

Sommario

DW22ChLength 3

IMPLEMENTATION 3

 Error 3

DW22ChLength

D = Device(CAMMING, CAMMING2, CAMMING3)

W = Writing functions

The DW22ChLength function is linked with the DC2xFlyCut or DC3xFlyCut functions (where $x > 0$) and is used in applications of flying cut. It serves to execute the change of length of workpiece.

To do this it takes arrays calculated by the DC2xFlyCut or DC3xFlyCut function. 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

DW22ChLength (cmCamma, CodeG, CodeM, CodeQm, CodeQs, ChExecut, Error)

Parameters:

IN/OUT	VARIABLE TYPE	EXAMPLE NAME	DIM	
IN	CAMMING / CAMMING2 / CAMMING3	cmCamma	-	Device type to which you can apply the function
IN	ARRSYS	CodeG	W/L	Array containing calculated G Code
IN	ARRSYS	CodeM	W/L	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/L	Error Var in the cam writing

Error

After calling the function, if there are any errors the error variable takes certain values, the meaning of these values corresponds to the variable errcode device.

Examples

1° Example

```

MAIN:
  IF gfCambioLun
    gfCambioLun = 0
    DC21FlyCut (TipoStart, LunPez, VriferM, VmaxS, TaccS, TdecS, TmAttHome, TmAttFTag, TmTaglio, TmAssest, TmExtraSp,
    ExtraSpaz, CodeG, CodeM, CodeQm, CodeQs, Error, NumSett, LunMin, SpazioRitM, SpazioRitS)
    IF NOT Error
      DW22ChLength (cmCamma, CodeG, CodeM, CodeQm, CodeQs, ChExecut, Error)
    ENDIF
  ENDIF

```

2° Example

```

MAIN:
  IF gfCambioLun
    gfCambioLun = 0
    DC31FlyCut (LunPez, VriferM, VmaxS, TaccS, TdecS, TmAttHome, TmAttFTag, TmTaglio, TmAssest, TmExtraSp, ExtraSpaz,
    CodeG, CodeM, CodeQm, CodeQs, Error, NumSett, LunMin, SpazioRitM, SpazioRitS)
    IF NOT Error
      DW22ChLength (cmCamma, CodeG, CodeM, CodeQm, CodeQs, ChExecut, Error)
    ENDIF
  ENDIF

```

Note

- This function always calculates the cam dividing it into 12 sectors.
- As cutting sector retains the number 3.

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