

Sommario

DW10ChLength 3

IMPLEMENTATION 3

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DW10ChLength

D = Device(CAM01)

W = Writing functions

The DW10ChLength function is linked with the DC20FlyCut or DC30FlyCut functions and is used in applications of flying cut. It serves to execute the change of length of workpiece.

Are required the calculated array from thee DC20FlyCut or DC30FlyCut functions It must be called before this to perform the calculation with the new length.

The function contains the instructions to Wait inside that block the task in which it appears. It is therefore recommended that you place the function in a task that doesn't need to be run entirely at each program scan.

IMPLEMENTATION

DW10ChLength (CodeG, CodeM, CodeQm, CodeQs, ChExecut, Error)

Parameters:

IN/OUT	VARIABLE TYPE	EXAMPLE NAME	DIM
IN	ARRSYS	CodeG	W Array containing calculated G Code
IN	ARRSYS	CodeM	W Array containing calculated M Code
IN	ARRSYS	CodeQm	L Array containing calculated Master Space
IN	ARRSYS	CodeQs	L Array containing calculated Slave Space
OUT	GLOBAL	ChExecut	F Flag (to toggle) to change the cam
OUT	SYSTEM	Error	B Var error of cam writing

Error

After calling the function, if there are any errors the error variable having the following values:

0 - No errors

1 - Error writing in the areas of cam

Examples

1° Example

```

MAIN:
  IF gfCambioLun
    gfCambioLun = 0
    DC20FlyCut (LunPez, VriferM, VmaxS, TaccS, TdecS, TmAttHome, TmAttFTag, TmTaglio, TmAssest, TmExtraSp, ExtraSpaz,
    CodeG, CodeM, CodeQm, CodeQs, Error, NumSett, LunMin, SpazioRitM, SpazioRitS)
    IF NOT Error
      DW20ChLength (cmCamma, CodeG, CodeM, CodeQm, CodeQs, ChExecut, Error)
    ENDIF
  ENDIF

```

2° Example

```

MAIN:
  IF gfCambioLun
    gfCambioLun = 0
    DC30FlyCut (LunPez, VriferM, VmaxS, TaccS, TdecS, TmAttHome, TmAttFTag, TmTaglio, TmAssest, TmExtraSp, ExtraSpaz,
    CodeG, CodeM, CodeQm, CodeQs, Error, NumSett, LunMin, SpazioRitM, SpazioRitS)
    IF NOT Error
      DW20ChLength (cmCamma, CodeG, CodeM, CodeQm, CodeQs, ChExecut, Error)
    ENDIF
  ENDIF

```

Note

- The 'ChExecut' flag is defined to toggle in that each time the function is invoked and bring to fruition his mission, It changes state (from 0 switch to 1 or vice versa).
- The function contains instructions to wait that block the task that hosts,It is recommended that you create a separate task that contains the function or put the function in a task that can be stopped.

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