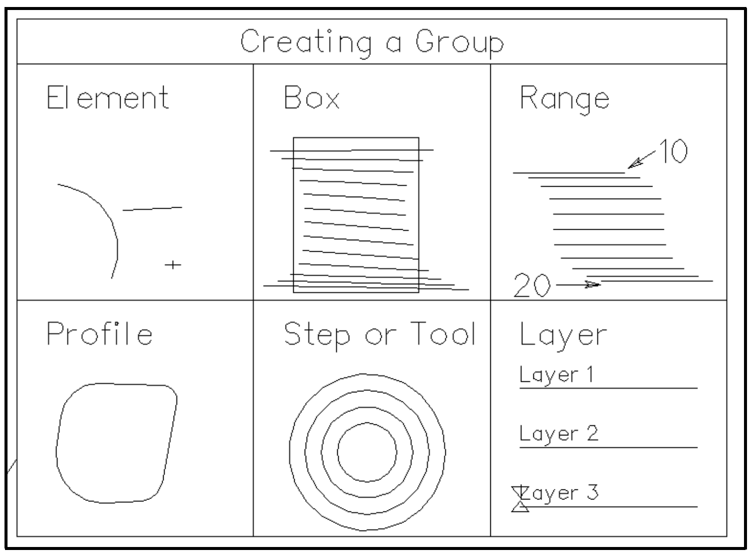


Figure 2-21 *Open AWGROUP.*

2. Select the **Group Tool Palette** icon . The **Group** tool palette is displayed.

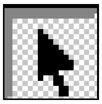
3. Select the **Group Element** icon .

4. Move your cursor over an element and select it by clicking your left mouse button, which adds it to the group. Otherwise, Control-click on a grouped element to remove it from the group.

   You can select an element in one of these ways:

   - Select the element from the graphic view.
   - Select the element from the list view.

Grouping Geometry by Box

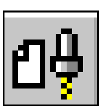


Grouping by box groups or ungroups multiple elements by defining a region or box on the screen with two corner locations. Elements inside or crossing the boundary of the box are grouped or ungrouped. Perform these tasks to group by box:

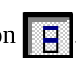
1. Select the **Group Tool Palette** icon . The **Group** tool palette is displayed.
2. Select the **Group Element** icon .
3. Click and drag the cursor in the graphics view to create a selection box to select geometry. There are two variations on box selection:
   - **Box Complete** is invoked by pressing the Shift key while making the box selection. This adds only elements that are entirely within the selection box.
   - **Box Partial** is the default method of box selection. This adds all elements with any part inside the box.

Note Hold the Control (ctrl) key while performing either a Box Complete or a Box Partial selection to ungroup items.

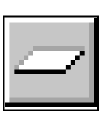
Grouping Geometry by Step



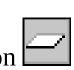
Grouping by step enables you to group or ungroup all elements that are defined with a selected step number. Perform these tasks to group geometry by step:

1. Select the **Group Tool Palette** icon . The **Group** tool palette is displayed.
2. Select the **Group by Step** icon  from the **Group** tool palette.
3. Select the step to add or remove. You can select a step in one of these ways:
   - Select an element associated with the step from the graphic view.
   - Select the step from the list view.

Grouping Geometry by Layer



Grouping by layer enables you to group or ungroup all elements that are on the selected layer. Perform these tasks to group geometry by layer:

1. Select the **Group Tool Palette** icon . The **Group** tool palette is displayed.
2. Select the **Group by Layer** icon  from the **Group** tool palette.
3. Select the geometry.

- Add geometry to the active group by selecting, from the list view, the layer that contains geometry you want added, or select geometry in the graphics view that is on the layer you want added to the active group.
- Remove geometry on a layer from the active group by pressing the Control key while selecting geometry from that layer in the graphics view or selecting that layer in the list view.

Saving Grouped Geometry

Save grouped geometry by performing these tasks:

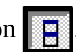
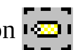
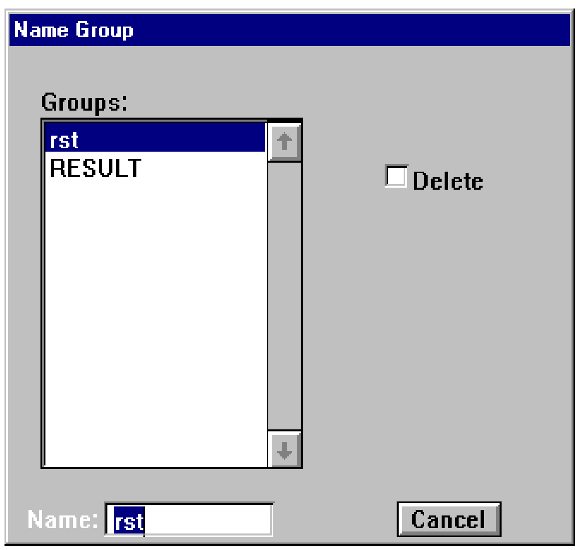
1. Select the **Group Tool Palette** icon . The **Group** tool palette is displayed.
2. Select a grouping method and group your elements.
3. Select the **Name Group** icon  on the **Group** tool palette. The **Name Group** dialog box is displayed.

Figure 2-22
Set the values on the Name Group dialog box.



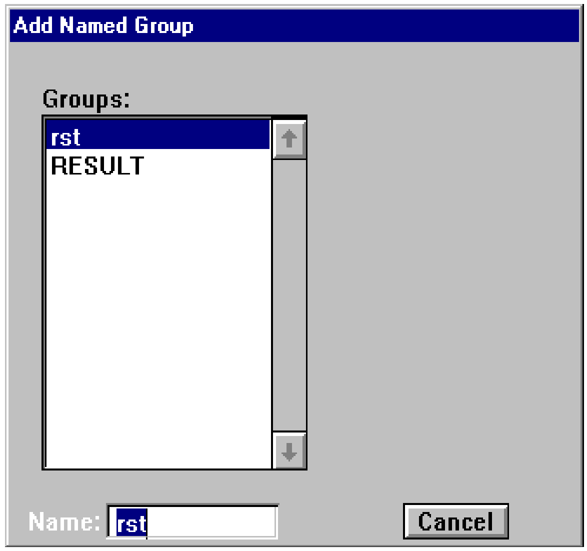
4. Set the **Name** input field, for example, rst.
5. Press the Enter key.

Adding and Removing Grouped Geometry

Retrieve grouped geometry by performing these tasks:

1. Select the **Group Tool Palette** icon . The **Group** tool palette is displayed.
2. Select the **Add Named Group** icon  on the **Group** tool palette. The **Add Named Group** dialog box is displayed.

Figure 2-23
Set the values on the Add Named Group dialog box.

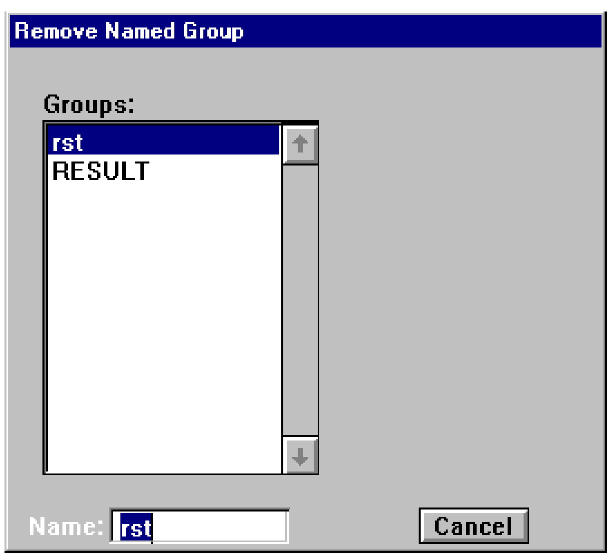


3. Set the **Name** input field to **rst**, or select **rst** from the **Groups** list.

   Note This is only an option if you named a group *rst* in the saving grouped geometry lesson above.

4. Press the Enter key.
5. Select the **Remove Named Group** icon. The Remove Named Group dialog box is displayed.

Figure 2-24
Set the values on the Remove Named Group dialog box.



6. Set the **Name** input field to **rst**, or select **rst** from the **Groups** list.
7. Press the Enter key.

Points to Remember

- ❑ You must create a group before you can perform procedures that involve more than one element.
- ❑ Tools that require groups are dimmed if no group is active.
- ❑ Group by element, box, range, profile, step, tool, or layer.
- ❑ You can place the Group tool palette anywhere on the screen.
- ❑ Single-click an element to add it to a group.
- ❑ Double-click a profile to add it to a group.
- ❑ Triple-click any element associated with the desired layer or step to add it to the group.
- ❑ Control-click items to remove them from a group.
- ❑ Hold the Shift key when using the group box feature to toggle from partial select to complete.

Using Edit Filters

Objectives

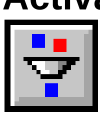
This lesson shows you how to perform these tasks:

- Activate edit filters.
- Turn edit filters on and off.
- Add filtered elements.
- Remove filtered elements.

Overview

Use Edit Filter to set the selection filtering criteria when you select an active group, view element data, or use Snap mode to enter coordinate values. When you use the filter, group, snap, and element data recognize only the element types that you specify in the Edit Filter dialog box.

Activating Edit Filters for an Active Group

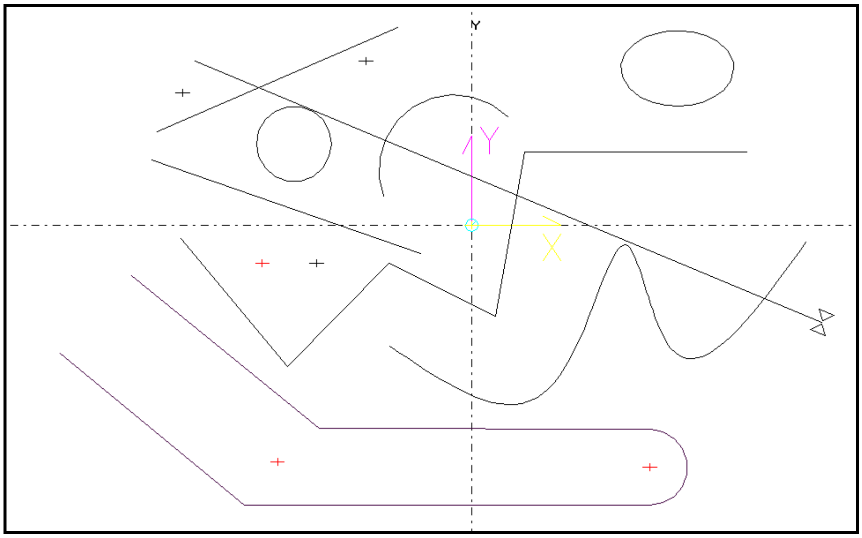


Model File: AWSNPGRP.PM4

Perform these tasks to activate edit filters:

1. Open the model file **`AWSNPGRP.PM4`**.

__Figure 2-25__
Open AWSNPGRP.



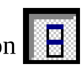
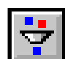
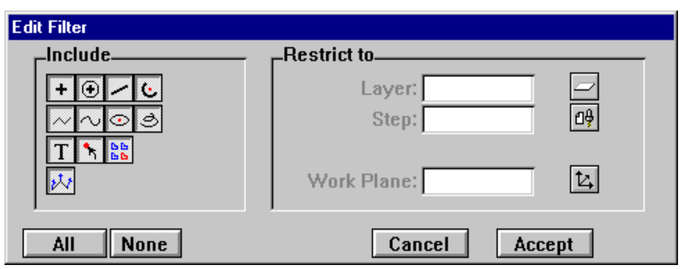
2. Select the **Group Tool Palette** icon  to open the **Group** tool palette.
3. Select the **Edit Filter** icon  from the **Group** tool palette. The **Edit Filter** dialog box is displayed.

__Figure 2-26__
Enter Include and Restrict values on the Edit Filter dialog box.

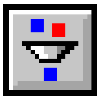


4. Under the **Include** heading, specify the element types for the system to recognize for the group functions. You can choose all element types by selecting the **All** button or exclude all element types by selecting the **None** button.

   Note All element types are activated by default. To select one element type, select the **None** button. Then specify the element type to include.

5. Under the **Restrict to** heading, you can choose to limit element selections by a specific layer, step, or work plane.
6. Select the **Accept** button.

Activating Edit Filters for Snapping

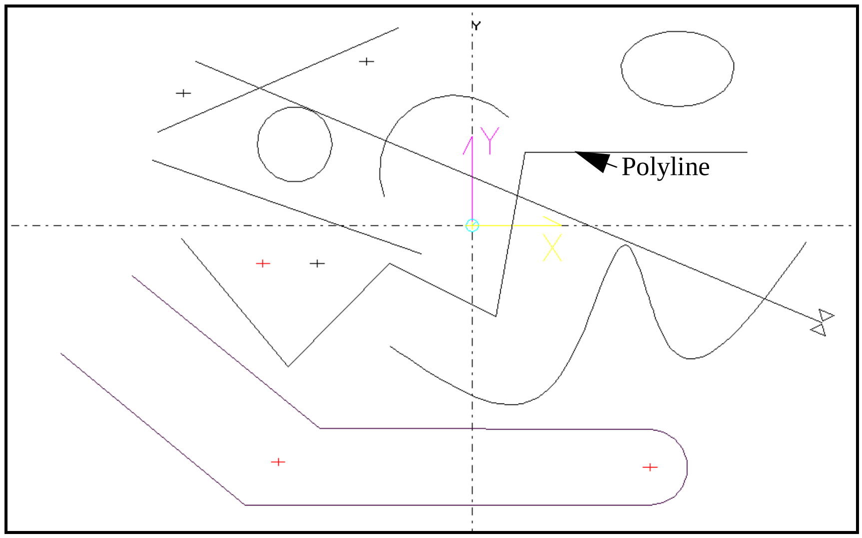


Model File: AWSNPGRP.PM4

Perform these tasks to activate edit filters:

1. Open the model file **`AWSNPGRP.PM4`**.

Figure 2-27 *Open AWSNPGRP.*



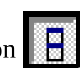
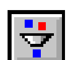
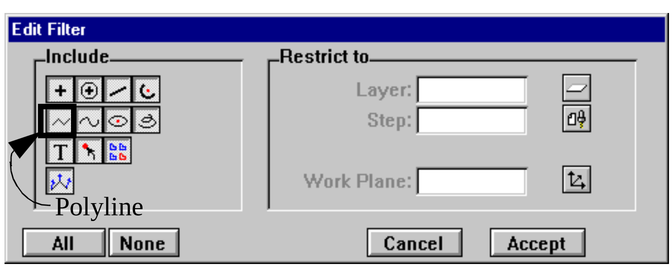
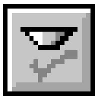
2. Select the **Group Tool Palette** icon  to open the **Group** tool palette.
3. Select the **Edit Filter** icon  from the **Group** tool palette. The **Edit Filter** dialog box is displayed.

Figure 2-28 *Enter Include and Restrict to values on the Edit Filter dialog box.*



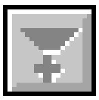
4. Include only polyline elements.
5. Select the **Accept** button.
6. Set the Snap mode to **Automatic**, and turn on all of the snap point settings that are on the readout line.
7. Select **Create—Geometry—Line**.
8. Move the cursor in the graphic view. Notice that the automatic snapping recognizes only the polyline element because the edit filter is on.

Turning Edit Filters On and Off



The on/off switch for using the edit filter is turned on when you complete the Edit Filter dialog box and select the Accept button. However, you can turn the filter on and off manually by selecting the Use Edit Filter icon.

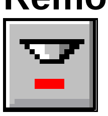
Adding Filtered Elements



Select the Add Filtered Elements icon, which is on the Group tool palette. You can select these elements:

- Points
- Holes
- Lines
- Arcs
- Text
- Splines
- Polylines
- Ellipses
- Helixes
- User Commands
- Sub Calls
- Layers
- Work Planes
- Steps
- Poly5x

Removing Filtered Elements



If necessary, use the Remove Filtered Elements icon to remove elements that are defined by the Edit Filter dialog box.

Points to Remember

- ❑ Select the Set Edit Filter icon to quickly open the Edit Filter dialog box.
- ❑ Select the All button on the Edit Filter dialog box to include all element types in a group.
- ❑ Restrict element selection by a specific layer, step, or work plane.
- ❑ You can use the Snap modes alone or with the Edit Filter dialog box to limit the element types that you snap to.

Self-Test

Directions

Test your understanding of the concepts and procedures in this section by answering the following questions. The answers for each self-test are in *Appendix A* of this manual.

______________ **1. Layer geometry generates code.**

a) true
b) false

______________ **2. Step geometry generates code.**

a) true
b) false

______________ **3. Which input field defines the height that the tool retracts to after making a cut?**

a) Level
b) Clear
c) Prof_Top
d) Insert

______________ **4. Which input field defines the height of the top of your part?**

a) Level
b) Clear
c) Prof_Top
d) Insert

______________ **5. What type of plane determines the orientation of geometry?**

a) kill
b) tool
c) work
d) home

______________ **6. Which SmartCAM feature enables you to use points and other element properties from existing geometry to enter coordinate values in input fields when you create or edit geometry?**

a) Group
b) Snap
c) Edit Filters
d) Kill Plane

______________ **7. Using Status interrupts the current task.**

a) true
b) false

______________ **8. How do you know if tools require groups if there are no active groups?**

a) Tools are dimmed.
b) Geometry is dimmed.
c) both a and b
d) neither a nor b

3

Using Job Operations

Overview

This unit shows you how to use the Job Operation Planner to build a new job operations setup, add process steps and tools, and print the Job Operations Setup Reports.

Lessons for This Unit

- Using the Job Operation Planner
- Using the Material Librarian
- Printing Job Operations Setup Reports

Using the Job Operation Planner

Objectives

This lesson shows you how to perform these tasks:

- Create a `.jof` file.
- Add and edit process steps.
- Remove and move steps and tools.
- Renumber steps.
- Sort steps and tools.

Overview

Use the Job Operation Planner to enter the units and machine files to use for code generation. You can also use it to create and edit process steps, which are combinations of tool and operation information. All of the step information you enter is then contained in a Job Operation File (`.jof`). SmartCAM generates a `.jof` when you save your model file (`.pm4`).

Every .jof includes some general information about the job to be completed. The Job Information section of the Job Operation Planner contains this data. Much of the data in this section is optional. You can leave it out to save time creating the process model and generating code. However, you must set the units in the Job Information section. It is also helpful to set the machine files at this point. You must also set the speed and feed information on the Edit Process Step dialog box to view toolpath.

The Job Information section includes the following basic information about the job:

- Units
- Part description
- Machine Define file (.smf)
- Machine Template file (.tmp)
- Material description

The steps used in the process model include the following information:

- Feedrate and units
- Spindle speed and units
- Turret and tool number
- Lead angle
- Tool shape and size

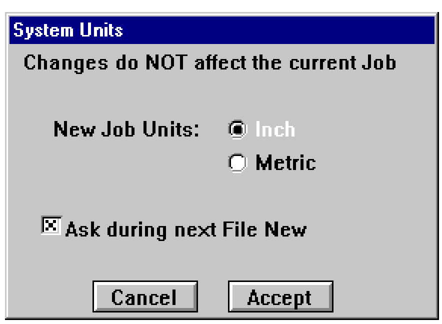
Creating a .jof File

Perform these tasks to create a .jof file:

1. If you use the same units for every job, perform these tasks:

    a. Select **Utility—System Units**. The **System Units** dialog box is displayed.

Figure 3-1 *Select Utility—System Units to display the System Units dialog box.*



    b. Set the **New Job Units** option switch to **Inch** or **Metric**.

    c. Turn off the **Ask during next File New** on/off switch.

    d. Select the **Accept** button.

2. If you use different units for different jobs, perform these tasks:

    a. Select **File—New**. The **New Job Units** dialog box is displayed.

Figure 3-2
File—New invokes the New Job Units dialog box.

b. Set the **New Job Units** option switch to **Inch** or **Metric**.

c. Select the **Accept** button.

3. Select **File—Planner**. The **Job Operation Planner** dialog box is displayed.

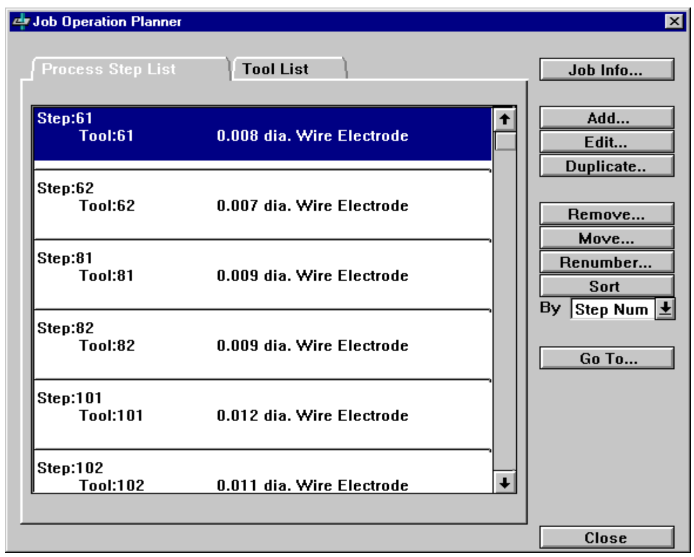
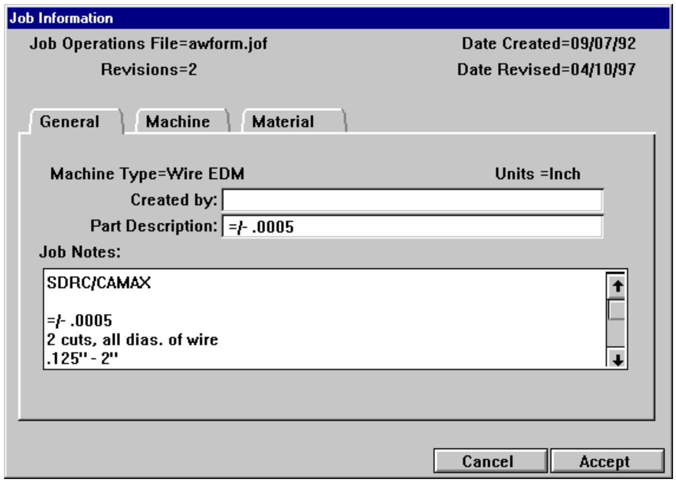


Figure 3-3
File—Planner invokes the Job Operation Planner dialog box.

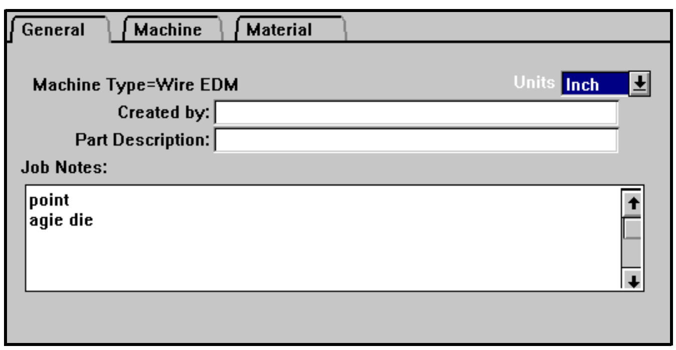
4. Select the **Job Info** button in the upper right corner of the **Job Operation Planner** dialog box. The **Job Information** dialog box is displayed.

Figure 3-4
The Job Info button invokes the Job Information dialog box.



5. Select the **General** tab. The **General** page is displayed.

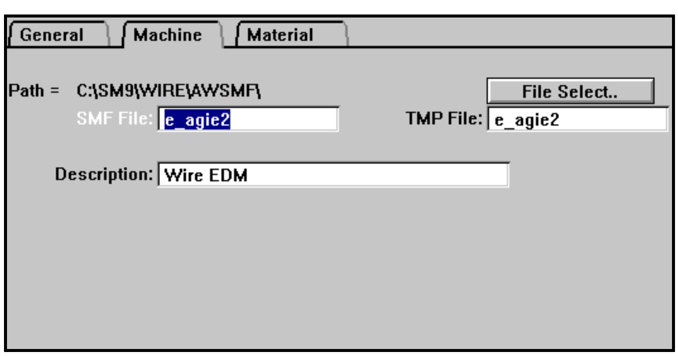
Figure 3-5
The General tab invokes the General page.



6. Set the **Created by**, **Part Description,** and **Job Notes** input fields. These fields are optional.

7. Select the **Machine** tab on the **Job Information** dialog box. Input fields for machine defined files and templates files are displayed.

Figure 3-6
The Machine tab invokes the Machine page.



8. Place the cursor in the **SMF File** input field, and select the **File Select** button. The **Open** dialog box is displayed.

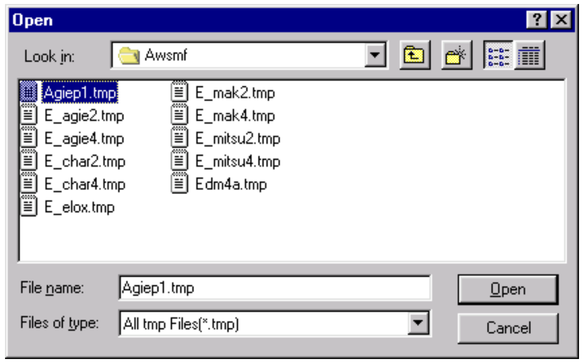


Figure 3-7
Select an SMF file to use from the AWSMF directory.

9. Select an SMF file to use from the AWSMF directory (for example: `AGIEP1.SMF`).

10. Select the **Open** button.

11. With the cursor still in the **SMF File** input field, press the Enter key, or click the right mouse button. The **TMP File** input field is then set. The name of the template file used is taken from question #1 of the .smf file.

12. Select the **Material** tab. The **Material** page is displayed.

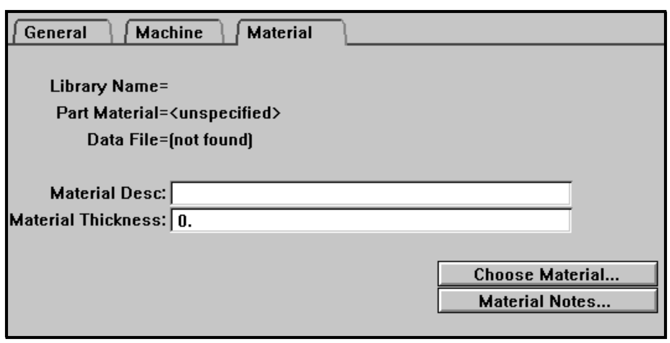


Figure 3-8
Use the Material page to set the material description.

13. Select the **Choose Material** button. The **Choose Material** dialog box is displayed.

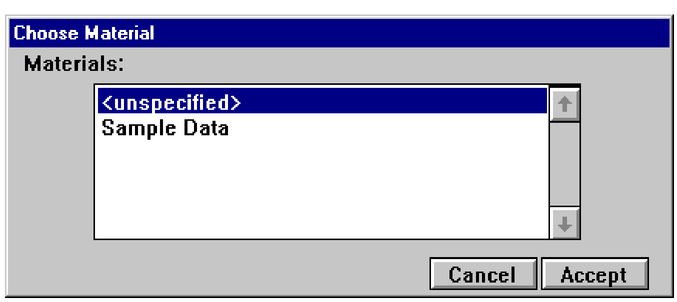


Figure 3-9
Use the Choose Material dialog box to specify the kind of material to use.

14. Select the name of the material to use.

Note Material options are set in the Material Librarian. For more information about setting these options, see *Setting Up a File with the Material Librarian,* on page 3-27.

15. Select the **Accept** button.
16. Set the **Material Desc** input field with the description of the material that you will process the part from. This step is optional.
17. Select the **Accept** button on the bottom of the **Job Information** dialog box, see Figure 3-4.

Adding a Process Step

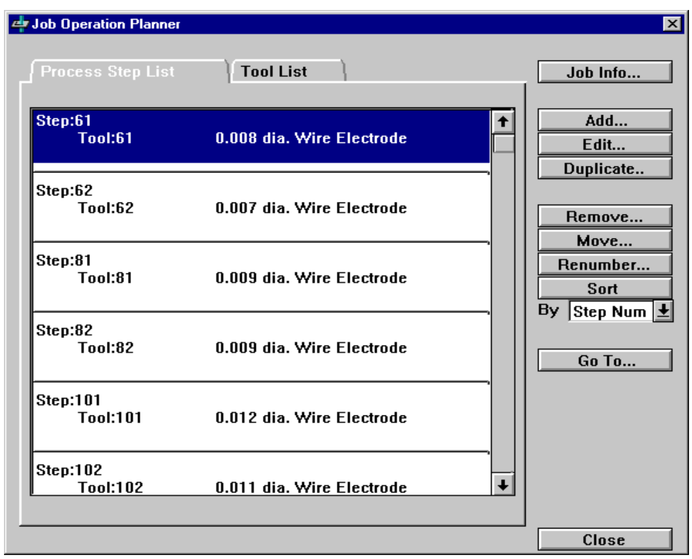
Remember, a step is a combination of tool and operation information. You must complete the tool description and feed/speed values to create a complete step.

Creating a Step Using Add

Perform these tasks, using a new file and either the values that are displayed in the first two steps in Figure 3-10 or values that you choose:

1. Select **File—Planner**. The **Job Operation Planner** dialog box is displayed.

Figure 3-10 *File—Planner invokes the Job Operation Planner dialog box.*



2. Select the **Add** button in the **Job Operation Planner** dialog box. The **Add Process Step** dialog box is displayed.

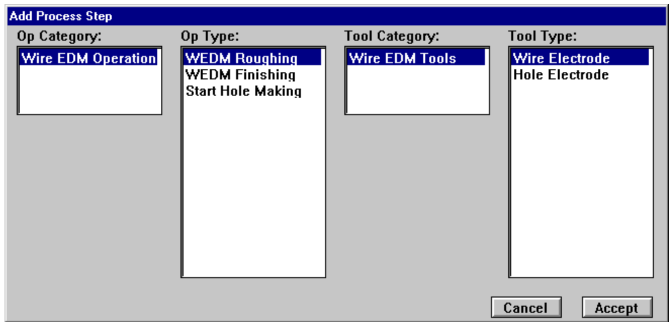


Figure 3-11
Select tool information with the Add Process Step dialog box.

3. Complete the **Add Process Step** dialog box by selecting one operation or tool from each of the four fields:

   - **Op Category** sets the operation category to use (for example, **Wire EDM Operation**).
   - **Op Type** sets the operation type to use. The listed operation type depends on the operation category (for example, **WEDM Roughing**).
   - **Tool Category** sets the tool to use. The list of tool categories depends on the operation category selected (for example, **Wire EDM Tools**).
   - **Tool Type** sets the tool type to use. The list of tools depends on the selected tool category (for example, **Wire Electrode**).

4. Select the **Accept** button on the bottom of the **Add Process Step** dialog box. The **Edit Process Step** dialog box is displayed.

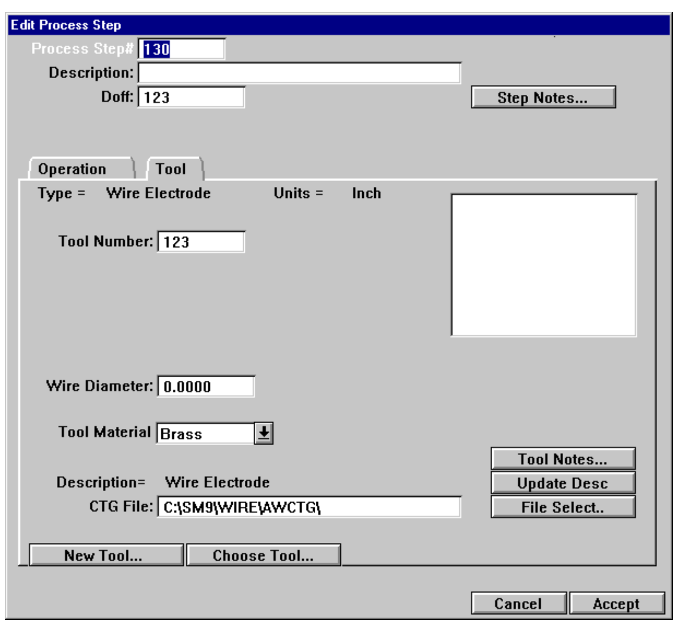


Figure 3-12
Select the Accept button to open the Edit Process Step dialog box.

5. Set the **Process Step #** input field if needed; otherwise, a default value is placed in the input field.

Note During each session, SmartCAM assigns colors to any steps that have numbers greater than 255. However, color assignments are not saved with these steps. Therefore, the colors for these steps may be different for each SmartCAM session.

6. Select the **Tool** tab, and complete the **Tool** page.
7. Select the **Operation** tab, and complete the **Operation** page.

Note The **Feed** and **Speed** input fields are for Show path (displaying the toolpath) purposes only. Code output depends on your machine, .smf file, and .tmp file.

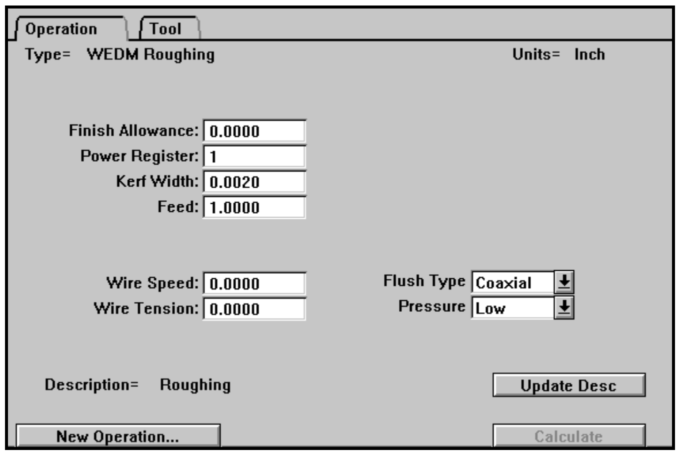


Figure 3-13 *Use the Operation page to enter operation information for the process step.*

8. Select the **Accept** button on the bottom of the **Edit Process Step** dialog box, see Figure 3-12. A new step is listed in the **Process Step List** page.

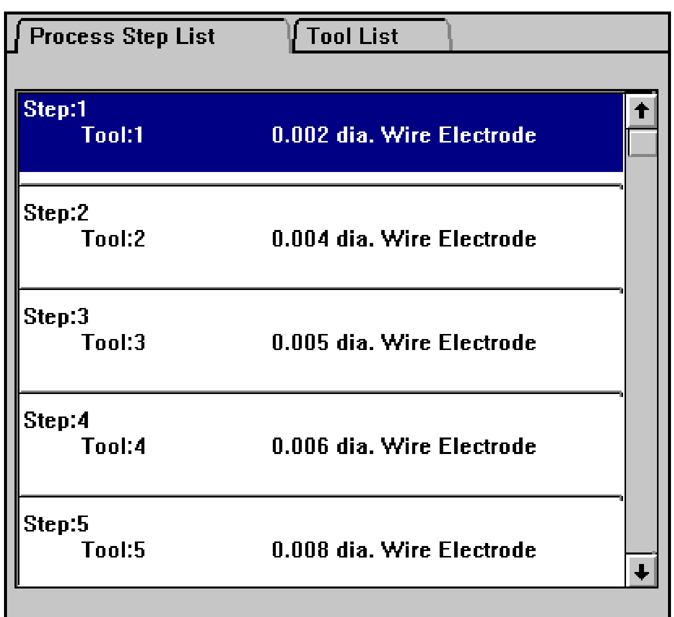


Figure 3-14 *The Process Step List page is updated.*

Creating a Step Using Duplicate

You can create a step using the Duplicate button on the Job Operation Planner dialog box only if other steps exist. When you select the Duplicate button, the selected step is copied to a new number. You can then change either the operation values or the tool parameters.

Perform these tasks to duplicate a step:

1. Select **File—Planner**. The **Job Operation Planner** dialog box is displayed.

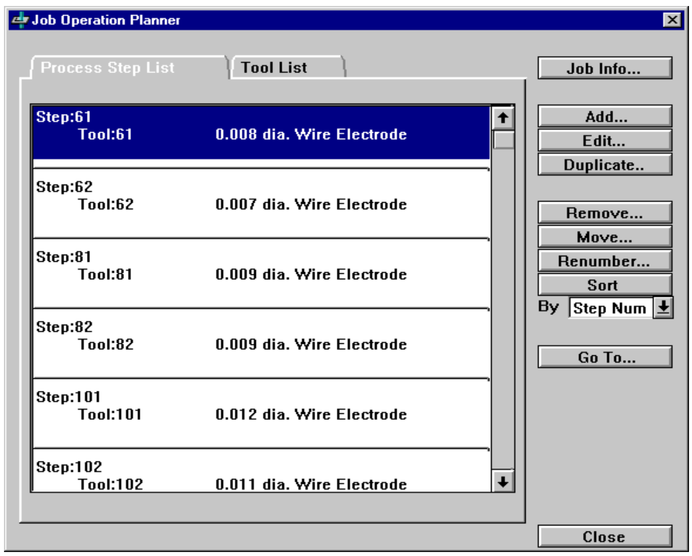
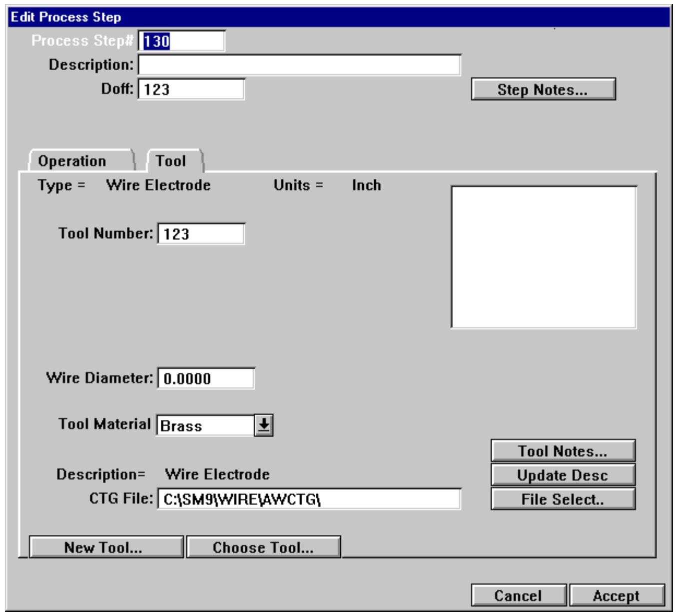


Figure 3-15
File—Planner invokes the Job Operation Planner dialog box.

2. Select the step to duplicate from the **Process Step List** tab. The step is highlighted.
3. Select the **Duplicate** button on the right side of the **Job Operation Planner** dialog box. The **Edit Process Step** dialog box is displayed.

Figure 3-16 *Select the Duplicate button to open the Edit Process Step dialog box.*



4. Change either the operation parameters or add new tool parameters.

Note Changes you make to the operation parameters are reflected only in the new step you create. However, changes you make to tool parameters are reflected in every step that uses that tool. Therefore, it is not advisable to change tool parameters when you duplicate a step. If you need a different tool for your step, select a different number tool for your new step or create a new tool. For more information about new tools, see *Using the New Tool Button*, on page 3-14.

- If you want to change operation parameters, perform these tasks:

  a. Select the **Operation** page.

  b. Make changes to the input fields as needed. The **Process Step #** input field increments to the next available number. You can change it to any number not used by a step.

- If you want to add new tool parameters, perform these tasks:

  a. Select the **Tool** page.

  b. Select the **New Tool** button. The **Choose Tool Type** dialog box is displayed.

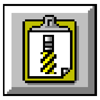
  c. Select a new tool.

  d. Select the **Accept** button.

  e. Complete the input fields on the **Tool** page to describe the new tool.

5. Select the **Accept** button.

Editing a Process Step



You can edit any step using the Job Operation Planner. You can use the Edit button or you can double-click a step to access the Edit Process Step dialog box.

By using the Edit button to edit a step, you can change the operation and tool descriptions to new values. Perform these tasks to edit a process step:

1. Select **File—Planner**. The **Job Operation Planner** dialog box is displayed.

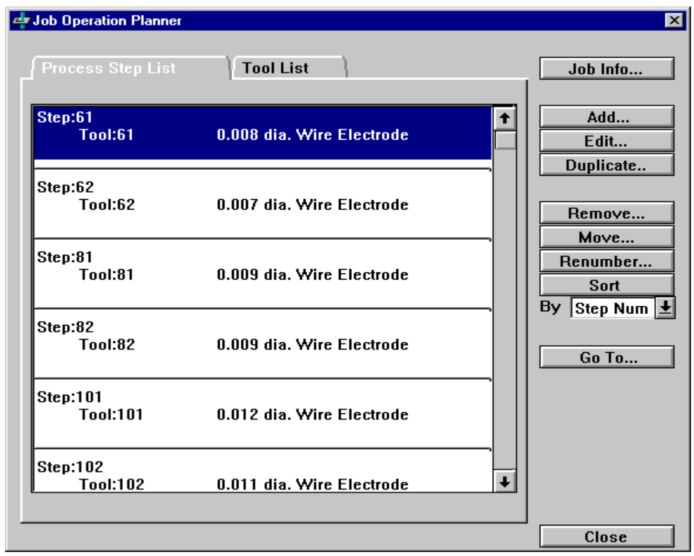


Figure 3-17
File—Planner invokes the Job Operation Planner dialog box.

2. Select the step to edit. The step is highlighted.
3. Select the **Edit** button on the right side of the **Job Operation Planner** dialog box. The **Edit Process Step** dialog box is displayed.

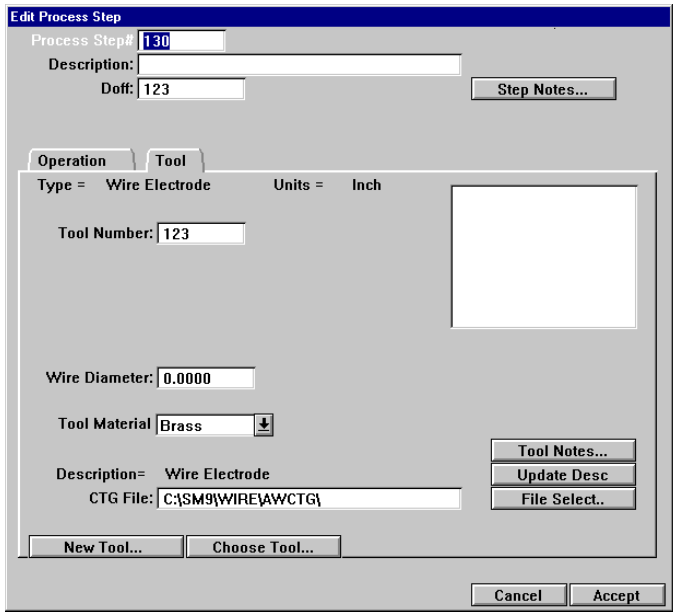


Figure 3-18
Select the Edit button to open the Edit Process Step dialog box.

4. Make changes to the input fields on either the **Tool** or **Operation** page.
5. Select the **Accept** button when you are done.

Using the New Tool Button

Use the New Tool button on the Tool page of the Edit Process Step dialog box to use a new tool when you edit an existing step. For example, you can switch from a roughing tool to a finishing tool. Perform these tasks to select a new tool to use:

1. Select **File—Planner**. The **Job Operation Planner** dialog box is displayed.

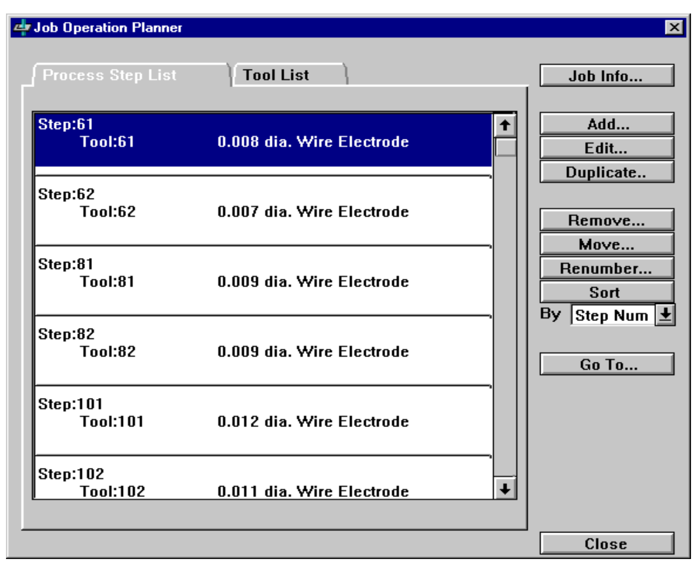
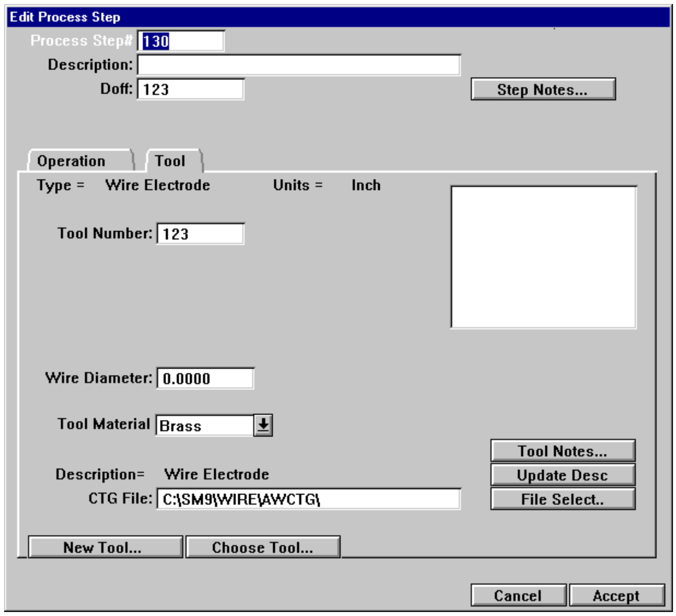


Figure 3-19
File—Planner invokes the Job Operation Planner dialog box.

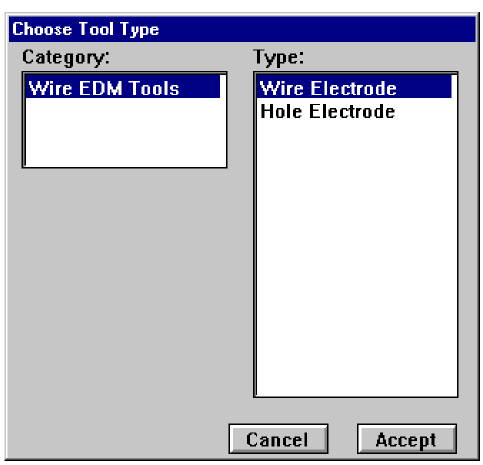
2. Select a step to edit. The step is highlighted.
3. Select the **Edit** button on the right side of the **Job Operation Planner** dialog box. The **Edit Process Step** dialog box is displayed.

Figure 3-20
Select the Edit button to open the Edit Process Step dialog box.



4. Select the **Tool** tab. The **Tool** page is displayed.
5. Select the **New Tool** button on the bottom of the **Tool** page to define a new tool to use with this step. The **Choose Tool Type** dialog box is displayed.

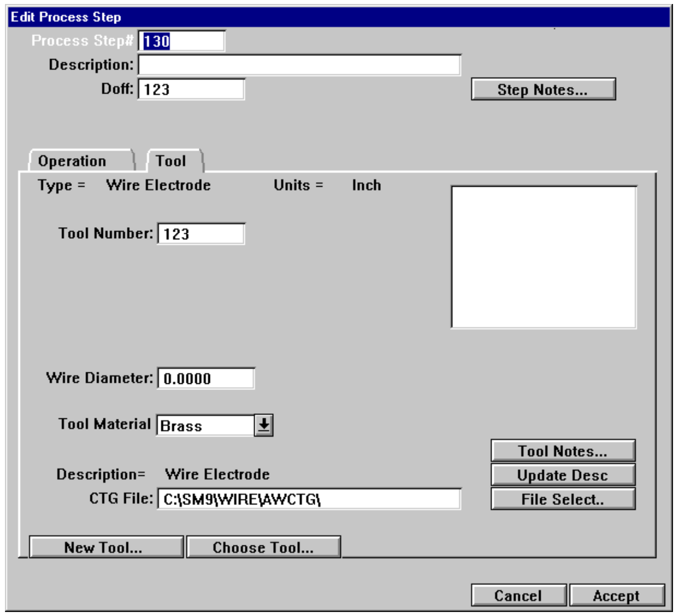
Figure 3-21
Use the Choose Tool Type dialog box to select a new tool category and type.



6. Select a new tool category. Remember, the available tool categories are based on the operation that you chose when you created the step.
7. Select a new tool type.

8. Select the **Accept** button on the bottom of the **Choose Tool Type** dialog box. The **Edit Process Step** dialog box is displayed.

Figure 3-22
Select the Accept button to open the Edit Process Step dialog box.



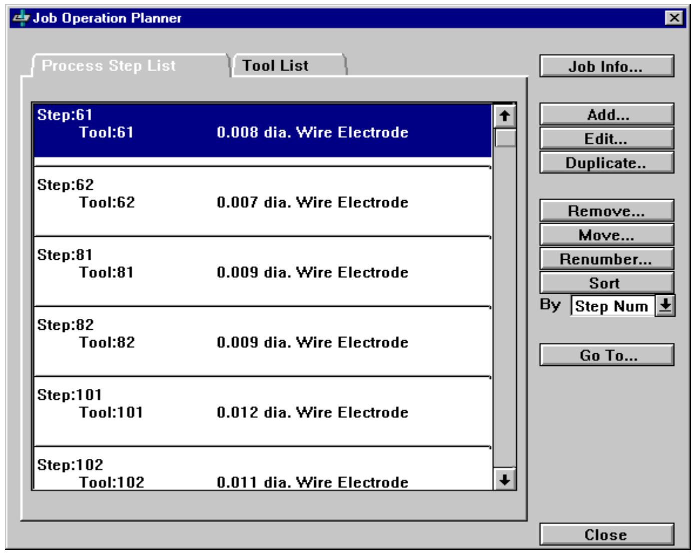
9. Complete the input fields on the **Tool** page to describe the new tool.
10. Select the **Accept** button.

Using the Choose Tool Button

Use the Choose Tool button to use an existing tool when you edit a step. You can either copy an existing tool to a new tool number or use it directly. Perform these tasks to choose a tool:

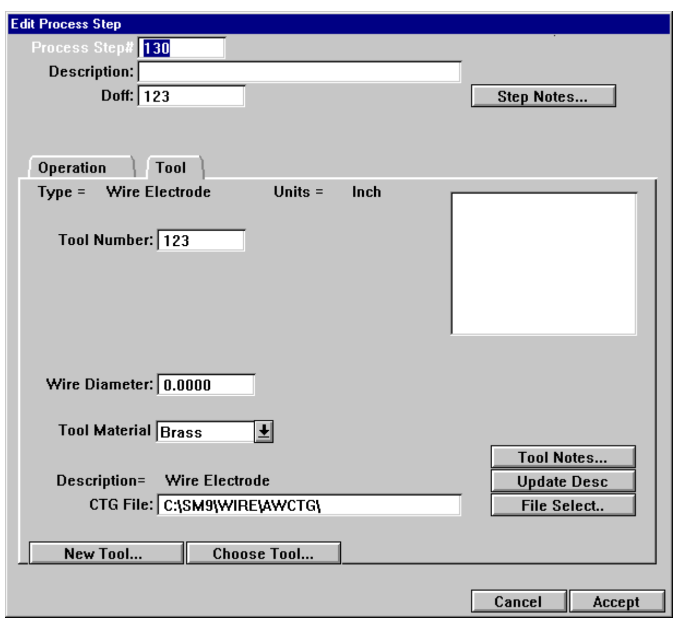
1. Select **File—Planner**. The **Job Operation Planner** dialog box is displayed.

Figure 3-23
File—Planner invokes the Job Operation Planner dialog box.



2. Select a step to edit. The step is highlighted.
3. Select the **Edit** button on the right side of the **Job Operation Planner** dialog box. The **Edit Process Step** dialog box is displayed.

Figure 3-24
Select the Edit button to open the Edit Process Step dialog box.



4. Select the **Tool** tab. The **Tool** page is displayed.
5. Select the **Choose Tool** button on the bottom of the **Tool** page to select an existing tool to use with this step. The **Choose Tool** dialog box is displayed.

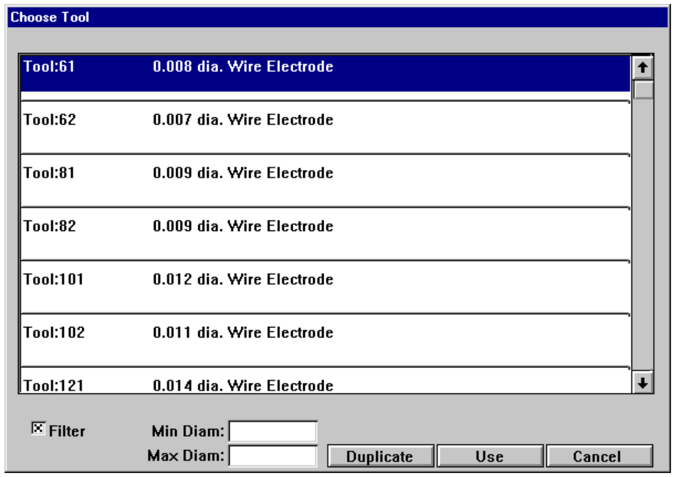
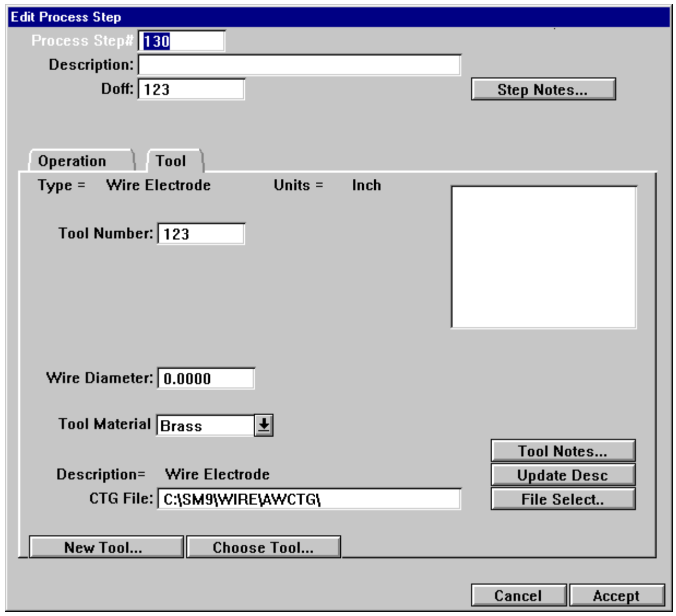


Figure 3-25
Use the Choose Tool dialog box to select an existing tool.

6. Set **Filter** to list the tool types you need to view.
   - Filter **on** causes this dialog to display only tools that match the original tool. For example, if the tool being edited is a wire electrode, only existing wire electrodes will be listed.
   - Filter **off** causes all tools in the current job (those listed in the **Job Operation Planner**) to be listed.
7. Select a tool from the list of existing tools.
8. Select either the **Duplicate** or **Use** button. The **Edit Process Step** dialog box is displayed. Values for the selected tool are set in the input fields, as follows:
   - The **Duplicate** button uses the attributes of the selected tool to create a new tool and assigns a new tool number to this new tool.
   - The **Use** button applies the existing tool to the step.

Figure 3-26
Select the Duplicate or Use button to open the Edit Process Step dialog box.



9. Select the **Accept** button to complete the edit process.

Finding Help About Tool and Operation Tabs

If you are using the Edit Process Step dialog box, you can find more information about a tool or one of the input fields using these methods:

- Use context-sensitive Help by performing these tasks:

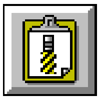
  a. Press **SHIFT +F1** to display a  cursor. Place the cursor anywhere on the Tool or Operation tab and click. A Help topic about Edit Process Step is displayed with an overview of information. If you select the **Fields** button for this topic, a new Help topic is displayed that describes the input fields for the general parameters.

  b. To learn more about either the Tool or Operation tab, select the underlined text for a tab in the Help topic. A Help topic is displayed that has an overview and buttons for **Fields** and **How To**. Each input field is described in Fields. The How To provides operational information about how to change the tab.

- Use **Search** to find information about specific input fields. You enable Search when you press **F1**, select **Search**, and then enter the word to learn about.

- Use **Glossary** to find a word and how it is used. You can also press **F1** and select the title **Glossary**. The Glossary contains conceptual information that applies in a broad context. Use **Search** or the **Fields** button when you need information about specific input fields.

Removing Steps and Tools

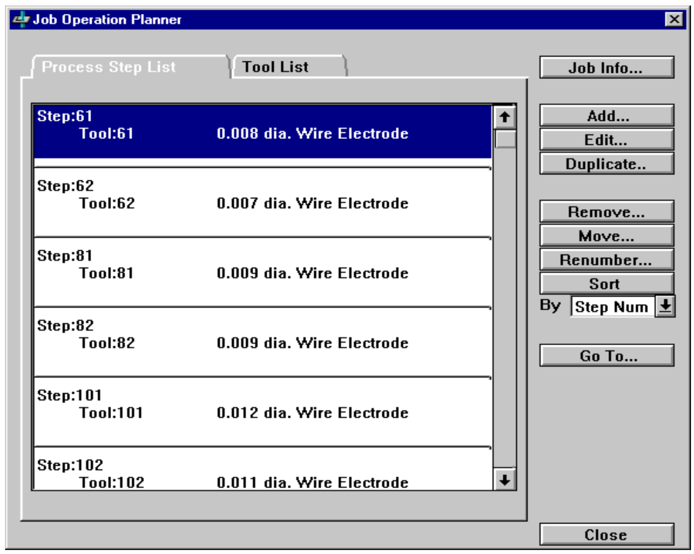


You can remove unused steps and tools from the Job Operation Planner dialog box. Only the steps or tools that are not used or selected as active are listed for possible removal.

Perform these tasks to remove unused steps and tools from the Job Operation Planner dialog box:

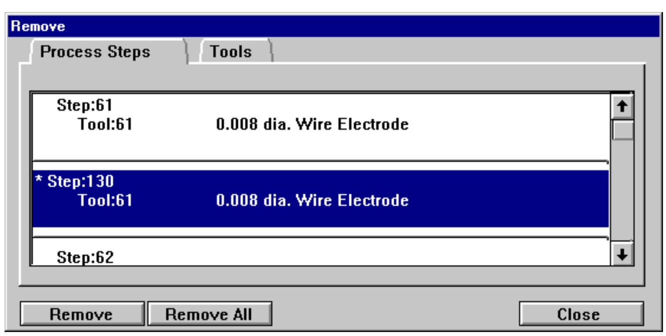
1. Select **File—Planner**. The **Job Operation Planner** dialog box is displayed.

Figure 3-27 *File—Planner invokes the Job Operation Planner dialog box.*



2. Select the **Remove** button on the right side of the **Job Operation Planner** dialog box. The **Remove** dialog box is displayed.

Figure 3-28 *Use the Remove dialog box to specify steps or tools to remove from the Job Operation Planner.*



3. Select the **Process Steps** tab to remove a step, or select the **Tools** tab to remove individual tools.

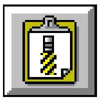
4. Select the step or tool to remove.

5. Select the **Remove** or **Remove All** button:

   ■ The **Remove** button removes the highlighted step or tool.

   ■ The **Remove All** button removes all unused steps or tools, depending on the tab that is selected.

Moving Steps and Tools



You can sequence one step or tool at a time using Move.

Moving Steps

Perform these tasks to move a step to a different place in the sequence:

1. Select **File—Planner**. The **Job Operation Planner** dialog box is displayed.

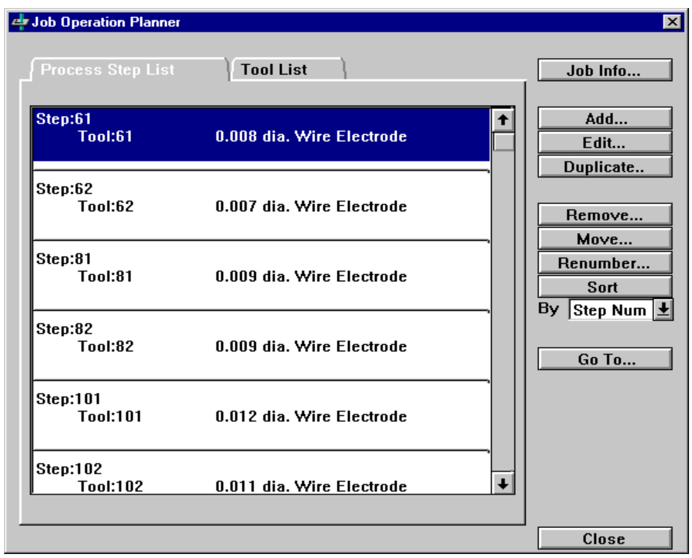


Figure 3-29
File—Planner invokes the Job Operation Planner dialog box.

2. Select the **Process Step List** tab to move a step.

3. Select the step to move.

4. Select the **Move** button on the right side of the dialog box. The **Move Process Step** dialog box is displayed.

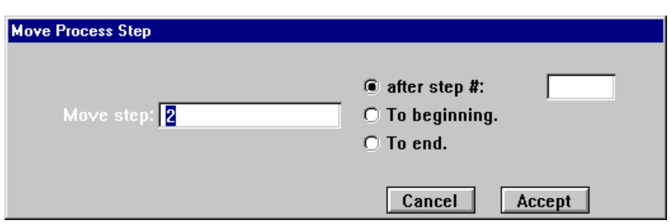


Figure 3-30
Use the Move Process Step dialog box to specify where to move the step.

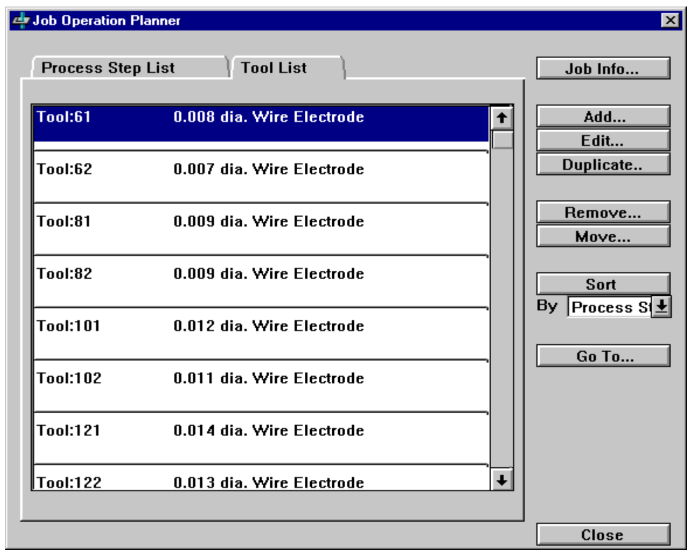
5. Specify where to move the step. You can move the step to these locations:
   - After a specified step number
   - To the beginning of the list of steps
   - To the end of the list of steps
6. Select the **Accept** button. The step is moved to its new location.

Moving Tools

Perform these tasks to move tools after a specified tool number, to the beginning of the list of tools, or to the end of the list of tools:

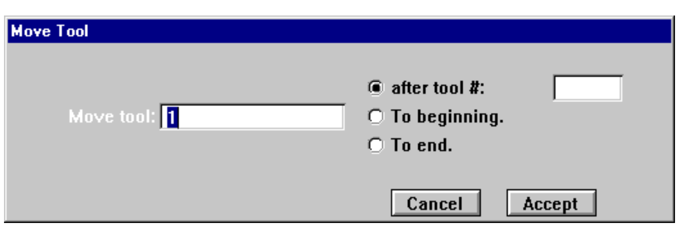
1. Select **File—Planner**. The **Job Operation Planner** dialog box is displayed.

Figure 3-31 *File—Planner invokes the Job Operation Planner dialog box.*



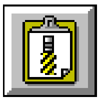
2. Select the **Tool List** tab to move a tool. The **Tool** page is displayed.
3. Select the tool to move.
4. Select the **Move** button on the right side of the dialog box. The **Move Tool** dialog box is displayed.

Figure 3-32 *Use the Move Tool dialog box to specify where to move the tool.*



5. Specify where to move the tool. You can move the tool to these locations:
   - After a specified tool number
   - To the beginning of the list of tools
   - To the end of the list of tools
6. Select the **Accept** button. The tool is moved to its new location.

Renumbering Steps



Perform these tasks to update or adjust step numbers:

1. Select **File—Planner**. The **Job Operation Planner** dialog box is displayed.

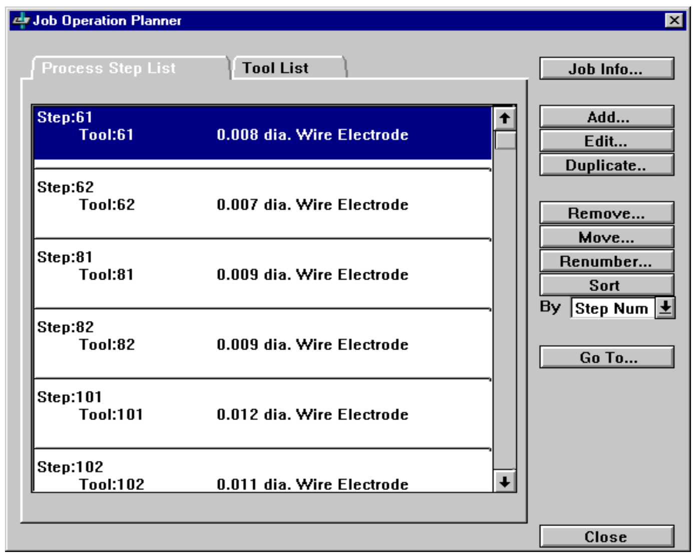


Figure 3-33 *File—Planner invokes the Job Operation Planner dialog box.*

2. Select the **Process Step List** tab. The **Process Step List** page is displayed.
3. Select the **Renumber** button on the right side of the dialog box. The **Renumber Process Step** dialog box is displayed.

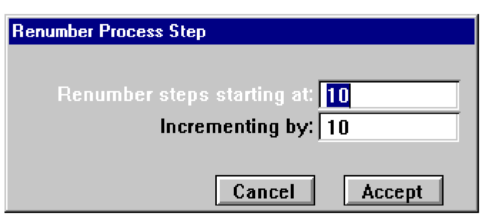
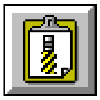


Figure 3-34 *Set the start and increment numbers by which to renumber steps.*

4. Set the starting value for renumbering. This is the number of the first step.
5. Set the value to increment by between each step.
6. Select the **Accept** button.

Sorting Steps and Tools



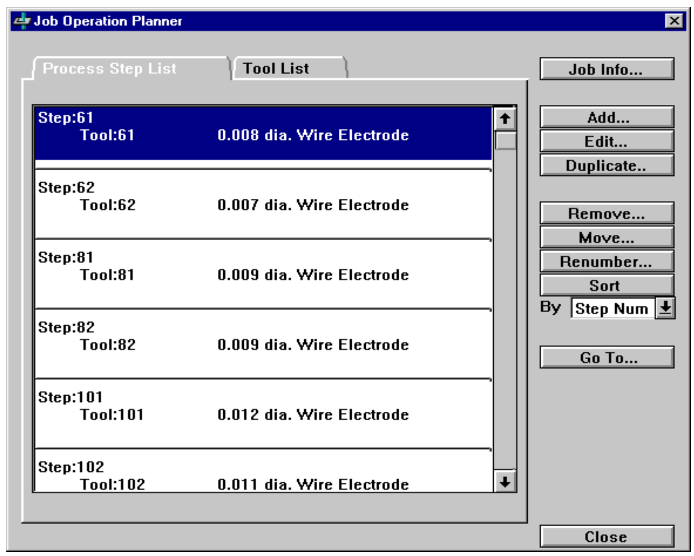
You can sort steps and tools in different ways. Sort steps by the step number or the order used in the process model. Sort tools by the steps they are used in, the order they are used in the process model, or by the tool number.

Sorting Steps

Perform these tasks to sort steps:

1. Select **File—Planner**. The **Job Operation Planner** dialog box is displayed.

Figure 3-35
File—Planner invokes the Job Operation Planner dialog box.



2. Select the **Process Step List** tab to sort the steps.
3. Set the **By** selector switch to one of the following methods for sorting the steps:
   - **Step Num** to sort by the step numbers
   - **Proc Mdl** to sort by the order used in the process model
4. Select the **Sort** button to sort the steps.

Sorting Tools

Perform these tasks to sort tools:

1. Select **File—Planner**. The **Job Operation Planner** dialog box is displayed.

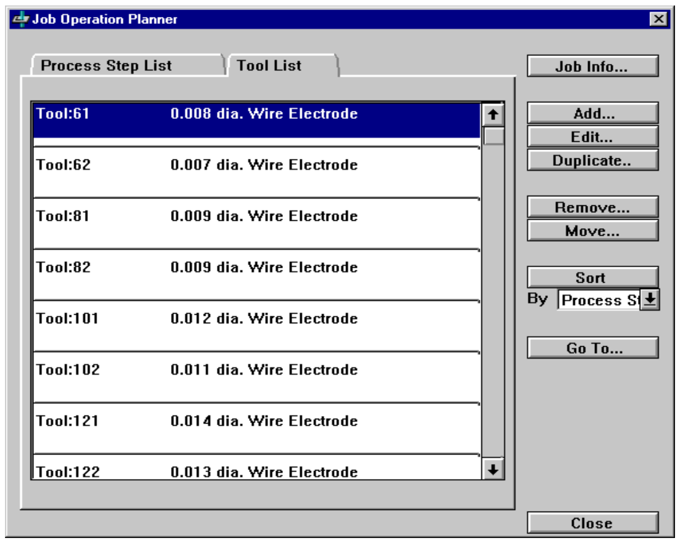


Figure 3-36 *File—Planner invokes the Job Operation Planner dialog box.*

2. Select the **Tool List** tab to sort the tools.
3. Set the **By** selector switch to one of the following methods for sorting the tools:
   - **Step Num** to sort by the step numbers they were used in
   - **Process Step** to sort by the step numbers they were used in
   - **Proc Mdl** to sort by the order used in the process model
   - **ToolNumber** to sort by the tool number
4. Select the **Sort** button to sort the tools.

Points to Remember

- ❑ Machine files must be set on the Job Information dialog box.
- ❑ A tool description and feed/speed values must be set to complete a process step.
- ❑ A step must exist if you want to use the Duplicate feature.
- ❑ If you make changes to a tool parameter when you use the Duplicate feature, the changes are reflected in every step that uses that tool.
- ❑ Only the steps or tools that are not used or selected as active are listed for possible removal.
- ❑ You can move only one step or tool at a time using the Move feature.
- ❑ Sort steps by step number or order used in the process model.
- ❑ Sort tools by the steps they are used in, the order they are used in the process model, or the tool number.

Using the Material Librarian

Objectives

This lesson shows you how to perform these tasks:

- Set up a material librarian file, which contains process options based on a specific part material.
- Open the material librarian file in the Job Operation Planner.

Overview

Use the Material Librarian to build and edit material information that the Job Operation Planner can use to calculate process step information like feeds and speeds. This keeps you from entering and reentering the same tool and process information for a specific material type. In some cases, if the Material Librarian does not contain an exact match, the resulting process options may be interpolated from available information.

Setting Up a File with the Material Librarian

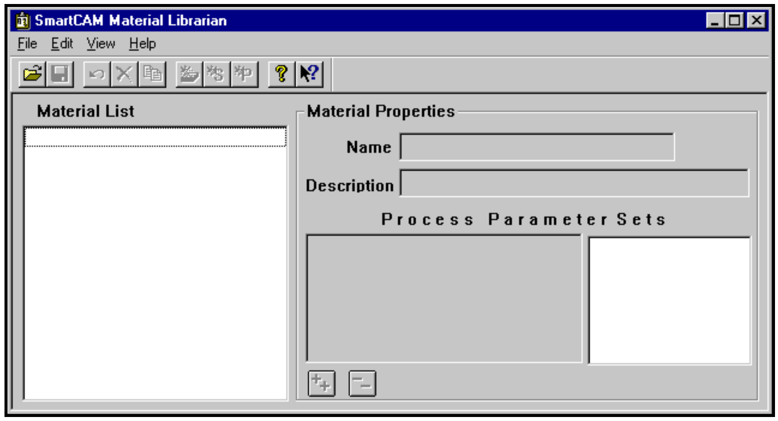
Perform these tasks to set up a file with the Material Librarian:

- Add material.
- Insert a parameter set.
- Insert a nested parameter set.
- Add a tool diameter parameter set.
- Define the process parameters.
- Duplicate a parameter set, if necessary.

Adding Material

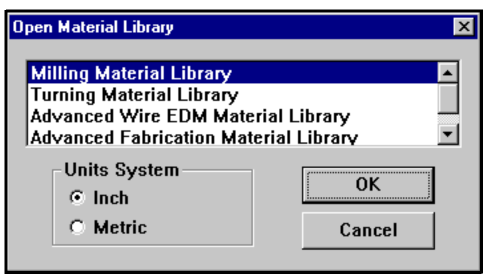
1. Select the **Material Librarian** icon from the SmartCAM program group. The **SmartCAM Material Librarian** is displayed.

Figure 3-37 Open the SmartCAM Material Librarian.



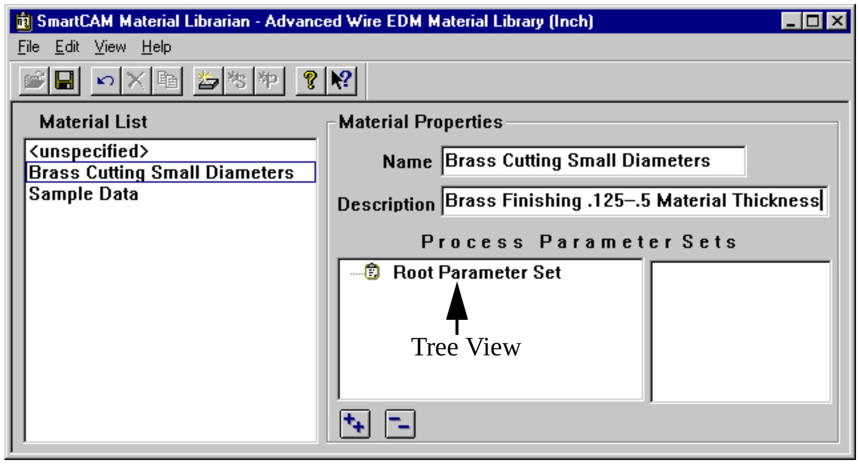
2. Select **File—Open Library**. The **Open Material Library** dialog box is displayed.

Figure 3-38 Open the Open Material Library dialog box.



3. Select **Advanced Wire EDM Material Library**.
4. Specify the **Units System** to use as the default.
5. Select the **OK** button. The updated **SmartCAM Material Librarian** dialog box is displayed.
6. Select **Edit—Add Material**.
7. Change the name of the material. The new material is added in alphabetic order.
8. Enter the material description.

Figure 3-39
Set the name and description.

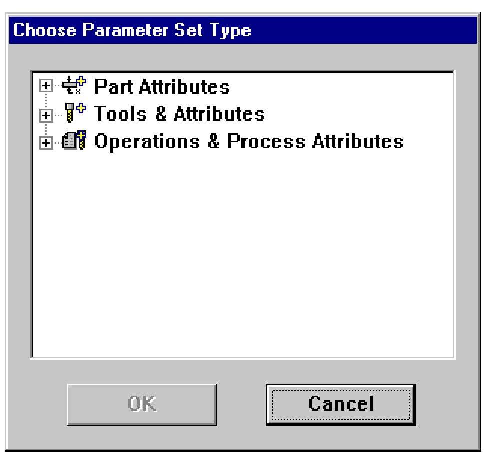


9. Keep the Material Librarian open and continue with the next procedure.

Inserting a Parameter Set

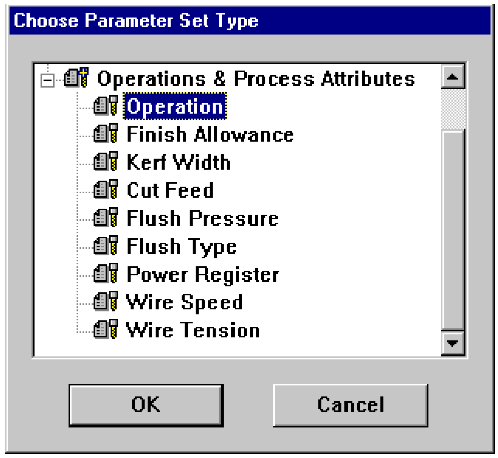
1. Highlight **Root Parameter Set**, which is displayed in the tree view, see Figure 3-39.
2. Select **Edit—Insert Parameter Set**. The **Choose Parameter Set Type** dialog box is displayed.

Figure 3-40
Open the Choose Parameter Set Type dialog box.



3. Select the plus sign that is next to **Operations & Process Attributes**. The section is expanded.
4. Select **Operation** from the list.

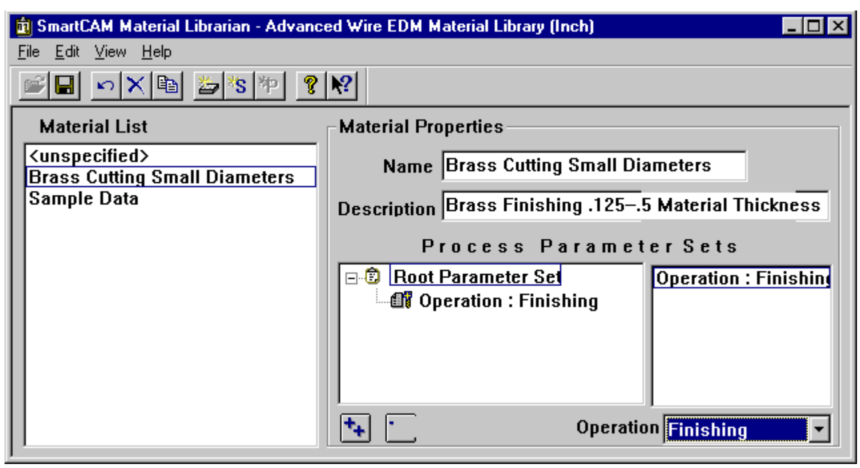
Figure 3-41
Select Operation from the list.



5. Select the **OK** button. The parameter set is added, and the **Choose Parameter Set Type** dialog box is closed.

6. Set the **Operation** selector switch to **Finishing**. This specifies the operation type for the parameter set.

Figure 3-42
Set the Operation selector switch.



7. Keep the Material Librarian open and continue with the next procedure.

Inserting a Nested Parameter Set

1. Select **Operation: Finishing** from the root parameter set in the tree view.

2. Select **Edit—Insert Parameter Set**. The **Choose Parameter Set Type** dialog box is displayed.

3. Select the plus sign that is next to **Tools & Attributes**. The section is expanded.

4. Select **Wire Diameter** from the list.

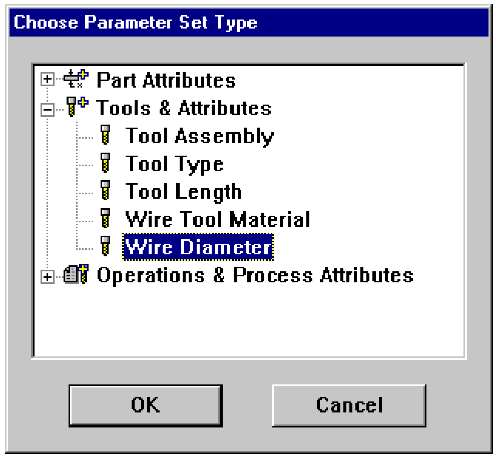


Figure 3-43 *The Tools and Attributes section is expanded.*

5. Select the **OK** button. The parameter set is added, and the **Choose Parameter Set Type** dialog box is closed.

6. Set the **Wire Diameter** input field to **.006**. This specifies the diameter for the parameter set.

7. Press Enter.

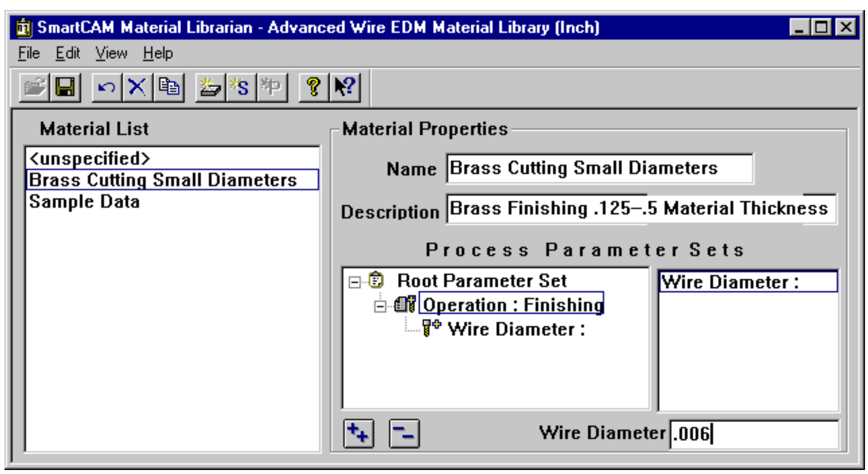


Figure 3-44 *Set the Wire Diameter value.*

8. Keep the Material Librarian open, and continue with the next procedure.

Adding a Tool Diameter Parameter Set

1. Select **Wire Diameter: .006** from the tree view.

2. Select **Edit—Insert Parameter Set**. The **Choose Parameter Set Type** dialog box is displayed.

3. Select the plus sign that is next to **Part Attributes**. The section is expanded.

4. Select **Material Thickness** from the list.

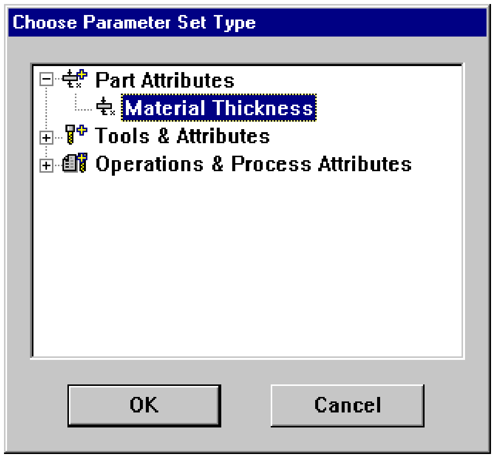


Figure 3-45
Select Material Thickness.

5. Select the **OK** button. The parameter set is added, and the **Choose Parameter Set Type** dialog box is closed.

6. Set the **Material Thickness** input field to **.125**.

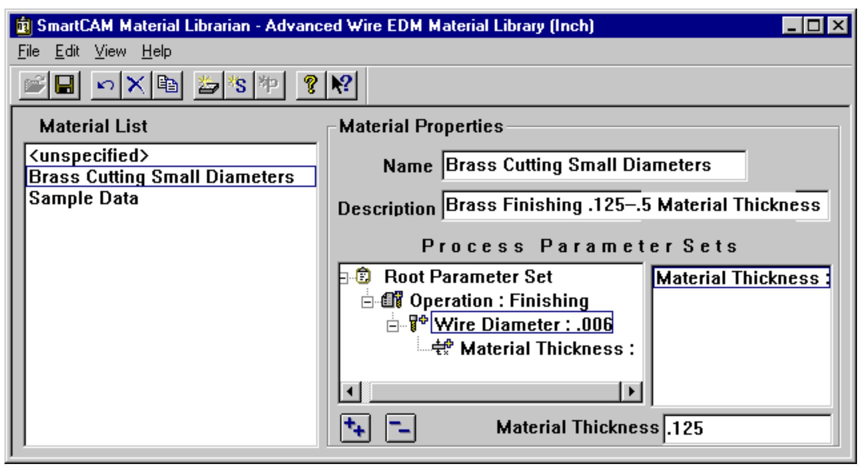


Figure 3-46
Set the Material Thickness value.

7. Press Enter.

8. Keep the Material Librarian open and continue with the next procedure.

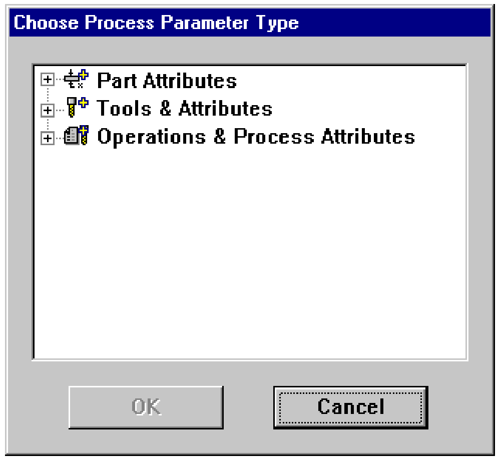
Defining Process Parameters

Process parameters are the last level of information that you add to a material library.

1. Select **Material Thickness: .125** from the tree view.

2. Select **Edit—Insert Process Parameter**. The **Choose Process Parameter Type** dialog box is displayed.

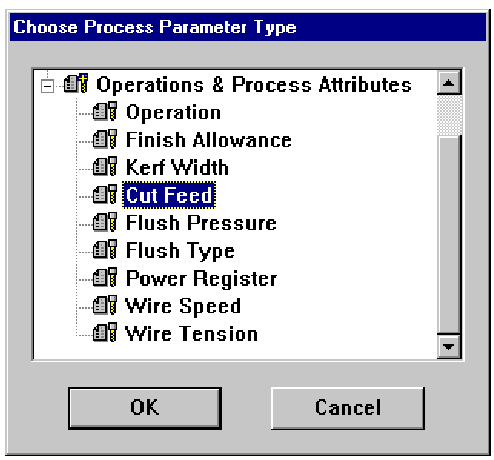
Figure 3-47
Open the Choose Process Parameter Type dialog box.



3. Select the plus sign that is next to **Operations & Process Attributes**. The section is expanded.

4. Select **Cut Feed.**

Figure 3-48
Select Cut Feed.



5. Select the **OK** button. The process parameter is added, and a box is drawn around it, indicating that this process parameter is the active parameter set.

6. Set the **Cut Feed** input field to the feed rate that you want to use.

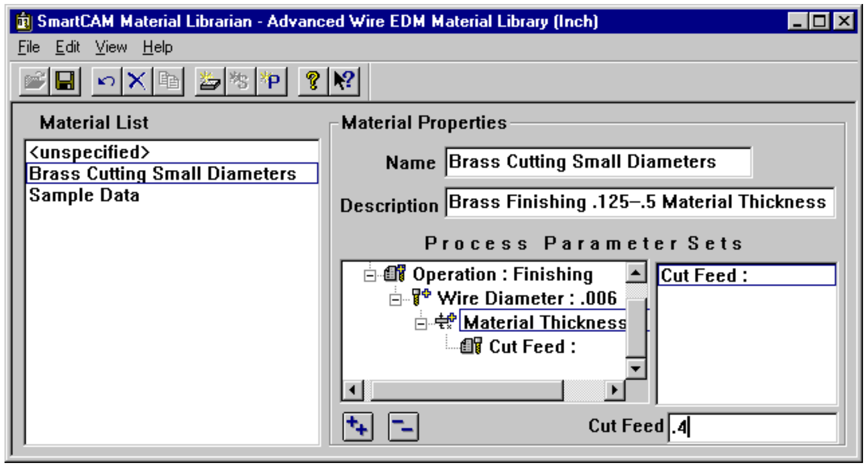


Figure 3-49
Set the Cut Feed input field to the rate that you want to use.

7. Repeat steps 2 through 6, substituting Wire Speed to set the speed.

Duplicating a Parameter Set

A material library can be simple or complex. To reduce the time it takes to build a complex library, build an initial parameter set. Then duplicate the parameters, so you can change their attributes.

1. Select **Wire Diameter: .006** from the tree view.
2. Select **Material Thickness: .125** from the edit list.

Note You can edit only values that are displayed in this list.

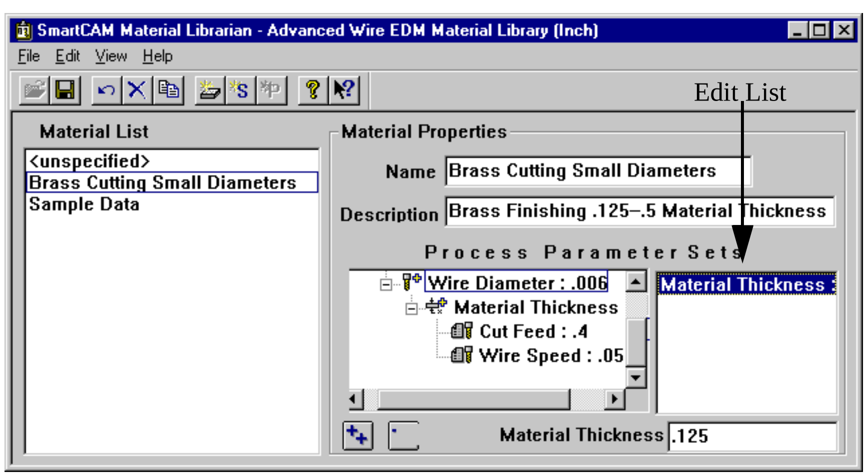


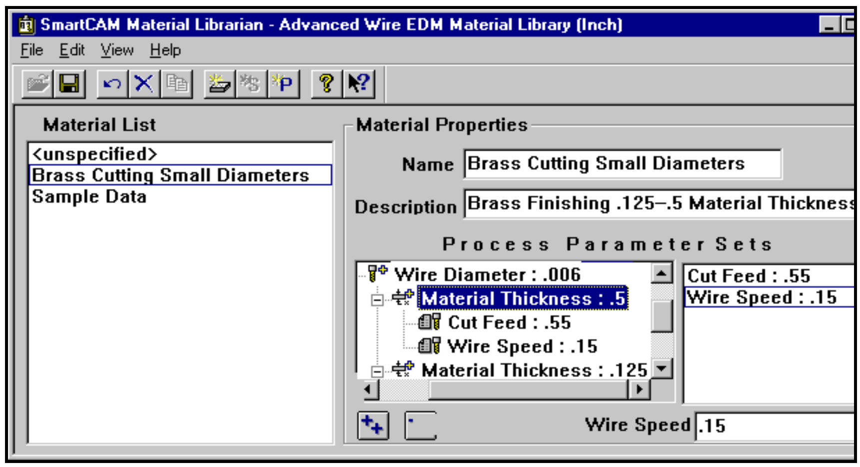
Figure 3-50
Select Material Thickness: .125 from the edit list.

3. Select **Material Thickness: .125** from the edit list.
4. Select **Edit—Duplicate** to copy the **Material Thickness: .125** parameter set and all of its parameters. A new Material Thickness parameter set is displayed below the first one in the edit list.

5. Set the **Material Thickness** input field to **.5**.
6. Press Enter.
7. Select Cut Feed or Wire Speed from the edit list and update those values.
8. You have completed defining parameters for a finishing operation with a cut feed of .4 and materials with thickness of .125 and .5.

Note Although you have not defined every possible value for feed and speed, SmartCAM interpolates these values.

Figure 3-51
Set the feed and speed for the new Material Thickness.



Viewing Results

To view the material that you added to the material library, select the plus sign that is next to **Material Thickness: .125** from the tree view.

Saving and Exiting

To save the material library and exit the Material Librarian, perform these tasks:

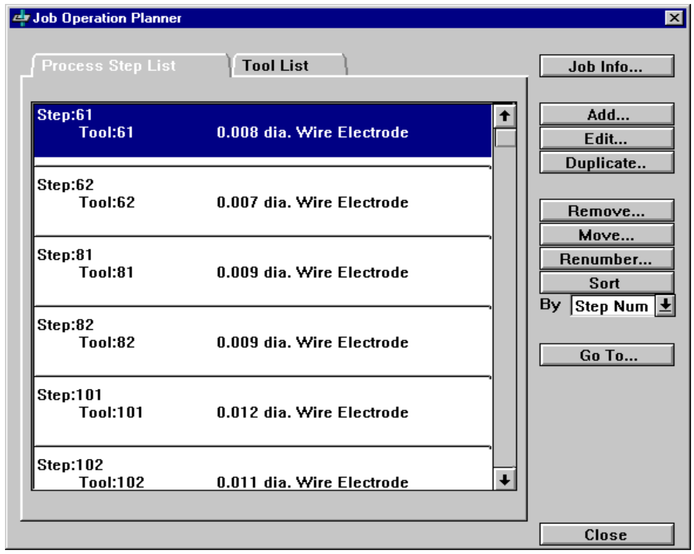
1. Select **File—Save Changes** to save the file.
2. Select **File—Exit** to close the Material Librarian.

Opening a Material Librarian File

Once you set a material librarian file, you can open it in the Job Operation Planner. To open a material librarian file, perform these tasks:

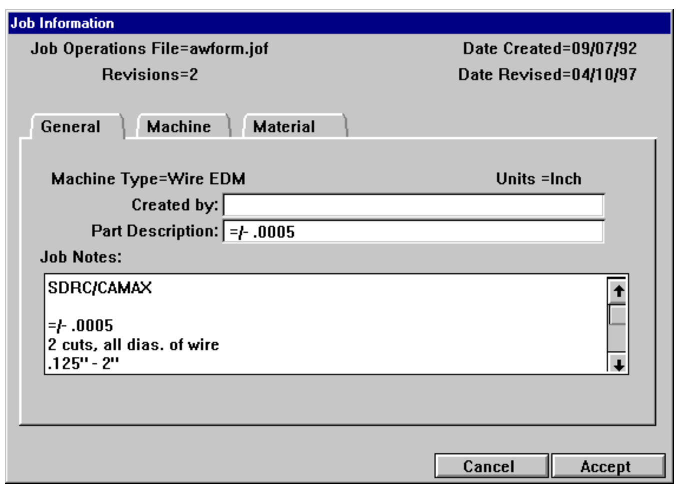
1. Select **File—Planner** from the Advanced Wire EDM application. The **Job Operation Planner** dialog box is displayed.

Figure 3-52
File—Planner invokes the Job Operation Planner dialog box.



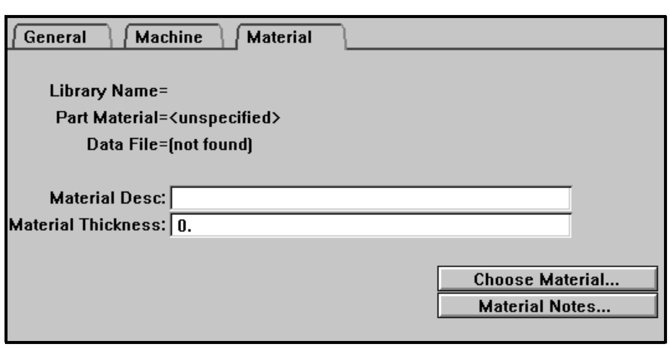
2. Select the **Job Info** button. The **Job Information** dialog box is displayed.

Figure 3-53
The Job Info button invokes the Job Information dialog box.



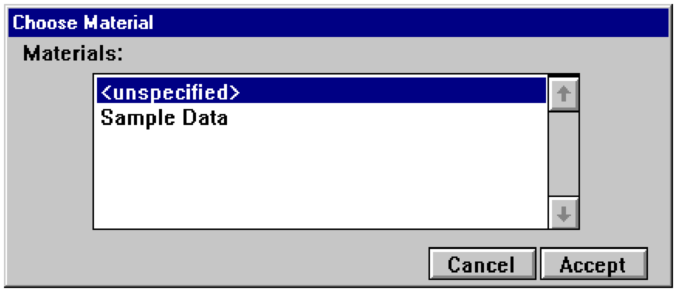
3. Select the **Material** tab. The **Material** page is displayed.

Figure 3-54
Use the Material page to set the material description.



4. Select the **Choose Material** button. The **Choose Material** dialog box is displayed.

Figure 3-55
Use the Choose Material dialog box to specify the file that you set up in the Material Librarian.



5. Select the name of the file that was set up in the Material Librarian.
6. Select the **Accept** button.
7. Select the **Accept** button on the **Job Information** dialog box.
8. Select the **Close** button on the **Job Operation Planner** dialog box.

Points to Remember

- [ ] The Material Librarian icon is found in the SmartCAM program group and not in the Advanced Wire EDM application.
- [ ] The Material Librarian enables you to choose tools, operations, and processes for specific material.
- [ ] Access a Material Librarian file from the Material tab of the Job Information dialog box.

Printing Job Operations Setup Reports

Objectives

This lesson shows you how to perform these tasks:

- Print a job information report.
- Print a tooling report.
- Print a step report.

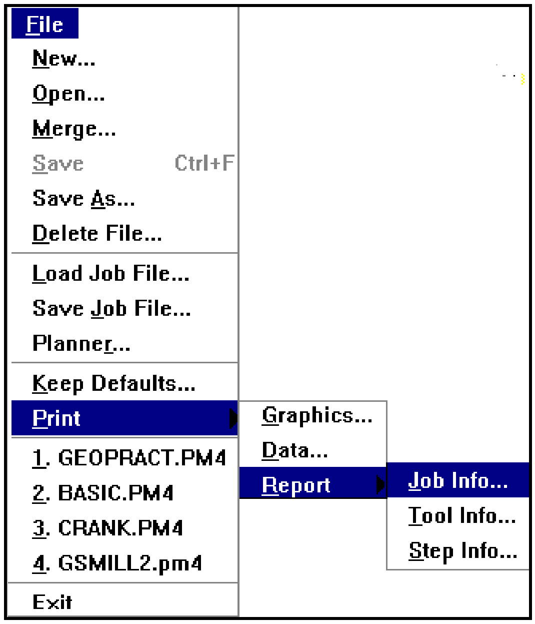
Overview

Use reports to provide operator instructions and machine setup information.

Select File—Print—Report to open the job operations setup reports submenu. There are three types of reports you can create in the job operations setup:

- **Job Info** opens the Print Job Info Report dialog box so you can print general information, machine information, and part material information.
- **Tool Info** opens the Print Tooling Report dialog box so you can print information about the tools in the job operations setup.
- **Step Info** opens the Print Step Report dialog box so you can print information about the steps in the job operations setup.

Figure 3-56
Select File—Print—Report, and specify the type of report to work with.



Printing a Job Information Report

Use Job Info to print job information or create a report file that contains job information for the open process model. The report can contain job information, machine information, and part material information.

Printing Job Information

Perform these tasks to print job information:

1. Select **File—Print—Report—Job Info** to open the **Print Job Info Report** dialog box.
2. Specify the path and filename of the report format file, or use **File Select** to choose a filename from the list of `.fmt` files on disk.
3. Specify the destination for the report, **Printer** or **File**. If you select **File**, enter the path and filename in the corresponding input field, or use **File Select** to choose a filename from the list of `.rpt` files on disk.
4. Select the **Accept** button to produce the report.

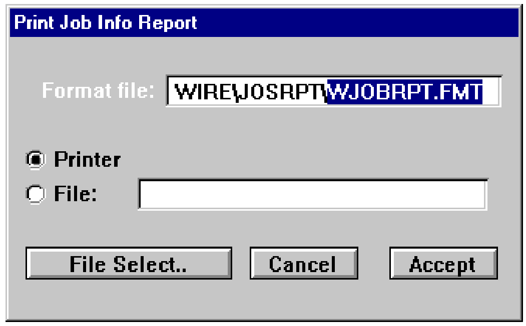


Figure 3-57 *Use the Print Job Info Report dialog box to create operator instructions.*

Printing Machine Setup, Operation, and Tool Information

To print reports with full information for machine setup and operation, use the Step Info Report. To print reports about the tools in the job operations setup, use the Tool Info Report.

A standard set of format files is located in the report subdirectory of the SmartCAM installation directory. To search for a format (`.fmt`) file, place the cursor in the Format File input field and then select the File Select button.

Printing a Tooling Report

Use Tooling Report to see information about the tools in the active job operations setup or to create a report file that contains tooling information. You can view information about all tools in the job operations setup, or you can limit the report to only those tools used in steps or in the active process model. You can sort the tooling report using one of these options:

- current order
- tool number
- step list order
- process model order

To print a tooling report, perform these tasks:

1. Select **File—Print—Report—Tool Info** to open the **Print Tooling Report** dialog box.

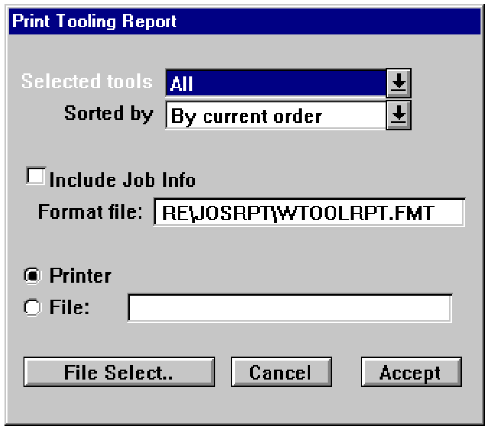


Figure 3-58
Use the Print Tooling Report dialog box to limit the report.

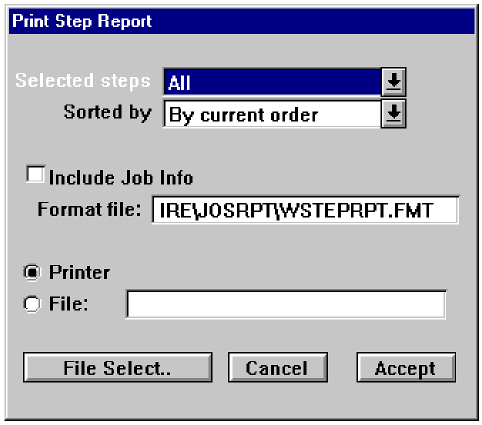
2. Enter the name of the format file to use for the report. To search for a file, select the **File Select** button.
3. Select **Printer** to print a paper copy of the report or **File** to print to a file. If you print to a file, enter the path and name of the file.
4. Turn on the **Include Job Info** on/off switch to include general job information with the tooling report. When the switch is off, the report prints only the tooling information.
5. Select the **Accept** button to print the tooling report or create the print file.

Printing a Step Report

Use Step Report to see information about the steps used in the active job operations setup or to create a report file that contains step information. You can print information about all steps in the job operations setup or limit the report to only those steps that are used in the active process model. You can sort the step report using one of several options.

1. Select **File—Print—Report—Step Info** to open the **Print Step Report** dialog box.

Figure 3-59
Use the Print Step Report dialog box to limit the report to specific steps.



2. Select the scope and sorting criteria for the report from the selector switches.
3. Enter the name of the format file to use for the report. To search for a file, use the **File Select** button to choose from the `.fmt` files on disk.
4. Turn on the **Include Job Info** on/off switch to include general job information with the step report. When the switch is off, the report prints only the step information.
5. Select the **Printer** option switch to print a paper copy of the report. Otherwise, select the **File** option switch to print to a file. If you print to a file, enter the path and name of the file.
6. Select **Accept** to print the step report or create the print file.

Points to Remember

- ❑ Use the Job Information Report to print job information or create a report file that contains job information for the open process model.
- ❑ Use the Tooling Report to print information about the tools in the active job operations setup or to create a report file that contains tooling information.
- ❑ Use the Step Report to print information about the steps used in the active job.

Self-Test

Directions

Test your understanding of the concepts and procedures in this section by answering the following questions. The answers for each self-test are in *Appendix A* of this manual.

______________ **1. What pieces of job information are required?**

a) unit
b) machine file
c) both a and b
d) neither a nor b

______________ **2. What values must be set to complete a process step?**

a) unit
b) machine file
c) both a and b
d) neither a nor b

______________ **3. How many steps or tools can you move at a time when you use the Move feature?**

a) 0
b) 1
c) 2
d) unlimited

______________ **4. You cannot remove active steps from a job.**

a) true
b) false

_______________ **5. Where do you define material information that you want to use on a regular basis?**

a) Material tab of the Job Information dialog box
b) Material Librarian
c) Job Information Report
d) anywhere in the planner

_______________ **6. Once material information is set up, how do you access it from Advanced Wire EDM?**

a) Material tab of the Job Information dialog box
b) Material Librarian
c) Job Information Report
d) anywhere in the planner

_______________ **7. Which report should you print if you want to know about the job information for the open process model?**

a) Job Information Report
b) Tooling Report
c) Step Report
d) Open Process Model Report

4

Working with Elements

Overview

Elements are the entities that SmartCAM places in the database, displays in the list view, and displays in the element data list. Element types include: lines, arcs, polylines, splines, user events, sub calls, holes, points, ellipses, and helixes.

Lessons for This Unit

- Creating Elements
- Viewing Element Data
- Editing Geometry
- Changing Properties and Attributes
- Using Show Path
- Using Order Path
- Transforming Geometry
- Importing a CAD File
- Exporting a SmartCAM File

Creating Elements

Objectives

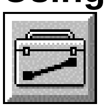
This lesson shows you how to perform these tasks:

- Create lines.
- Create arcs.
- Create wall offsets.
- Create holes.
- Create rapid points.
- Create start profiles.
- Create line profiles.
- Create arc profiles.
- Create polylines.
- Create splines.
- Create ellipses.
- Create user events.
- Create rectangles.
- Create polygons.
- Create lead ins/lead outs.

Overview

With SmartCAM, you can create a variety of geometric elements from various points. Before you create geometry, use the Insert property bar to identify the insert location and the properties for the new geometry. If a step is active, the geometry results in CNC code when you use the Generate Code feature. Create geometry when a layer is active to describe non-coded areas of a part, such as fixtures, clamps, material boundaries, and construction geometry.

Using the Geometry Toolbox



Use the Geometry toolbox modeling tools to create point rapid, hole, line, and arc elements.

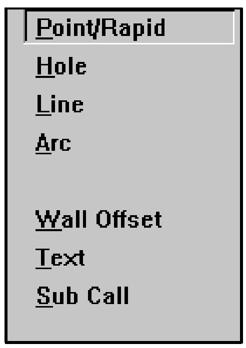
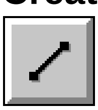


Figure 4-1
Use the Geometry toolbox to create geometry.

Creating Lines



Model File: AWLINES.PM4

Use Line to insert a single line element. To create a line, you do not always need to know all of the values in the control panel before SmartCAM can solve for it. Perform these tasks to create lines:

1. Open the model file **`AWLINES.PM4`**.

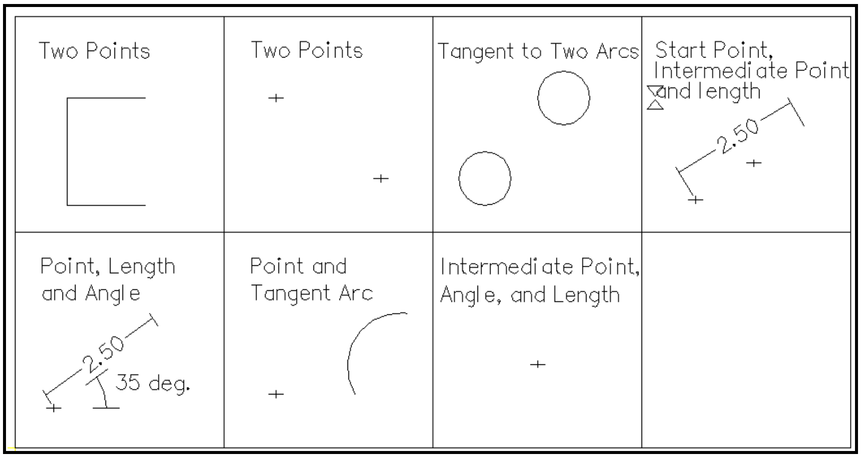


Figure 4-2
Open AWLINES.

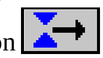
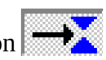
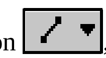
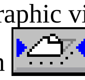
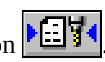
2. Set the insert location.
   - Set the **Before** icon  or **After** icon  to indicate if the insert point is to be before or after the selected element, process step, tool, or layer.
   - Select the **Element** icon , and select the element to be before or after in the list view or graphic view.
   - Select the **On Layer** icon  or the **With Step** icon .
   - If you inserted on a layer, set the **Layer Number** input field on the Insert property bar. If you inserted on a step, set the step number in the list view.
   - If you are inserting with a step, set the **Level**, **Prof Top**, **Clear**, and **Offset** input fields on the Insert property bar.
   - If you are inserting on a layer, set the **Level** and **Prof Top** input fields on the Insert property bar.

Figure 4-3
Set the Insert property bar.

3. Select **Create—Geometry**.
4. Select **Line** from the toolbox. The **Line** control panel is displayed.

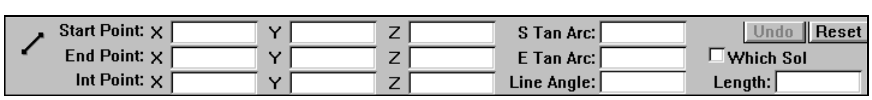


Figure 4-4
Set the values on the Line control panel.

5. Create the lines in the model file by setting point values in the input fields or by using a point, a distance, and an angle. Lines can be made tangent to arcs by using the **S Tan Arc** and **E Tan Arc** input fields.

Figure 4-5
This line has two known points.

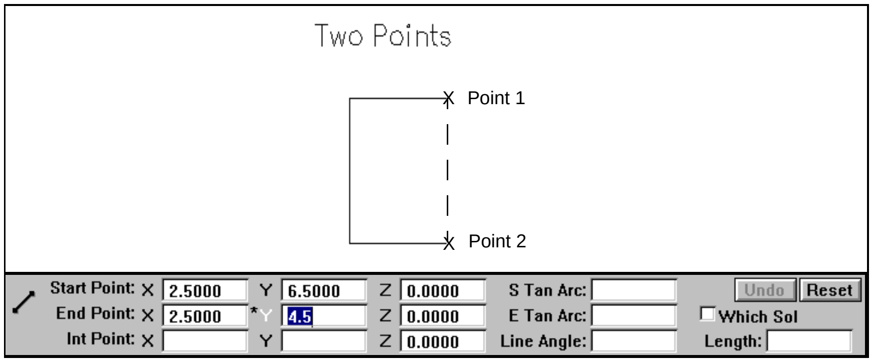


Figure 4-6
This line has two known points.

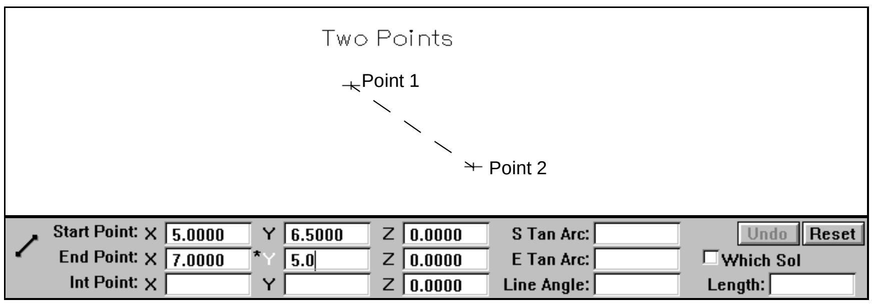


Figure 4-7
This line is tangent to two arcs.

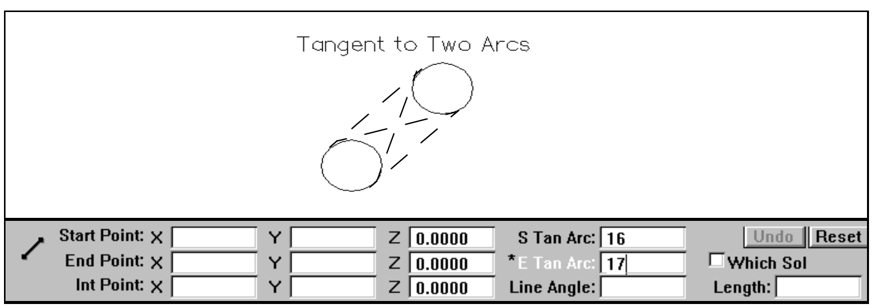


Figure 4-8
This line has a known start point, intermediate point, and length.

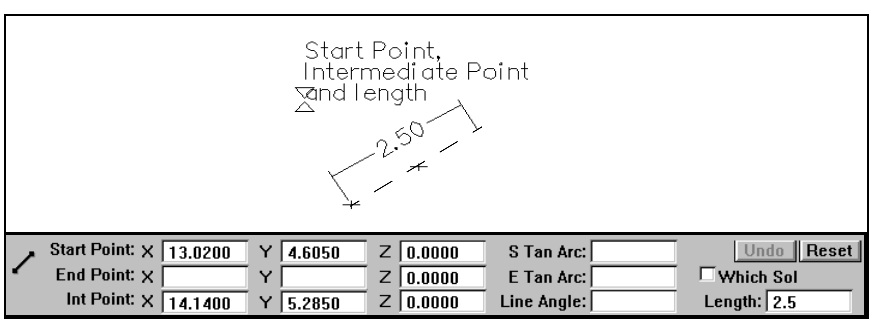


Figure 4-9
This line has a known start point, length, and angle.

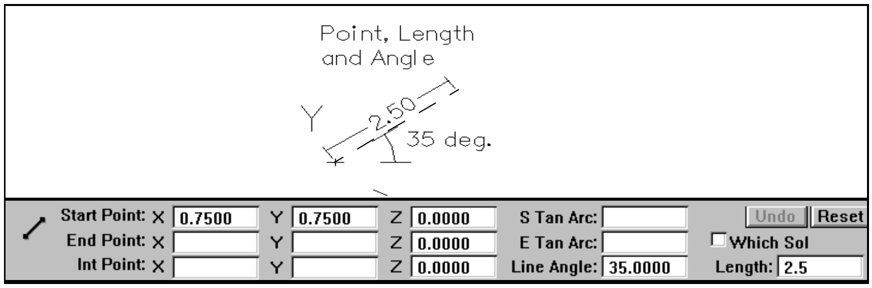


Figure 4-10
This line has a known end or intermediate point, and a tangent arc.

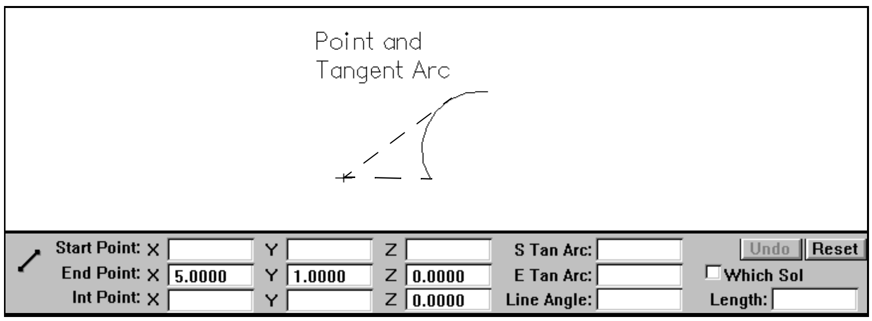
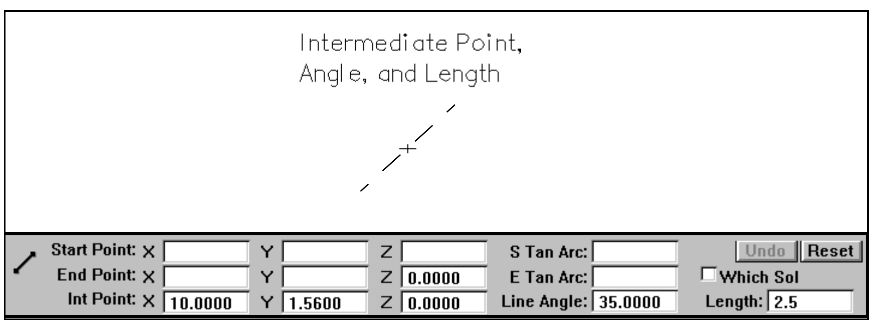
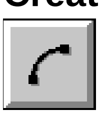


Figure 4-11
This line has a known intermediate point. Specify any angle and length.



Creating Arcs



Model File: AWARCS.PM4

If you associate an arc with a step, a circular cutting move results. Perform these tasks to create full or partial arcs:

1. Open the model file **AWARCS.PM4**.

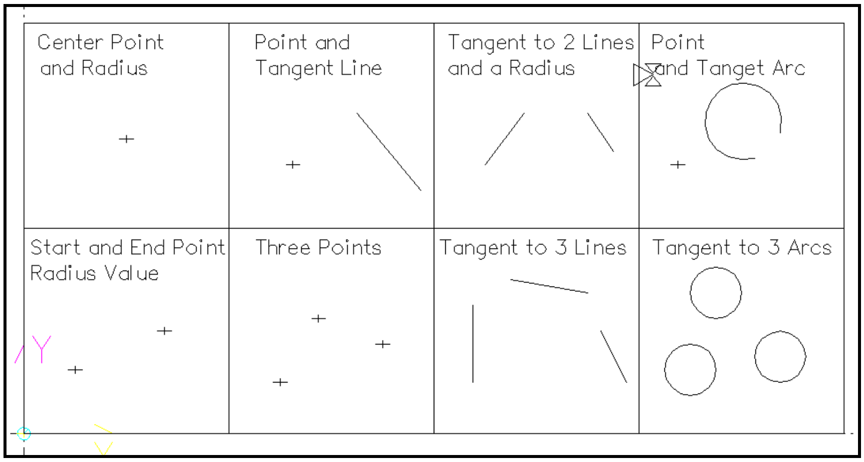


Figure 4-12
Open AWARCS.

2. Set the insert location.
   - Set the **Before** icon or **After** icon on the Insert property bar to indicate if the insert point is to be before or after the selected element, process step, tool, or layer.
   - Select the **Element** icon on the Insert property bar.
   - Select the element to be before or after in the list view.
   - Select the **On Layer** icon or the **With Step** icon.
   - If you are inserting with a step, select a tool from the list view. If you are inserting with a layer set the **Layer Number** input field on the Insert property bar.
   - If you are inserting with a step, set the **Level**, **Prof Top**, **Clear**, and **Offset** input fields on the Insert property bar. If you are inserting with a layer, set the **Work Plane**, **Layer**, **Level** and **Prof Top** input fields on the Insert property bar.

Figure 4-13
Set the Insert property bar.

3. Select **Create—Geometry**.
4. Select **Arc** from the toolbox. The **Arc** control panel is displayed.

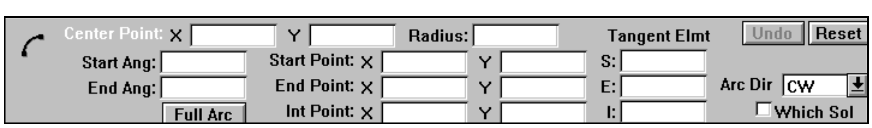


Figure 4-14
Set the values on the Arc control panel.

5. Locate the position of the line by inserting X and Y values in the input fields for the arc's center point. Use the **Tangent Element** input fields to define tangent conditions for the arc.
6. Set the **Arc Direction** selector switch to **CW** or **CCW**:

- **CW** generates a clockwise arc.
- **CCW** generates a counterclockwise arc.

7. Set the **Radius** input field.
8. Set the **Start Ang** and **End Ang** input fields or select **Full Arc**.

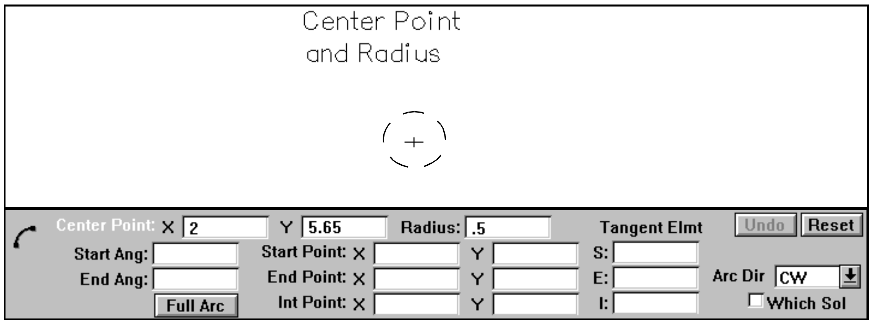


Figure 4-15
Create an arc that has a known center point and any radius that you specify.

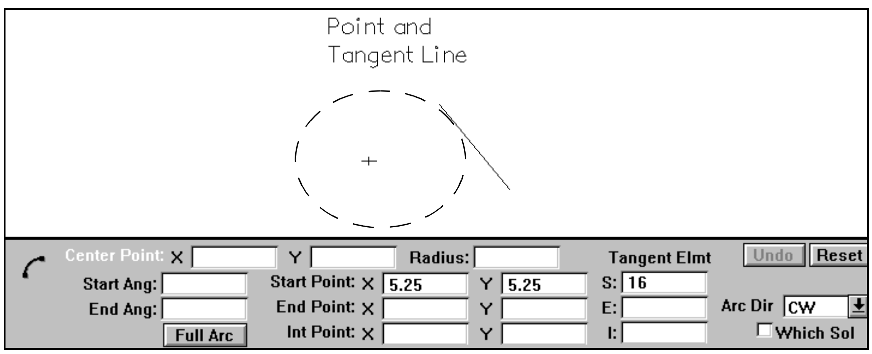


Figure 4-16
Create an arc that has a center point and a tangent line.

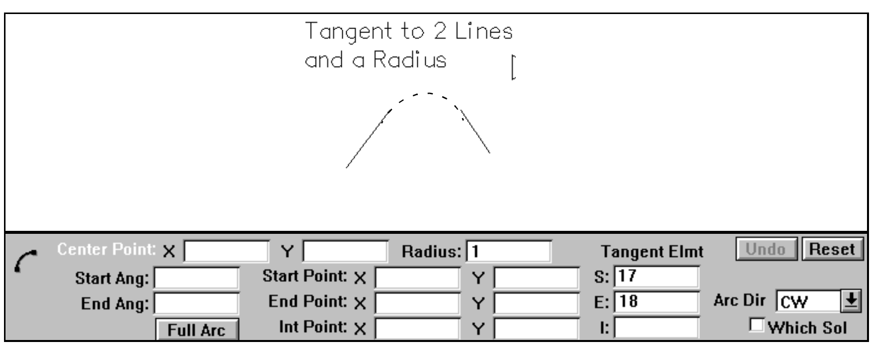


Figure 4-17
Create an arc that is tangent to two lines and has any radius that you specify.

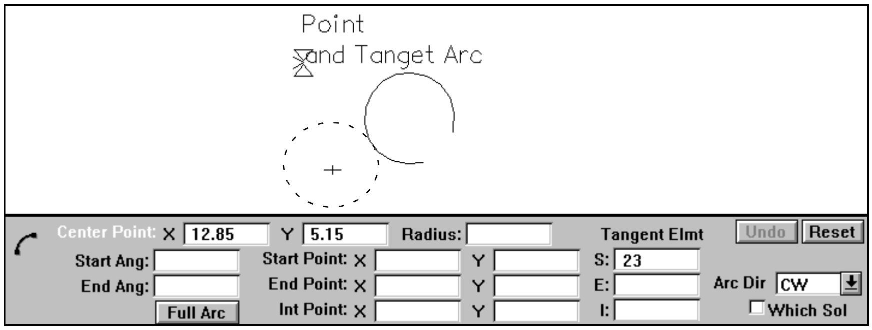


Figure 4-18
Create an arc that has a known center point and that is tangent to an arc.

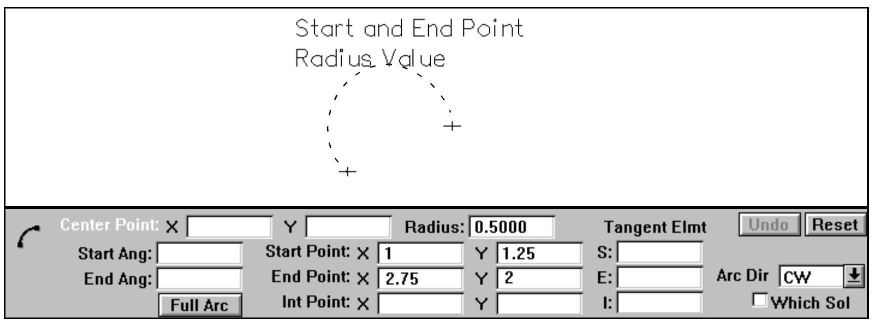


Figure 4-19
Create an arc with a start point, end point, and radius.

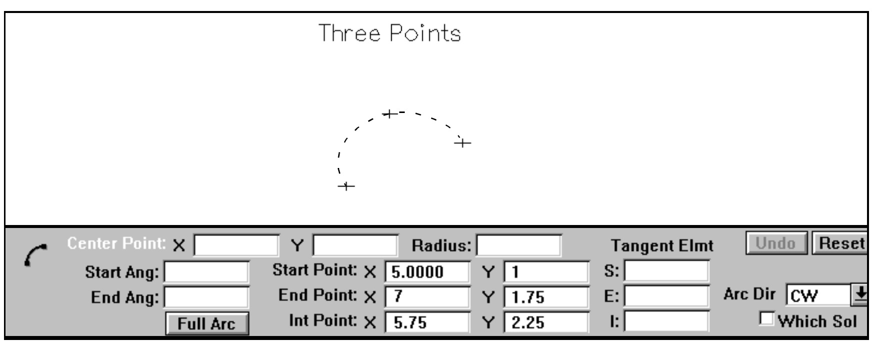


Figure 4-20
Create an arc with a known intermediate point, start point, and end point.

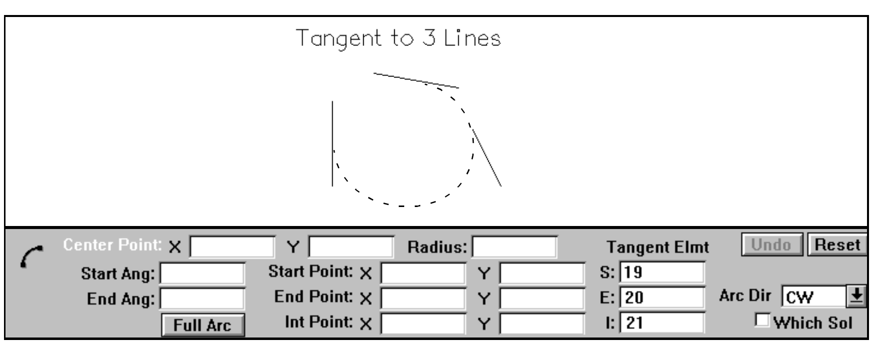


Figure 4-21
Create an arc that is tangent to three lines.

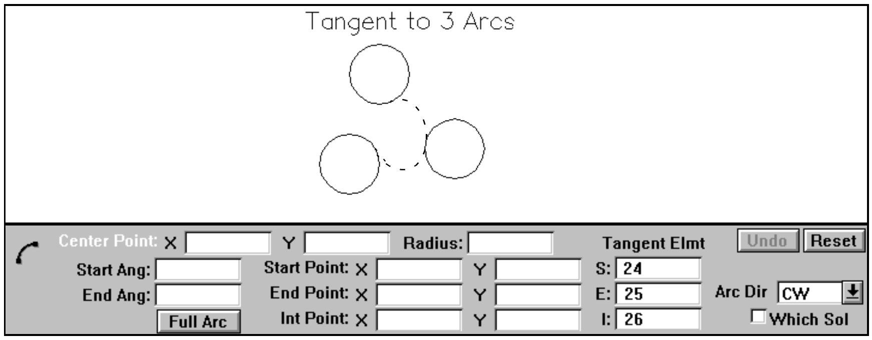
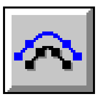


Figure 4-22
Create an arc that is tangent to three arcs.

Creating Wall Offsets



Model File: AWOFFSET.PM4

Use Wall Offset to create parallel geometry that is offset from the original geometry. Create offset geometry from an existing element, group of elements, or profile. The properties of the new geometry can match the existing geometry, or you can specify different properties with the Insert property bar. Perform these tasks to create a wall offset:

1. Open the model file **`AWOFFSET.PM4`**.

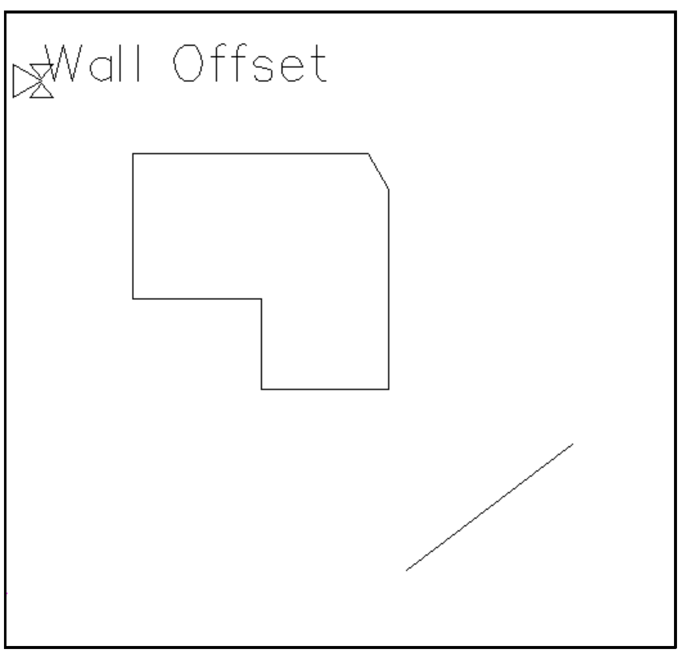


Figure 4-23
Open AWOFFSET.

2. Set the insert location:

- Set the **Before** icon or **After** icon on the Insert property bar to indicate if the insert point is to be before or after the selected element, process step, tool, or layer.
- Select the **Element** icon on the Insert property bar.
- Select the element to be before or after in the list view.
- Select the **With Step** icon.
- Set the **Level**, **Prof Top**, **Clear**, and **Offset** input fields on the Insert property bar.

Figure 4-24
Set the Insert property bar.

3. Select **Create—Geometry**.
4. Select **Wall Offset** from the toolbox. The **Wall Offset** control panel is displayed.

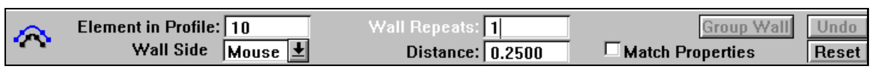
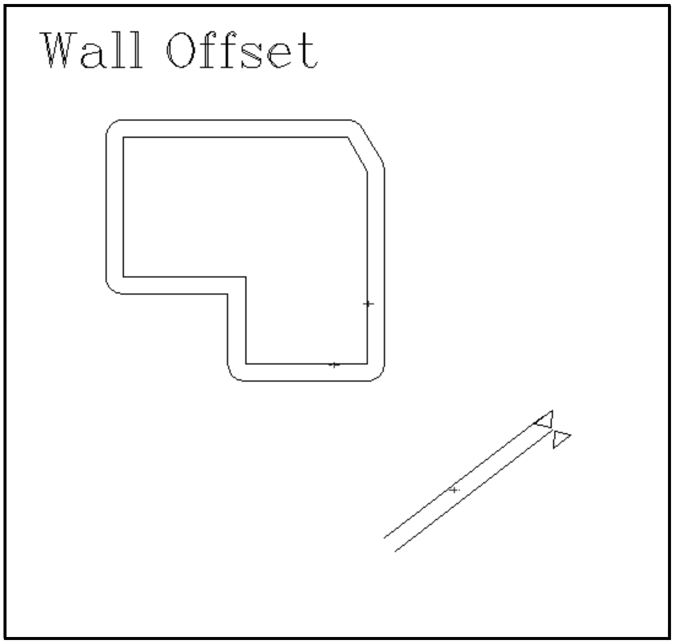


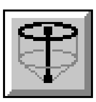
Figure 4-25
Set the Wall Side, Distance, and Wall Repeats.

5. Set the **Element in Profile** input field, and select a profile.
6. Set the following fields on the control panel as necessary.
   - Set the **Wall Side** input field.
   - Set the **Wall Repeats** input field to the desired number.
   - Set the **Distance** input field to the correct offset.
   - Turn on the **Match Properties** on/off switch to force the wall offset geometry to use the same offset, level, clear, and Prof Top properties as the original geometry. When set to off, the wall offset geometry uses the offset, level, clear, and Prof Top properties set on the Insert property bar.

Figure 4-26
This is a result of creating wall offsets.



Creating Holes

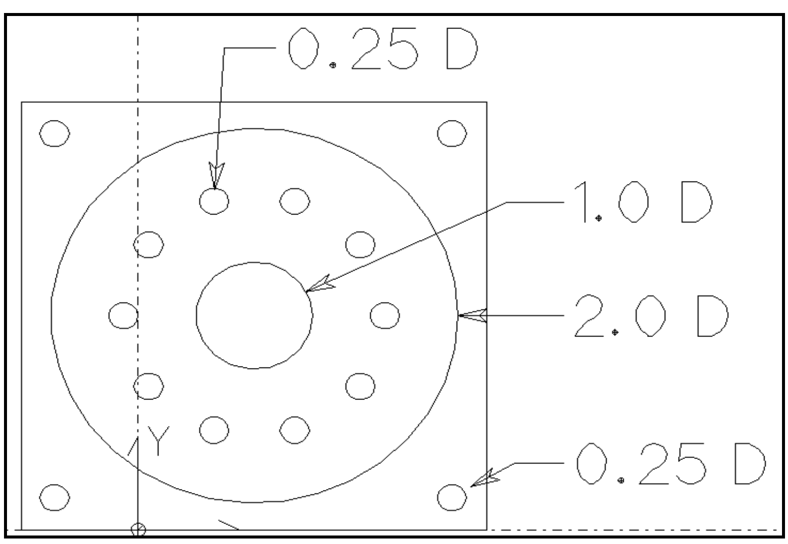


Model File: AWHOLES.PM4

Use Hole to create a hole-making operation using the active step and related properties. Hole enables you to create holes at selected locations, or in a radial or linear pattern on the part. Perform these tasks to create a hole:

1. Open the model file **`AWHOLES.PM4`**.

Figure 4-27
Open AWHOLES.



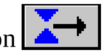
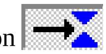
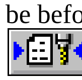
2. Set the insert location.
   - Set the **Before** icon  or **After** icon  on the Insert property bar to indicate if the insert point is to be before or after the selected element, process step, tool, or layer.
   - Select the **Element** icon  on the Insert property bar.
   - Select the element to be before or after in the list view.
   - Select the **With Step**  icon, and select a hole electrode from the list view.
   - Set the **Level, Prof Top**, and **Clear** input fields on the Insert property bar.

Figure 4-28
Set the Insert property bar.

3. Select **Create—Geometry**.
4. Select **Hole** from the toolbox. The **Hole** control panel is displayed.
5. Set the **Tip Depth** input field to the depth of the hole.

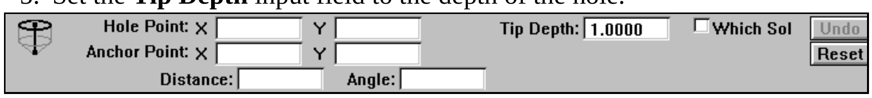


Figure 4-29
Set the values on the Hole control panel.

6. Locate the position of the hole by setting the **Hole Point** input fields or by setting the **Anchor Point**, **Distance**, and **Angle** input fields. Multiple hole operations can be performed at a single location.

   Note The hole size is determined by the properties of the tool used to create it.

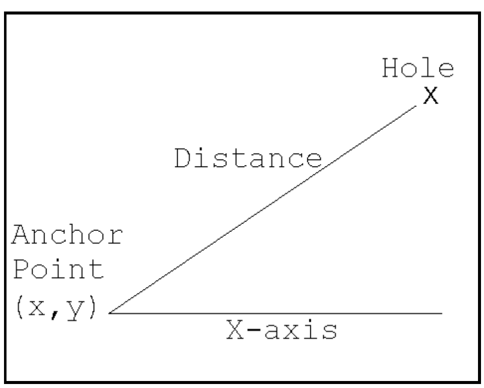
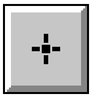


Figure 4-30
Use anchor points to define a hole.

7. These additional fields on the control panel can be set for further contol of the hole.
   - Turn on the **Which Sol** on/off switch if you want to choose between multiple possible solutions before accepting your geometry.

Creating Rapid Points



A rapid point is a three-dimensional location in space. Rapid points are often used to move the tool to a safe location at the start or end of the program or at tool changes. If you assign a rapid point to a step, the resulting point becomes a rapid-positioning move.

1. Open a model file.

2. Set the insert location:
   - Set the **Before** icon or **After** icon on the Insert property bar to indicate if the insert point is to be before or after the selected element, process step, tool, or layer.
   - Select the **Step** icon on the Insert property bar.
   - Select the step to be before or after in the list view.
   - Select the **With Step** icon.
   - Select **Step #3** to make this a rapid move with a tool.

3. Select **Create—Geometry**.

4. Select **Point/Rapid** from the toolbox. The **Point/Rapid** control panel is displayed.

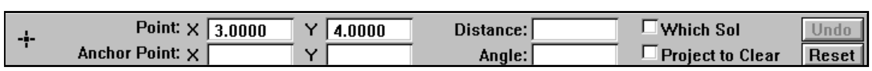


Figure 4-31 *Set the values on the Point/Rapid control panel.*

5. Set the **Clear** input field on the Insert property bar.

6. Locate the position of the point by setting the **Point** input fields or by setting the **Anchor Point**, **Distance,** and **Angle** input fields.

Using the Profiles Toolbox

Use the Profiles toolbox modeling tools to create a continuous profile of line and arc elements. These modeling tools can solve relationships between elements that you cannot define completely with the available information, enabling you to maintain a continuous profile even if some elements on it are unsolved or pending. SmartCAM can have up to two pending elements at a time before it must solve them with the information you provide for a third element.

Information about pending elements is listed under Pending Elems on the workbench. SmartCAM tracks the information for pending elements, and as soon as it can solve for a pending element, it automatically does so and updates the model. This intelligent-solution capability speeds up the profiling process.

You can create open and closed profiles. An open profile has a separate start point and end point. You can use it to define the outline of a part or a feature. In a closed profile the start point and the end point are at the same coordinate location, thus creating a closed feature such as a cut-out.

There are two methods for creating a profile:

- Use Create—Profiles—Arc and Line Profiles to create the profile elements sequentially.
- Create each profile element independently. Use Group to place the elements in an active group, and then use Edit—Geo Edit—Profile Trim to create a profile from them.

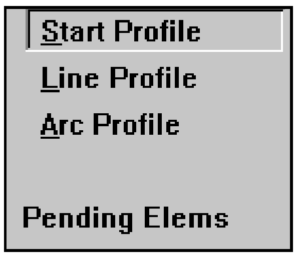


Figure 4-32
Use the Profiles toolbox to create profiles.

Creating Start Profile Points

Use Start Profile to identify the start of the first element in a profile. If you do not specify a start profile point, SmartCAM uses the end point of the element occurring before the current insert position as the start of the profile. If you use the With Step option in the Insert property bar, the finished profile is a continuous toolpath.

Use values that you want as you perform the tasks in this procedure:

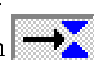
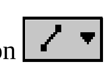
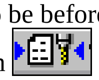
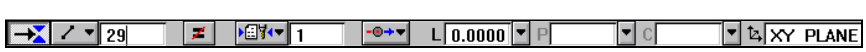
1. Open a model file.
2. Set the insert location:
   - Set the **After** icon  on the Insert property bar to indicate if the insert point is to be before or after the selected element, process step, tool, or layer.
   - Select the **Element** icon  on the Insert property bar.
   - Select the element **(13)** to be before or after in the list view.
   - Select the **With Step** icon  and select a tool from the list view **(10)**.
   - Set the **Level**, **Prof Top**, **Clear**, and **Offset** input fields.

Figure 4-33
Set the Insert property bar.



3. Select **Create—Profile**.

4. Select **Start Profile** from the toolbox. The **Start Profile** control panel is displayed.

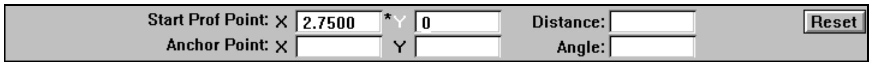


Figure 4-34 *Set the values on the Profile Start control panel*

5. Locate the start position by setting the **Start Prof Point** input fields, or by selecting the input field and using the snap icons. It is easiest to use Snap pick mode and the Snap Endpoint icon to select the right end of the lower line. When the cursor turns into a Snap pick mode cursor (short cross hairs), press the left mouse button.
6. Keep the model file open.

Creating Line Profiles

Use Line Profile to create a line that is tangent to or intersects the previous element in the profile. If the line is not completely defined, it is displayed as dashed. Use the Advance button to move to the next element.

Use the values you want as you perform the tasks in this procedure:

1. Continue from the start profile.
2. Select **Line Profile** from the toolbox. The **Line Profile** control panel is displayed.

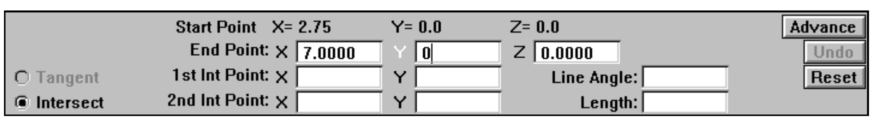


Figure 4-35 *Set the values on the Line Profile control panel.*

3. Locate the end position by setting the **End Point** input fields to **7, 0**, or you can define the line using an angle and a tangent element.
4. Select the **Advance** button. This is useful if you cannot fully define the line element.

Creating Arc Profiles

Use Arc Profile to create an arc that is tangent to or intersects the previous element in the profile. If the arc is not completely defined, it is displayed as dashed. Use the Advance button to move to the next element.

Use values that you want as you perform the tasks in this procedure:

1. Continue from the last line profile.
2. Select **Arc Profile** from the toolbox. The **Arc Profile** control panel is displayed.

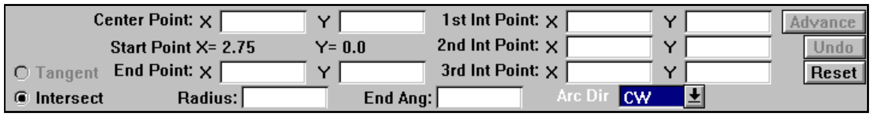


Figure 4-36 *Set the values on the Arc Profile control panel.*

3. Set these values on the control panel:
   - Select the**Tangent** option switch.
   - Set the **Arc Direction** selector switch to **CCW**.
   - Set the **Radius** input field to **.5 [12.7]**.
   - Set the **Center Point** input fields to **7 [177.8], 1.75 [44.45]**.
4. Select the **Advance** button and then define the next element.

Completing the Profile

To complete the profile, perform these tasks:

1. Select **Line Profile** from the toolbox.
2. Select the **End Point** input fields, and snap to the endpoint, which is the right end of the upper horizontal line. The completed profile is displayed.

Challenge Project

Directions

Use the Profile feature to generate the part shown in Figure 4-37 by performing these tasks:

1. Set the start profile point at the origin.
2. Create the line and arc profiles in the clockwise direction.
3. If you want additional practice, create the profiles again, but use the counter-clockwise direction.

   Note You need to use the Advance button due to the lack of information on the part print.

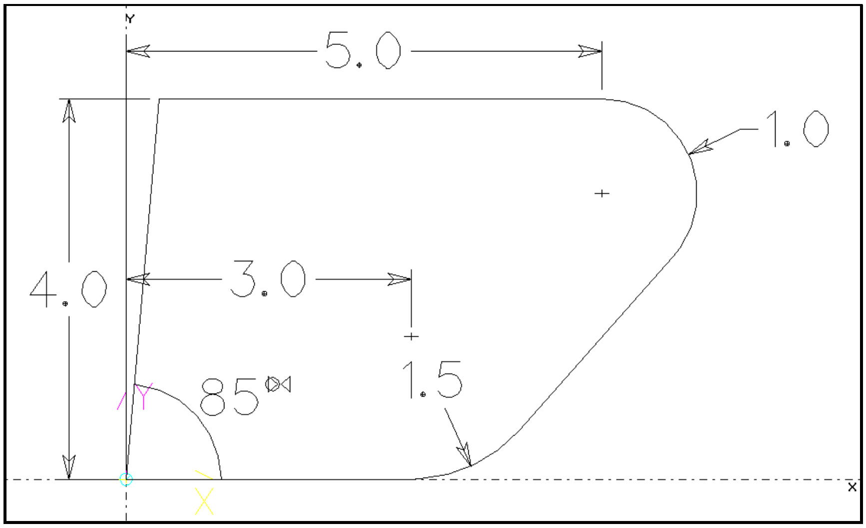


Figure 4-37
Use the Profile feature to generate this part.

Using the Curves Toolbox

Use the Curves toolbox modeling tools to create polyline, spline, ellipse, and helix elements.

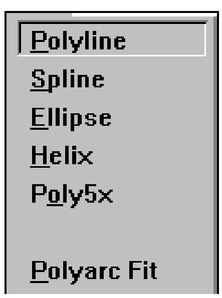
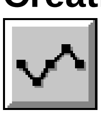


Figure 4-38
Use the Curves toolbox to create polylines, splines, ellipses, and helixes.

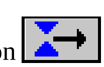
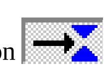
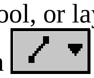
Creating Polylines



Use Polyline to create an element made up of a sequence of line segments. Use polylines when you need to create multiple straight line curves or stock boxes. Polylines help reduce the number of line segments in complex models.

Use values that you want as you perform these tasks to create a polyline:

1. Set the insert location:

   - Set the **Before** icon  or **After** icon  on the Insert property bar to indicate if the insert point is to be before or after the selected element, process step, tool, or layer.
   - Select the **Element** icon  on the Insert property bar.
   - Select the element to be before or after in the list view.

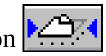
- Select the **On Layer** icon  or the **With Step** icon  on the Insert property bar.
- If you inserted on a layer, set the **Layer Number** input field on the Insert property bar. If you inserted on a step, set the step number in the list view.
- Set the **Level**, **Prof Top**, **Clear**, and **Offset** input fields on the Insert property bar.

Figure 4-39
Set the Insert property bar.

2. Select **Create—Curves**.
3. Select **Polyline** from the toolbox. The **Polyline** control panel is displayed.

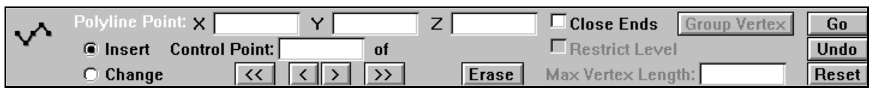
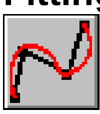


Figure 4-40
Set the values on the Polyline control panel.

4. Set the **Polyline Point** input fields for each of the points in the polyline.
5. Select the **Go** button.

Fitting a Polyline with a Polyarc



Use Polyarc Fit to transform the conventional point data of a polyline into a polyarc.

Perform these tasks to create a polyarc fit:

1. Set the insert location.
2. Select **Create—Curves—Polyarc Fit**.
3. Select **Polyarc Fit** from the toolbox. The **Polyarc Fit** control panel is displayed.

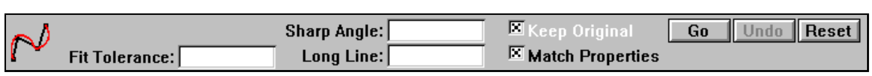
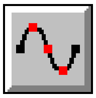


Figure 4-41
Set the values on the Polyarc Fit control panel.

4. Group the polylines that you want to fit.
5. Set the **Fit Tolerance** input field.
6. Set the **Sharp Angle** input field.
7. Set the **Long Line** input field to the length beyond which chords are not fit.
8. Turn off the **Keep Original** on/off switch to erase the original polylines after the new polyarcs are created.
9. Select the **Go** button. The resulting polyarcs are displayed in the Elements list as line or arc profiles.

Creating Splines



Use Spline to create a smooth element through multiple points. Splines are useful when you need a smooth flowing surface.

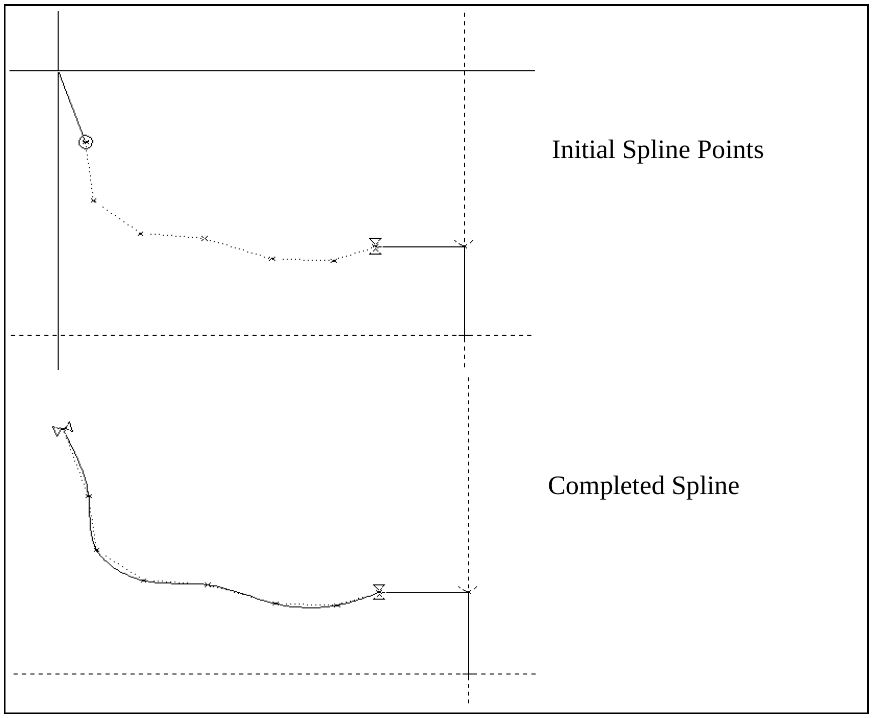
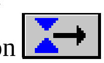
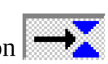
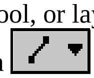
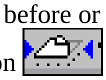


Figure 4-42
Compare initial spline points to a completed spline.

Perform these tasks to create a spline:

1. Set the insert location:
   - Set the Before icon  or After icon  on the Insert property bar to indicate if the insert point is to be before or after the selected element, process step, tool, or layer.
   - Select the **Element** icon  on the Insert property bar.
   - Select the element to be before or after in the list view.
   - Select the **On Layer** icon  or the **With Step** icon  on the Insert property bar.
   - If you inserted on a layer, set the **Layer Number** input field in the list view. If you inserted on a step, set the step number in the list view.
   - Set the **Level**, **Prof Top**, **Clear**, and **Offset** input fields on the Insert property bar.

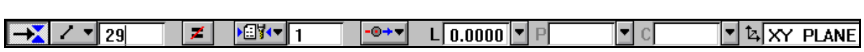
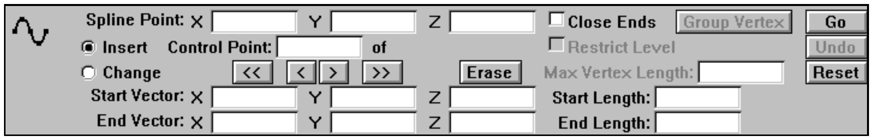


Figure 4-43
Set the Insert property bar.

2. Select **Create—Curves**.

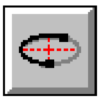
3. Select **Spline** from the toolbox. The **Spline** control panel is displayed.

Figure 4-44
Set values on the Spline control panel.



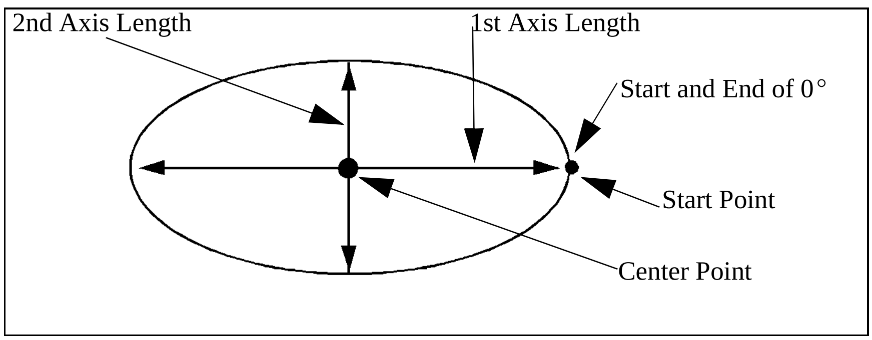
4. Set the **Spline Point** input fields to the value for each of the points.
5. Select the **Go** button.

Creating Ellipses



Use the Ellipse control panel to create an ellipse. You need to indicate a center point, angle of inclination, primary axis length, secondary axis length, start point, start angle, and an end angle.

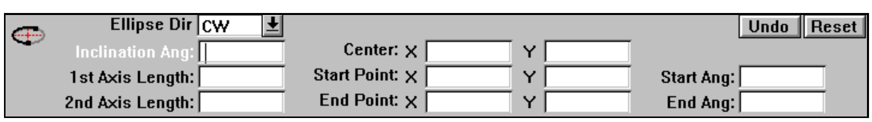
Figure 4-45
Construct an ellipse from different locations.



Once you set the insert location and elect to insert with a step or on a layer, perform these tasks:

1. Select **Create—Curves**.
2. Select **Ellipse** from the toolbox. The **Ellipse** control panel is displayed.

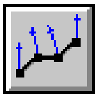
Figure 4-46
Set the ellipse values.



3. Select a clockwise (**CW**) or a counterclockwise (**CCW**) ellipse direction.
4. Specify the position of the center point.
5. Select the **Inclination Angle** input field. This is the angle of the primary axis of the ellipse, which is parallel to the X axis and has positive angles that are measured in the counterclockwise direction.
6. Set the **1st Axis Length** input field.
7. Set the **2nd Axis Length** input field.
8. Set the **Start Point** input fields.

9. Set the **End Point** input fields.
10. Set the **Start Angle** and **End Angle** input fields. To create a full ellipse, enter **0** for the start and end angles.

Creating a Five-Axis Polyline



Model File: AWPOLY5X.PM4

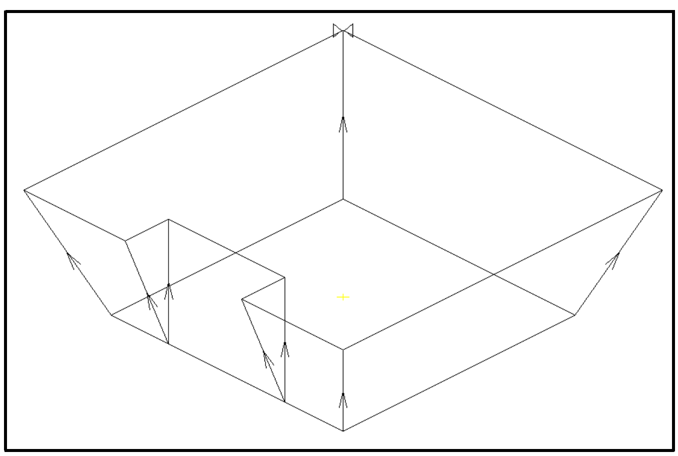
A 5-axis polyline is a sequence of line segments with vectors at each segment end point, which is a *control point*. Use Poly5x to create a 5-axis polyline that controls the angle and direction the wire moves during a 4-axis wire EDM operation. With Poly5x, you identify control points and the angle of the wire at those points. You also specify the direction of the toolpath between control points.

You can also modify the 5-axis polyline using the Edit—Geo Edit—Modify feature. For automatic 5-axis polyline creation, see *Creating Links*, on page 5-6.

Perform these tasks to create a 5-axis polyline:

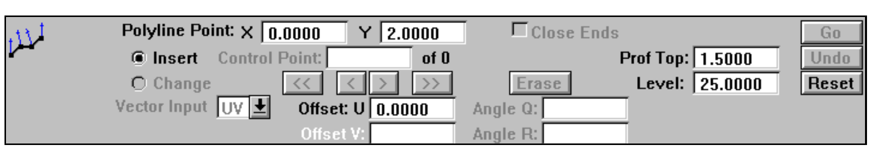
1. Open the model file **`AWPOLY5X.PM4`**.

Figure 4-47
Open AWPOLY5X.



2. Select **Create—Curves**.
3. Select **Poly5x** from the toolbox. The **Poly5x** control panel is displayed.

Figure 4-48
Set the values on the Poly5x control panel.



4. Turn on the **Insert** option switch.
5. Set the **Level** input field to the polyline's Z-height for the active work plane, in this case, **-0.25[6.35]**.

6. Set the **Prof Top** input field to represent the top of the surface defined by the polyline. This must be different from **Level**. Enter **1.5**.
7. Identify the work plane and step for the polyline.
8. Set the **Polyline Point** input fields to **0, -2[-50.8] , 0, 0** (Offset U, Offset V, X, Y) to identify the location of the first polyline point. This is the first control point.
9. Set the **Vector** input field to identify the offset for the first control point.
10. Set the second control point to **1, -2[-50.8] , 0, 0**. The readout line helps you establish the correct location. For the second control point, you must use the **UV** offset option for the wire's vector position. Once you create the second control point in a different location from the first, a move (segment) is defined and the vector angle QR option is available.

    Note As you enter control points, SmartCAM displays the segments and vectors for the 5-axis polyline. It displays each vector as a line from the control point and wire vector, with an identification circle and an arrow marker.

11. Create these additional control points and related vectors:
    - Third—**1[24.5], -2[-50.8], 0, -.75[-19.05]**
    - Fourth—**2[50.8], -2[-50.8], .75[19.05], -.75[-19.05]**
    - Fifth—**2[50.8], 2[-50.8], .75[19.05], .75[19.05]**
    - Sixth— **-2[-50.8], 2[50.8], -.75[-19.05], .75[19.05]**
    - Seventh— **-2[-50.8], -2[-50.8], -.75[-19.05], -.75[-19.05]**
    - Eighth— **-1[-24.5], -2[-50.8], 0, -.75[-19.05]**
    - Ninth— **-1[-24.5], -2[-50.8], 0, 0**
    - Tenth—**0, -2[-50.8], 0, 0**
12. Select the **Go** button. SmartCAM displays the segments and vectors for the 5-axis polyline. It displays each vector as a line from the control point, at the defined angle, to the height set by the **Prof Top** input field.

    Note If the vector lines are not displayed, select Utility—Display Modes. Turn on Thickness and turn on Auto Redraw.

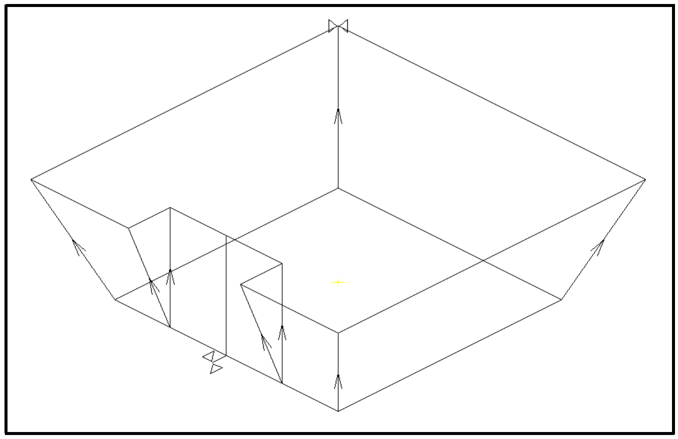
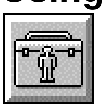


Figure 4-49
This is a result of Poly5X.

Using the User Elements Toolbox



Use the User Elements toolbox modeling tools to create user-specific commands, rectangles, and polygon elements.

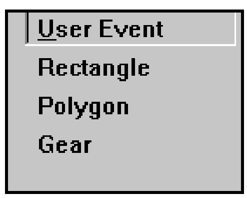
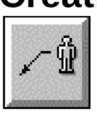


Figure 4-50
Use the User Elements toolbox.

Creating a User Event



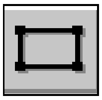
Use the User Event control panel to insert a machine-control event at a specific point in the process model. These commands can include program stops, comments, calls to template file selections, and other machine functions. Perform these tasks to create a user event:

1. Set the insert location for the user event.
2. Select **Create—User Elmts**.
3. Select **User Event** from the toolbox. The **User Event** control panel is displayed.

Figure 4-51
Enter a command in the Event Text input field.

4. Enter the command that you want in the **Event Text** input field.
5. Set the **X** and **Y** coordinates of the **Location Point** for the point in the graphic view where the user event is displayed.
6. Select the **Go** button. The user event record is displayed in the list view.

Creating a Rectangle



Use the Rectangle control panel to create the rectangle shown by entering a length, width, corner position, and an angle. To generate a true rectangle with square corners, you must enter **0** in the Corner Radius input field.

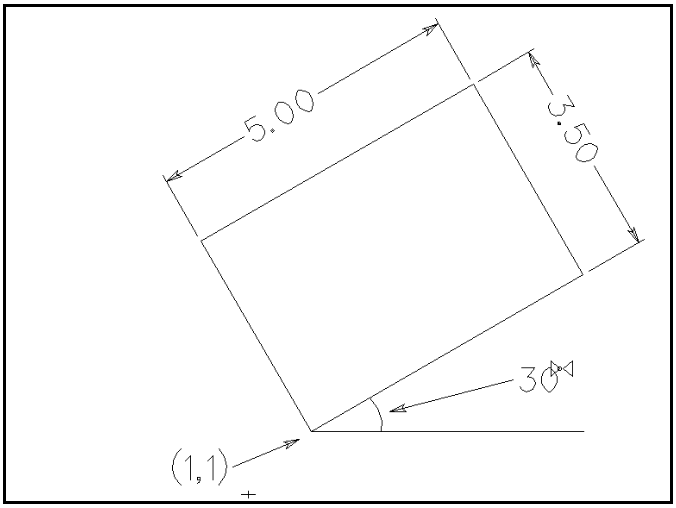


Figure 4-52 *Draw this rectangle.*

Perform these tasks to create the rectangle:

1. Set the insert location.
2. Select **Create—User Elmts**.
3. Select **Rectangle** from the toolbox. The **Rectangle** control panel is displayed.

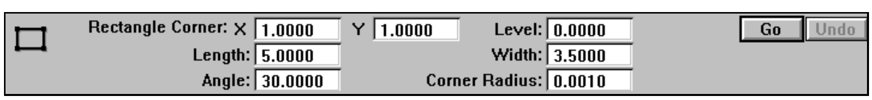
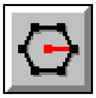


Figure 4-53 *Enter rectangle information.*

4. Enter values in the **Rectangle Corner**, **Length** (along X axis), **Angle** (from X axis, positive is counterclockwise), **Width** (along Y axis), **Corner Radius**, and **Level** input fields. The **Level** sets the Z-height of the rectangle.
5. Select the **Go** button.

Creating a Polygon



Use the Polygon control panel to create a polygon with a specific number of sides.

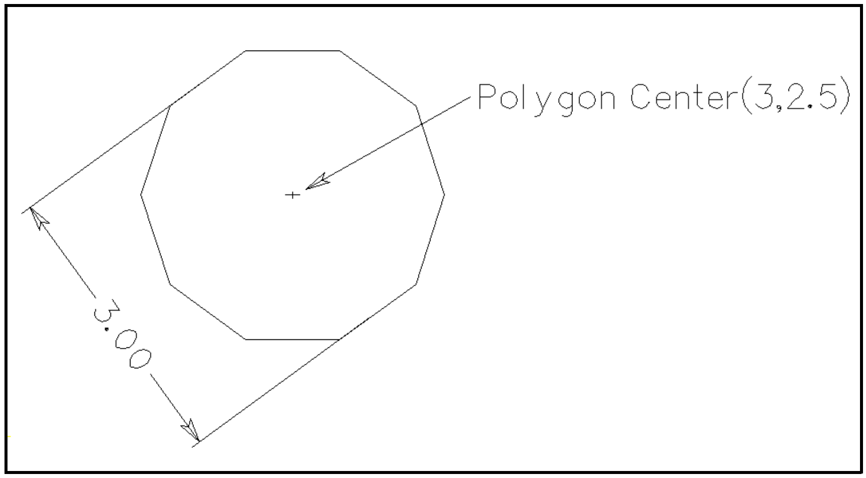


Figure 4-54
Draw this polygon.

Perform these tasks to create a polygon:

1. Set the insert location.
2. Select **Create—User Elmts**.
3. Select **Polygon** from the toolbox. The **Polygon** control panel is displayed.

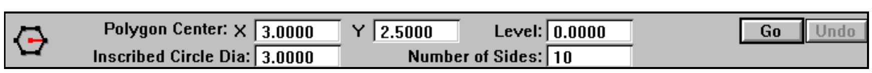
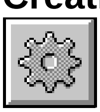


Figure 4-55
Enter polygon information.

4. Enter the **Polygon Center**, **Inscribed Circle Dia**, **Number of Sides**, and **Level** input fields.
5. Select the **Go** button. The results are grouped automatically.

Creating Gears



Job File: AWGEAR.JOF

Use Gear to create gear geometry with straight (nonhelical) involute spline teeth. You can specify a different pressure angle for each gear you create.

Perform these tasks to create a gear:

1. Select **File—New**.
2. Select **File—Load Job File**.
3. Open the job file **`AWGEAR.JOF`**.
4. Select **Create—User Elmts**.

5. Select **Gear** from the toolbox. The **Gear** control panel is displayed.

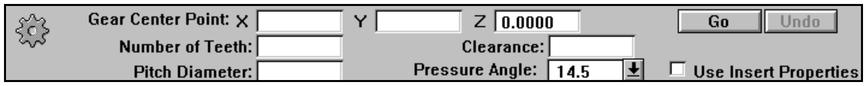


Figure 4-56
Set the values on the Gear control panel.

6. Set the coordinates for the **Gear Center Point** input fields to **0,0,0**.
7. Set the **Number of Teeth** input field to **14.** This is the number of teeth that the gear will have.
8. Set the **Pitch Diameter** input field to **10**.
9. Set the **Clearance** input field to **.01**, which is the clearance value (backlash) to use on the gear.
10. Select the **Pressure Angle** input field, and enter the pressure angle of the tooth.
11. Choose whether to turn on the **Use Insert Properties** on/off switch:
    - **On—**Use the settings from the Insert property bar.
    - **Off—**Use the default settings.
12. Select the **Go** button to create the gear.

    Note You must enter a setting for all the input fields on the control panel. If a setting is missing, SmartCAM will prompt you for the value.

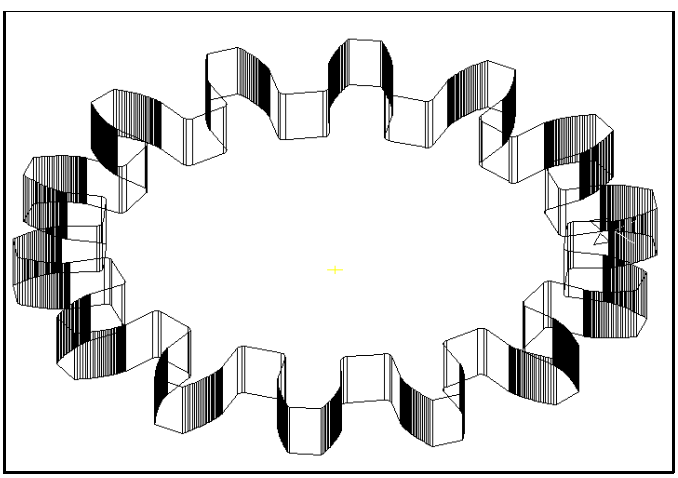
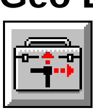


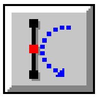
Figure 4-57
This is a result of creating a gear.

Geo Edit Toolbox



The Geo Edit toolbox contains modeling tools that enable you to change, add, or delete geometry elements.

Leading In/Out



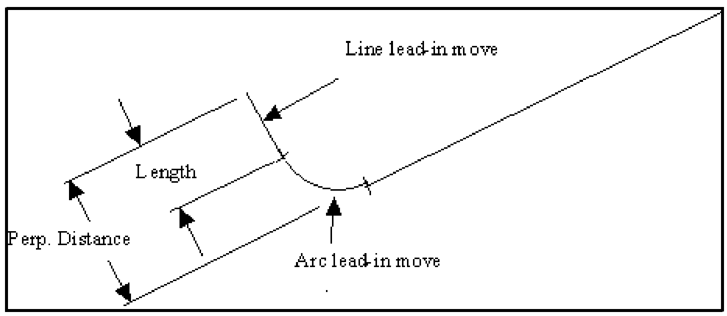
Model File:AWLEAD.PM4

Use Lead In/Out to create lines or arcs to produce gradual tool-feed movement into and out of a profile. The start and end elements of the profile must be lines, arcs, polylines, or ellipses.

The lead is created on the same side as the profile offset. If there is no offset, the lead will be created on the right. SmartCAM automatically sequences the lead-in and lead-out moves relative to the profile.

Leading In/Out for an Open Profile

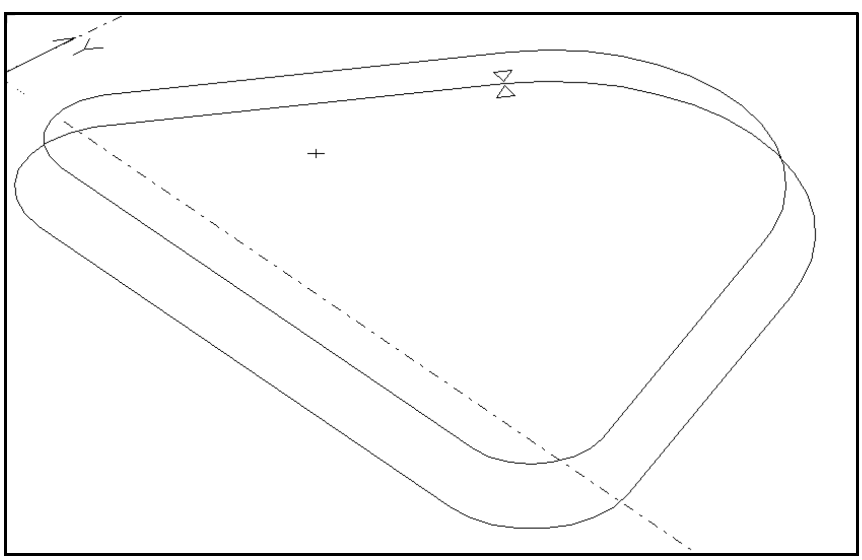
Figure 4-58
Compare the line and arc lead-in moves.



Perform these tasks to create a lead in or a lead out for an open profile:

1. Open the model file **`AWLEAD.PM4`**.

Figure 4-59
Open AWLEAD.



2. Select **Edit—Geo Edit**.
3. Select **Lead In/Out** from the toolbox. The **Lead In/Out** control panel is displayed.

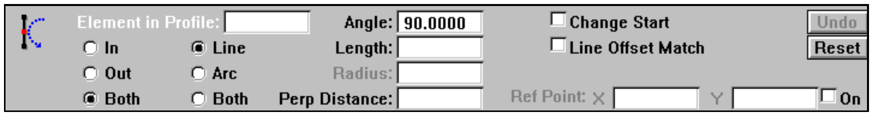


Figure 4-60
Enter the Lead In/Out information.

4. If the **Ref Point** on/off switch is turned on, set **Ref Point** to the point for the lead-in and lead-out moves to start and end.

5. If the **Ref Point** on/off switch is turned off, set these input fields:

   ■ Set **Angle** to the sweep angle of the arc.

   ■ Set **Length** to the length for lead-in and lead-out line moves. You can leave this field blank and specify a value in the Perp. Distance field instead.

   ■ Set **Radius** to a radius for lead-in and lead-out arc moves. You need to turn on **Arc** or **Both** (from the Line, Arc, Both column) to enable this field.

6. Select the **Element in Profile** input field and an element in the profile where you want the lead-in and lead-out moves to be done.

7. Turn on the **In**, **Out**, or **Both** option switch:

   ■ **In** places a lead-in move on the profile.

   ■ **Out** places a lead-out move on the profile.

   ■ **Both** places both a lead-in move and a lead-out move on the profile.

8. Turn on the **Line**, **Arc**, or **Both** option switch:

   ■ **Line** uses lines for the lead-in and lead-out moves.

   ■ **Arc** uses arcs for the lead-in and lead-out moves.

   ■ **Both** places a line before an arc lead-in move and after an arc lead-out move.

   ■ Set **Perp. Distance** to the perpendicular distance from the profile where the lead-in and lead-out moves will begin and end.

9. Turn on the **Change Start** on/off switch to reorder the elements in a profile before placing the lead-in and lead-out moves.

Points to Remember

- ❑ Identify the insert location and the properties for the geometry before creating new geometry.
- ❑ You do not need to know all the values on a control panel to create profiles. SmartCAM can solve for some data.
- ❑ Associating geometry with a step results in CNC code.
- ❑ Associating geometry with a layer does not result in CNC code.
- ❑ Use Wall Offset to create geometry that is parallel to existing geometry.
- ❑ Insert a machine-control event at a specific point in the process model with the User Event feature.

Viewing Element Data

Objectives

This lesson shows you how to find information about element coordinates and properties.

Overview

Use the Element Data feature to view information about the element coordinates and properties for each element in a model. Viewing element data does not affect the geometry database.

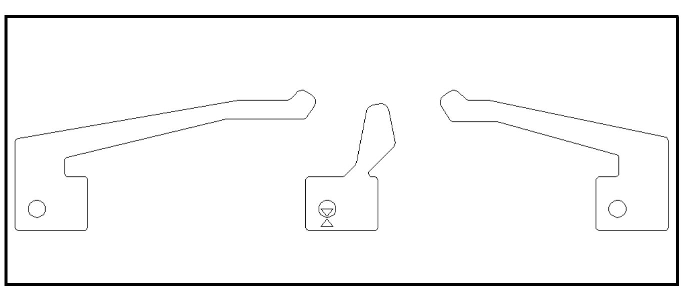
Using Element Data

Model File: AWNOCORE.PM4

Use the Element Data dialog box to view the modeling data for each element in a model. Hidden elements are not displayed. Perform these tasks to view visible modeling data:

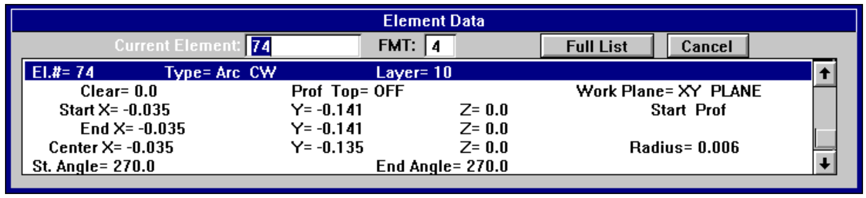
1. Open the model file **`AWNOCORE.PM4`**.

Figure 4-61
Open AWNOCORE.



2. Select **Utility—Element Data**, or press **F7**. The **Element Data** dialog box is displayed.

Figure 4-62
Set the values on the Element Data dialog box.



3. Use the input fields, list view, or graphic view to select an element.
4. Select the **Full List** button to display a full screen of the element data for the model.
5. Select the **Cancel** button when you are finished viewing the data.

Points to Remember

- ❑ You can view modeling data for each element in a model.
- ❑ Viewing element data does not affect the geometry database.
- ❑ Hidden data is not displayed in the Element Data dialog box.

Editing Geometry

Objectives

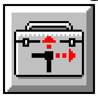
This lesson shows you how to perform these tasks:

- Trim and extend geometry.
- Trim a group of elements.
- Trim a profile.
- Explode an element.
- Blend lines and arcs
- Create a chamfer.
- Split a curve.
- Modify the shape of elements.
- Delete elements.

Overview

Use Trim/Extend to trim elements or extend disconnected elements to an intersection point. Elements to be trimmed or extended must be on the same work plane. Trim/Extend does not work on complex curves, such as splines and helixes.

Using the Geo Edit Toolbox



Use the modeling tools in the Geo Edit toolbox to change, add, or delete geometry elements.

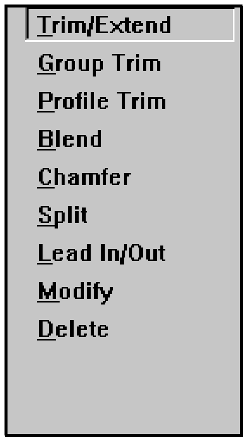
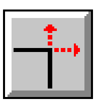


Figure 4-63
Use the options in the Geo Edit toolbox.

Trimming and Extending Geometry



Model File: AWTRIMEX.PM4

Use Trim/Extend to trim elements or to extend disconnected elements to an intersection point. Elements to be trimmed or extended must be on the same work plane. Perform these tasks to trim or extend geometry:

1. Open the model file **`AWTRIMEX.PM4`**.

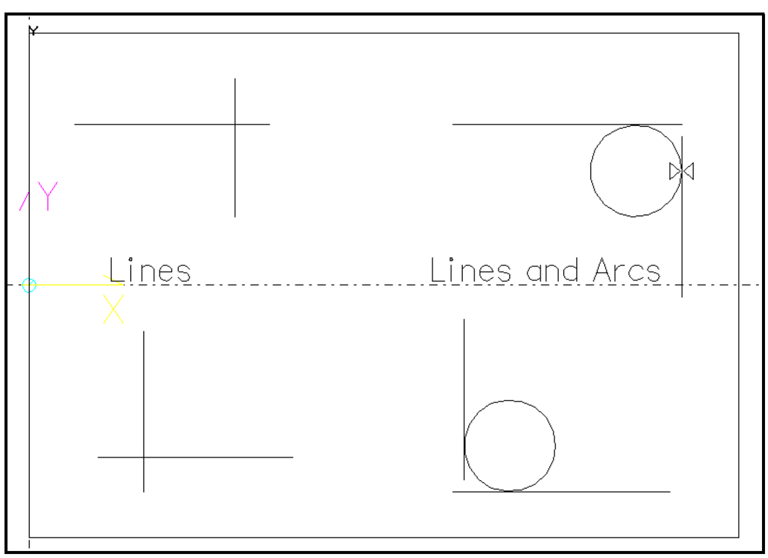


Figure 4-64
Open AWTRIMEX.

2. Select **Edit—Geo Edit**.

3. Select **Trim/Extend** from the toolbox. The **Trim/Extend** control panel is displayed.

Figure 4-65 *Set the values on the Trim/ Extend control panel.*

4. Set these values on the **Trim/Extend** control panel:
   - Turn on the **Which Segments** on/off switch to view all solutions for trimming and extending the elements you select.
   - Set the **1st Keep Side** selector switch to the side of the first curve to keep. Typically, this is set to **Mouse** to keep the portion of the curve you select.
   - Set the **2nd Keep Side** selector switch to the side of the second curve to keep. Typically, this is set to **Mouse** to keep the portion of the curve you select.
   - Select the **1st Element** input field.
   - Select the geometry to trim.
   - Select the **2nd Element** input field.

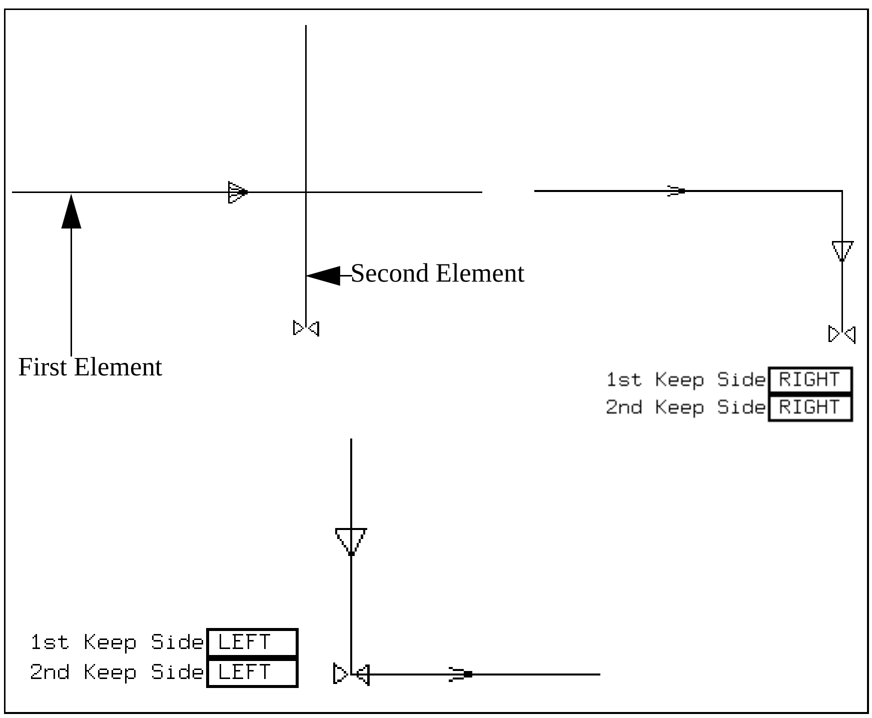
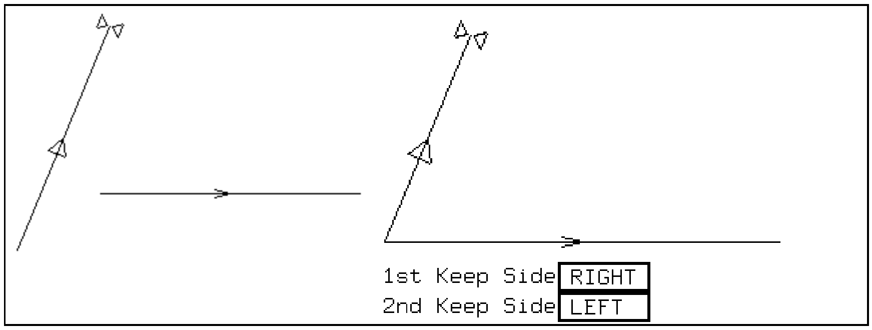


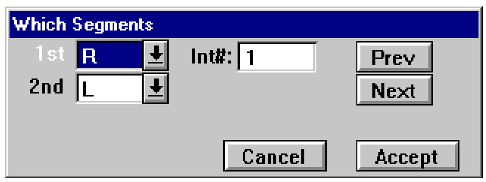
Figure 4-66 *Trim the lines.*

Figure 4-67
Extend the lines.



5. Select the geometry to trim. The **Which Segments** dialog box is displayed.

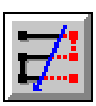
Figure 4-68
Specify the segments that you want to use.



6. Set these values on the **Which Segments** dialog box:

   - Select the **Previous** or **Next** buttons until the solution you want is displayed.
   - Select the **Accept** button when you have selected a solution. If you do not want any of the solutions, select the **Cancel** button.

Trimming a Group of Elements



Model File: AWTRIMGP.PM4

Use Group Trim to trim the elements in the active group to their intersections with a selected profile or element. You can trim a single element or a group consisting of lines, arcs, or polylines. Group Trim does not enable you to extend elements. Perform these tasks to trim a group of elements:

1. Open the model file **`AWTRIMGP.PM4`**.

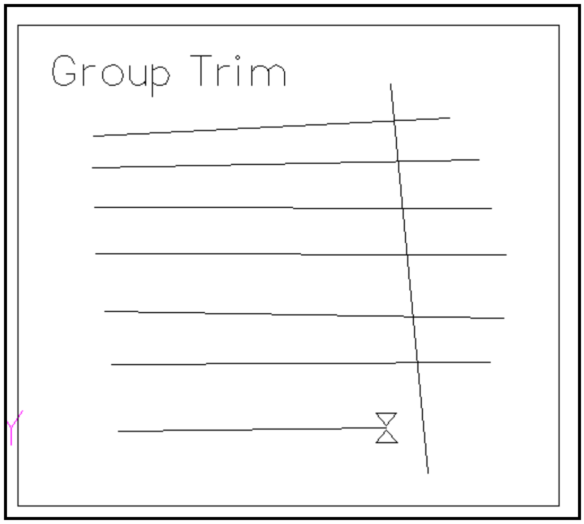


Figure 4-69
Open AWTRIMGP.

2. Group the elements to trim.
3. Select **Edit—Geo Edit**.
4. Select **Group Trim**. The **Group Trim** control panel is displayed.

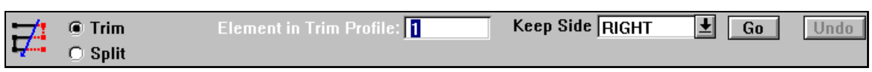


Figure 4-70
Set the values on the Group Trim control panel.

5. Set these values on the **Group Trim** control panel:
   - Select the element to trim to.
   - Turn on the **Trim** option switch.
   - Turn on the **Keep Side** selector switch to control which element parts are affected.
   - Select the **Element in Trim Profile** input field, and select an element with which to trim.
6. Select the **Go** button. If the results are not what you want, select the **Undo** button to remove the incorrect solution.

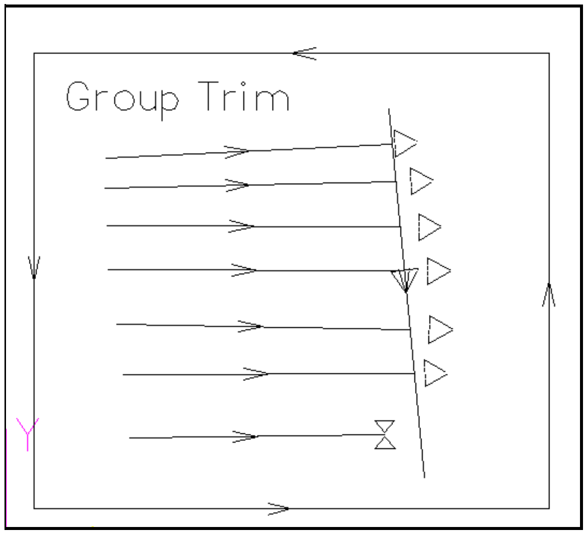
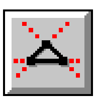


Figure 4-71
This is the result of trimming the group.

Trimming a Profile



Model File: AWTRIMPF.PM4

Use Profile Trim to intersect, trim or extend, and sequentially order groups that are on the same level and work plane. Profile Trim is useful for creating profiles from unconnected elements imported from a CAD system or created by planar cuts. Perform these tasks to trim a profile:

1. Open the model file **`AWTRIMPF.PM4`**.

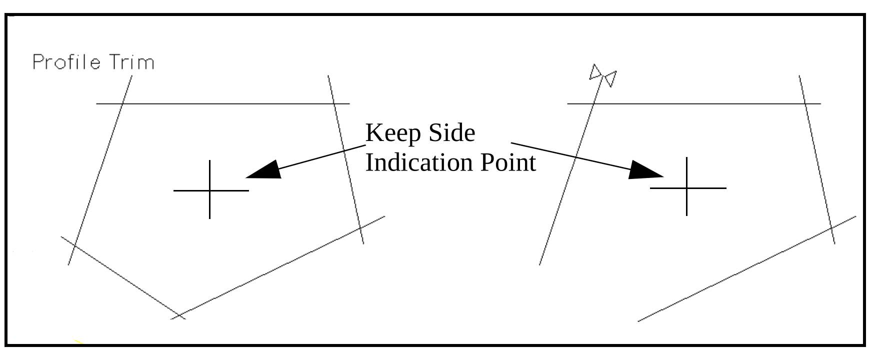


Figure 4-72
Open AWTRIMPF.

2. Group the geometry to change.
3. Select **Edit—Geo Edit**.
4. Select **Profile Trim** from the toolbox. The **Profile Trim** control panel is displayed.

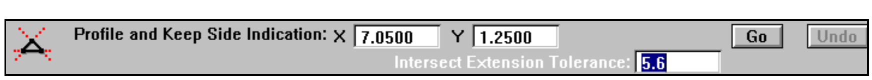


Figure 4-73
Set the Profile and Keep Side Indication input fields on the Profile Trim control panel.

5. Set these values on the **Profile Trim** control panel:
   - Set the **Profile and Keep Side Indication** input fields.
   - Set the **Intersect Extension Tolerance** input field.

   Note Identify the Profile and Keep Side Indication by either entering the coordinates in the X and Y fields or selecting a position in the graphics view.

6. Select the **Go** button. The profile is trimmed.

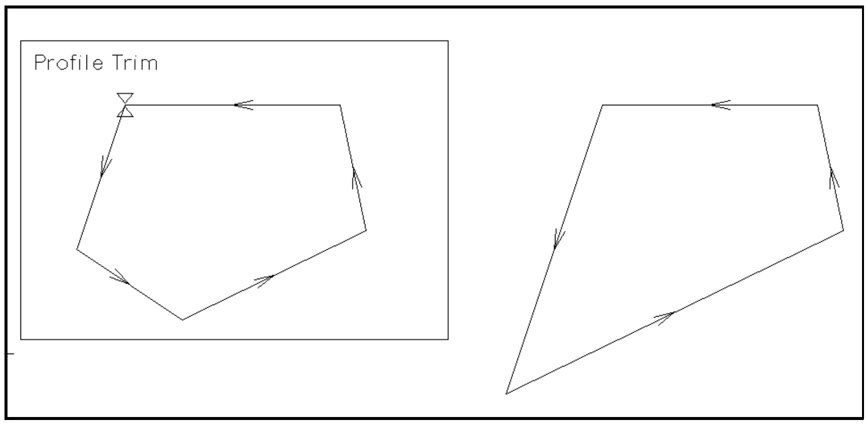
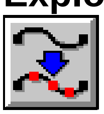


Figure 4-74 *This is a result of trimming the profile.*

Exploding an Element



Model File: AWBLEND.PM4

Use Explode to convert elements in the active group into primitive elements (arcs, lines, or polylines). This lets you control the arc tangencies or polyline segments that represent curved portions of profiles.

1. Open the model file **AWBLEND.PM4**.

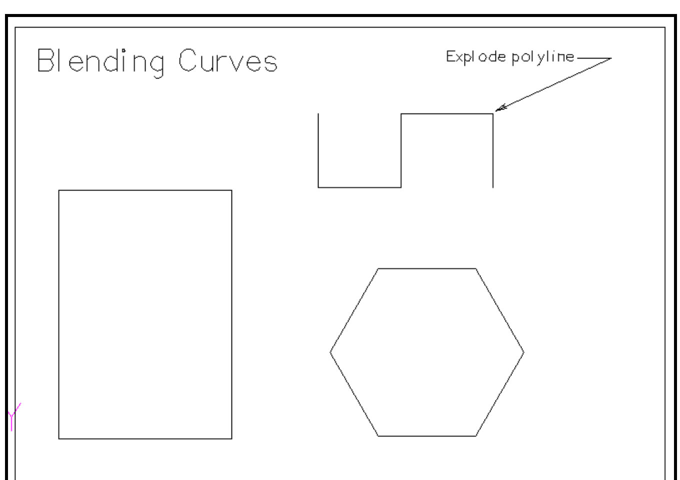
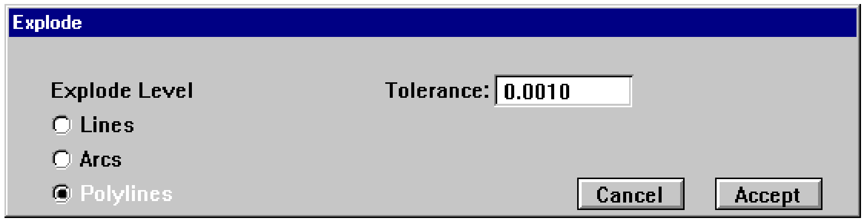


Figure 4-75 *Open AWBLEND.*

2. Select **Group—New Group**, and select the elements to explode.
3. Select **Edit—Explode**. The **Explode** dialog box is displayed.

Figure 4-76
Set the values on the Explode dialog box.

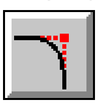


4. Turn on the **Polylines** option switch.
5. Set the **Tolerance** input field, which is the maximum chordal allowance for the resulting elements. The tighter the tolerance, the smaller the resulting elements.

   Note Once an element or group of elements is modified with Explode, you cannot change the new, primitive elements back to the original elements. Be sure you save your model and select the correct elements and explode level before completing the operation.

6. Select **Accept**.

Blending Lines and Arcs

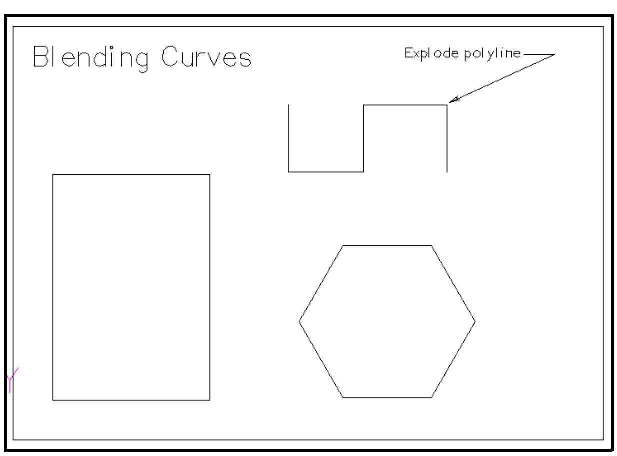


Model File: AWBLEND.PM4

Use Blend to insert an arc segment between two lines or arcs, and trim them to the arc tangent points. The lines and arcs to blend must be on the same work plane. The blended arc uses the same properties as the first selected element and is inserted immediately after it in the database. Perform these tasks to blend lines and arcs:

1. Open the model file **`AWBLEND.PM4`**.

Figure 4-77
Open AWBLEND.



2. Select **Edit—Geo Edit**.

3. Select **Blend** from the toolbox. The **Blend** control panel is displayed.

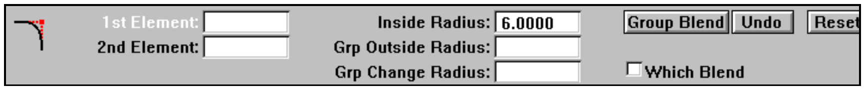


Figure 4-78 *Set the values on the Blend control panel.*

4. Select the **1st Element** input field, and select the first element or group the geometry to be blended with the Group Blend feature.
5. Set the following as necessary:
   - Set the **Inside Radius** input field to the blend radius value.
   - Set the **Grp Outside Radius** input field to the radius value to use for creating group blends when the tool offset is outside the corner. A value of **0** removes the blending arc between two elements.
   - Set the **Grp Change Radius** input field to specify a new radius for arcs if you are blending a group.
6. Either select the **2nd Element** input field, and select the second element, or select the **Group Blend** button.

   The blend is executed.

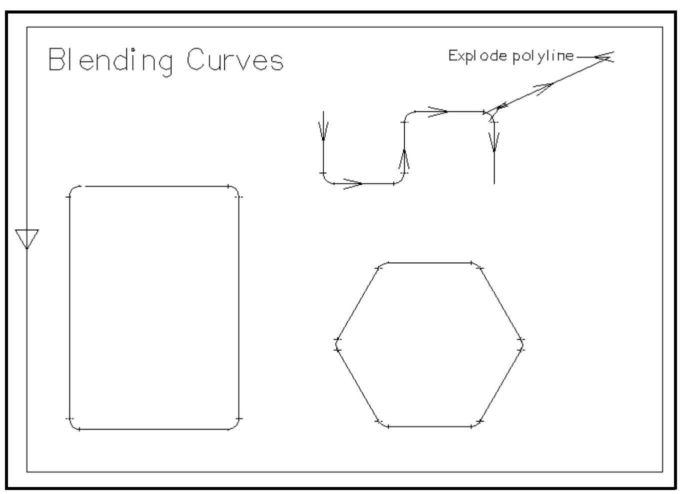
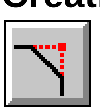


Figure 4-79 *This is a result of blending the curves.*

Creating a Chamfer



Model File: AWLINES.PM4

Use Chamfer to insert a line of a given size at an angle relative to two line, arc, elliptical, or polyline elements on the same work plane. The two elements do not have to connect, but the chamfer must reach between them. The Chamfer modeling tool also trims or extends the two existing elements to the intersection point of the chamfer. Perform these tasks to create a chamfer:

1. Open the model file **AWLINES.PM4**. You will chamfer the two lines in the first *Two Points* box.

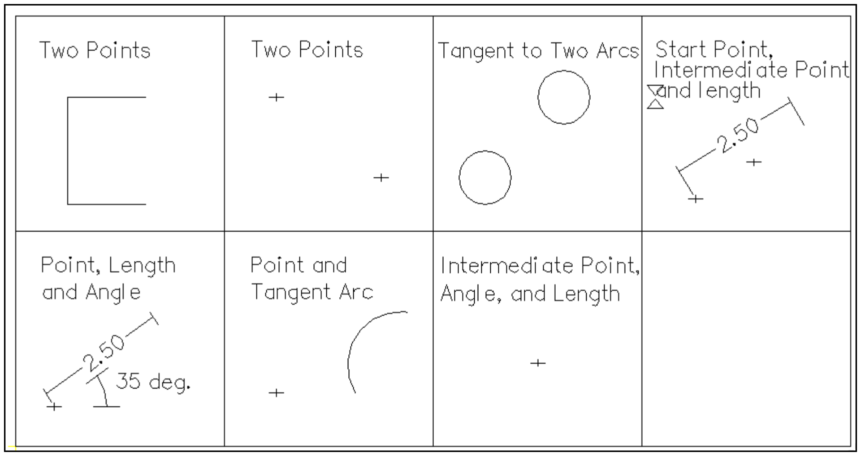


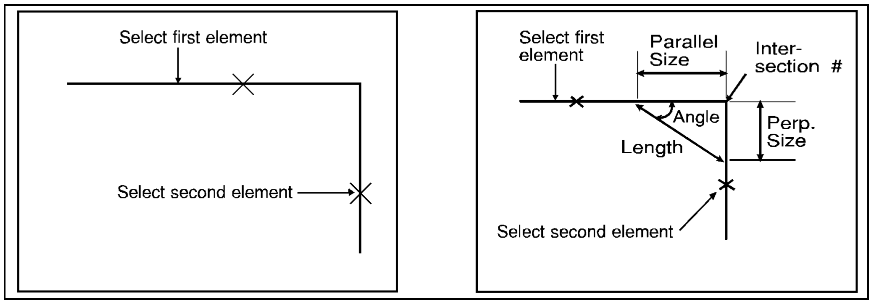
Figure 4-80 *Open AWLINES .*

2. Select **Edit—Geo Edit**.
3. Select **Chamfer** from the toolbox. The **Chamfer** control panel is displayed.

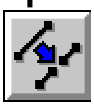
Figure 4-81 *Set the values on the Chamfer control panel.*

4. Set the **Angle** input field to the angle of the chamfer. The angle of the chamfer is measured from the first element. Positive angles are measured counterclockwise from the first element, and negative angles are measured clockwise from the first element.
5. Set the **Length**, **Parallel Size**, or **Perp Size** input fields.
   - **Length** specifies the length of the chamfer.
   - **Parallel Size** specifies the width of the chamfer. (If length and angle are set, SmartCAM can automatically calculate this value.)
   - **Perp. Size** specifies the height of the chamfer. (If length and angle are set, SmartCAM can automatically calculate this value.)
6. Select the **1st Element** input field, and select the first curve in the graphic view.
7. Select the **2nd Element** input field, and select the second curve in the graphic view.

Figure 4-82
Specify the solution that you want to use.



Splitting a Curve



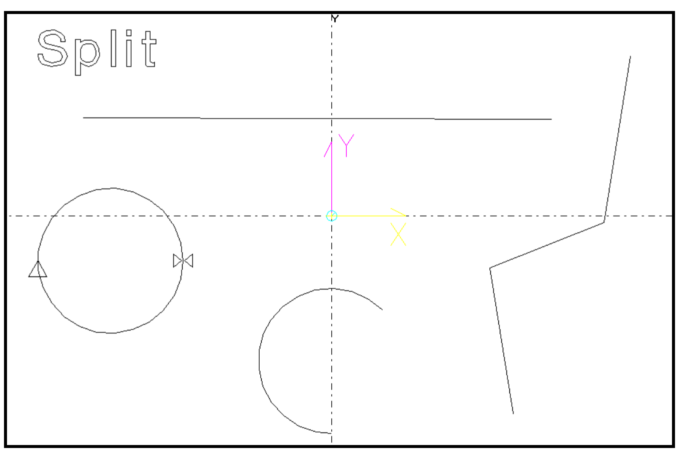
Model File: AWSPLIT.PM4

Use Split to divide an arc, line, ellipse, or polyline at any point along its length. You can extend or trim the elements at the split point to create a break or an overlap.

Split creates an additional element in the database. (Two elements appear in the database to replace the single element that was split.) SmartCAM keeps the new element in the correct sequence with the original properties. Perform these tasks to split a curve:

1. Open the model file **AWSPLIT.PM4**.

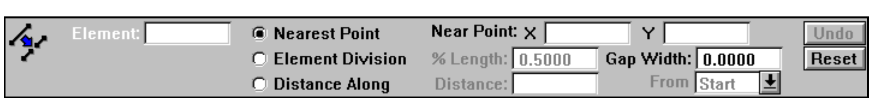
Figure 4-83
Open AWSPLIT.



2. Select **Edit—Geo Edit**.

3. Select **Split** from the toolbox. The **Split** control panel is displayed.

Figure 4-84
Specify values on the Split control panel.

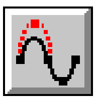


4. Set **Nearest Point**, **Element Division**, or **Distance Along**:

- If you choose **Nearest Point**, enter the coordinates for the split point on the element in the **Near Point** input fields.
- If you choose **Element Division**, enter the decimal equivalent for the percent of the element's length where the split should occur in the **% Length** input field. Also set the **From** selector switch to identify where to measure from to calculate **% Length**.
- If you choose **Distance Along**, enter the distance along the element for the split to occur in the **Distance** input field. Also set the **From** selector switch to identify where to measure from to calculate **Distance**.

5. Set the **Element** input field and select an element to split.

Modifying the Shape of Elements



Model File: AWMODIFY.PM4

Use Modify to change the geometric information for a selected element. When you select Modify and an element, SmartCAM displays solution settings for that element in the control panel. Change the settings to create a different solution for the element.

You can modify these element types:

- Holes
- Lines
- User elements
- Points
- Helixes
- Subroutines
- Arcs
- Polylines
- Text (dimensions)
- Ellipses
- Splines

When you select an element to modify, the appropriate dialog box for the element is displayed.

1. Open the model file **`AWMODIFY.PM4`**.

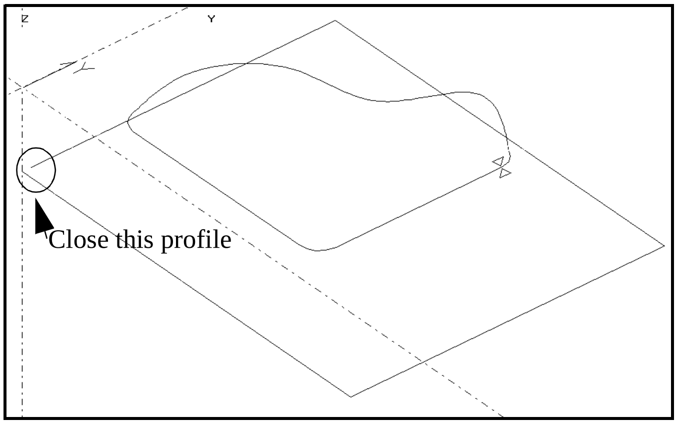


Figure 4-85
Open AWMODIFY.

2. Select **Edit—Geo Edit**.
3. Select **Modify** from the toolbox. The **Modify** control panel is displayed.

Figure 4-86
Open the Modify control panel.

4. Select the **Element to Modify** input field.
5. Select the element to modify. The element-appropriate dialog box, in this case the **Modify Polyline** dialog box, is displayed.

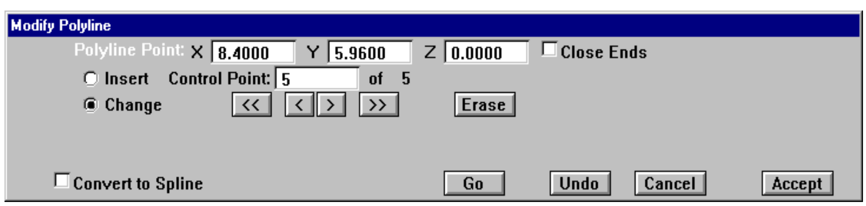
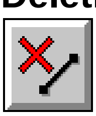


Figure 4-87
The Modify Polyline dialog box is displayed.

6. Make the necessary changes, and select the **Go** button.
7. Select the **Accept** button.

Deleting Elements

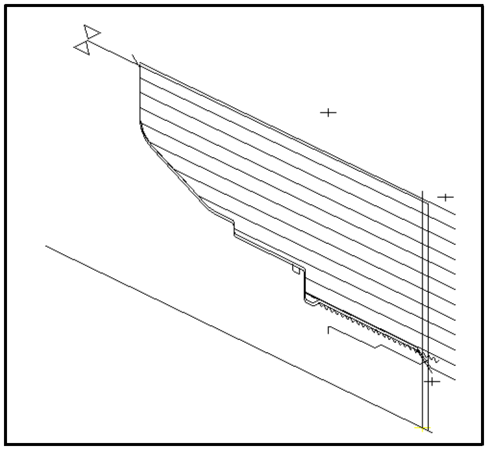


Model File: AWLINES.PM4

Use Delete to remove an element or a group of elements from the database. Undo enables you to recover the last element or group deleted. Once you close the Delete control panel, you cannot recover deleted items. Perform these tasks to delete an element:

1. Open the model file **`AWLINES.PM4`**

Figure 4-88
Open AWLINES.



2. Select **Edit—Geo Edit**.
3. Select **Delete** from the toolbox. The **Delete** control panel is displayed.

Figure 4-89
Set the Delete control panel.

4. Select the **Element to Delete** input field.
5. Select the element to delete. The element is deleted.
6. Select the **Undo** button to restore the most recently deleted element.

   Note You cannot undo more than the most recently deleted element.

Points to Remember

- ❑ Elements to be trimmed or extended must be on the same work plane.
- ❑ Group Trim impacts only the active group. It does not extend an element.
- ❑ Split creates an additional element in the database.
- ❑ Only the last element or group deleted can be recovered with the Undo button.

Changing Properties and Attributes

Objectives

This lesson shows you how to perform these tasks:

- Change toolpath properties.
- Change layer properties.
- Change hole or point properties.

Overview

Use Property Change to change these properties for an element or set of elements:

- The clearance heights
- The step associated with the geometry
- The Z level
- The offset direction
- Whether a piece of geometry is drawn on a layer or with a step

Using the Property Chg Submenu

Use the Property Chg submenu to update modeling properties associated with existing elements.

Note You must have an active group of elements before using Property Change modeling tools. Use the Group tool palette to select an active group.

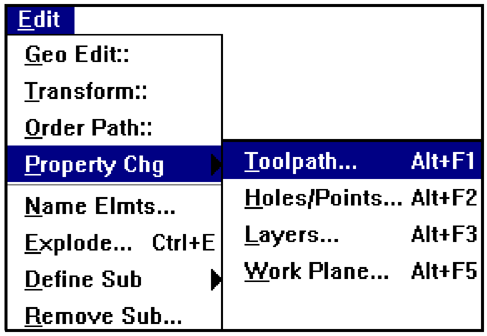
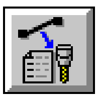


Figure 4-90
Learn the components of the Property Change submenu.

Changing a Toolpath Property



Model File: AWPRPCHG.PM4

Use Toolpath to change one or more toolpath properties for an active group of elements. Properties that you can change include step, tool offset, level,clear, and prof top. You must select an active group of elements before you can access the Toolpath Property Change dialog box. Perform these tasks to change a toolpath property:

1. Open the model file **`AWPRPCHG.PM4`**.

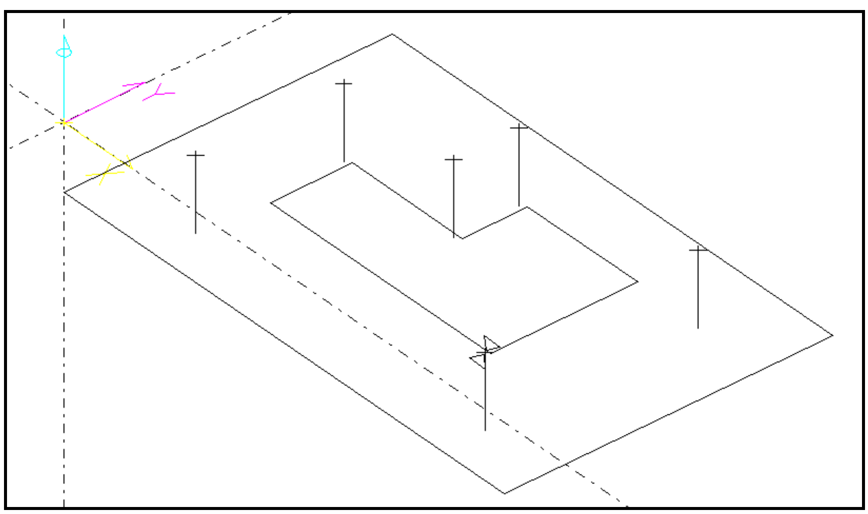
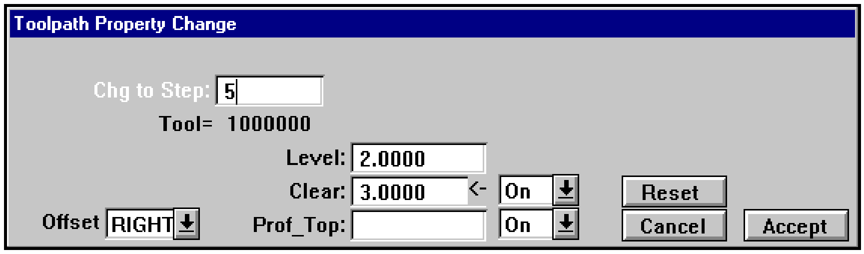


Figure 4-91
Open AWPRPCHG.

2. Group the geometry to change.
3. Select **Edit—Property Chg—Toolpath**. The **Toolpath Property Change** dialog box is displayed.

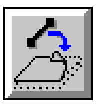
Figure 4-92 Set the values on the Toolpath Property Change dialog box.



4. Enter the changes on the dialog box. To change the **Offset**, **Clear**, and **Prof Top** values, you must change the **Offset** selector switch from **N/C** to another value.

5. Select the **Accept** button.

Changing a Layer Property

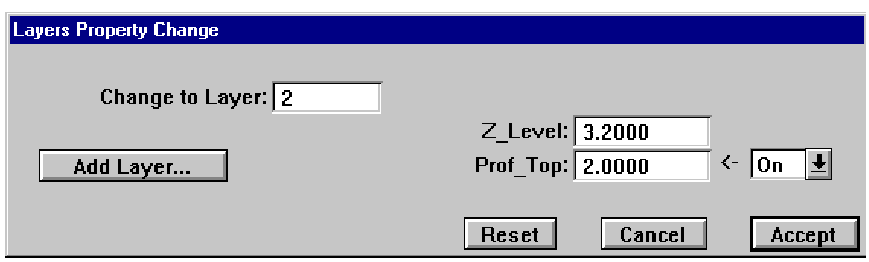


Use Layers to associate the active group of elements with a layer or to change layer assignments. If you associate elements with a layer, SmartCAM does not generate code for them. Place items such as clamps and part blanks on layers to check tool clearance of obstacles during Show Path. Perform these tasks to change a layer property:

1. Group the geometry that you want to change.

2. Select **Edit—Property Chg—Layers**. The **Layers Property Change** dialog box is displayed.

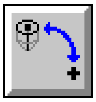
Figure 4-93 Set the values on the Layers Property Change dialog box.



3. Enter the changes on the dialog box. To change the **Prof Top** input field, you must change the **Prof Top <-** selector switch from **N/C** to another value.

4. Select the **Accept** button.

Changing a Hole or Point Property



Use Holes/Points to change the properties of hole or point elements in the active group. You can change the assigned step, level, clearance, or spot diameter, or you can change a group of points into holes. Perform these tasks to change a hole or a point property:

1. Select **Edit—Property Chg—Holes/Points**. The **Holes/Points Property Change** dialog box is displayed.

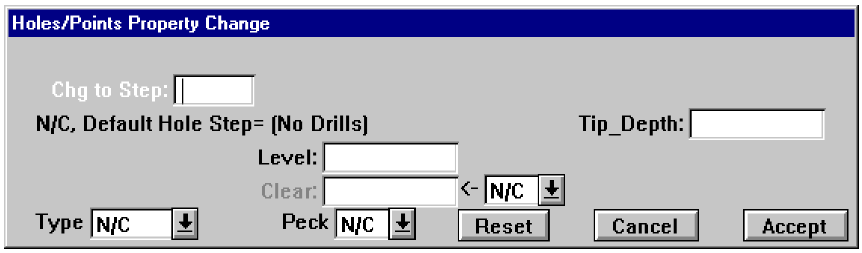
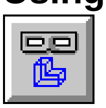


Figure 4-94 *Set the values on the Holes/ Points Property Change dialog box.*

2. Enter the changes on the dialog box. To change the **Type** selector switch and **Clear** input field, you must change the **Clear** **<-** selector switch from **N/C** to another value.

3. Select the **Accept** button.

Using Show/Mask



Model File: ELECTRODE.PM4

Use the Show/Mask dialog box, which is on the Utility menu, to show or mask geometry in a model file. You can select elements by layer, step, tool, or work plane. SmartCAM does not display, select, or code hidden or masked elements. Masked elements are not deleted from the database; they are just hidden.

Show/Mask is useful for selectively viewing only a portion of the model. This reduces the redraw time and the time required when using Show Path.

Perform these tasks to show and mask elements:

1. Open the model file **`ELECTRODE.PM4`**.

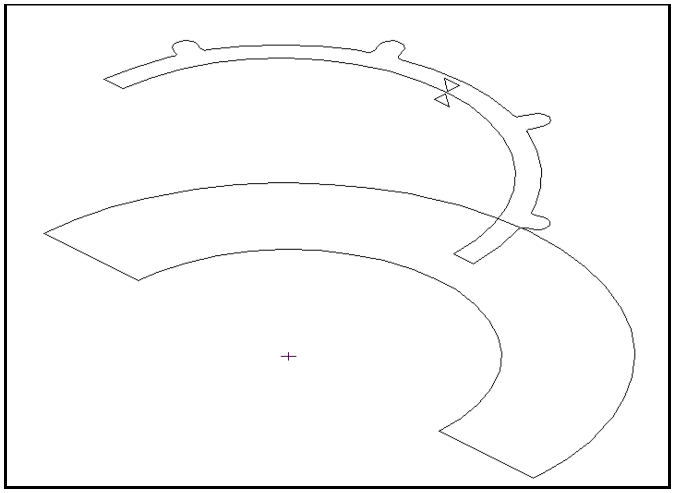


Figure 4-95 *Open ELECTRODE.*

2. Select **Utility—Show/Mask**. The **Show/Mask** dialog box is displayed.

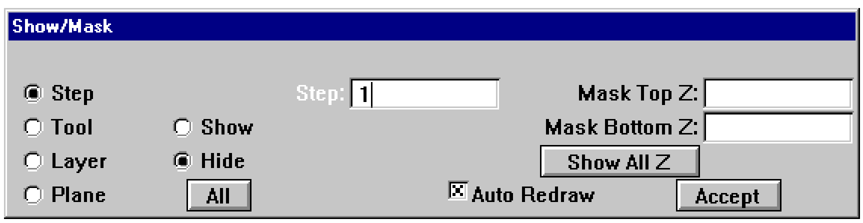


Figure 4-96 *Set the values on the Show/ Mask dialog box.*

3. Select the method to choose elements to show or mask (**Step**, **Tool**, **Layer**, or **Plane**).

4. Select either the **Show** or the **Hide** option.

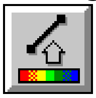
5. Use the list view, the input field, or the graphic view to select the elements to show or mask.

   Note An H is displayed in the list view next to an element, step, or layer that is hidden. When the Show Mask dialog box is displayed, you can select the hidden element to redisplay that geometry. You can also select an element that is not hidden to automatically mask that geometry.

6. Select the **Accept** button. The geometry is displayed or hidden.

7. Press **F8** to redraw the screen, if necessary. Remember to use this key anytime you want to instantly identify what is masked.

Using Color Change



Model File: ELECTRODE.PM4

Use the Color Change dialog box, which is on the Utility menu, to change the color, layer style, or both for existing elements in the model. The colors available depend on your computer's graphic display card. This option affects only the display, not the code generation.

Perform these tasks to change the color:

1. Open the model file **`ELECTRODE.PM4`**.

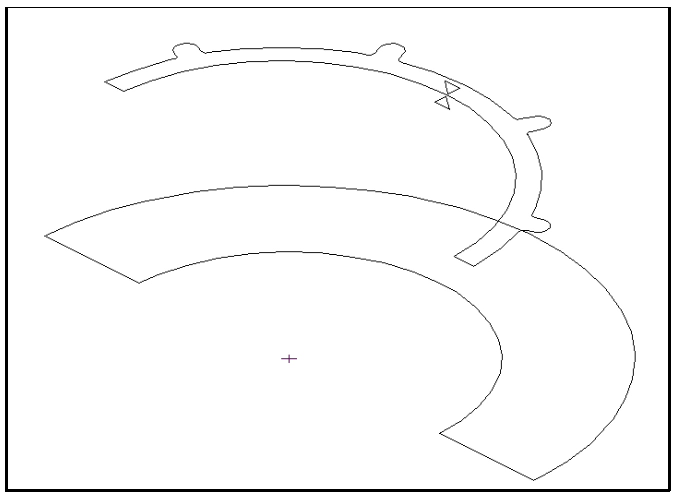


Figure 4-97
Open ELECTRODE.

2. Select **Utility—Color Change**. The **Color Change** dialog box is displayed.

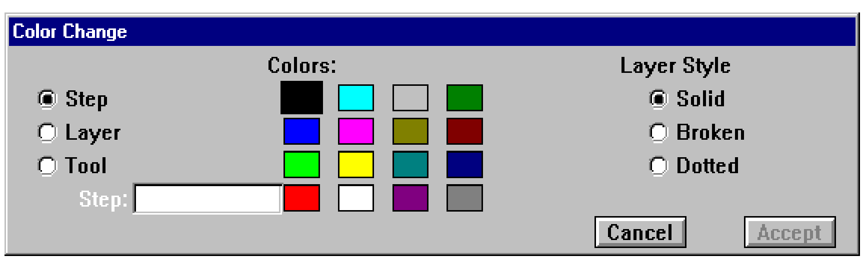


Figure 4-98
Set the values on the Color Change dialog box.

3. Select the **Step**, **Layer**, or **Tool** option to indicate what type of geometry to change.

   Note Color assignments for any steps that have numbers greater than 255 are not saved by SmartCAM following a session. Therefore, only color information for step numbers 255 or less is consistent between SmartCAM sessions.

4. Use the list view, input field, or graphic view to select elements to change.
5. Select the **Accept** button.

Points to Remember

- You must have an active group of elements before using Property Change modeling tools.
- You can change toolpath, layer, and hole/point properties.
- When you associate elements with a layer, code is not generated for them.
- The Color Change feature enables you to change the color of specified elements.
- Changing the color of elements affects only the display, not the code generation.

Using Show Path

Objectives

This lesson shows you how to perform these tasks:

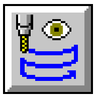
- Set the Show Path control panel.
- Start Show Path.
- Stop Show Path.

Overview

Show Path provides a representation of the toolpath before any parts are cut. Use Show Path to verify the sequence and toolpath of the model based on your machine's capabilities.

Note Show Path uses information stored in the custom tool graphics (CTG) file for each tool to perform the machining simulation in the graphic view. If you have not specified a CTG file in the tooling information, SmartCAM will display a standard tool based on your tooling selection.

Showing the Toolpath



Model File: AWSHPTH.PM4

Perform these tasks to show the toolpath:

1. Open the model file **`AWSHPTH.PM4`**.

2. Select **View—Get View**. The **Get View** dialog box is displayed.

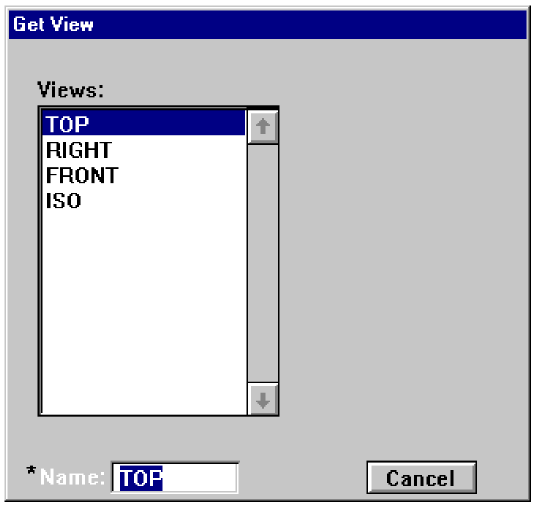


Figure 4-99
Select ISO from the Get View dialog box.

3. Select **ISO** from the **Get View** dialog box.

4. Select **View—Show Path**. The **Show Path** dialog box is displayed.

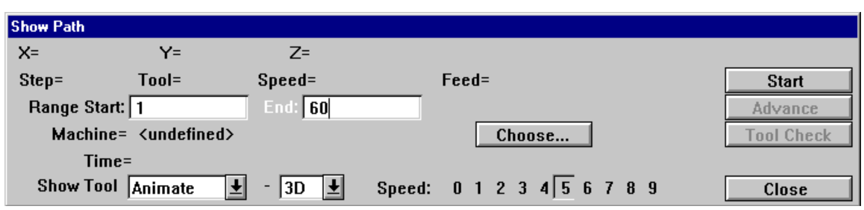


Figure 4-100
Set the values on the Show Path dialog box.

5. Set **Show Tool** to **Animate - 3D**, and set **Speed** to **5**.

6. Select the **Start** button. SmartCAM simulates the toolpath. You can see whether the geometry has the necessary sequence and manufacturing properties.

   Note You may change the simulation speed any time during Show Path by pressing the number keys 1-9.

7. To stop **Show Path**, press the Esc key.

Points to Remember

- ❑ Show Path verifies the sequence and toolpath before you cut parts.
- ❑ SmartCAM displays a standard tool based on your tooling selection unless you specify a CTG file for the tooling information.
- ❑ Select the Start button on the Show Path dialog box to begin displaying toolpath.
- ❑ Select ESC to stop displaying toolpath.

Using Order Path

Objectives

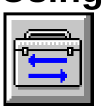
This lesson shows you how to perform these tasks:

- Chain geometry.
- Reverse the order of geometry.
- Move the profile start.
- Resequence curves.
- Optimize the order of hole operations.
- Use Step Sort.

Overview

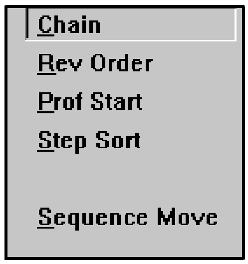
Use Order Path modeling tools to change the sequence and direction of the toolpath. You can verify that the toolpath is valid by using Order Path to order elements sequentially and in the same direction. If necessary, you can change the database sequence of the active group or sort it according to the assigned steps.

Using the Order Path Toolbox

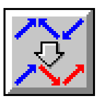


Open the Order Path toolbox by selecting the Order Path Toolbox icon or by selecting Order Path from the Edit menu. You can use the Order Path toolbox to change the order and sequence of the toolpath.

Figure 4-101
Open the Order Path toolbox.



Chaining Geometry

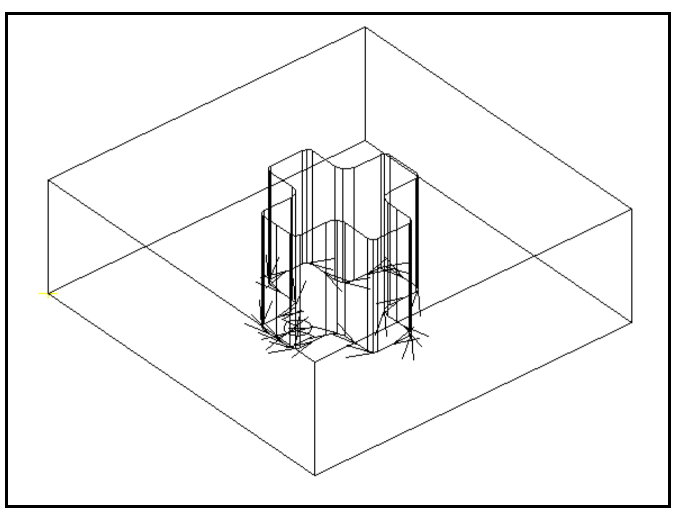


Model File: AWCHAIN.PM4

Use Chain to convert connecting elements into a contiguous profile of sequential elements so that the end point of one element is the start point of the next element. You can also join individual lines or polylines into one polyline element. Perform these tasks to chain geometry:

1. Open the model file **`AWCHAIN.PM4`**.

Figure 4-102
Open AWCHAIN.



2. Select **View—Show Path**. The **Show Path** control panel is displayed.
3. Select the **Start** button.
4. Select the **Close** button after you are finished viewing the toolpath.

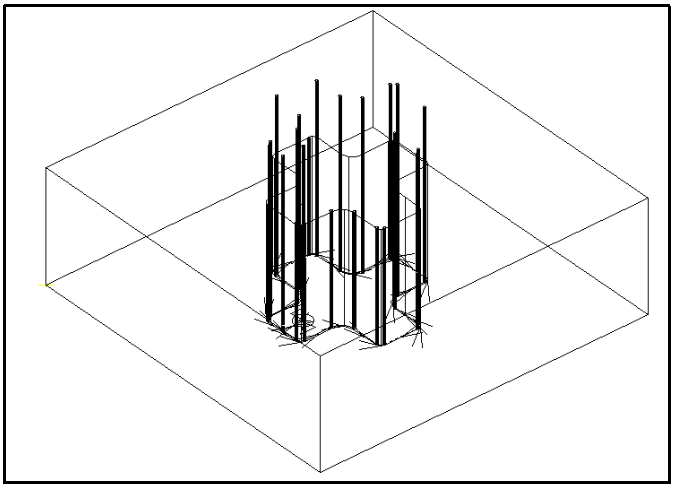


Figure 4-103
Notice the initial toolpath is out of order.

5. Select **Edit—Order Path**.
6. Select **Chain** from the toolbox. The **Chain** control panel is displayed.

Figure 4-104
Set the values on the Chain control panel.

7. Set the **Element in Profile to Chain** input field. Select any element of the profile to chain.

   Note The element you select determines the direction of the other elements. If the connected elements form a closed profile, the selected element is the starting element of the profile.

8. Set the **Chain**, **Polyline Join**, or **Both** option switch; otherwise, select the **Group Chain** button:

   - **Chain** links all elements together in one profile.
   - **Polyline Join** joins a series of lines or polylines into one polyline, decreasing the number of elements in the database.
   - **Both** creates a continuous polyline and a profile chain at the same time.
   - **Group Chain** chains selected groups.

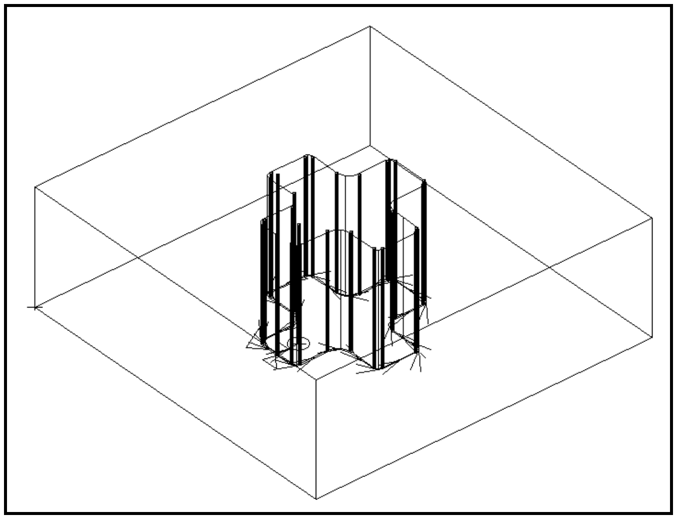
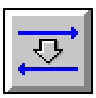


Figure 4-105 *Notice that the final toolpath is in order and does not gouge the part.*

Reversing the Order of Geometry



Model File: AWREVORD.PM4

Use Rev Order to reverse the direction or database order of a selected element, profile, or group of elements. Perform these tasks to reverse the order of geometry:

1. Open the model file **AWREVORD.PM4**.

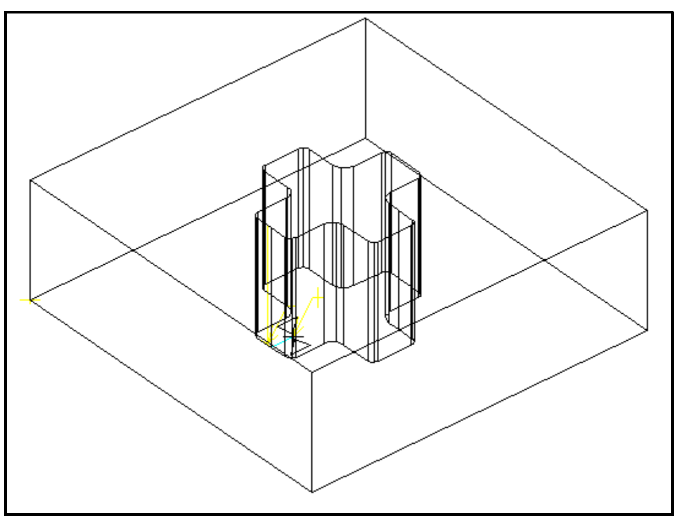


Figure 4-106 *Open AWREVORD.*

2. Select **Edit—Order Path**.
3. Select **Rev Order** from the toolbox. The **Reverse Order** control panel is displayed.

Figure 4-107 *Specify values for the Reverse Order control panel.*

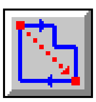
4. Set one of the following:

   - **Order and Direction** reverses the order of the elements or profiles relative to each other and the element direction of each individual element or profile.
   - **Direction Only** reverses the element direction only, leaving individual elements or profiles in the same location in the database.
   - **Order Only** reverses the order of profiles or individual elements without changing their direction.

5. Set the **Element in Profile to Reverse** input field. Select an element to reverse. To reverse an entire profile, select any element in the profile.

6. Select the **Group Reverse** button to perform the reverse order operation on the active group.

Moving Profile Start



Model File: AWPRFST.PM4

Use Prof Start to resequence a single profile so that the element you select is the first element. You can use Prof Start to position cut starts strategically at convenient locations. Perform these tasks to move the profile start:

1. Open the model file **`AWPRFST.PM4`**.

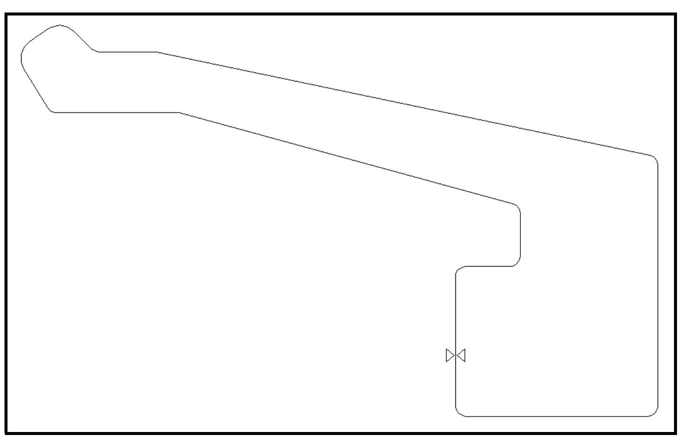


Figure 4-108 *Open AWPRFST.*

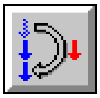
2. Select **Edit—Order Path**.

3. Select **Prof Start** from the toolbox. The **Prof Start** control panel is displayed.

Figure 4-109 Specify values on the Prof Start control panel.

4. Set the **Start Point of Start Profile Element** field to a start point.

Resequencing Curves



Model File: AWSEQMV.PM4

Use Sequence Move to change the sequence of the active group to a defined position. You can also rearrange the selected elements into the order in which they were added to the group. Use Sequence Move to place different machining events or elements into the most efficient order in the database. Perform these tasks to resequence curves:

1. Open the model file **AWSEQMV.PM4**.

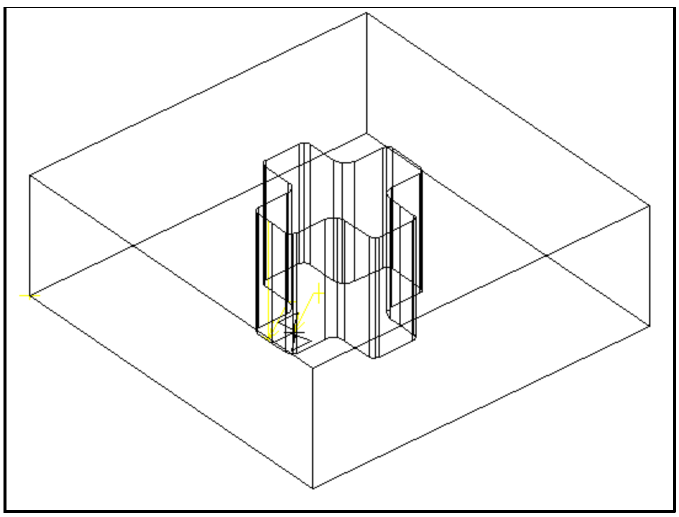


Figure 4-110 Open AWSEQMV.

2. Set the insert position where you want it in the database because Sequence Move places the newly sequenced curves at this location.

3. Select **Edit—Order Path**.

4. Select **Sequence Move** from the toolbox. The **Sequence Move** control panel is displayed.

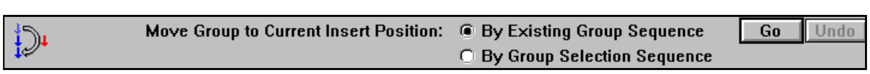


Figure 4-111 Specify values for the Sequence Move control panel.

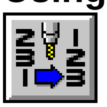
5. Group the geometry.

6. Set the **Move Group to Current Insert Position** switch to one of the following:

- **By Existing Group Sequence** moves an active group of elements to a new location in the existing sequence.
- **By Group Selection Sequence** moves an active group of elements to a new location in the order in which you select them.

7. Select the **Go** button to reorder the curves. Select the **Undo** button to undo the selection.

Using Step Sort



Model File: AWSTPSRT.PM4

Use Step Sort to resequence a group of elements or all the elements in the process model according to the steps or tools associated with them.

When you copy geometry to different locations, the order of events stays the same for each location. Use Step Sort to change the order of events so that one tool finishes all of its operations before SmartCAM indexes the next tool.

You can sort elements in the following ways:

- Sort elements associated with a step or tool.
- Sort all elements in the database according to the step order or tool order in the job operations setup.
- Sort an active group according to the step order or tool order in the job operations setup.

Perform these tasks to sort by steps:

1. Open the model file **`AWSTPSRT.PM4`**.

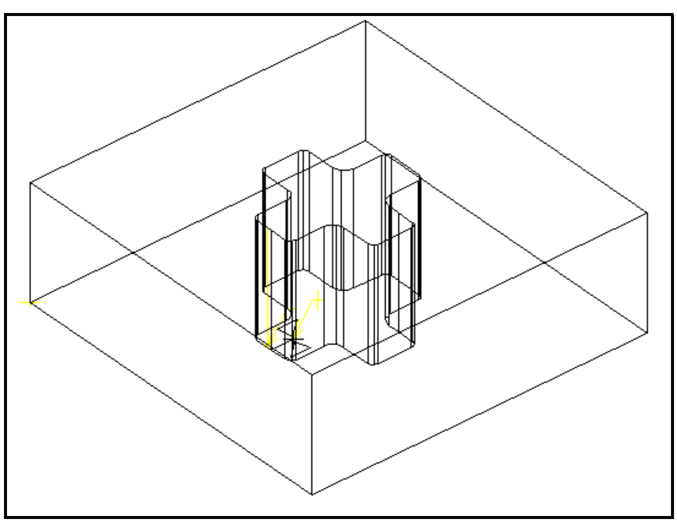


Figure 4-112 *Open AWSTPSRT.*

2. Select **Edit—Order Path**.

3. Select **Step Sort** from the toolbox. The **Step Sort** control panel is displayed.

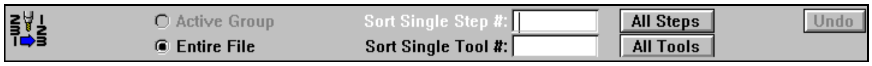


Figure 4-113 *Specify values on the Step Sort control panel.*

4. Select the **Active Group** or **Entire File** option switch.
   - **Active Group** resequences only elements in the active group.
   - **Entire File** resequences all elements in the database.

   Note Elements associated with layers will be sequenced before elements associated with steps.

5. Specify whether you want to sort one step or tool, or all steps or tools.
   - **One step or tool—**Specify a step or tool number in the **Sort Single Step #** or **Sort Single Tool #** input field. You can use the same tool in multiple steps.
   - **All steps or tools—**Select the **All Steps** or **All Tools** button. The steps or tools are sorted using the order of the tools in the job operations setup.

Points to Remember

- ❑ Use Order Path to change the sequence and direction of the toolpath.
- ❑ Use Rev Order to reverse the direction or database order of a selected element.
- ❑ Use Sequence Move to place machining events or elements in the most efficient order in the database.

Transforming Geometry

Objectives

This lesson shows you how to perform these tasks:

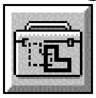
- Move geometry.
- Rotate geometry.
- Mirror geometry.
- Scale geometry.
- Show and mask geometry.

Overview

Use the Transform toolbox to change, or transform, the geometry of the active group. The Transform toolbox includes tools to move, rotate, scale, mirror, or copy a group.

Note The Transform modeling tools are not available unless there is an active group.

Using the Transform Toolbox



Open the Transform toolbox by selecting the Transform Toolbox icon or by selecting Transform from the Edit menu. Use the modeling tools in the Transform toolbox to move, rotate, mirror, project, or scale geometry elements that are in the active group.

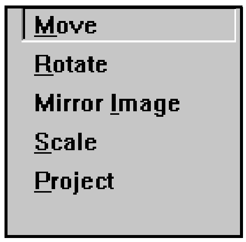
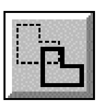


Figure 4-114
Use the Transform toolbox.

Creating Work Planes When Transforming

You can create a work plane when you rotate and mirror geometry by turning off the Suppress Plane on/off switch. The work plane you create is based on the current transformation.

Moving Geometry

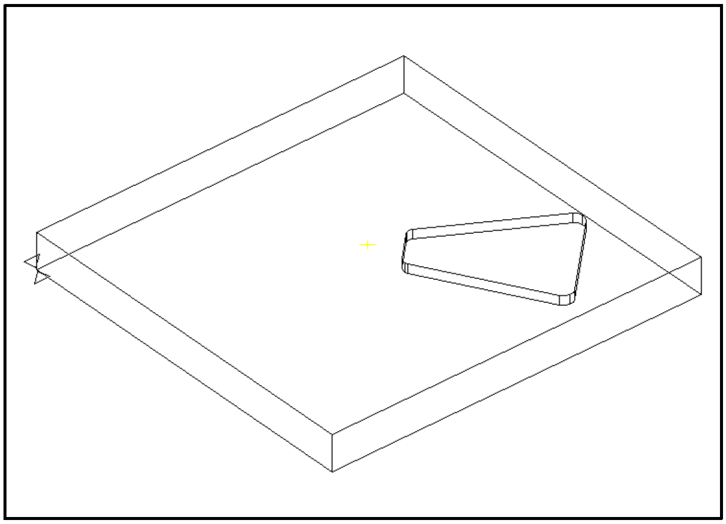


Model File: AWROTATE.PM4

Use Move to change the location of the active group or, with the Copy option, move one or more copies to new locations. You can also move an active group from the current work plane to a destination plane. Perform these tasks to move geometry:

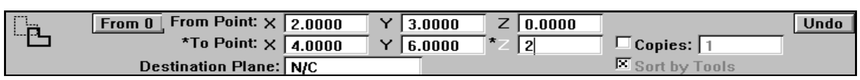
1. Open the model file **`AWROTATE.PM4`**.

Figure 4-115
Open AWROTATE.



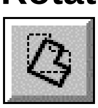
2. Group the elements to move.
3. Select **Edit—Transform**.
4. Select **Move** from the toolbox. The **Move** control panel is displayed.

Figure 4-116
Set the values on the Move control panel.



5. Set the **From Point** input fields to the point from which to move the group.
6. Set the **To Point** input fields to the location to which you are moving the group.

Rotating Geometry

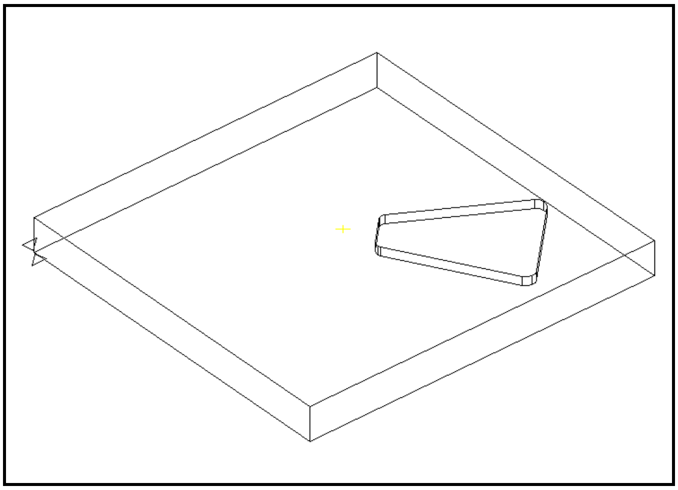


Model File: AWROTATE.PM4

Use Rotate to rotate an active group around a pivot axis on the active work plane. With the Sort by Tools option, elements are automatically sequenced and can be sorted so that all uses of each tool are grouped together to reduce tool changes. Perform these tasks to rotate geometry:

1. Open the model file **`AWROTATE.PM4`**.

Figure 4-117
Open AWROTATE.

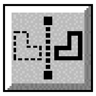


2. Group the elements to rotate.
3. Select **Edit—Transform**.
4. Select **Rotate** from the toolbox. The **Rotate** control panel is displayed.

Figure 4-118
Set the values on the Rotate control panel.

5. Turn on the **2D** or **3D** option switch:
   - **2D** pivots the active group around the specified point. The rotation is parallel to the active work plane.
   - **3D** rotates the active group around the specified three-dimensional axis.
6. Set the **Pivot Axis Point** or **Axis End Point** input fields to the location of the pivot point, as follows:
   - For **2D** rotation, this is the point around which the active group pivots.
   - For **3D** rotation, this is one end of the pivot axis. If the option switch is set to **3D**, identify the other end of the pivot axis.
7. Turn on the **Suppress Planes** on/off switch to limit creation of auto planes for two-dimensional operations and nonplanar elements for three-dimensional operations.
8. Set the **Rotation Angle** input field.
9. Select the **Go** button.

Mirroring Geometry



Model File: AWMIRROR.PM4

Use Mirror Image to create a reverse, or mirror image, of the elements in the active group. You can use this to create symmetrical parts or left- and right-handed versions of the same part.

Mirror Image reverses the toolpath direction and places the offsets on the proper side. You can maintain the same cut type for the image as for the original or you can reverse the cut type. Perform these tasks to mirror geometry:

1. Open the model file **`AWMIRROR.PM4`**.

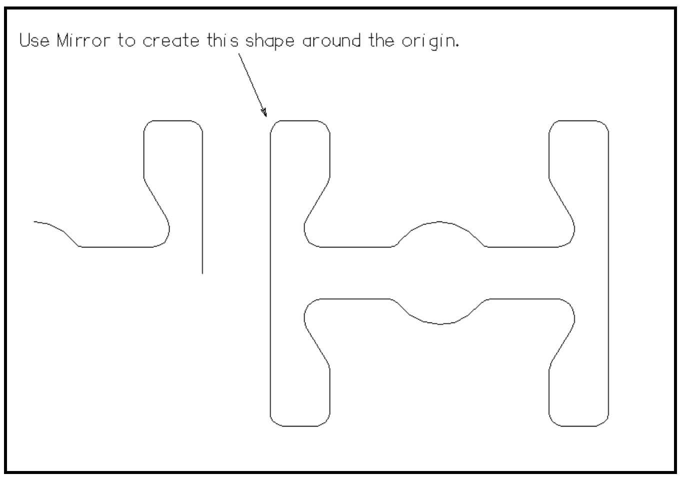


Figure 4-119 *Open AWMIRROR.*

2. Group the elements to mirror.
3. Select **Edit—Transform**.
4. Select **Mirror Image** from the toolbox. The **Mirror Image** control panel is displayed.

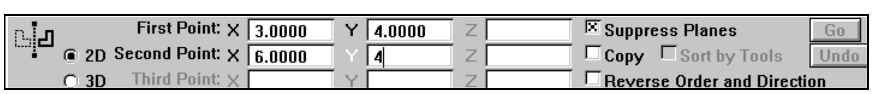
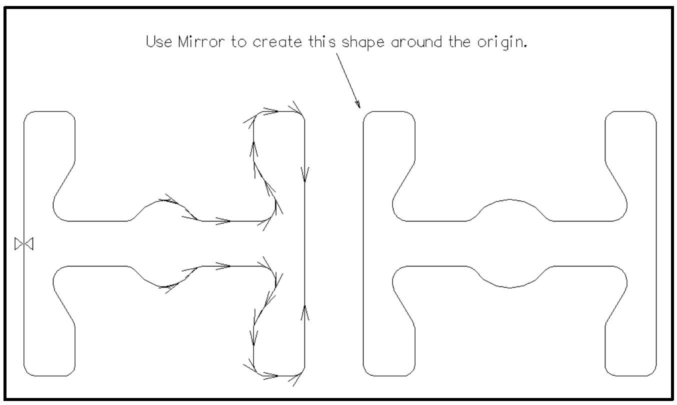


Figure 4-120 *Set the values on the Mirror Image control panel.*

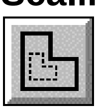
5. Turn on the **2D** or **3D** option switch:
   - **2D** creates a mirror image across a line.
   - **3D** creates a mirror image across a plane.
6. Set the **First Point** input fields to the starting point of the line along which to mirror the image.
7. Set the **Second Point** input fields to the ending point of the line along which to mirror the image.

8. Turn the **Copy** on/off switch **on** to create a copy of the original group of elements on the mirror side.
9. If **Copy** is on, turn off the **Sort by Tools** on/off switch to machine the elements in each copy independently of all other copies. Turn on this on/off switch to coordinate sequencing of the elements in all copies so that each tool completes its operation in all copies before moving to the next tool.
10. Turn on the **Reverse Order and Direction** on/off switch to create mirror-image elements that travel in the same direction as the original elements. Turn this switch off to create mirror-image elements that travel in the opposite direction.
11. Select the **Go** button.

Figure 4-121 *This is the result of mirroring the geometry.*



Scaling Geometry



Model File: AWROTATE.PM4

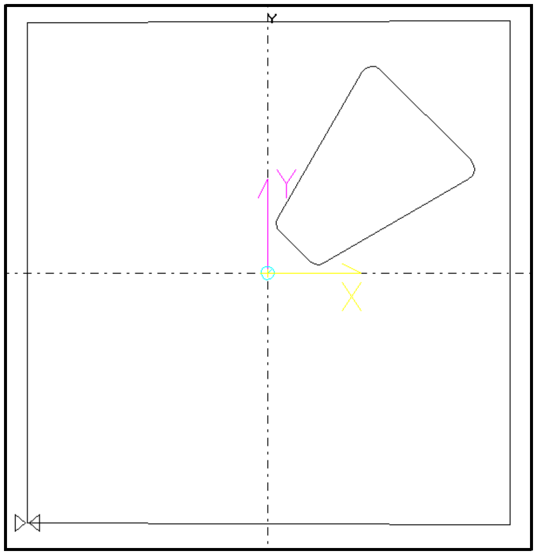
Use Scale to increase or decrease the size of a selected group. You can change the size of the elements proportionally or distort them by using different values for the X, Y, or Z axes. Scale operates relative to the XY plane.

Elements that can be scaled include holes, arcs, lines, polylines, ellipses, splines, points, and user elements. If you scale a helix nonproportionally, SmartCAM uses the larger scale factor as a radius to maintain the circular shape. You cannot scale dimensioned text.

Scale is often used to allow for shrinkage or expansion factors and scale conversions. Scale changes the size of elements in the database and the corresponding machine code. Perform these tasks to scale geometry:

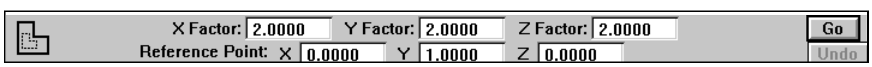
1. Open the model file **`AWROTATE.PM4`**.

Figure 4-122
Open AWROTATE.



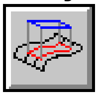
2. Group the elements to scale.
3. Select **Edit—Transform**.
4. Select **Scale** from the toolbox. The **Scale** control panel is displayed.

Figure 4-123
Set the values on the Scale control panel.



5. Set the following fields on the control panel:
   - Set the **X Factor** input field to the value by which to alter the size of the group of elements along the world X axis.
   - Set the **Y Factor** input field to the value by which to alter the size of the group of elements along the world Y axis.
   - Set the **Z Factor** input field to the value by which to alter the size of the group of elements along the world Z axis.
   - Set the **Reference Point** input fields to the value from which the scaling operation occurs. This is the only point in the scaled group that does not change.
6. Select the **Go** button.

Projecting Geometry



Use Project to project an image of the active group of planar elements to a plane. With Project you can create toolpath or layer geometry on planes that are parallel to or oblique to the work plane. Projecting is similar to shining a light across the existing geometry in the direction of the active work plane's Z axis and casting the shadow on the defined projection plane. The shadow becomes the new geometry, and SmartCAM assigns it to an auto work plane.

Ensure that the elements are in the active group. SmartCAM places the projected geometry in the database location you specify in the Insert property bar. The properties and database location of the original geometry in the active group remain unchanged.

Perform these tasks to project geometry:

1. Group the geometry to project.
2. Set the insert location:
   - Set the **Before** icon on the Insert property bar.
   - Select the **Element** icon on the Insert property bar.
   - Select the element to be before or after in the list view.
   - Select the **With Step** icon and select a thread step from the list view.
   - Set the **Work Plane** direction. The projection will be parallel to this direction.
3. Select **Edit—Transform**.
4. Select **Project** from the toolbox. The **Project** control panel is displayed.

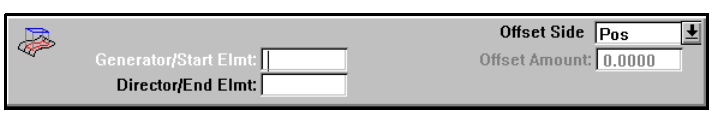


Figure 4-124 *Set the values on the Project control panel.*

5. Set the **Generator** input field to the starting element on the generator profile.
6. Set the **Director** input field to the ending element on the director profile.
7. Set the **Offset Side** selector switch, and select the side of the surface to offset the projection. This input field has no affect on tool offset.
8. Select the **Offset Amount** input field to the distance you want the projection offset from the surface. This field is active only when **Offset Side** is set to **Pos** or **Neg**.
9. Select the **Go** button. The projection is completed.

Points to Remember

- Transforming tools are not available unless there is an active group.
- Use Move to change the location of the active group.
- Use Rotate to rotate an active group around a pivot axis on the active work plane.
- Mirror Image reverses the toolpath directions and places the offsets on the proper side. You can maintain the same cut type for the image as for the original or you can reverse the cut type.
- Use Scale to increase or decrease the size of a selected group.
- Use Scale for unit conversions.
- SmartCAM does not display masked elements, so you cannot select or code them.
- Masked elements are not deleted from the database.
- Press F8 to instantly identify masked elements.

Importing a CAD File

Objectives

This lesson shows you how to bring a CAD file into SmartCAM.

Overview

Import transfers the geometry contained in DXF, DWG, VDA-FS, and IGES files into a SmartCAM process model file (.pm4).

The quality and reliability of the data transfer improves when you select only the geometry you need and appropriate conversion options from the CAD system before importing the CAD file.

Using Import

A CNC process model is created using either inch or metric units, and it consists of a .pm4 file and a .jof file. The .pm4 file holds the geometry while the .jof file specifies all the tooling and operation information. Every time you save a CNC process model, these files are saved as a pair.

The unit setting establishes the units for everything relating to the model, including the job tooling. SmartCAM does not support inch and metric units in the same model. When you are ready to import a file, determine the units of both the file being imported and the .jof file in the process model. How you import the geometry depends on whether these two file units are the same or different.

You can import in these ways:

- Import into a model file that has the same units.
- Import into a model file that has different units, and adopt the units of the existing file.
- Import into a model file that has different units, and adopt the units of the incoming file.

Importing into a Model with the Same Units

Perform these tasks to import a CAD file into a new or existing model that has the same units:

1. If you are importing into a new file, set the units in the new file to match the units of the file to import. If you are importing into an existing file, proceed to step 2.
2. Select **File—Import**. The **Import** dialog box is displayed.

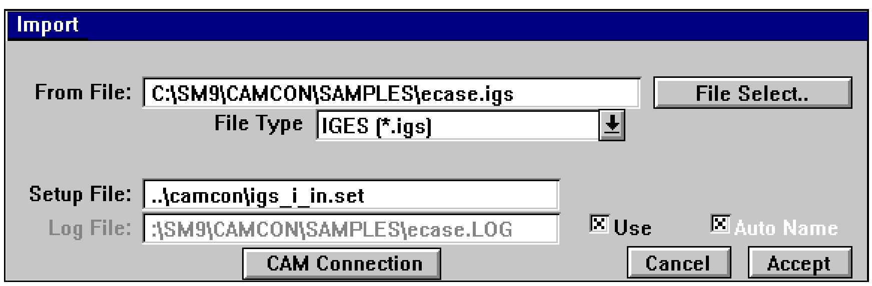


Figure 4-125
Open the Import dialog box.

3. Set the **File Type** selector switch.
4. Enter the path and name of the file to import in the **From File** input field, or use the **File Select** button to specify the path and name of the file.
5. Enter the name of the setup file used with the file type of the imported file in the **Setup File** input field. Generally, there is a separate setup file for each file type. In most cases, the setup file is automatically inserted when the file type is selected. You can also use a customized setup file.
6. Turn on the **Use** on/off switch if you want to create a log file.

   Note Leave this switch off unless you have problems importing the file because log files are typically very large.

7. Name the log file or have SmartCAM name it for you.
   - To name the log file, enter the name of the log file to create in the **Log File** input field.
   - To have SmartCAM name the log file, turn on the **Auto Name** on/off switch. (You must have turned on the **Use** on/off switch.)
8. Select **Accept** to load the file.

Importing and Adopting the Existing Model File's Units

Perform these tasks to import a CAD file into a new or existing model that has different units:

1. Open the model file that you want to import the CAD file into.
2. Complete steps 2 through 8 of *Importing into a Model with the Same Units,* on page 4-80.
3. Select the **Name Group** icon from the **Group** tool palette.
4. Select the **Result** group.
5. Select **Edit—Transform—Scale**.
6. Specify the appropriate scale factor.
   - To change from inch to metric, multiply by **25.4**.
   - To change from metric to inch, multiply by **.03937**.
7. After the import, assign tools and operations to the geometry.
8. Verify the model using **Show Path** or **Element Data**.

Importing and Adopting the Incoming Model File's Units

1. Open the model file that you want to import the CAD file into.
2. Complete steps 2 through 8 of *Importing into a Model with the Same Units,* on page 4-80.
3. Select **File—Load Job File**.
4. Use the **File Select** button, which opens the **Open** dialog box, and browse for the `.jof` file that you want to use to load your steps.

   Note When you load a `.jof` file, the units setting in the existing model is changed to the units of the newly loaded `.jof` file, regardless of the units set in Utility—System Units.
5. Select the **Name Group** icon from the **Group** tool palette.
6. Select the **Result** group.
7. Select **Edit—Transform—Scale**.
8. Specify the appropriate scale factor.
   - To change from inch to metric, multiply by **25.4**.
   - To change from metric to inch, multiply by **.03937**.
9. After the import, assign tools and operations to the geometry.
10. Verify the model using **Show Path** or **Element Data**.

Points to Remember

- The quality and reliability of the data transfer improves when you select only the geometry you need and appropriate conversion options from the CAD system before importing the CAD file.
- SmartCAM does not support inch and metric units in the same model.
- When you are ready to import a file, determine the units of both the file being imported and the .jof file in the process model. How you import the geometry depends on whether these two file units are the same or different.
- You can import in these ways:
  - Import into a model file that has the same units.
  - Import into a model file that has different units, and adopt the units of the existing file.
  - Import into a model file that has different units, and adopt the units of the incoming file.
- If you are importing into a new file, set the units in the new file to match the units of the file to import.

Exporting a SmartCAM File

Objectives

This lesson shows you how to convert the elements in an existing SmartCAM process model to a DXF (.dxf), DWG (.dwg), VDA-FS (.vda), or an IGES (.igs) file.

Overview

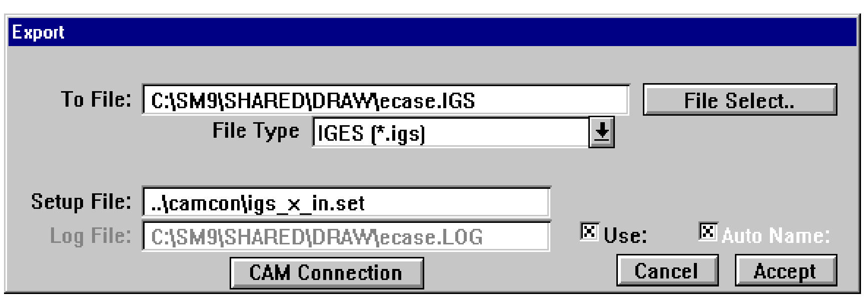
The quality and reliability of the data transfer improves when you select only the geometry you need and appropriate conversion options before exporting the SmartCAM process model.

Using Export

Perform these tasks to export a SmartCAM process model to a CAD file:

1. Select **File—Export**. The **Export** dialog box is displayed.

Figure 4-126
Open the Export dialog box.



2. Set the **File Type** selector switch.

3. Enter the path and name of the file to export in the **To File** input field, or use the **File Select** button to specify the path and name of the file.

4. Confirm the name of the setup file used with the file type of the exported file in the **Setup File** input field. Generally, there is a separate setup file for each file type. In most cases, the setup file is automatically inserted when the file type is selected. You can also create a customized setup file. If the selected file type does not require a setup file, this input field is dim.
5. Turn on the **Use** on/off switch if you want to create a log file.
6. Name the log file or have SmartCAM name it for you.
   - To name the log file, enter the name of the log file to create in the **Log File** input field.
   - To have SmartCAM name the log file, turn on the **Auto Name** on/off switch. (You must have turned on the **Use** on/off switch.)
7. Select **Accept** to export the file. When the export is complete, the window displays a *Done* message, and the status and export windows are automatically closed.

Points to Remember

- You can export SmartCAM process model files to a DXF (.dxf), DWG (.dwg), or an IGES (.igs) file.
- The quality and reliability of the data transfer improve when you select only the geometry you need and appropriate conversion options before exporting the SmartCAM process model.

Self-Test

Directions

Test your understanding of the concepts and procedures in this section by answering the following questions. The answers for each self-test are in *Appendix A* of this manual.

_______________ **1. What do you need to do before creating new geometry?**

a) Identify the insert location.
b) Identify the properties for the geometry.
c) both a and b
d) neither a nor b

_______________ **2. Associating geometry with a step will result in code.**

a) true
b) false

_______________ **3. Associating geometry with a layer will result in code.**

a) true
b) false

_______________ **4. How many elements in a model can you view modeling data for?**

a) 0
b) 1
c) 2
d) as many as you want

_______________ **5. Viewing element data affects the geometry database.**

a) true
b) false

______________ **6. Viewing element data affects the geometry database.**

a) true
b) false

______________ **7. Changing the color of elements:**

a) never affects code generation
b) rarely affects code generation
c) usually affects code generation
d) always affects code generation

______________ **8. Elements to be trimmed or extended should be on different work planes.**

a) true
b) false

______________ **9. How many groups does trimming by group impact?**

a) 0
b) 1
c) 2
d) as many as you want

______________ **10. How many deleted groups can be recovered with the Undo button?**

a) 0
b) 1
c) 2
d) as many as you want

5

Generating Toolpath/ Verifying 4-Axis Toolpath

Objectives

These lessons show you how to perform Rough machining to generate toolpath.Use Viewsurf to verify 4-axis toolpath.

Lessons for This Unit

- Generating Toolpath
- Verifying 4-Axis Toolpath

Generating Toolpath

Objectives

This lesson shows you how to perform these tasks:

- Use Nocore to generate a continuous toolpath that removes all the material within a boundary without any scrap pieces.
- Create links between two defining profiles.
- Modify links between two defining profiles.
- Remove links between two defining profiles.

Overview

Use the Process menu to generate toolpath for roughing an area, generate CNC code, and access optional functions you have purchased.

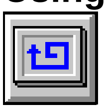
Figure 5-1
Use the Process menu.

Using the Rough Toolbox

Use the Rough toolbox to generate continuous toolpath that removes all the material within a boundary without any scrap pieces.

Figure 5-2
Create roughing toolpath with the Rough toolbox.

Using Nocore



Model File: AWCROSS.PM4

This type of roughing process is helpful for operations in which falling scrap can jam the machine or wire.

Note To use Nocore, you must have a hole inside of a closed boundary area from which the roughing passes can start.

Follow these steps to use nocore:

1. Open the model file **AWCROSS.PM4**.

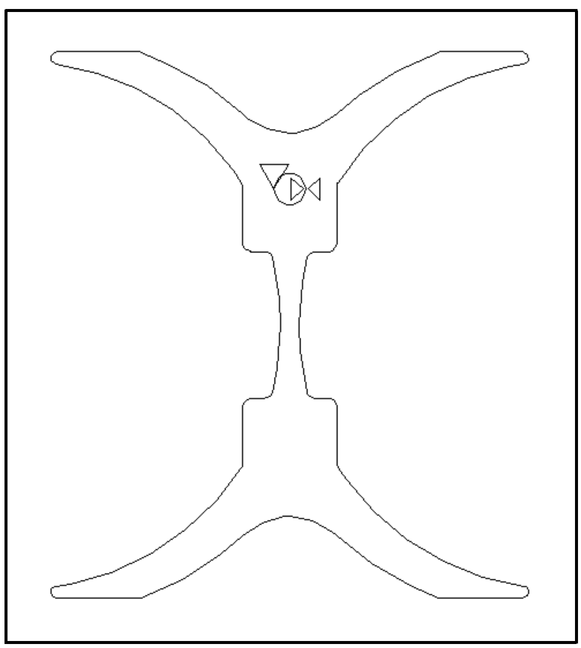
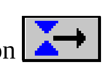
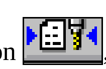


Figure 5-3
Open AWCROSS.

2. Set the insert location.

■ Set the **Before** icon , and select an element for the new element to come before.

■ Set the **With Step** icon , and select the step number to use.

■ Set the **C** (Clear) input field.

■ Set the **P** (Profile Top) input field to **1**.

3. Select **Process—Rough**.
4. Select **Nocore** from the toolbox. The **Nocore** control panel is displayed.

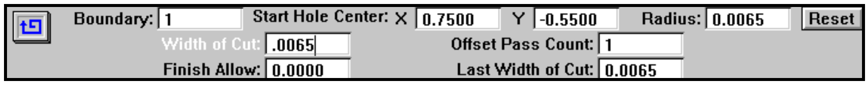


Figure 5-4
Set the values on the Nocore control panel.

5. Select the **Boundary** input field, and select an element in the closed profile.
6. Set the **Start Hole Center** input fields. Make sure this point is far enough inside the boundary profile that the roughing passes will not violate the finish profile.
7. Set the other parameters as needed.
8. This is an automatically triggered control panel. When SmartCAM has enough information to perform the operation, it will launch the Nocore operation.

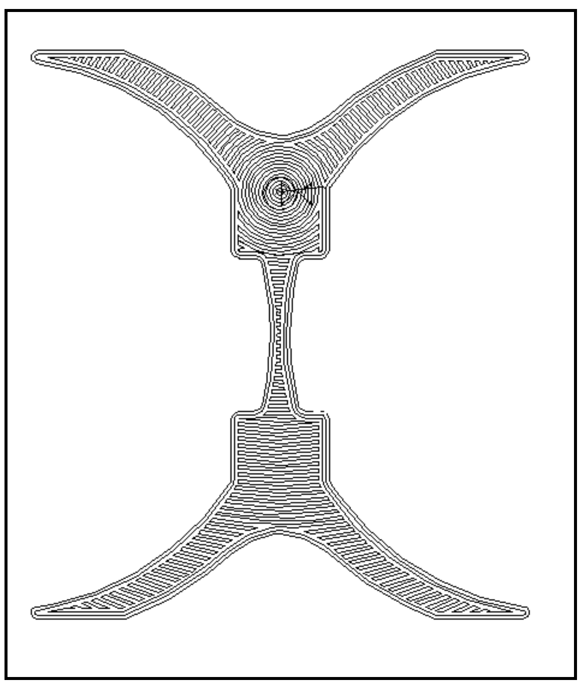
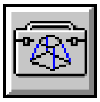


Figure 5-5
This is a result of Nocore roughing.

Using the 4-Axis Toolbox



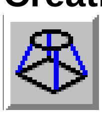
The 4-Axis toolbox has modeling tools that enable you to create toolpath for 4-axis wire applications. The surface representation consists of boundaries for the primary and secondary profiles.

When you create links between these two profiles, you control when the wire transitions from one angle to the next. You can then use links to modify the surface between the boundaries.

Note Use Viewsurf to display a simulation of the surface. Then create, modify, or remove links, and use Viewsurf again to see the results. Repeat these steps until you obtain the results that you desire.

Figure 5-6
Create roughing toolpaths with the 4-Axis toolbox.

Creating Links



Model File: CRLINKS.PM4

Use Createlinks to establish links between two defining profiles. You can create links between individual elements or between ranges of profile elements. Links control the wire's inclination as it moves along the bottom (primary) and top (secondary) defining profiles.

Createlinks automatically creates a link between the start of the first profile element and the start of the second profile element. It continues along both profiles, adding links when a new element occurs on both profiles. When you select the Element option, Createlinks places a link between the starts of the elements you identify.

Use links to connect the primary and secondary profiles to semi-independently influence the rate of wire advance at each boundary profile. Links enable you to modify the boundaries considered for proportional spaces. Because the wire advances between links along the primary and secondary profiles at rates that are proportional, placing links at points of your choosing enables you to control the wire inclination very closely. This is useful in fine-tuning the toolpath so that the machined surface is how you want it to be.

Note To use Createlinks, you must have an active layer.

Perform these tasks to pocket multiple areas:

1. Open the model file **`CRLINKS.PM4`**.

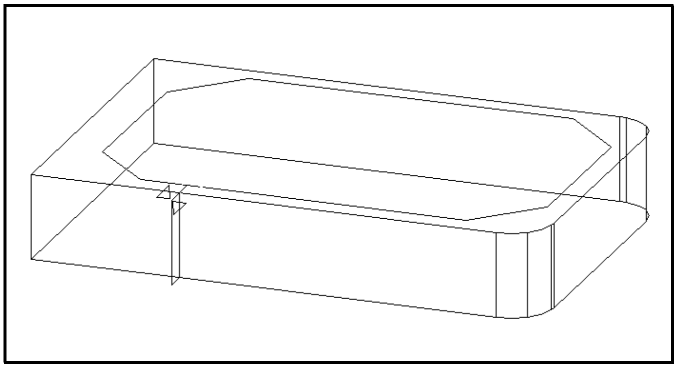
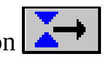
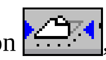


Figure 5-7
Open CRLINKS. (a view of the model with thickness turned on in Display Modes.)

2. Set the insert location:
   - Set the **Before** icon , and select an element for the new element to come before.
   - Set the **On Layer** icon , and select **Layer 2**.
   - Set the **P** (Profile Top) input field to **1**.
3. Select **Process—4Axis**.
4. Select **Createlinks** from the toolbox. The **Createlinks** control panel is displayed.

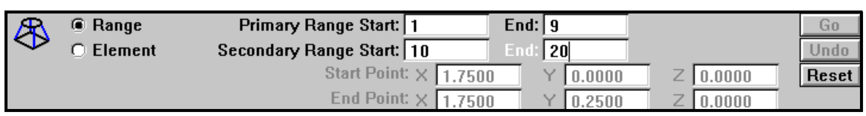


Figure 5-8
Set the values on the Createlinks control panel.

5. Specify where to create a link using the **Range** option switch.
6. Set the **Primary Range Start** input field to **1**, and the **End** input field to **9**.
7. Set the **Secondary Range Start** input field to **10**, and the **End** input field to **20**.
8. Select the **Go** button to start the operation.

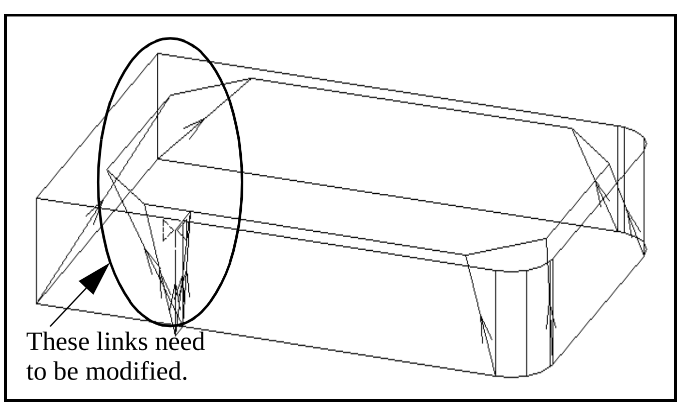
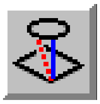


Figure 5-9
This is the result of creating links.

9. Keep this model file open, and use it to practice modifying links.

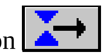
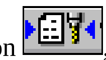
Modifying Links



Model File: CRLINKS.PM4

Use Modifylinks to change the start and end points of links between elements.

Perform these tasks to modify links in the part that you just used to create links:

1. Set the insert location:
   - Set the **Before** icon , and select an element for the new element to come before.
   - Set the **With Step** icon , and set the step number to **3**.
   - Set the **C** (Clear) input field.
   - Set the **P** (Profile Top) input field to **1**.
2. Select **Process—4Axis**.
3. Select **Modifylinks** from the toolbox. The **Modifylinks** control panel is displayed.

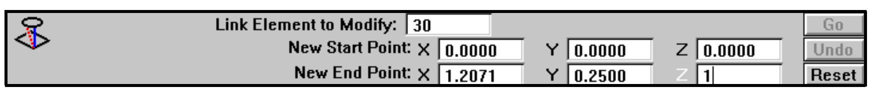
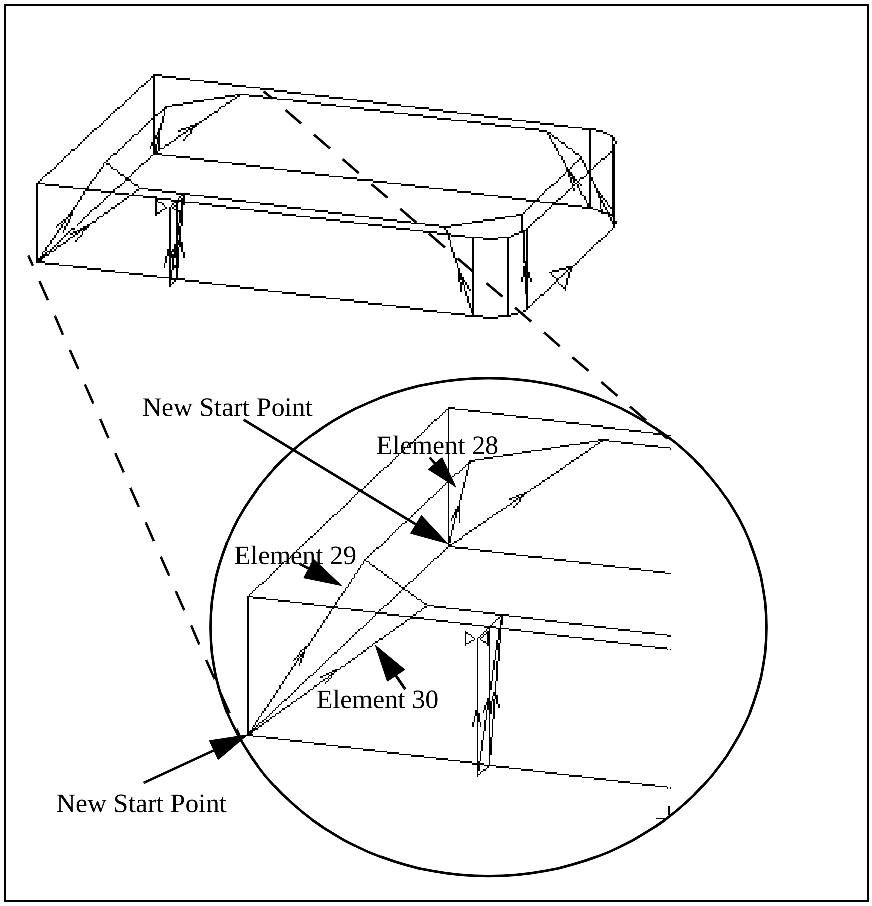


Figure 5-10 *Set the values on the Modifylinks control panel.*

4. Set the **Link Element to Modify** input field to **28**, and set the **New Start Point** and **New End Point** fields for it. See Figure 5-11.

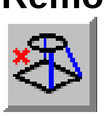
   Note A dashed line is displayed to show the pending link position.
5. Select the **Go** button to accept the new link position.
6. Repeat steps 3 and 4 for elements **29** and **30**.

Figure 5-11
This is the result of modifying links.



7. Keep this model file open, and use it to practice removing links.

Removing Links



Model File: CRLINKS.PM4

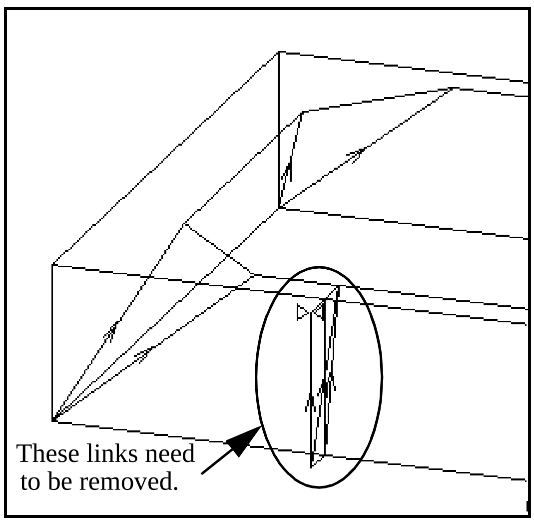
Use Removelinks to delete a link or a range of links from between two profiles. A link must be in the active group for you to remove it. The built-in intelligence of Removelinks eliminates the chance of accidental deletion of profile elements or other model elements. (Links control the wire inclination between the primary and secondary profiles at various points along the profiles.)

Even though you can remove link elements from the database by using the Delete modeling tool, Removelinks offers these advantages to that process:

- Removes only link elements from the database. This is extremely helpful when you want to remove links from an entire range of defining profile elements.
- Enables SmartCAM to complete the range values for the Removelinks control panel with the values you entered when using Createlinks. This means that if you create a set of links for the primary and secondary profiles and then find they are not acceptable, you can quickly delete them from the range of profile elements.

Perform these tasks to remove links in the part that you just used to create and modify links:

Figure 5-12 *Remove these links.*



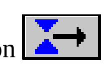
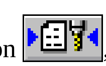
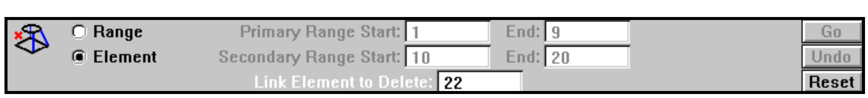
1. Group the elements **21, 22,** and **31**, which are the links to delete.
2. Set the insert location:
   - Set the **Before** icon , and select an element for the new element to come before.
   - Set the **With Step** icon , and select the step number to use.
   - Set the **C** (Clear) input field.
3. Select **Process—4Axis**.
4. Select **Removelinks** from the toolbox. The **Removelinks** control panel is displayed.

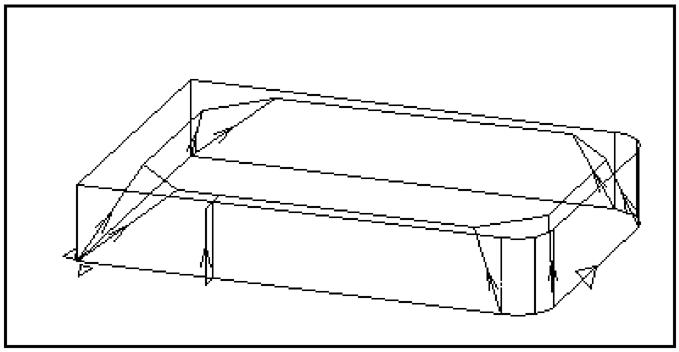
Figure 5-13 *Complete the Removelinks control panel.*



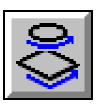
5. Specify removal of a link element using the **Element** option switch.

6. Set the **Link Element to Delete** input field to **31**.
7. Select the **Go** button.
8. Set the **Link Element to Delete** input field to **22**.
9. Select the **Go** button.
10. Set the **Link Element to Delete** input field to **21**.
11. Select the **Go** button.

Figure 5-14
This is the result of removing links.



Creating 4-Axis Toolpath



Model File: HANDLE.PM4

In this procedure, you create an additional profile between the primary and secondary profiles. In the first part of the procedure, the tops of the vectors for the 5-axis polyline extend only halfway to the secondary (top) defining profile. In the second part of the procedure, the vectors extend to the secondary profile.

Note Before using this modeling tool, make sure your profiles and links are suitable for the surface to machine. Use the Viewsurf option with the other 4-Axis modeling tools to preview the resulting surface. For the 5-axis polyline that 4axisPath creates to display the correct toolpath with Show Path and generate the correct code, it must have lead-in and lead-out lines at the start and end of the polyline.

Perform these tasks to create 4-axis toolpath for the lower half of the model:

1. Open the model file **`HANDLE.PM4`**.

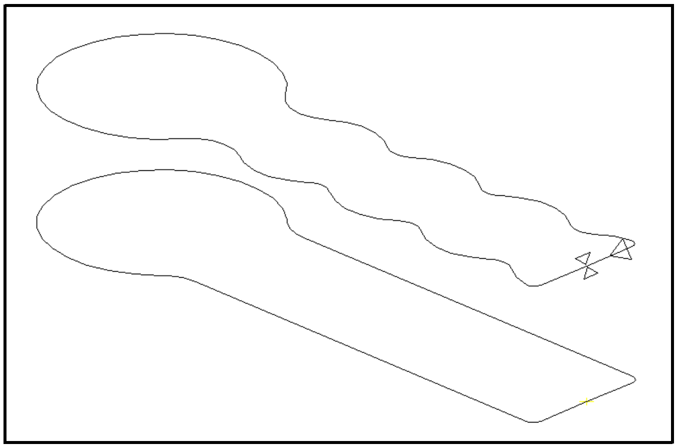


Figure 5-15
Open HANDLE.

2. Set the insert location:
   - Set the **After** icon, indicating that the new element comes after the specified element.
   - Select the **Element** icon.
   - Set the **After Element** input field to **32**.
   - Set the **With Step** icon, and set the **With Step** input field to **2**.
   - Select the **No Offset** icon.
   - Set the **L** (Level) input field to **0.0**.
   - Set the **P** (Profile Top) on/off switch, and enter **.75 [19.05]**. This setting controls the height of the 5-axis polyline vectors. It must be turned off if you plan to use the upper profile to indicate that height. In this instance, it is set to half the height of the secondary profile.
3. Select **Process—4Axis—4axisPath**. The **4axisPath** control panel is displayed.

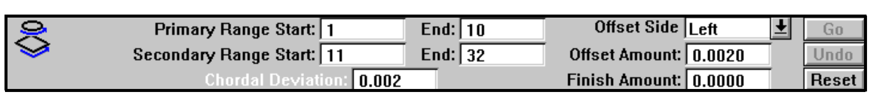


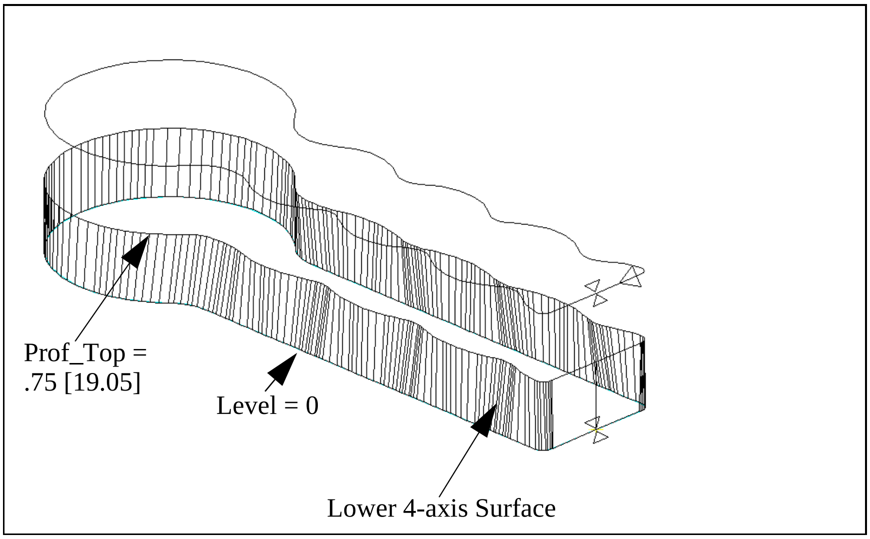
Figure 5-16
Set the values on the 4axisPath control panel.

4. Set these values on the **4axisPath** control panel:
   - Set the **Primary Range Start** input field to **1**, and set the **End** input field to **10**.
   - Set the **Secondary Range Start** input field to **11**, and set the **End** input field to **32**.
   - Set the **Offset Side** selector switch to **Left**.
   - Set the **Offset Amount** input field to **.002 [.05]**.
   - Set the **Chordal Deviation** input field to **.002 [.05]**.
   - Set the **Finish Amount** input field to **0.0**.

5. Select the **Go** button. SmartCAM creates the 5-axis polyline element for the 4-axis toolpath. The tops of the vectors extend only halfway to the top defining profile. This is because of the Prof Top setting of **.75 [19.05]** that you entered in step 2.

   Note Make sure that the **Thickness** on/off switch is turned on in the **Display Modes** dialog box.

Figure 5-17
Notice the lower half of the surface.



Perform these tasks to create a second 4-axis toolpath for the upper part of the model:

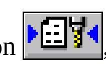
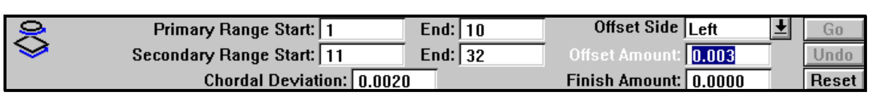
1. Set the insert location:
   - Set the **With Step** icon , and set the **With Step** input field to **3**.
   - Set the **L** (Level) input field to **.75 [19.05]**.
   - Set the **P** (Profile Top) input field to **1.5 [38.11]**. This setting controls the height of the 5-axis polyline vectors. It must be turned off if you plan to use the upper profile to indicate that height. In this instance, it is set to the height of the secondary profile going from .75 up to 1.5.
2. Select **Process—4Axis—4axisPath**. The **4axisPath** control panel is displayed.

Figure 5-18
Set the values on the 4axisPath control panel.



3. Set these values on the **4axisPath** control panel:
   - Set the **Primary Range Start** input field to **1**, and set the **End** input field to **10**.
   - Set the **Secondary Range Start** input field to **11**, and set the **End** input field to **32**.
   - Set the **Offset Side** selector switch to **Left**.

- Set the **Offset Amount** input field to **.003 [.08]**.
- Set the **Chordal Deviation** input field to **.002 [.05]**.
- Set the **Finish Amount** input field to **0.0**.

4. Select the **Go** button. SmartCAM creates another 5-axis polyline at the new level and limits the vector height to **1.5 [38.1]** above the active work plane. Remember that Level and Prof_Top values are based on the active work plane.

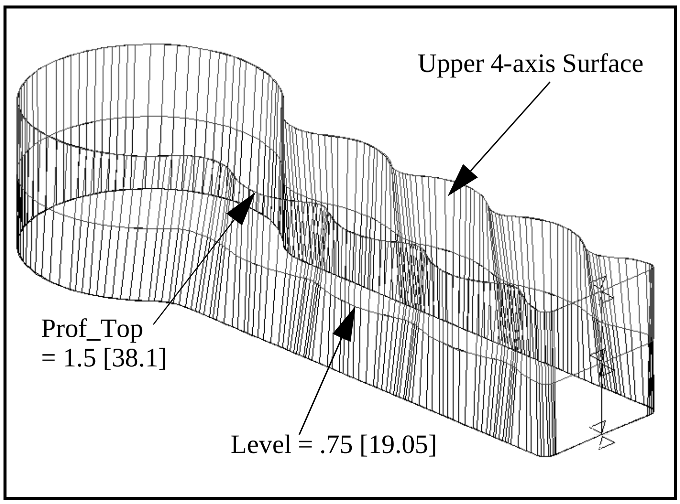


Figure 5-19
Notice the top half of the surface.

Perform these tasks to add lead-in and lead-out moves to the toolpath:

1. Select **Edit—Geo Edit**.
2. Select **Lead In/Out** from the toolbox. The **Lead In/Out** control panel is displayed.

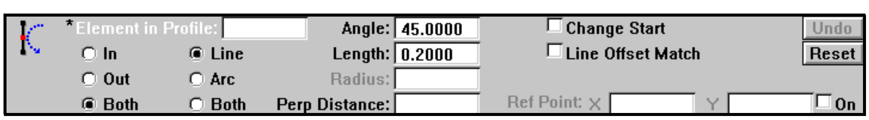


Figure 5-20
Set the values on the Lead In/ Out control panel.

3. Set these values on the **Lead In/out** control panel:
   - Turn on the **Both** option switch.
   - Turn on the **Line** option switch.
   - Set the **Angle** input field to **45**.
   - Set the **Length** input field to **.2 [5]**.
   - Select the **Element in Profile** input field, and select the lower 4-axis surface by selecting the first Poly5x element in the list view.
   - Select the **Element in Profile** input field, and select the upper 4-axis surface by selecting the second Poly5x element in the list view.

4. Select **View—Show Path**. The **Show Path** dialog box is displayed.
5. Select the **Start** button. The wire advances along the toolpath and adjusts to cut the surface you defined.

Points to Remember

- To use Nocore, you must have a hole inside of a closed boundary area from which the roughing passes can start.
- Links control the wire's inclination as it moves along the bottom (primary) and top (secondary) defining profiles.
- Use Modifylinks to change the start and end points of links between elements.
- A link must be in the active group for you to remove it in a range.
- For the 5-axis polyline that 4axisPath creates to display the correct toolpath with Show Path and generate the correct code, it must have lead-in and lead-out lines at the start and end of the polyline.

Verifying 4-Axis Toolpath

Objectives

This lesson shows you how to verify the 4-axis toolpath using Viewsurf.

Overview

Use Viewsurf to display a simulation of the surface to be created by the wire with a correctly offset toolpath. Viewsurf builds a temporary ruled surface on the graphic display between the primary and secondary profiles using the links in the active group.

Note SmartCAM only uses links that touch both profiles and are in the active group.

Using Viewsurf

Model File: HANDLE.PM4

Perform these tasks to view a surface:

1. Open the model file **`HANDLE.PM4`**.

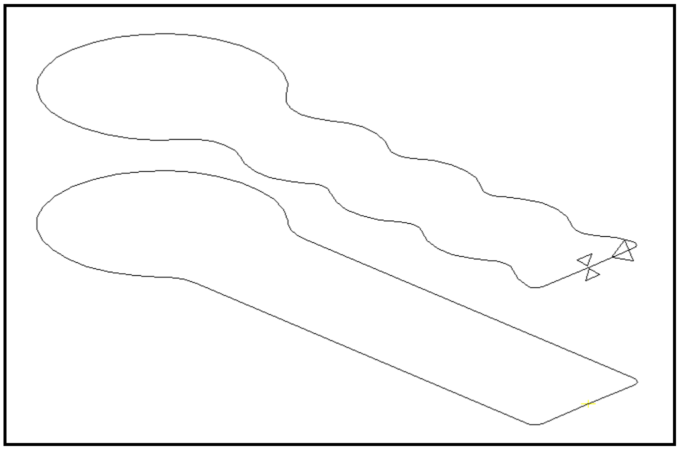
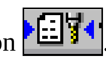


Figure 5-21
Open HANDLE.

2. Set the insert location:
   - Set the **With Step** icon .
   - Select step **1**.
3. Select **Process—4Axis**.
4. Select the **Viewsurf** button from the toolbox. The **Viewsurf** dialog box is displayed.

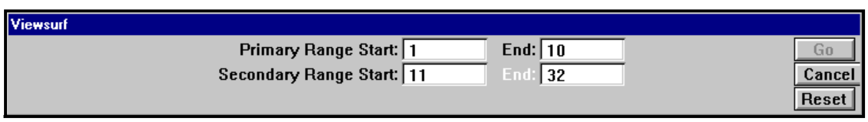


Figure 5-22
Set the values on the Viewsurf dialog box.

5. Set the **Primary Range Start** and **End** input fields to identify the first (**1**) and last elements (**10**) in the primary profile.
6. Set the **Secondary Range Start** and **End** input fields to identify the first (**11**) and last (**32**) elements in the secondary profile.
7. Select the **Go** button to start the operation.

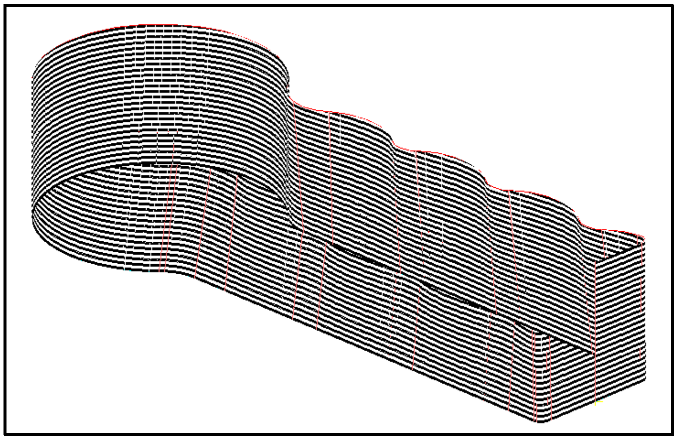


Figure 5-23
This is the result of using Viewsurf.

8. Select **View—Redraw** to restore the view of the model without the temporary surface.

Points to Remember

- ❑ Viewsurf builds a temporary ruled surface on the graphic display between the primary and secondary profiles using the links in the active group.
- ❑ Select View—Redraw to restore the view of the model without the temporary surface.

Self-Test

Directions

Test your understanding of the concepts and procedures in this section by answering the following questions. The answers for each self-test are in *Appendix A* of this manual.

_______________ **1. What is needed to use Nocore?**

a) A hole outside of an open boundary.
b) A hole inside of an open boundary.
c) A hole inside of a closed boundary.
d) A hole outside of a closed boundary.

_______________ **2. What controls the wire's inclination as it moves along the bottom and top defining profiles?**

a) Holes
b) Profiles
c) Boundaries
d) Links

_______________ **3. You can change only the start point of links between elements with Modifylinks.**

a) true
b) false

_______________ **4. What condition must a link meet for you to remove it for a range?**

a) It must be in the active group.
b) It must be parallel to the work plane.
c) It must have a hole through it.
d) It must have been modified.

_______________ **5. What type of surface does Viewsurf build?**

a) Permanent
b) Solid
c) both of the above
d) none of the above

6

Generating Code

Overview

SmartCAM generates NC code for various CNC machine and controller operations using the Code feature.

Lessons for This Unit

- Generating Code

Generating Code

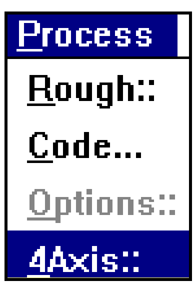
Objectives

This lesson shows you how to code a file.

Overview

Use the Code feature to generate NC code for the part and to estimate the total cycle time. SmartCAM generates code for all unmasked step-property elements in the database.

Figure 6-1
Use the Process menu to generate code.



Learning File Types for Code Generation

Code is generated from the process model as an ASCII text file (`.txt`) that can be viewed using any text editor. Edit Plus is the text editor that is shipped with SmartCAM. SmartCAM uses machine definition (`.smf`) and template (`.tmp`) files to generate code. You can find more information about .smf files and .tmp files in the *Code Generation Guide*, which is distributed online.

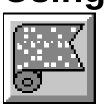
Machine Definition Files

Machine definition, or `.smf`, files contain information for the machine tool, including information on your machine tool configuration, the G and M codes it uses, and numeric formats. You must specify an **`.smf`** file for the tool.

Template Files

Template (**`.tmp`**) files contain variables and if /then statements that are used to format the code so that the controller can read it. You must specify a **`.tmp`** file for each `.smf` file that you define.

Using Code



Model File: AWSKIM3.PM4

Use Code to generate the CNC code for your part and estimate the total cycle time. SmartCAM generates code for all unmasked step property elements in the database. Code is generated as a text file that you can view and edit using a text editor.

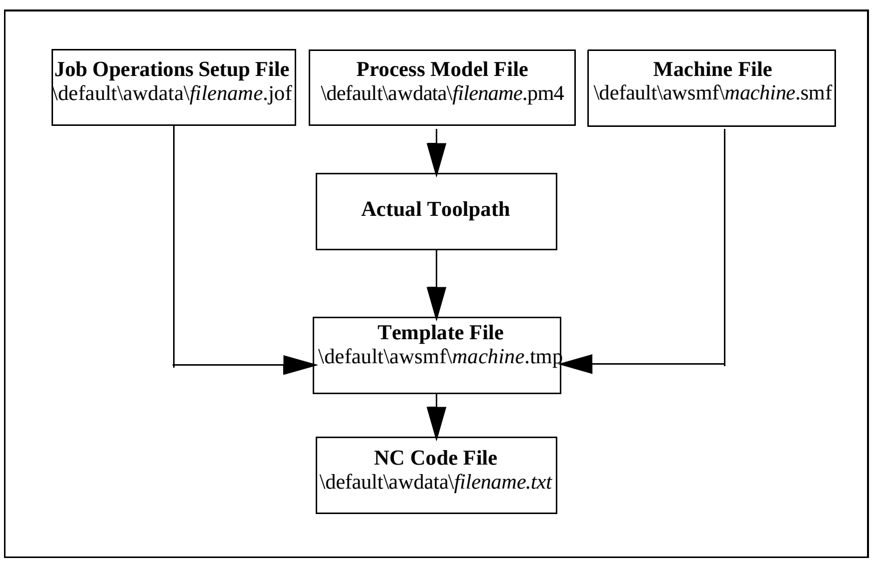
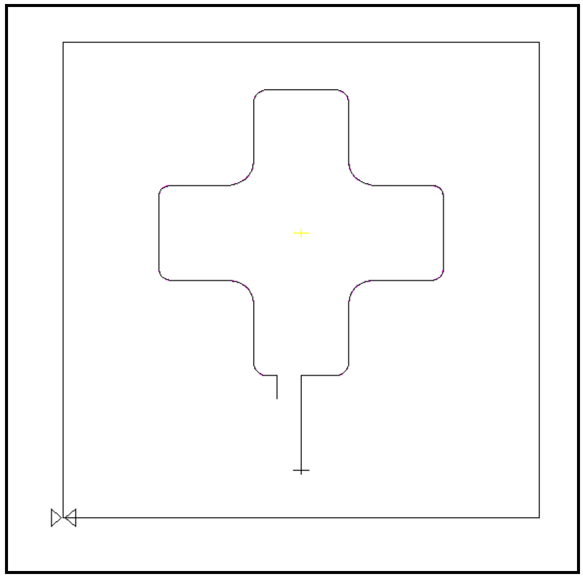


Figure 6-2 *SmartCAM uses these files to generate code.*

Perform these tasks to code a file:

1. Open the model file **`AWSKIM3.PM4`**.

Figure 6-3
Open AWSKIM3.



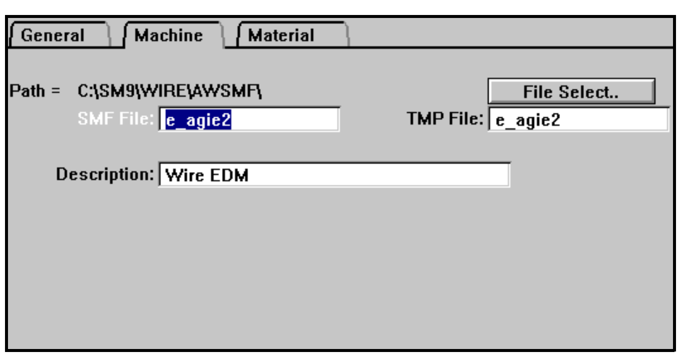
2. Select **Process—Code**. The **Code** dialog box is displayed.

Figure 6-4
Set the values on the Code dialog box.

3. Set **Code File** to the name of the file in which you want SmartCAM to place the code, or choose the **File Select** button to access the **Save As** dialog box and locate the file.

4. Select the **Choose** button. The **Job Information** dialog box is displayed and is opened to the Machine page.

Figure 6-5
Set the .smf and the .tmp files.



5. Set the **Smf File** field to the machine (`.smf`) filename by selecting the input field and pressing the **File Select** button. The **Open** dialog box appears.
6. Perform the following actions on the **Open** dialog box:
   - Select a file.
   - Select the **OK** button.
7. While the cursor is still in the SMF File input field, set the **Tmp File** input field to the template (`.tmp`) filename by performing a right mouse click. The cursor automatically advances to the TMP File input field and enters the appropriate template file name in the field.

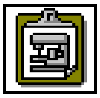
   If you need to use a different template file, press the File Select button when the cursor is in the TMP file field and repeat the selection method in step 6 .
8. Select the **Accept** button on the **Job Information** dialog box.
9. Set these values on the **Code** dialog box:
   - Turn on the **Show Path** on/off switch to see the toolpath simulation during code generation (optional).

     Note Code generation speed increases when this switch is turned off.
   - Turn on the **Disp Code** on/off switch to display each block of code as it is generated (optional).

     Note Code generation speed increases when this switch is turned off.
   - Set **Show Tool** to display variations of toolpath motion when **Show Path** is on, as follows:
     - **Nibble** draws an image of the tool as it follows the toolpath on the model.
     - **Draw End** displays the outline of the tool at the start and end of each element.
     - **Animate** shows the tool’s profile, location, and motion, leaving a path.
     - **Filled** draws the CTG shape of the tool and fills it with the tool’s color.
     - **3D** displays the operation with three-dimensional graphics.
     - **Flat** displays the operation with two-dimensional graphics.
   - Set **Speed** to a value between 0 and 9. The larger the number, the faster the graphics are displayed, and the faster the code is processed.
10. Select the **Start** button to begin code processing.

    Note Select the **Start** button repeatedly to view the processing sequence one block at a time when **Speed** is set to **0**.

Editing an .smf File Using Machine Define



Perform these tasks to edit an `.smf` file using Machine Define:

1. Select the **Machine Define** icon in the SmartCAM Program Group. The **Machine Define** dialog box is displayed.

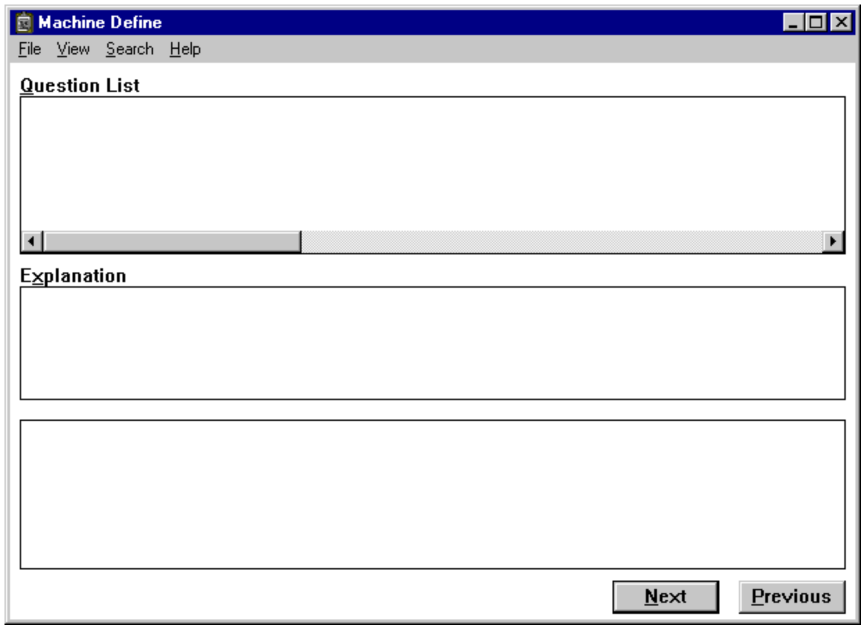
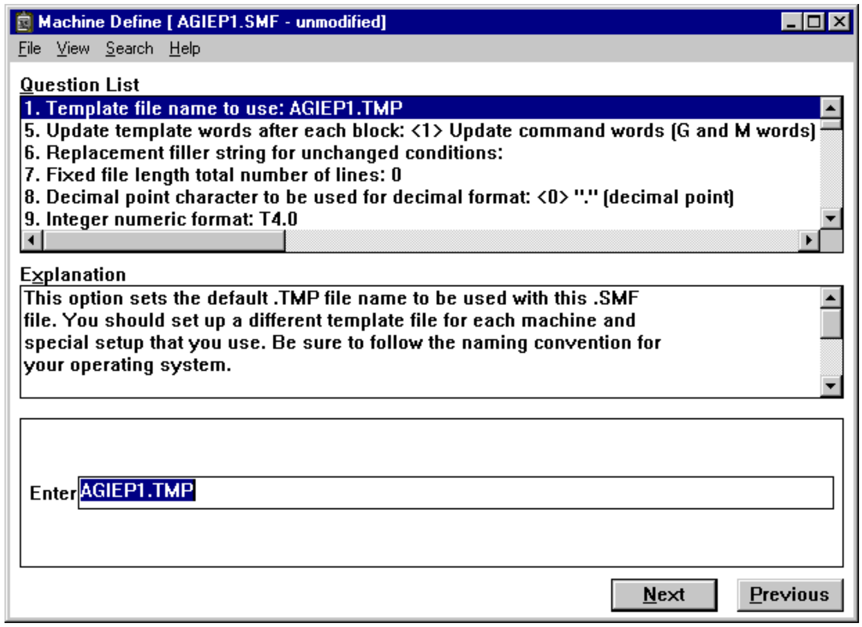


Figure 6-6
Set the values on the Machine Define dialog box.

2. Select **File—Open SMF**. The **Open SMF** dialog box is displayed.
3. Select the **`AGIEP1.SMF`** file to open.

Figure 6-7
Select the question to change and enter the changes.



4. Select the question to change and enter the changes. You can use the **Search** menu to search for the question you want to change.

   Note Typically, you would select **File—Save** to save the file. However, do not save your changes now.

5. Select **File—Exit** to exit Machine Define.

   Note If you use Job Operations Planner data in your `.tmp` file, question 471 must be present and set accordingly in your `.smf` file. If this question is not present in your file (verify using Machine Define), choose the **File—Save As SMF V5** option to save your file as an updated `.smf` file. Saving as an updated `.smf` file generates question 471, which is available each time that you open `.smf` files in Machine Define.

Points to Remember

- ❑ SmartCAM generates code for all unmasked step-property elements in the database.
- ❑ Code is generated from the process model as a text file that can be viewed using any text editor. Edit Plus is the text editor that is shipped with SmartCAM.
- ❑ Machine Definition, or `.smf`, files contain information on the machine tool.
- ❑ Template (`.tmp`) files contain variables and if /then statements that are used to format the code so that the controller can read it.

Self-Test

Directions

Test your understanding of the concepts and procedures in this section by answering the following questions. The answers for each self-test are in *Appendix A* of this manual.

______________ **1. .tmp files contain this information:**

a) geometry
b) code formatting information
c) tool information
d) machine definition questions and answers

______________ **2. .smf files contain this information:**

a) machine tool
b) operations
c) part geometry
d) group

______________ **3. Code is generated from the process model in this form:**

a) .doc
b) .txt
c) .tmp
d) .smf

______________ **4. SmartCAM generates code for all step-property elements in the database.**

a) true
b) false

______________ **5. SmartCAM ships this text editor:**

a) Production Milling
b) Material Librarian
c) Machine Define
d) Edit Plus

7

Applying Advanced Wire EDM Techniques

Objectives

These lessons show you how to apply challenging techniques with ease.

Lessons for This Unit

- Using Glue Stops
- Changing the Register of the Machine
- Cutting with Constant Tapers
- Cutting with Skimming Passes

Using Glue Stops

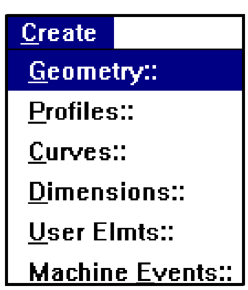
Objectives

This lesson shows you how to prevent a slug from obstructing a machining operation.

Overview

Use Glue Stops to prevent a slug from dropping out of a part and binding or obstructing the operation when you cut out a section. When the machine reaches the glue stop, it stops and waits for you to perform an action, such as installing a clamp to temporarily hold the slug in place. Typically, you insert a glue stop just before the end of a profile. In some instances, however, such as with a large or heavy slug that could sag or bend, you may use two or more glue stops. Multiple glue stops enable you to take action at more than one point in the cutting operation.

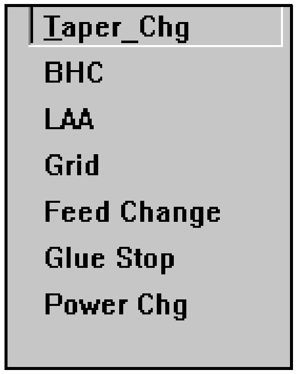
Figure 7-1
Use the Create menu.



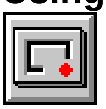
Using the Machine Events Toolbox

Use the Machine Events toolbox to create user commands that control special machine cycles. You can create commands for machines that support pattern cycles for holes around a radius, holes on a line, or holes in a grid, along with feed-rate changes.

Figure 7-2 Create roughing toolpath with the Machine Events toolbox.



Using Glue Stops



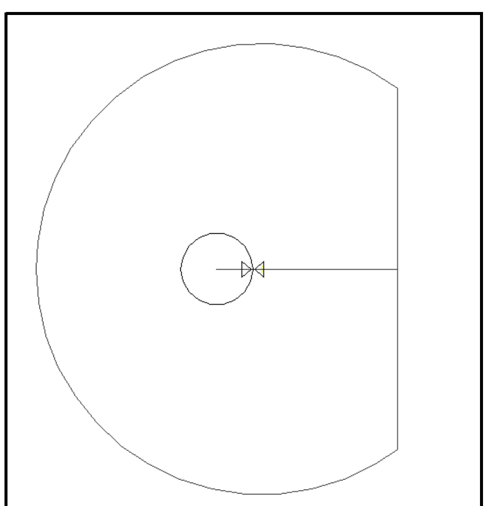
Model File: AWDHOLE.PM4

Use Glue Stop to add a user command that modifies a profile. When machine code is created, machine stop occurs, permitting the operator to insert a part clamp before the slug is cut free, to an existing profile.

Follow these steps to use a glue stop:

1. Open the model file **`AWDHOLE.PM4`**.

Figure 7-3 Open AWDHOLE.



2. Set the insert location:
   - Set the **C** (Clear) input field.
   - Set the **P** (Profile Top) input field.
3. Select **Create—Machine Events**.
4. Select **Glue Stop** from the toolbox. The **Glue Stop** control panel is displayed.

Figure 7-4 *Set the values on the Glue Stop control panel.*

5. Select the **Select Split Element** input field, and select the element to split and place the glue stop in.
6. Select the **Glue Stop Width** input field, and identify the location of the split.

   Note If the Glue Stop Width value is larger than the last element in the element or profile, SmartCAM moves back along the profile that distance. This causes the split to occur on an element other than the last one in the profile.

7. Select the **User Event Text** input box, and select which @ section to use in the template file for coding the model. The information in the @ section controls the type of information sent to the machine (for example, @STOP, @OPSTOP, @CUT, or @OTHER).

   The template file SmartCAM uses to generate code for a model with a glue-stop command must have the proper @GLUE section. To generate the correct code with the glue stop command, the corresponding @ sections must exist in the template file you use for coding. In that section, place the command your machine recognizes for that operation. For example, you could add the following information:

   - **@OPSTOP—**M01 (message for machine operator)
   - **@STOP—**M00 (message for machine operator)
   - **@GLUE—**M00 (message for machine operator)
   - **@OTHER—**This prompts you for the desired @ section.

8. Split the element or the profile:

   - Select the **Split Element** button to back up the width of the glue stop from the end of the element, and insert the glue stop.
   - Select the **Split Profile** button, and provide lead in/out information to back up the glue stop width distance from the end of the profile and insert a glue stop.

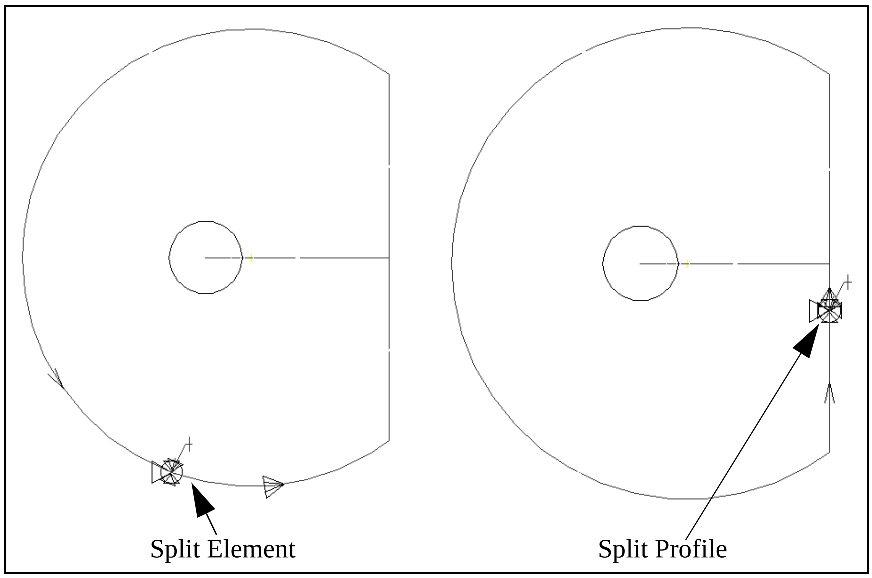


Figure 7-5
This is a result of using glue stops.

Points to Remember

- ❑ Use glue stops to prevent a slug from dropping out of a part and binding or obstructing the operation when you cut out a section.
- ❑ Typically, you insert a glue stop just before the end of a profile. In some instances, however, such as with a large or heavy slug that could sag or bend, you may use two or more glue stops.
- ❑ The template file SmartCAM uses to generate code for a model with a glue-stop command must have the proper @GLUE section.

Changing the Register of the Machine

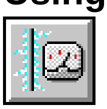
Objectives

This lesson shows you how to add a command in the specified database location that changes the register or setting of the machine.

Overview

Use Power Chg to change the register or setting of the machine by adding a command in the specified database location. SmartCAM displays the command in the list view and a leader pointing to the command in the graphic view.

Using Power Chg



Model File: AWPWRCHG.PM4

Perform these tasks to use Power Chg:

1. Open the model file **`AWPWRCHG.PM4`**.

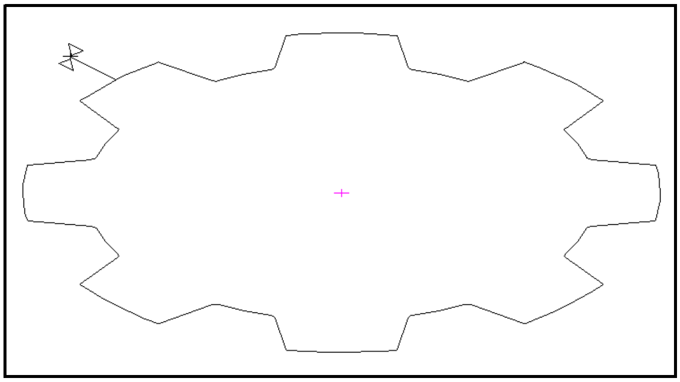
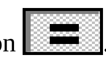


Figure 7-6
Open AWPWRCHG.

2. Set the insert location:
   - Set the **Match Element** icon .
   - Set the **C** (Clear) input field on the Insert property bar.
   - Set the **P** (Profile Top) input field on the Insert property bar.
3. Select **Create—Machine Events**.
4. Select **Power Chg** from the toolbox. The **Power Chg** control panel is displayed.

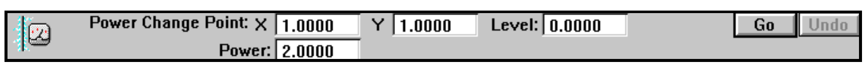


Figure 7-7
Set the values on the Power Chg control panel.

5. Set the **Power Change Point** input fields to identify the location for the power-change point in the model.
6. Set the **Level** input field by entering the level at which to locate the command. This has no bearing on the code; it pertains only to the display.
7. Set the **Power** input field to reflect the power to send to your machine. Make sure that this value is appropriate for the requirements of your machine.
8. Select the **Go** button to add the power-change command to the database.

   Note You must enter a setting for each control panel input field. If a setting is missing, SmartCAM will display a dialog box prompting you for the value using the following variable assignments:

   - Power Change Point = #XS2, #YS2
   - Level = #LV
   - Power = #D1

9. To generate the correct code with the power-change command, the @POWERCHG section must be in the template file you use for coding. In that section, place the command your machine recognizes for a power-change operation and the #U1 variable. For example, you could add the following:

   `@POWERCHG`

   `CODE#U1`

   CODE is the code your machine uses to change the current output.

Points to Remember

- SmartCAM displays the command in the list view and a leader pointing to the command in the graphic view.
- Setting the Level input field has no bearing on the code, it pertains only to the display.
- To generate the correct code with the power-change command, the @POWERCHG section must be in the template file you use for coding.

Cutting with Constant Tapers

Objectives

This lesson shows you how to execute a constant taper on a profile.

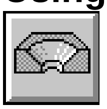
Overview

Use Taper Chg to initiate the taper on the lead-in move, produce the toolpath to cut the taper around the entire profile, and then remove the taper on the lead-out move. Taper Chg creates an @TAPER command at the beginning of a tapered profile to be cut. The command contains the desired wire angle value for the profile that follows, and it directs the machine to change the angle of the wire before proceeding with the cut.

Use Taper Chg for 2-axis processes with profiles that represent constant taper surfaces. Taper Chg creates a constant tool inclination relative to the profile and results in a constant taper surface. Use it for applications such as dies and uniform mold relief (draft).

Note Attach a taper command only to a line element, and assign only one taper command to a profile. If a taper command already exists and you enter new information, SmartCAM modifies the existing command to match the new information.

Using Taper Chg



Model File: AWTAPER2.PM4

Perform these tasks to cut with constant tapers:

1. Open the model file **AWTAPER2.PM4**.

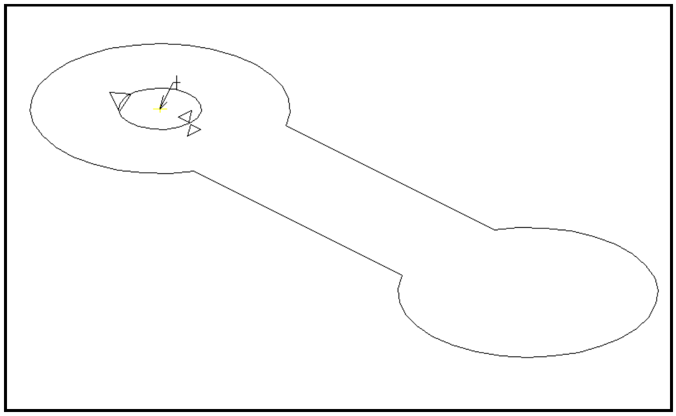
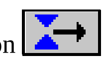
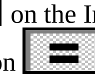


Figure 7-8
Open AWTAPER2.

2. Set the insert location:
   - Set the **Before** icon  on the Insert property bar.
   - Set the **Match Element** icon .
   - Set the **With Step** icon , and select the step number to use.
   - Set the **C** (Clear) input field.
3. Select **Edit—Geo Edit—Lead In/Out**. The **Lead In/Out** control panel is displayed.

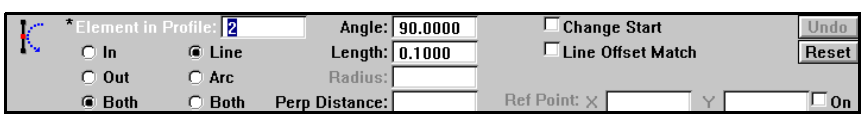


Figure 7-9
Set the values on the Lead In/Out control panel.

4. Turn on the **Both** option switch.
5. Turn on the **Line** option switch.
6. Set the **Angle** input field to **90**.
7. Set the **Length** input field to **.1 [2.45]**.
8. Set the **Element in Profile** input field to **2**.
9. Make sure the profile to use is assigned to the step. If it is not, use **Edit—Property Chg—Toolpath** to assign it to an appropriate step.
10. Select **Create—Machine Events—Taper Chg**. The **Taper Change** control panel is displayed.

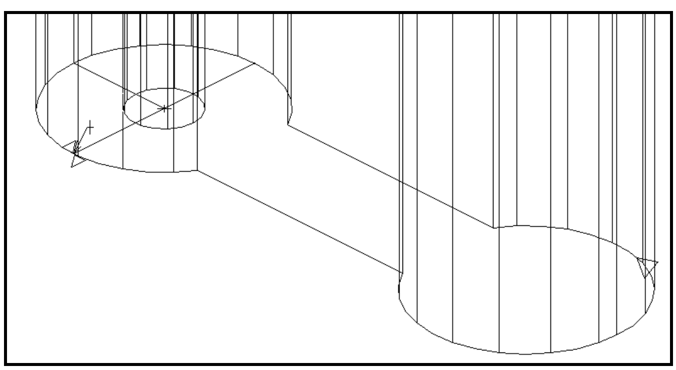
Figure 7-10
Set the values on the Taper Change control panel.

11. Select the **Profile Element** input field, and select the line element that is the start of the profile. You must have assigned a tool to the line element that you select. The last element in the profile must also be a line element.
12. Select the **Taper Angle** input field, and enter the sign and angle of the taper angle. Valid inputs are real numbers in the range of +80 through -80. The sign controls the direction of the taper: A positive value causes the wire to tilt to the right relative to the direction of travel; a negative value causes the wire to tilt to the left.
13. Select the **Go** button to create the command.

    Note If a taper command exists, you must determine whether to modify it. Depending on your choice, SmartCAM either modifies the command or stops and waits for your next action. However, if you moved another command to a point immediately before the profile containing the taper command, SmartCAM will execute that command instead of the taper change.

14. Select **View—Show Path**. The **Show Path** control panel is displayed.
15. Select the **Start** button, and watch the wire tilt on the lead-in move, indicate the taper on the profile, and tilt back on the lead-out move.

Figure 7-11
This is a result of using Taper Chg.



Points to Remember

- ❑ Use Taper Chg to initiate the taper on the lead-in move, produce the toolpath to cut the taper around the entire profile, and then remove the taper on the lead-out move.
- ❑ Taper Chg creates an @TAPER command at the beginning of a tapered profile to be cut.
- ❑ Valid Taper Angle inputs are real numbers in the range of +80 through -80.
- ❑ A positive value causes the wire to tilt to the right relative to the direction of travel; a negative value causes the wire to tilt to the left.

Cutting with Skimming Passes

Objectives

This lesson shows you how to use skimming passes to cut and finish a part.

Overview

Use multiple skimming passes to cut and finish a part. In this lesson, you use one roughing pass and two finish passes to cut out a block of material. The part is a punch component of a die set, so it is left-attached to the rest of the material for the entire skim-cut operation. To accomplish this, the procedure includes a gap (in the cut) at the end of the profile to hold the part in place while making the three passes. You would later cut through the gap section.

To avoid removing the tool from the part (cut the wire) and moving back to the start point, ensure that these cut directions are made:

- First Pass—CCW
- Second Pass—CW
- Third Pass—CCW

In this lesson you use three different tools. (SmartCAM names different power settings as different tools. With power reduction on passes nearer to the final profile, the wire is less affected by reactive forces from the material that you cut. In this way, the system can cut with the highest precision.)

Using Skim Cuts

Model File: AWSKIM.PM4

Perform these tasks to use skim cuts:

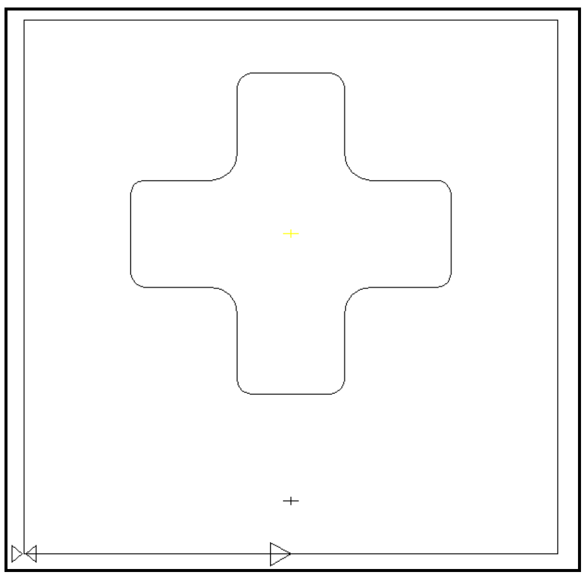
- Create the first, second, and third profiles.
- Create lead-in and lead-out moves.
- Reverse the second profile.

Creating the First Profile

Perform these tasks to create the first profile:

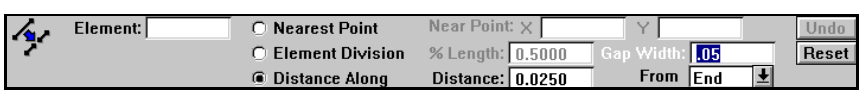
1. Open the model file **AWSKIM.PM4**. Notice that there is a point .2 inches [5.0] below the part in the display. This is the start hole.

Figure 7-12
Open AWSKIM.



2. Select **Edit—Geo Edit—Split**. The **Split** control panel is displayed.

Figure 7-13
Set the values on the Split control panel.



3. Set these values on the **Split** control panel:
   - Turn on the **Distance Along** option switch.
   - Set the **Distance** input field to **.025 [.6]**.
   - Set the **From** selector switch to **End**.
   - Set the **Gap Width** input field to **.05 [1.2]**.
   - Select the **Element** input field, and select the last element in the profile. A gap of **.05 [1.2]** is displayed at the end of the profile.

4. Group the profile.
5. Select **Edit—Property Chg—Toolpath**. The **Toolpath Property Change** dialog box is displayed.

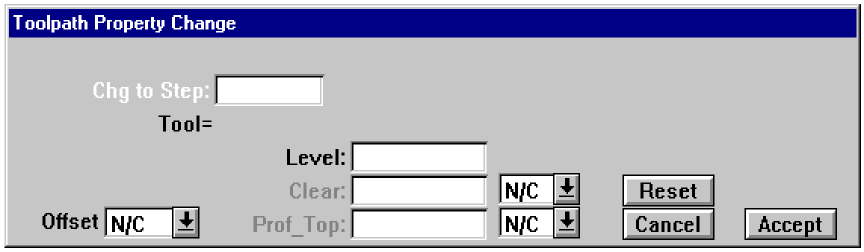
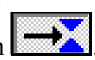
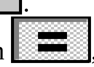


Figure 7-14 *Set the values on the Toolpath Property Change dialog box.*

6. Set these values on the **Toolpath Property Change** dialog box:
   - Set the **Chg to Step** input field to **1**.
   - Set the **Offset** selector switch to **RIGHT**.
   - Turn on the **Prof Top** selector switch.
   - Select the **Prof Top** input field, and set it to **1.5** [**38.0**].
7. Select the **Accept** button. SmartCAM displays the first profile, which includes the gap at the end of the profile.

Creating the Second Profile

Perform these tasks to continue the process and create the second profile:

1. Set the insert location:
   - Set the **After** icon .
   - Select the **Profile** icon .
   - Set the **Match Element** icon , and select any element in the profile.
   - Set the **With Step** icon , and select step **1**.
2. Select **Edit—Transform—Move**. The **Move** control panel is displayed.

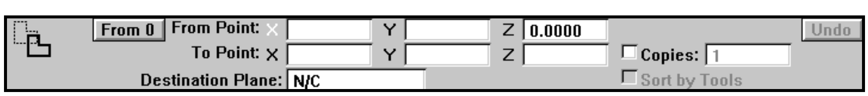


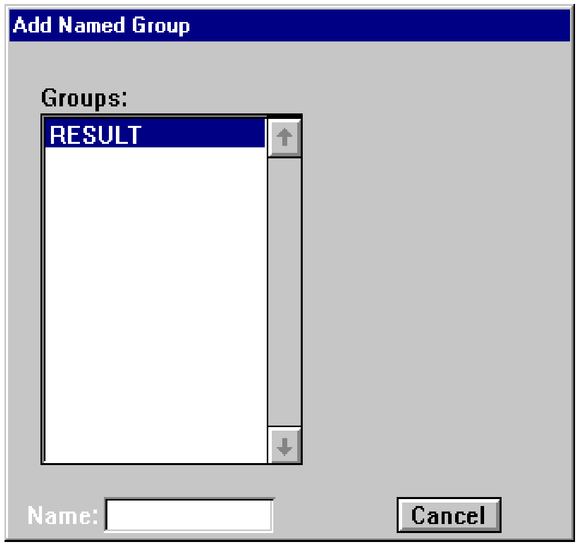
Figure 7-15 *Set the values on the Move control panel.*

3. Turn on the **Copies** on/off switch, and set the input field to **1**.
4. Set the **From Point** input fields to **0**, **0**, **0**.
5. Set the **To Point** input fields to **0**, **0**, **0**.

   The number of elements in the element list is doubled.
6. Clear the active group.

7. Select the **Add Named Group** icon  on the Group tool palette. The **Add Named Group** dialog box is displayed.

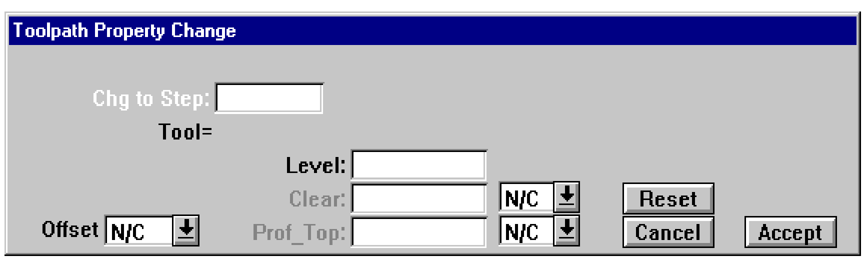
Figure 7-16
Set the values on the Add Named Group dialog box.



8. Select **RESULT**. This adds the second copy of the profile to the current group.

9. Select **Edit—Property Chg—Toolpath**. The **Toolpath Property Change** dialog box is displayed.

Figure 7-17
Set the values on the Toolpath Property Change dialog box.

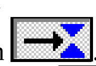
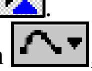
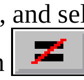


10. Set the **Chg to Step** input field to **2**.

11. Select the **Accept** button. SmartCAM displays the second profile on the first profile.

Creating the Third Profile

Perform these tasks to continue the process and complete the third profile:

1. Set the insert location:
   - Set the **After** icon .
   - Select the **Profile** icon , and select after the second profile.
2. Set the **Don't Match Element** icon .

3. Select **Edit—Transform—Move**. The **Move** control panel is displayed.

Figure 7-18
Set the values on the Move control panel.

4. Make sure that the **Copies** on/off switch is still turned on.
5. Make sure that the **Copies** input field is still set to **1**.
6. Make sure that the **From Point** and the **To Point** input fields are still set to **0**.

   Note Notice that the number of elements in the element list has tripled from the initial number. The **To Point** input fields are reset.

7. Clear the active group.
8. Select the **Add Named Group** icon  on the Group tool palette. The **Add Named Group** dialog box is displayed.

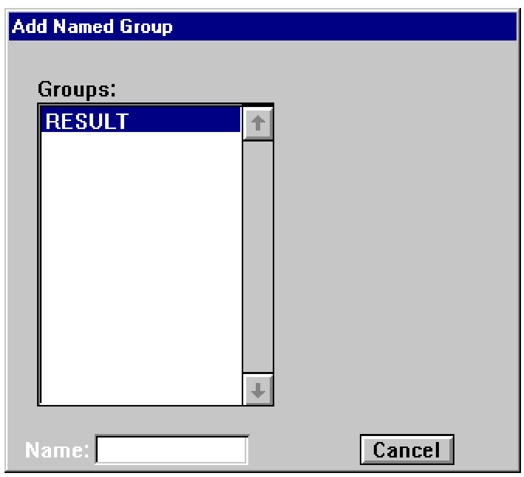


Figure 7-19
Set the values on the Add Named Group dialog box.

9. Select **RESULT**.
10. Select **Edit—Property Chg—Toolpath**. The **Toolpath Property Change** dialog box is displayed.

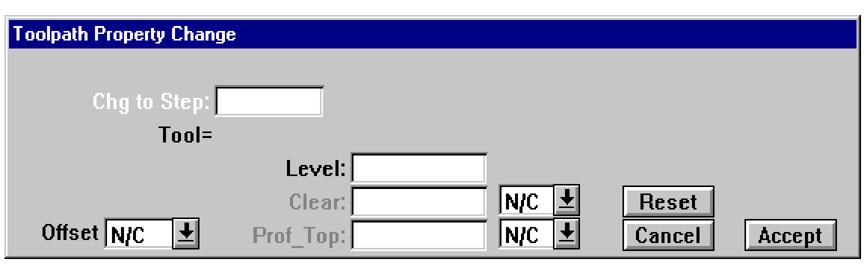


Figure 7-20
Set the values on the Toolpath Property Change dialog box.

11. Set the **Chg to Step** input field to **3**.
12. Select the **Accept** button. SmartCAM displays the third profile on the second profile.

Creating Lead-In and Lead-Out Moves

Perform these tasks to continue the process by creating lead-in and lead-out moves.

1. Select **Edit—Geo Edit—Lead In/Out**. The **Lead In/Out** control panel is displayed.

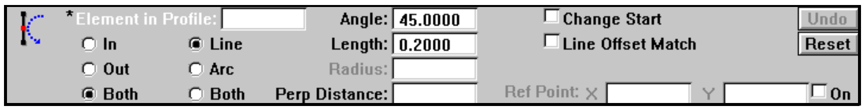


Figure 7-21
Set the values on the Lead In/Out control panel.

2. Turn on the **In** option switch.
3. Turn on the **Line** option switch.
4. Turn off the **Change Start** on/off switch.
5. Turn on the **Ref Point** on/off switch.
6. Select the **Ref Point** input field label, and select the point **.2** [**5**] below the part on the Y axis.
7. Select the **Element in Profile** input field, and select from the list view any element in the profile that is created with tool 1. (Repeat this for tools 2 and 3.)
8. Turn on the **Out** option switch.
9. Turn off the **Ref Point** on/off switch.
10. Set the **Angle** input field to **90**.
11. Set the **Length** input field to **.05** [**1.0**].
12. Select the **Element in Profile** input field, and select from the list view the last element in the profile created with tool 1. (Repeat this for tools 2 and 3.)

    SmartCAM displays lead-in and lead-out moves for all three profiles. The lead ins and the lead outs are inserted in the correct locations with the correct step numbers.

Reversing the Second Profile

To avoid cutting the wire and repositioning the tool to the profile start point, you need to reverse the tool direction for the second profile. The tool then starts cutting the second profile at the end of the first profile, and it is in position to start cutting the third profile at the end of the second profile.

1. Use the **Group by Tool** icon  on the Group tool palette to select tool 2 from the list view.

2. Select **Edit—Order Path—Rev Order**. The **Rev Order** control panel is displayed.

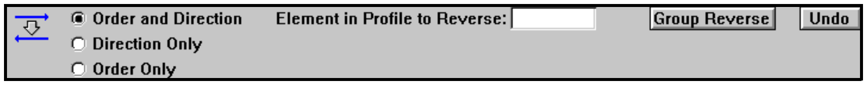


Figure 7-22 *Set the values on the Rev Order control panel.*

3. Turn on the **Order and Direction** option switch.
4. Select the **Group Reverse** button.
5. Select **View—Redraw** to refresh the screen.
6. Select **View—Show Path**. The **Show Path** dialog box is displayed.
7. Select the **Start** button.
8. Select **View—Get View—Iso** to see the isometric view of the toolpath.

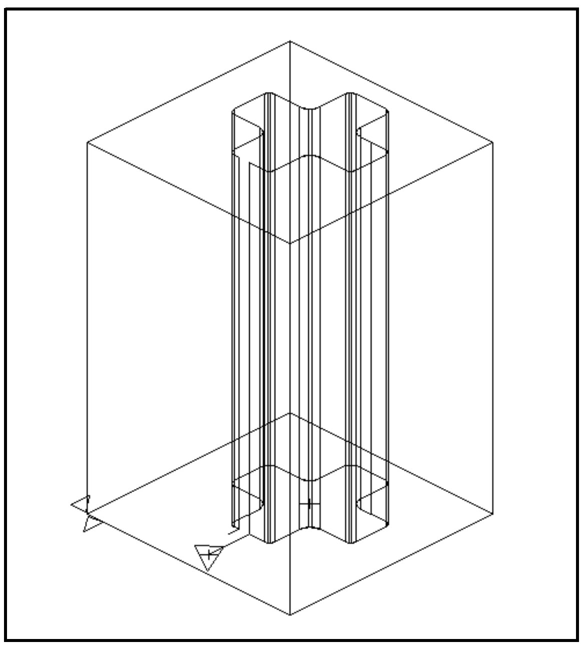


Figure 7-23 *SmartCAM displays the isometric view of the part.*

Points to Remember

- ❑ You can use multiple skimming passes to cut and finish a part.
- ❑ SmartCAM names different power settings as different tools.

Self-Test

Directions

Test your understanding of the concepts and procedures in this section by answering the following questions. The answers for each self-test are in *Appendix A* of this manual.

_______________ **1. Which SmartCAM feature should you use to prevent a slug from dropping out of a part and binding or obstructing the operation when you cut out a section.**

a) Glue Stop
b) Taper Change
c) Skim Pass
d) Feed Change

_______________ **2. Typically, you insert a glue stop just before the start of a profile.**

a) true
b) false

_______________ **3. Which section does the SmartCAM template file use to generate code for a model with a glue-stop command?**

a) @GLUESTOP
b) @STOP
c) @GLUE
d) none of the above

_______________ **4. Use Taper Chg to initiate the taper on the lead-in move, produce the toolpath to cut the taper around the entire profile, and then remove the taper on the lead-out move**.

a) true
b) false

_______________ **5. Which command does Taper Chg create at the beginning of a tapered profile to be cut?**

a) @TAPERCUT
b) @TCUT
c) @CUT
d) @TAPER

_______________ **6. What is the real-number range of valid Taper Angle inputs?**

a) -180 through +180
b) -80 through +180
c) -80 through +80
d) -18 through +180

_______________ **7. A positive value causes the wire to tilt to the right relative to the direction of travel.**

a) true
b) false

_______________ **8. A negative taper angle causes the wire to tilt to the left.**

a) true
b) false

_______________ **9. What does SmartCAM name different power settings as?**

a) different power settings
b) different jobs
c) different steps
d) different tools

A

Appendix A: Self-Test Answers

Overview

Use the answers to check your self-tests. Review lessons that correspond to questions that you completed incorrectly.

Advanced Wire EDM Answers

Becoming Acquainted with SmartCAM

B 1. **It is possible to select dimmed menu items.**
Lesson *Using Workplace Areas,* page 1-4

C 2. **What does an asterisk (*) in the control panel indicate?**
Lesson *Using Workplace Areas,* page 1-4

C 3. **Which of these workplace items does each control panel correspond to?**
Lesson *Using Workplace Areas,* page 1-4

A 4. **What do process model files graphically represent?**
Lesson *Learning SmartCAM File Types,* page 1-17

B 5. **What do job operation files contain?**
Lesson *Learning SmartCAM File Types,* page 1-17

C 6. **Which View features magnify specific areas of the view?**
Lesson *Using Window,* page 1-22, *Using Zoom,* page 1-23

D 7. **What View features manipulate the orientation of the view?**
Lesson *Using Pan,* page 1-24, *Using Full,* page 1-24, *Using Last View,* page 1-24, *Using Get View,* page 1-25, *Using Name View,* page 1-26, *Using Dynamic View,* page 1-27

B 8. **What feature do you use to control how the geometry is displayed in the graphic view?**
Lesson *Using Display Modes,* page 1-27

Working with SmartCAM

_____**B**_____ **1. Layer geometry generates code.**
Lesson Overview, page 2-3

_____**A**_____ **2. Step geometry generates code.**
Lesson Overview, page 2-3

_____**B**_____ **3. Which input field defines the height that the tool retracts to after making a cut?**
Lesson Setting Levels, Clearance, and Profile Top, page 2-10

_____**C**_____ **4. Which input field defines the height of the top of your part?**
Lesson Setting Levels, Clearance, and Profile Top, page 2-10

_____**C**_____ **5. What type of plane determines the orientation of geometry?**
Lesson Overview, page 2-13

_____**B**_____ **6. Which SmartCAM feature enables you to use points and other element properties from existing geometry to enter coordinate values in input fields when you create or edit geometry?**
Lesson Operating Snap, page 2-20

_____**B**_____ **7. Using Status interrupts the current task.**
a). *Checking Levels, Clearance, and Profile Top,* page 2-11

_____**A**_____ **8. How do you know if tools require groups if there are no active groups?**
Lesson Using the Group Arrow Icon, page 2-24

Using Job Operations

_____**C**_____ **1. What pieces of job information are required?**
Lesson Overview, page 3-3

_____**D**_____ **2. What values must be set to complete a process step?**
Lesson Overview, page 3-3

_____**B**_____ **3. How many steps or tools can you move at a time when you use the Move feature?**
Lesson Moving Steps and Tools, page 3-21

_____**A**_____ **4. You cannot remove active steps from a job.**
Lesson Removing Steps and Tools, page 3-20

_____**B**_____ **5. Where do you define material information that you want to use on a regular basis?**
Lesson Setting Up a File with the Material Librarian, page 3-27

A 6. **Once material information is set up, how do you access it from Advanced Wire EDM?**
Lesson Opening a Material Librarian File, page 3-35

A 7. **Which report should you print if you want to know about the job information for the open process model?**
Lesson Printing a Job Information Report, page 3-40

Working with Elements

C 1. **What do you need to do before creating new geometry?**
Lesson Overview, page 4-4

A 2. **Associating geometry with a step will result in code.**
Lesson Overview, page 4-4

B 3. **Associating geometry with a layer will result in code.**
Lesson Overview, page 4-4

B 4. **You can select and code masked elements**
Lesson Using Show/Mask, page 4-52

D 5. **How many elements in a model can you view modeling data for?**
Lesson Using Element Data, page 4-33

B 6. **Viewing element data affects the geometry database.**
Lesson Overview, page 4-33

A 7. **Changing the color of elements:**
Lesson Using Color Change, page 4-54

B 8. **Elements to be trimmed or extended should be on different work planes.**
Lesson Trimming and Extending Geometry, page 4-36

B 9. **How many groups does trimming by group impact?**
Lesson Trimming a Group of Elements, page 4-38

B 10. **How many deleted groups can be recovered with the Undo button?**
Lesson Deleting Elements, page 4-47

Generating Toolpath/Verifying 4-Axis Toolpath

___C___ **1. What is needed to use Nocore?**
Lesson Using Nocore, page 5-4

___D___ **2. What controls the wire's inclination as it moves along the bottom and top defining profiles?**
Lesson Creating Links, page 5-6

___B___ **3. You can change only the start point of links between elements with Modifylinks.**
Lesson Modifying Links, page 5-8

___A___ **4. What condition must a link meet for you to remove it for a range?**
Lesson Removing Links, page 5-9

___D___ **5. What type of surface does Viewsurf build?**
Lesson Overview, page 5-17

Generating Code

___B___ **1. .tmp files contain this information:**
Lesson Learning File Types for Code Generation, page 6-3

___A___ **2. .smf files contain this information:**
Lesson Learning File Types for Code Generation, page 6-3

___B___ **3. Code is generated from the process model in this form:**
Lesson Learning File Types for Code Generation, page 6-3

___B___ **4. SmartCAM generates code for all step-property elements in the database.**
Lesson Learning File Types for Code Generation, page 6-3

___D___ **5. SmartCAM ships this text editor:**
Lesson Learning File Types for Code Generation, page 6-3

Applying Advanced Wire EDM Techniques

___A___ **1. Which SmartCAM feature should you use to prevent a slug from dropping out of a part and binding or obstructing the operation when you cut out a section.**
Lesson Overview, page 7-3

___B___ **2. Typically, you insert a glue stop just before the start of a profile.**
Lesson Overview, page 7-3

___C___ **3. Which section does the SmartCAM template file use to generate code for a model with a glue-stop command?**

Lesson Using Glue Stops, page 7-4

____A____ **4. Use Taper Chg to initiate the taper on the lead-in move, produce the toolpath to cut the taper around the entire profile, and then remove the taper on the lead-out move**.
Lesson Overview, page 7-11

____D____ **5. Which command does Taper Chg create at the beginning of a tapered profile to be cut?**
Lesson Overview, page 7-11

____C____ **6. What is the real-number range of valid Taper Angle inputs?**
Lesson Using Taper Chg, page 7-12

____A____ **7. A positive taper angle causes the wire to tilt to the right relative to the direction of travel.**
Lesson Using Taper Chg, page 7-12

____A____ **8. A negative value causes the wire to tilt to the left.**
Lesson Using Taper Chg, page 7-12

____D____ **9. What does SmartCAM name different power settings as?**
Lesson Overview, page 7-15

Glossary

Accept

Select this action button to accept entries into the active control panel.

Action Button

Control panel token that is labeled according to what action it carries out.

Active Group

The elements selected for an operation.

After

Setting on the Insert property bar. Used with the Before switch. One of the switches must be selected when you create new geometry to determine where a new element is to be placed in relation to an existing element, profile, step, tool, or layer.

Air-Cut Time

The time between when the tool starts to feed and when it starts cutting stock.

Area of Uncut Material (AUM)

The difference between the actual and nominal net shapes represents the area of uncut material. (For example, when the selected tool is too large to cut all areas of an operation.) The user defines the nominal net shape by indicating a set of profiles while creating a machining process.

Axial Length

Distance input. Enter the length of the thread as measured parallel to the Z axis.

Ball Mill

Conventional end mill with a full radius bottom (corner radius equals tool radius). It may be straight (cylindrical) or tapered (conical).

Base Envelope

A viewing window which is defined when you start a new model. It enables you to redisplay the intended part size quickly after using the various viewing options.

Before

Setting on the Insert property bar. Used with the After switch. One of the switches must be selected when you create new geometry to determine where a new element is to be placed in relation to an existing element, profile, step, tool, or layer.

Boring

The Boring operation type provides the primary operation parameters for single-point boring operations. Use it with single-point boring tools.

Boring Tool

A single-point tool used to finish predrilled holes to a precise size tolerance.

Boundary Profile

The profile enclosing the material to be removed.

Bull Mill

Conventional end mill with a flat bottom and rounded corners. May be either straight (cylindrical) or tapered (conical).

C0 Continuity

Signifies that two adjacent surfaces or curves are contiguous (their end points coincide).

C1 Continuity

Signifies that two adjacent surfaces or curves are tangent.

C2 Continuity

Signifies that two adjacent surfaces or curves have a constant rate of curvature.

Cancel

Select this button to close the dialog box or panel without saving any changes.

Canned Cycle

A series of preset directions, or machine cycle, that a machine control uses to perform repetitive tasks. The function is called by a code containing information about where to place the event. For example, hole cycles are typically between the G76 and G89 code numbers.

CCW (Counterclockwise)

Sets the rotation direction of a tool, or the toolpath direction along an arc element.

Center Drill

A stepped drill with an outer body diameter and a smaller drill diameter that are connected by a 60-degree, included point angle. In some cases the transition between the 60-degree point angle and the outer body diameter is broken by a 120-degree point angle beginning at the bell diameter. This tool type is typically used to create a precision center location for subsequent turning or grinding operations.

Center Drilling

The Center Drilling operation type provides the primary operation parameters for center drilling.

Chordal Deviation

The distance between the midpoint of an arc and the midpoint of a line drawn between the ends of that same arc. This distance is the width of the tolerance band that SmartCAM should use when interpolating arcs or curves into lines. The band restricts the size of the polyline segments that SmartCAM creates when approximating curves. The larger the size of the band, the greater the chordal deviation and resulting polyline segments.

Clean-up Pass

Cutting tool performs a clean-up pass on the profile to remove any inconsistencies in the surface after roughing.

Clear

The Z-height necessary for the tool to make positioning moves safely. The point from which the tool begins to feed.

Climb Cut

Roughing cut option in which the tool's rotation pulls the tool in the same direction as the cutting motion. This is the opposite of conventional cutting in which the tool rotation pushes the tool in the opposite direction from the cutting motion.

Close

Use to close an active panel. If changes are not saved, a prompt will be displayed, enabling you to save or discard the changes.

Control Panel

Each modeling tool has its own control panel, with input switches and buttons to operate the tool. A control panel appears at the bottom of the screen display when a tool is selected and remains open as long as the tool is active.

Conventional Cut

Roughing cut option in which the tool's rotation pushes it in the opposite direction from the cutting motion. This is the opposite of climb cutting in which the tool's rotation pulls it in the same direction as the cutting motion.

Core

A body of material that has separated from the part and fallen out because the wire has cut around it and disconnected it from the rest of the material.

Counterbore

A piloted flat bottom cutting tool used to create counterbores in existing holes. This tool is often used to create recesses for cap screw fasteners.

Counterboring

The Counterboring operation type provides the primary operation parameters for counterboring an existing hole. Use Counterboring with a piloted counterboring tool.

Countersink

A short tool used to create chamfers at the top of existing holes. This tool typically contains an 82-degree, included point angle, and it is primarily used to create recesses for flat head screw fasteners.

Countersinking

The Countersinking operation type provides the primary operation parameters for countersinking an existing hole. Use with 82-degree counterbore tools.

Createlinks

A link tool that helps you fine-tune the part surface according to your part requirements. Createlinks controls wire movement between the top and bottom profiles or elements.

Crest Start

Distance input. Enter the outside radius if it is an external thread or the inside radius if it is an internal thread. When a face-grooving tool is active, Crest Start applies to a Z-axis value.

Cursor

The location indicator on the screen, moved by manipulating the mouse; the cursor is displayed in one of five forms, depending on its location.

CW (Clockwise)

Sets the rotation direction of a tool, or the toolpath direction along an arc element.

Delta Major

The radial distance from the Nominal diameter to Major diameter.

Delta Minor

The radial distance from Nominal diameter to Minor diameter.

Design Model File

Enter the name of the design model file created by your CAD program. If you need to search for the file, use the File Select action button at the top of the form.

Design Ref

Represents the functional design perspective of the part.

Dialog Boxes

Dialog boxes open temporarily to allow selection or control of a variety of events. A dialog box may appear anyplace on the screen display and closes when its action is completed or canceled. If a dialog box is open, you must complete the required action or cancel it before doing anything else to the model.

Dimmed Text

When the text for a menu item is dimmed, you cannot select the menu item until some other action is performed. For example, most of the options on the top menu bar remain dim until you load a model file or until a current group is active.

Double D Punch

The tool type used to enter the tool parameters for a Double D punching tool. The width is the distance between the flats.

Drilling

The Drilling operation type provides the primary operation parameters for basic hole drilling. Use Drilling to create holes that can be completed with a single feed motion.

Edge Milling

The Edge Milling operation type provides the primary machining parameters for edge machining. Use Edge Milling for machining chamfers or round corners in customized machining procedures (such as macros).

Element

The toolpath or boundary definition that SmartCAM places in the database and displays in the list view and Element Data list; element types include lines, arcs, polylines, splines, user events, sub calls, holes, points, ellipses, and helixes.

Element Data

Information about the element coordinates and properties in a model are stored in the database.

End Mill

Conventional end mill with a flat bottom and sharp corners. Cutting edges may be either straight (cylindrical) or tapered (conical).

Evaluator Expression

SmartCAM's evaluator function uses standard mathematical functions and the assigned expressions for each field to perform calculations. The expressions are system terms representing known measurements. For example, tl(tl_len) represents tool length, and it can be multiplied to equal another input such as 3*tl(tl_len).

External Groove Tool

A tool used to machine grooves on the outside diameter of a turned part.

External Thread Tool

A tool used to create threads on the outside diameter of a turned part.

External Turn Tool

A tool used to machine the outside diameter of a turned part.

Face Groove Tool

A tool used to machine grooves on the face of a turned part.

Face Grooving

The Face Grooving operation type provides the primary machining parameters for adding a groove to the face of a turned part.

Face Mill

Arbor-mounted mill intended for machining large flat surfaces. Typically contains replaceable carbide inserts with rounded corners. Cutting edges may be either straight (cylindrical) or tapered (conical).

Face Milling

The Face Milling operation type provides the primary machining parameters for face milling. Use it to create toolpath with the Process—Rough—Face option in SmartCAM.

Facing Tool

A tool used to machine the end of a turned part.

File Select

Select this to open the File Select dialog box to search for a file. This button can only be selected if the active field requires entry of a file name.

Finish Allowance

Used for Rough, Face, and Surface Milling operations. Enter the thickness of the material to be left on the part after the machining operation.

Finish Amount

The amount of material to be left on the sides of the boundary profile after roughing. (This material can later be removed with a finish pass.)

Finish Milling

The Finish Milling operation type provides the primary machining parameters for finish profile machining. Use Finish Milling for machining any SmartCAM finish profile.

Finish Pass

The cutting moves made next to a desired profile to complete the part's shape. A finish pass occurs next to the pocket's outer profile and next to each island profile.

Finish Turning

The Finish Turning operation type provides the primary machining parameters for finishing internal or external turning, face, or profiling operations.

Form Hole

Special tool containing a custom edge profile. This tool type typically contains multiple diameters and shoulders, and it is used to finish existing predrilled holes to a specific shape.

Form Hole Making

A hole making operation that uses a tool with multiple cutting diameters.

Form Mill

Special end mill with a custom cutting edge profile. This tool type typically has a non-cutting body diameter as well as a cutting tool diameter. Use the Form Mill tool type to define tools such as Chamfer Mills, Radius Mills, and similar specialty tools.

Gear

A modeling tool that produces "textbook" involute gears.

Generator Curve

The curve that is swept through space, usually along the path of a director curve, defining the shape of a surface or mesh.

Glue Stop

A user command that modifies the existing profile so that, when machine code is created, machine stop occurs, permitting the operator to insert a part clamp before the slug is cut free.

Go

Activates the new sequence according to the input values.

Graphic View

The graphic view provides a visual representation of the process model. Additions or changes to the graphic view are reflected immediately. The displayed model may be viewed from any angle, rotated, moved, enlarged, or panned. You can view the toolpath and make changes quickly and easily.

Grooving

The Grooving operation type provides the primary machining parameters for adding grooves to the internal diameter or external diameter of a turned part.

Group

Use Group to create an active group of elements. You can use the Group Arrow icon or the Group tool palette found on the readout line below the graphic view.

Help

Online Help provides information about each menu item, toolbox, modeling tool, control panel, and dialog box.

Hole Electrode

The tool type used to enter the tool parameters for a Wire EDM hole electrode.

Hot Keys

Shortcut keystroke combinations that provide a quick way of performing a task or setting a mode of operation. The hot key assignments shipped with SmartCAM and information about customizing hot keys are available from the Help menu Keyboard option.

Icon Bar

The icon bar provides shortcuts for accessing SmartCAM functions.

IGES

A universal graphics file format that is used to convert CAD/CAM files from proprietary software systems to a format that can be read by other systems.

Input Fields

Control panels and dialog boxes contain input fields for specific types of information, such as a file name, a line angle, or coordinates. An input field can contain various types of information.

Insert

The Insert function enables you to add geometry. You can add geometry with a step or on a layer.

Internal Groove Tool

A tool used to machine grooves in the inside diameter of a turned part.

Internal Thread Tool

A tool used to create threads on the inner diameter of a turned part.

Internal Turn Tool

A tool used to machine the inside diameter of a turned part.

Job Operations File (`.jof`)

The file that contains the job operations setup information. It is saved when you save the associated process model file. The file has the same file name as the model file and is assigned a `.jof` extension. To use a different job operations setup file, use File—Load Job File to find and load the desired .jof file.

Job Operations Setup

The information about tools, operations, and machines to use for machining a part. It is stored in the job operations file (`.jof`). To enter job operations setup information, select File—Planner to open the Job Operation Planner.

Job Plan

In earlier versions of the software, the job plan file contained the tooling information used by the process model. It had a `.jof` extension. If you open a model file that uses a job plan file, SmartCAM will use the information in the **`.jsf`** file to create a job operations setup (`.jof)` file.
SmartCAM CAM Connections still require the use of a .jsf file when converting CAD files.

Layers

Layer information is CAD geometry. Each layer in a model has one of sixteen colors, and the maximum number of layers is 99. Items such as clamps, fixtures, and material boundaries are examples of geometry to draw on layers and do not represent toolpath. In addition, no tool or operation information is associated with layer geometry.

Level

A specific position on the Z axis of the active work plane's local coordinate system.

LH Tool

Left-hand tool. A tool is left-handed if its flutes twist away from the observer in a counterclockwise direction when viewed from either end of the cutter. Cutting occurs on the left-hand side of the tool for Climb cutting and on the right-hand side for Conventional cutting.

Link Element

A link between a primary and secondary profile. Link elements control wire movement between the top and bottom profiles or elements. Thus they control the final shape of the part cut by the wire.

List View

A list of the elements, tools, steps, work planes, or layers that comprise the process model is displayed in the list view. To change the type of list, select the appropriate tool on the workbench. Additions or changes can be made to items on any of the lists. Changes are displayed in the graphic view.

Live Tooling

Some turning centers include motorized turrets with the capability to perform milling/drilling operations. Live tooling describes the action of the turret's rotary cutting tool motion as opposed to the normal stationary cutting position. The tool is “live” because it rotates.

Lookup

This action button calculates values for Crest Start, Root Start, Root End, and 1st Pass Depth. The information comes from the thread table file, using the Nominal Diameter and Pitch values that you enter.

Machine File

Machine files have an `.smf` extension and consist of a list of questions and options that tell SmartCAM how to format code for your machine. For information about machine files see the *SmartCAM Code Generation Guide*.

Match View

Match generated view. A Show Cut option which returns the generated view to match the existing graphic view orientation.

Material Elmt.

Text/Selection input. Select an element in the material profile. This defines the material boundary profile of which the element is a part.

Menu Bar

The application menu is displayed as a bar across the top of the SmartCAM screen display. Select items from the menu bar to display pull-down menus with selections to open toolboxes, dialog boxes, or submenus.

Mill-Turn

A turning center (machine) that can do both turning and milling operations.

Model Space

The three-dimensional coordinate system used to build the model. The model remains fixed with respect to this coordinate system. Rotating a view is achieved by rotating the geometric model and the model space axes.

Modifylinks

Modifylinks changes the start and end points of link elements between two defining profiles.

NC File

Enter the name of the numeric control code file to be created.

Nested Pocket

A pocket that lies entirely within an island profile.

Nocore Roughing

A Wire EDM roughing process used to generate a continuous toolpath that removes all the material within a boundary without any scrap pieces. Nocore is helpful in those operations where falling scrap can jam the machine or wire.

Nominal Diameter

This is a distance input that specifies the diameter (nominal size), which is the general identification of a thread.

Nub

A special area of uncut material created during spiral roughing at the corner of adjacent roughing passes when the width of cut is greater than the tool radius.

Number of Passes, see *Material Elmt.*

Integer input. Enter the number of cutting passes you want to make. This field is dim if you select a material boundary.

NURBS (Non-Uniform Rational B-Spline Curves)

A method of representing complex sculptured shapes. NURBS geometry can exactly represent points, lines, arcs, conics, Bezier geometry, and conventional B-Spline geometry. A NURB can represent an entire arc or conic without approximation.

Offset Amount

The radius of the wire plus the size of the spark gap between the wire and the material being machined (overburn).

Offset Pass

A cutting pass that is a closed profile along the inside of the boundary profile. Each closed profile is derived from a wall offset of the boundary profile. A closed profile can not cross itself.

Offset Pass Count

The number of offset passes to use when finishing the boundary profile.

Offset Side

The side of the primary profile to which the wire is to be offset as viewed from the direction of tool travel on the primary profile. The choice are Left, Right, and None; None does not offset the tool.

On/Off Switches

On/Off switches are used to set a mode or turn a function or input field on or off. An on/off switch is on when an x appears in the box and off when the box is empty. You can have more than one on/off switch turned on at a time. Click the mouse on a switch to turn it on or off, or TAB to the box and press Enter.

Operation

The process parameters used with a cutting tool to perform a process step.

Option Switches

Option switches enable you to select one of a pair or group of options. Option indicators are round and become highlighted when selected. To select an option from the keyboard, press the Tab key until the desired input field is highlighted.

Outer Profile

A profile that is either an outermost profile or the first profile that is entirely within an island profile.

Outermost Profile

A profile that lies entirely outside any other profile.

Overlap Passes

This is an on/off switch that creates an overlap along the profile after each roughing pass. This eliminates the “stair stepping” that can occur on the profile during roughing passes.

Peck Drilling

The Peck Drilling operation type provides the primary operation and increment parameters for deep hole drilling. Use Peck Drilling for creating holes that require multiple in-feed moves to complete.

Pinch-Turning

This is an industry term to describe two tools simultaneously cutting on opposite sides of a part. The equalized tool pressure stabilizes the material, minimizing deflection, and cuts the part twice as fast.

Pitch (Milling)

The pitch of the tap in inches or a metric unit.

Pitch (Turning)

The distance along the Z axis between adjacent thread crests. The pitch of a thread is the lead divided by the number of starts.

Pocket

A false cavity represented by a set of profiles which contain an outer profile and any number of island profiles.

Polyline Point

A connecting point between two polyline segments in the wire’s movement or toolpath.

Power Change

User command that adjusts the amount of power to the wire during a wire EDM operation. SmartCAM assigns the value you enter in the POWER template.

Pressure Angle

The contact angle between the involute spline curve of the gear tooth. The available pressure angles are 14.5, 20, 25, 30, 37.5, and 45 degrees. The default is 14.5.

Primary Range

Values used to identify the first and last elements of the primary profile. The primary range must not overlap with the secondary range.

Process Model

The interactive graphic image you build which represents true tool motion. It is used to create and modify the actual process for the cutting of parts.

Process Model File

The part model file produced by SmartCAM.

Process Plan Step List

The list of steps which make up one process.

Process Step

The combination of a tool and an operation used to perform one step in a process. Also called a *step*.

Production Turning

Product name for the turning package without any advanced capabilities.

Prof Top

Identifies the top of the profile (thickness) for layers and milling operations.

Profile

A series of related elements linked to create a single geometry feature. Elements in a profile must:

- be linked (The end point of one element is the start point of the following element.)
- be in the same direction
- be assigned to the same tool or layer
- be on the same work plane

An open profile has a separate start point and end point. It may be used to define the outline of a part or a feature. In a closed profile the start point and the end point are at the same coordinate location, thus creating a closed feature such as a pocket or an island.

Profile Start Point

The point on a profile on which the toolpath for that profile begins.

Properties

Assigns machining parameters such as tool selection, depths, tool offset direction, and machine/control behavior to the toolpath.

Pull-down Menu

Selection of a menu item followed by four dots (::) opens a toolbox. Selection of an item followed by three dots (...) opens a dialog box to perform a specific task. Selection of an item followed by a triangle opens a submenu offering further selections.

Rapid Traverse Speed

The rapid speed for the machine.

Read-out Line

The read-out line is visible below the bottom left corner of the graphic view and occasionally in the control panels. The information displayed depends on the task in progress.

Reamer

A non-center cutting multifluted tool used to finish predrilled holes to a precise size tolerance.

Reaming

The Reaming operation type provides the primary operation parameters required to generate precise diameters for existing holes. Use Reaming for reaming holes.

Regen

Regenerate. Erases the results of the previous simulation and returns the display of the material and fixture layers to the window.

Region

An area of material which can be removed by a continuous toolpath without tool retractions.

Remove synch

Modeling tool that enables you to select and delete a pair of matching Wait commands, or all Start, End, and Wait synch commands associated with the active group. Use this tool when you want to modify existing synchronized operations.

Removelinks

Removelinks deletes existing link elements between primary and secondary profiles.

Reset

Returns the input fields to their previous settings or default entries at the time the panel was opened. Use Reset or Revert to clear entries before you enter new information.

Revert

Returns the graphic view display to what it was when you opened the dialog box.

RH Tool

Right-hand tool. A tool is right-handed if its flutes twist away from the observer in a clockwise direction when viewed from either end of the cutter. All tools are assumed to be right-handed. Cutting occurs on the right side of the tool for Climb cutting, and on the left side for Conventional cutting.

Rough Milling

The Rough Milling operation type provides the primary machining parameters for roughing procedures. Use Rough Milling to rough out pockets and create other roughing toolpath.

Rough Turning

The Rough Turning operation type provides the primary machining parameters for roughing procedures during external and internal turning, facing, or groove making operations.

RPM

Select to specify the speed mode.

Secondary Range

Values used to identify the first and last elements of the secondary profile. The secondary range must not overlap the primary range.

Section

The set of profiles in a cavity or pocket created by intersecting the cavity or pocket with a plane at a specified level.

Selector Switches

Selector switches provide short lists of options in a control panel or dialog box. Move the pointer over the selector switch, and click the mouse to display the list of options.

Sequence

Specifies the order of machining operations and toolpath, such as roughing/finishing, drilling/tapping, or feed/speed changes.

Slitting

The process of cutting along single or multiple lines with a single-edge or a gang of circular blades.

Slotting

The process of cutting or punching an elongated hole or rectangular slug.

Slug

A body of material that has separated from the part and fallen out because the wire has cut around it and disconnected it from the rest of the material.

Slugging

The process of creating a shear button by partially punching a hole. The projecting material is used as a locating surface on subsequent operations.

SMF File

A file used by SmartCAM to create machine code. The **`.smf`** file contains information about the machine that will manufacture the part. For more information about machine files, refer to the *SmartCAM Code Generation Guide*.

Snap

The Snap on/off switch appears in the read-out line below the graphic view. An x appears in the box when Snap is on. The box is blank when Snap is off. When Snap is on, the cursor “snaps” like a magnet to the nearest element and displays the element's X, Y, and Z coordinate values. Use Increment to set the pick limit and tolerance for Snap. (See *Increment* in the reference manual for your application.)

Solution Indicators

SmartCAM uses asterisk (*) symbols in the input fields to indicate that entering a value in the field will trigger a solution.

Spindle

The rotational part of a turning machine that holds the part.

Spot Drill

A short, stout drill used to create accurate start hole locations for subsequent drilling operations. This tool typically contains a 90-degree included point angle, and it is often used to spot the hole location to a depth large enough to leave a chamfer on the top of the finished hole.

Spot Drilling

The Spot Drilling operation type provides the primary operation parameters for creating accurate start locations for subsequent drilling procedures. Use Spot Drilling with 90-degree spot drilling tools.

Spot Facing

The Spot Facing operation type provides the primary machining parameters for creating a flat surface in preparation for subsequent machining operations. Use Spot Facing with flat bottom end cutting tools.

Start Hole

A pre-drilled hole or cavity in the part through which the wire can be beaded prior to the start of roughing.

Start Hole Making

The operation type used to enter the primary process parameters for a Wire EDM hole operation.

Station

A specific tool station on a machine.

Station Number

The physical location specified for tool setup on machines with automatic tool changers or turrets. This is related to but separate and distinct from tool number. Although these are usually the same, in cases such as manual tool change and coded tooling, they are different.

Step, see *Process Step*

A unique number for the new step. This field defaults to the number automatically assigned when the Insert action button on the control bar is selected.

OR...

A combination of the tool and the operation used to perform one step in a process.

Stepover Value

The distance between consecutive toolpath passes. The minimum value you can use is 0.0001 inch [0.00254 mm]. If you enter a smaller number, SmartCAM will use the minimum value.

SUPM (Surface Units Per Minute)

Used on the Step dialog box to indicate that the output will be in surface units per minute.

SWEL Commands

The SmartCAM Workplace Environment Language (SWEL) is a set of system commands and symbols used for special configuration of the hot keys or icon buttons. A complete list of commands for customizing hot keys is available by selecting Keyboard—Customizing Hot Keys from the Help pull-down menu.

Tap

A tool with helical threads at a defined pitch used to create internal threads in predrilled holes.

Taper Angle (Turning)

Angle input used to enter the thread angle for tapered threads. This is the absolute angle measured from the centerline of the thread.

Taper Angle (Wire)

Used for 2-axis processes with profiles that represent constant taper surfaces. Creates a constant tool inclination relative to the profile and results in a constant taper surface. Use it for applications such as dies and uniform mold relief (draft).

Taper Change

A user command used to change the taper angle in the profile.

Tapping

The Tapping operation type provides the primary machining parameters for the tapping of holes. Use with solid body taps for creating interior threads in an existing hole.

Template File

Template files have a `.tmp` extension and determine the format SmartCAM uses to generate your code. SmartCAM combines information from the model's database, Job Operations (`.jof`) and machine (`.smf`) files, and outputs it through a template file. For more information about template files, refer to the *SmartCAM Code Generation Guide*.

Thread Depth

Depth of a thread based on its nominal diameter and pitch.

Thread Lead In

This is a distance input in which you enter the incremental distance to start threading before the root start. This enables you to start threading off the end of the part. The default is two times the pitch.

Thread Pitch

The distance from a point on a thread to a corresponding point on the next thread.

Thread Table

This is a text input field in which you enter the name of the thread table you want to use to look up data for the thread diameter. Selecting Lookup enables you to automatically input values to the control panel from values in the thread table.

Threading

The Threading operation type provides the primary machining parameters for adding threads to the internal diameter or external diameter of a turned part.

Title Bar

The title bar is displayed across the top of the SmartCAM screen display. It contains the application name and the current path and file name.

TMP File

A template file (`.tmp`) SmartCAM uses to format information in a process model into the code for a machine. For more information about template files, refer to the *SmartCAM Code Generation Guide*.

To Size

On/Off switch. Turn on this switch if you want the final groove pass to produce the actual groove size. When off, the final pass is separated from the groove size by the amount you specify with finish allowance.

Tolerance

The range of variation permitted in the toolpath creation for an element, or the graphic display of an element.

Tool Graphics

Standard program and user-customized files that display basic machine tool profiles during Show Path operations.

Toolpath

The graphic representation of the tool movement and travel as it machines the part. You can assign toolpath to geometry as you create it, or use Edit—Property Chg—Toolpath to assign toolpath to existing geometry.

Toolpath for a surface usually consists of a polyline mesh that is offset from the surface element based on the remaining stock amount and the cut settings (that is, contact point, tool tip, or center point). SmartCAM uses the surface element, the job operations step, and surface machining settings to create the toolpath.

Toolbox

Each toolbox contains a set of modeling tools used to create and change the model. For example, the Geometry toolbox contains modeling tools that enable you to create geometric elements, such as lines, arcs, holes, and points.

Select toolboxes from pull-down menus or from the workbench. The three most recently used toolboxes are always available in the workbench. The tools in the selected toolbox are displayed in a list below the workbench.

Tooling

Physical “hard” tooling such as cutting tools, forming tools, work-holding tools, and fixtures as well as “soft” meta-tools such as process features.

Tool plane

A tool plane defines the tool's normal orientation to a work plane. You can assign tool planes to an existing work plane and position them at an angle to a work plane.

Traverse Cut

The roughing movement of a tool as it removes excess material.

Triggers

SmartCAM provides a triggering mechanism that gives you more flexibility for defining geometry without completing all of the input fields on a control panel. SmartCAM indicates it is ready to “trigger” a solution for an element by placing an asterisk next to the last required input field.

Turn Rough

Toolbox with modeling tools which enable you to create roughing toolpath for an existing profile.

Twist Drill

A conventional fluted drill used to create blind or through holes. This tool typically contains a 118-degree, included point angle.

Undo

Undo removes the most recently completed operation from the graphic display and the database.

Units

The measurement units, inches or metric, used in the process model. Set the units for a job in the Job Information dialog box in the Job Operation Planner. Do not change the units for an existing job because the Planner will not convert values in existing steps from one system to another.

Up Cutting

The process of clearing chips away from the part during milling operations.

UPM

Specifies the feed mode in units per minute for output.

Vector Angle

The angle at which you want the wire's vector to be tilted for the current polyline control point. Available only when Vector Input is set to QR and after you have identified the first two polyline lines. Q is the variable that sets the tilt to the left or right of the current path direction. R is the variable that sets the tilt forward from or backward to the current path direction.

Vector Offset

The offset location of the wire's vector at the active work plane's Prof Top level. SmartCAM locates the offset by establishing a position directly above the polyline control point on the active work plane's Prof Top level (Z axis). Available only when vector Input is set to UV. U is parallel to X; V is parallel to Y.

View Space

The three-dimensional coordinate system that represents your viewpoint of the model. The origin of the view space coordinate system is located at the center of your computer screen. The XY plane is parallel to the computer screen and the Z-axis points out of the screen toward you. For example, the XYZ coordinate (1,1,0) is located at the upper right corner of your screen. Objects located in view space, such as vector light sources, do not move with manipulations of the model space. Rotating a view, for example, rotates the geometric model and the model space axes while the view space axes remained fixed.

Viewsurf

Enables you to see the surface that will result from the machining process by displaying a simulation. Viewsurf builds a temporary ruled surface on the graphic display between the primary and secondary profiles by using the links in the active group.

Which Solution

When the Which on/off switch is on, you can step through the possible solutions when multiple solutions exist. When it is off, SmartCAM uses the most likely solution.

Width of Cut

The distance (step over) between roughing passes.

Wire EDM Finishing

The operation type used to enter the primary process parameters for a Wire EDM finishing operation.

Wire EDM Roughing

The operation type used to enter the primary process parameters for a Wire EDM roughing operation.

Wire Electrode

The tool type used to enter the tool parameters for Wire EDM wire electrodes.

Work Plane

A flat or level surface on which to work or assign geometry. SmartCAM has three reserved system work planes positioned according to the X, Y, and Z axes to build a process model. You can also define your own work planes.

Workbench

This portion of the screen provides quick access to frequently used toolboxes. The three most recently used toolboxes occupy the three spaces on the workbench. To add a new toolbox to the workbench, select it from a menu.

ZCHK (check distance)

The distance above the Prof Top where the tool starts to feed. #ZCHCK is assigned in the SMF file.

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