MultiBAZ Description

This document explains the setting possibilities of the Add-On **MultiBAZ**.
With the Add-On **MultiBAZ** parts, supported by different properties, can be assigned to individual machines.
It is important that if more properties are added to the definition, the more it is checked if the part is valid for this machine.

We have attempted to keep the content of the document complete, accurate and under permanent review.
However, due to the continuous development of described software, it is not possible to guarantee up to date and accurate information, integrity or quality of the content at all times.
As far as we are able to detect errors or omissions or those, which have been reported to us, our attempt is to correct these with the following versions.
imos is not responsible for any direct or indirect damages caused by the use or non-use of the presented information or through the use of faulty and incomplete information. The descriptions in this document can be changed at any time without prior notice.

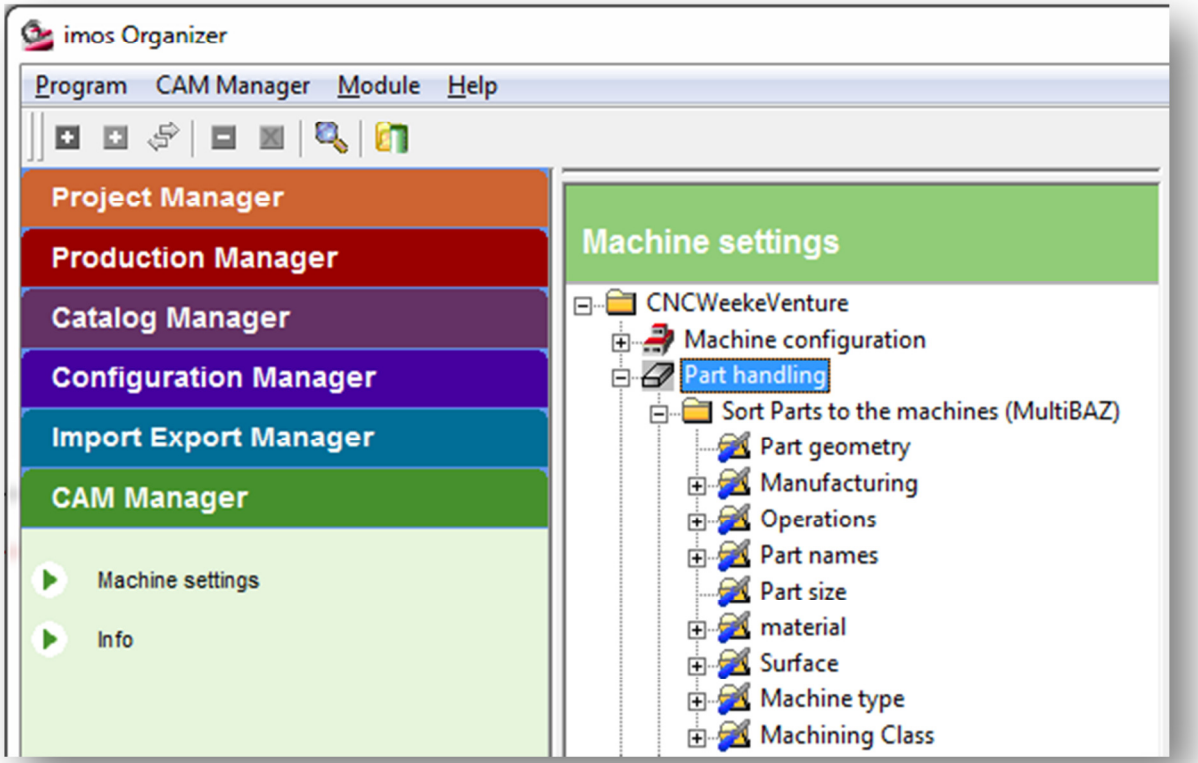
Creation date: June 2015
Used Version: 12.0; Standard CAM Installation mit einer CNC Weeke Venture Maschine

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1. Navigation

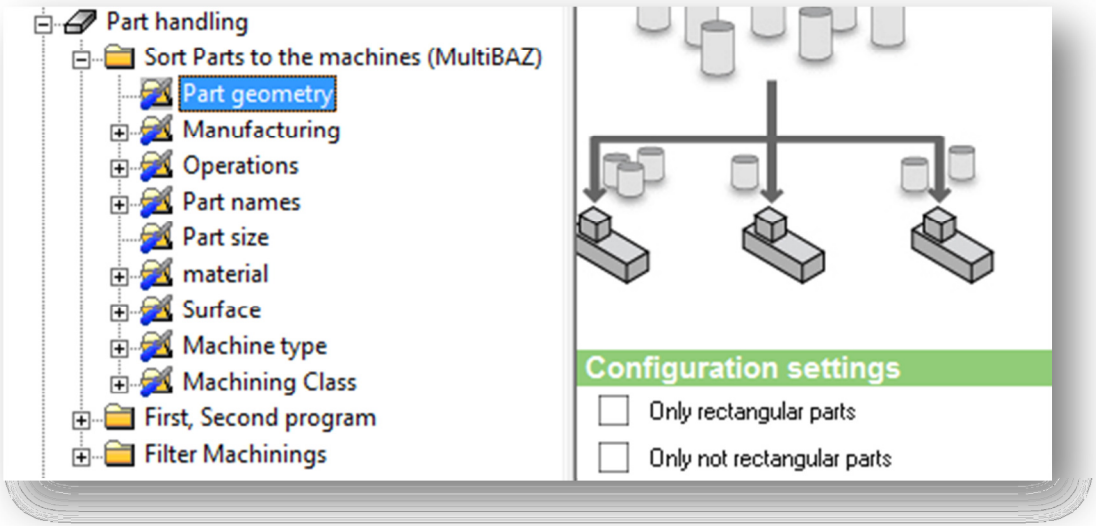
The settings for the MultiBAZ are in the CAM Manager under **part handling/ sort parts to machines (MultiBAZ).**



2. Configuration settings

2.1 Part geometry

Via the part geometry you can define which types of parts of the machine have to be assigned. In doing so, there is a difference between rectangular/straight and not rectangular/straight outer contours.

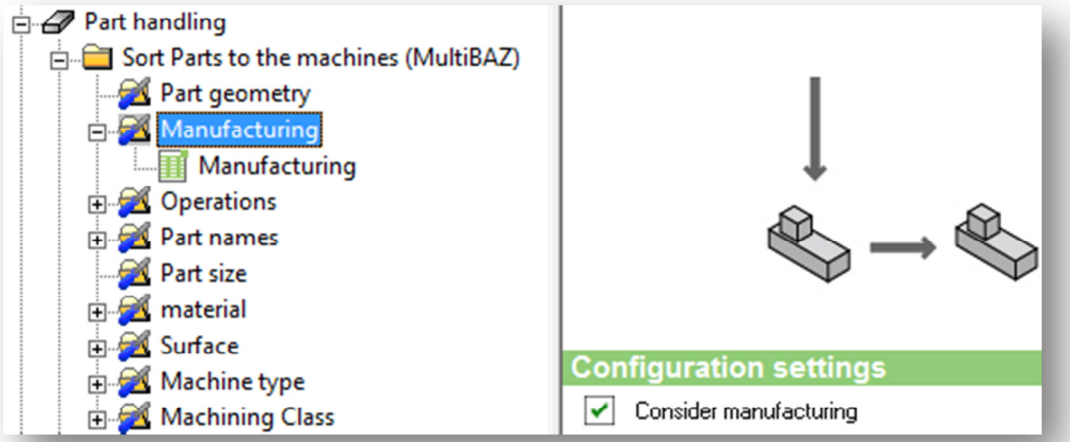


Description	Explanation
Only rectangular parts	The setting means that only rectangular parts are assigned. If a part has a curve or a cut on the edge, then this part is not assigned to the machine.
Only not rectangular parts	This means that only parts with a curve or a cut on one of the edges are assigned here.

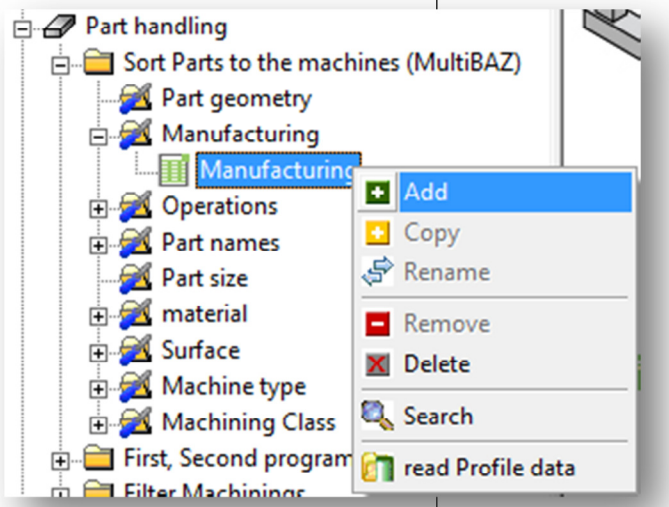
If both checkboxes are activated, no parts approach this machine or no programs are written.

2.2 Manufacturing

If the function **manufacturing** should be considered, the checkbox **consider manufacturing** must be activated in the configuration settings.

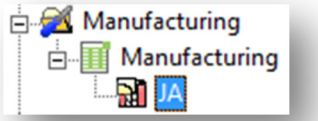


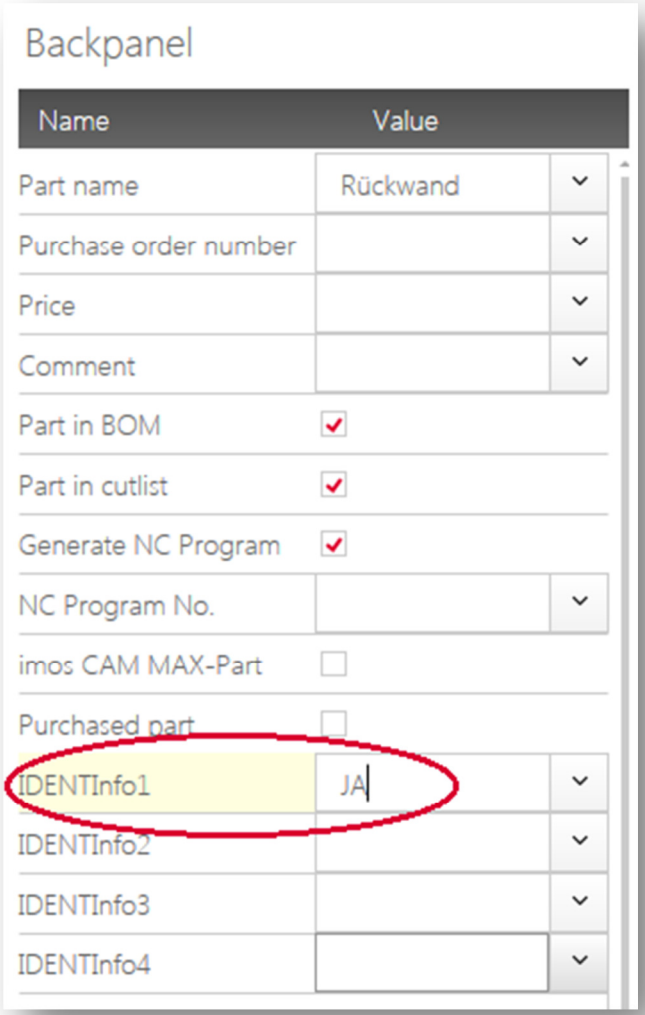
Additionally, the name for the manufacturing must be entered here.
To do this, mark the entry **manufacturing** by clicking once with the right mouse button and select **add** in the context menu.



Here the **IDENTinfo**- Fields from the **manufacturing information** of the part are evaluated.

It is important that a program is written first when the name of the Identinfo Field matches with the one in the manufacturing.



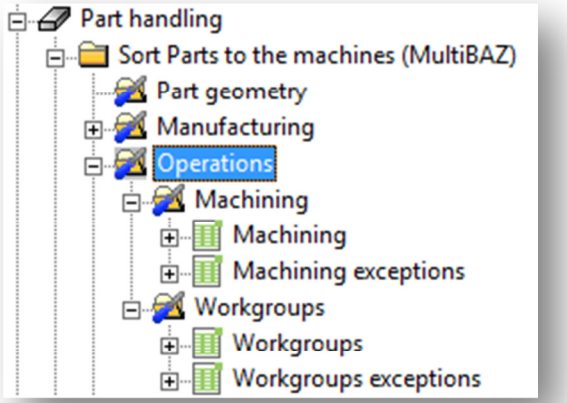


For transferring the data correctly from the CAD to CAM, check if following values are entered in your imos.ini:
[FXM]
MANUFACTURING=IDBGPL.INFO1

You can also insert INFO2, 3 or 4 for “INFO1”!

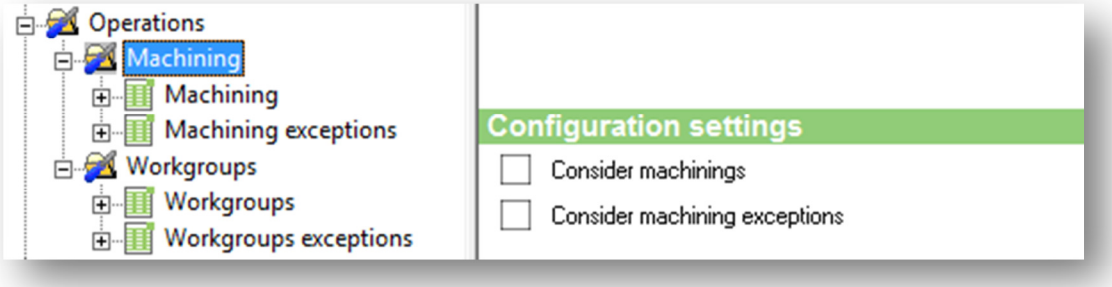
2.3 Part handling

With the support of **operations** and **workgroups** parts can be assigned to individual machines via the **part handling**.



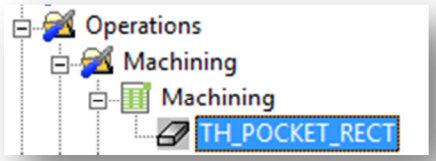
2.3.1 Operations

With the **configuration settings** of the **operations** you can define if the parts with the selected operations of the machine are assigned or not.

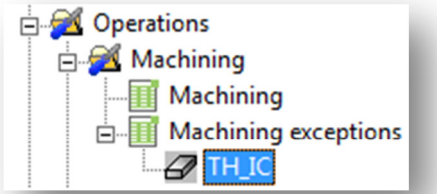


This includes:

- **Consider operations** means that the part with the settings under operations is valid for this property.

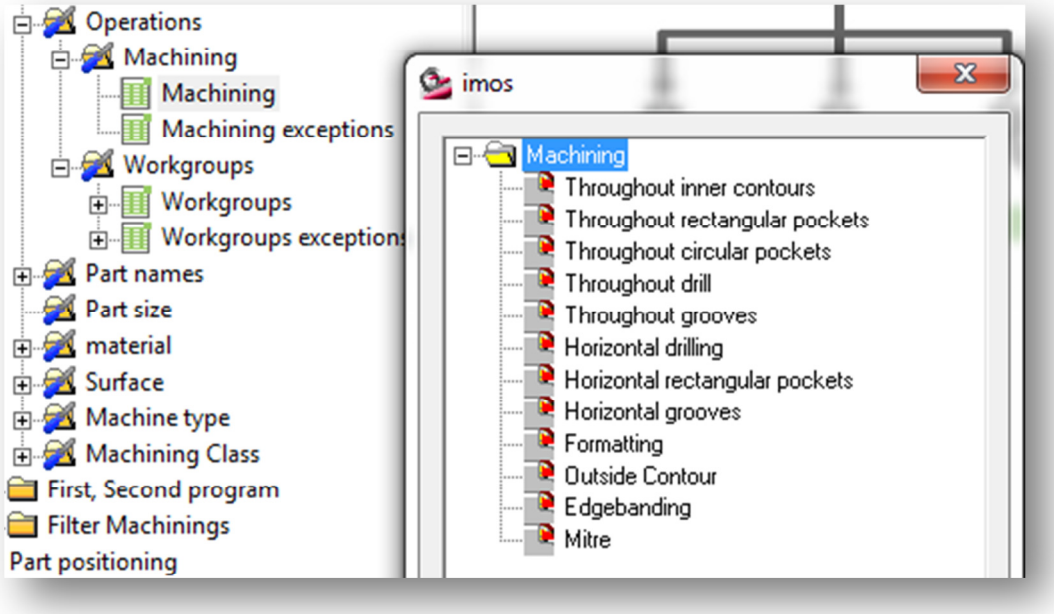


- **Consider machine type exception** means that the part with the settings under **machine exceptions** is not valid for this property.



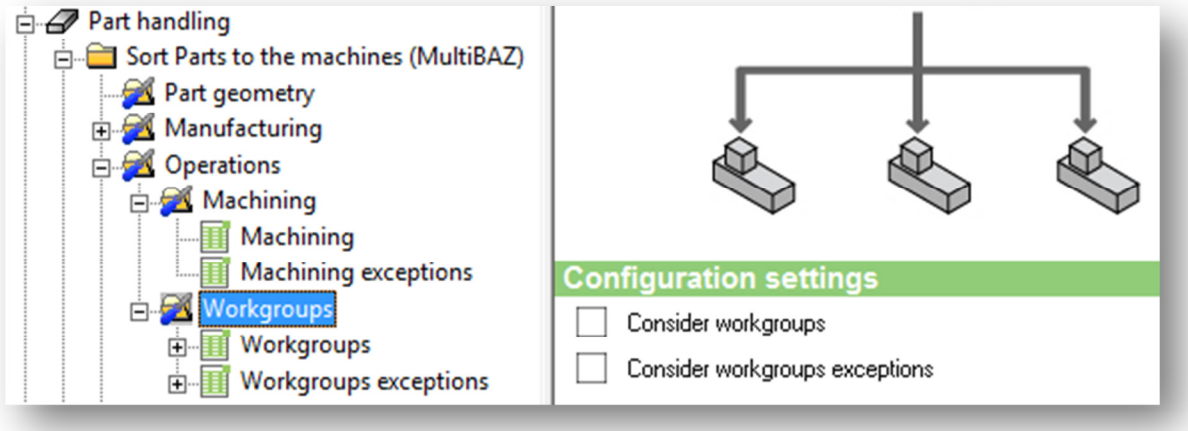
The settings under **operations** and **machine exceptions** are only then effective if the respective checkbox is activated.

By right clicking with the mouse button on the entries **operations** and **machine exceptions**, individual operations can be added.



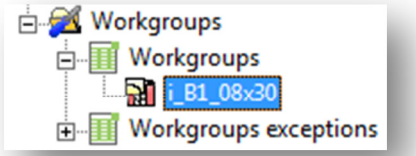
2.3.2 Workgroups

As with **operations** you can select here which parts with the respective workgroups are valid for this machine and which are not.



This includes:

- **Consider workgroups** means that the part with the settings under **workgroups** is valid for this property.



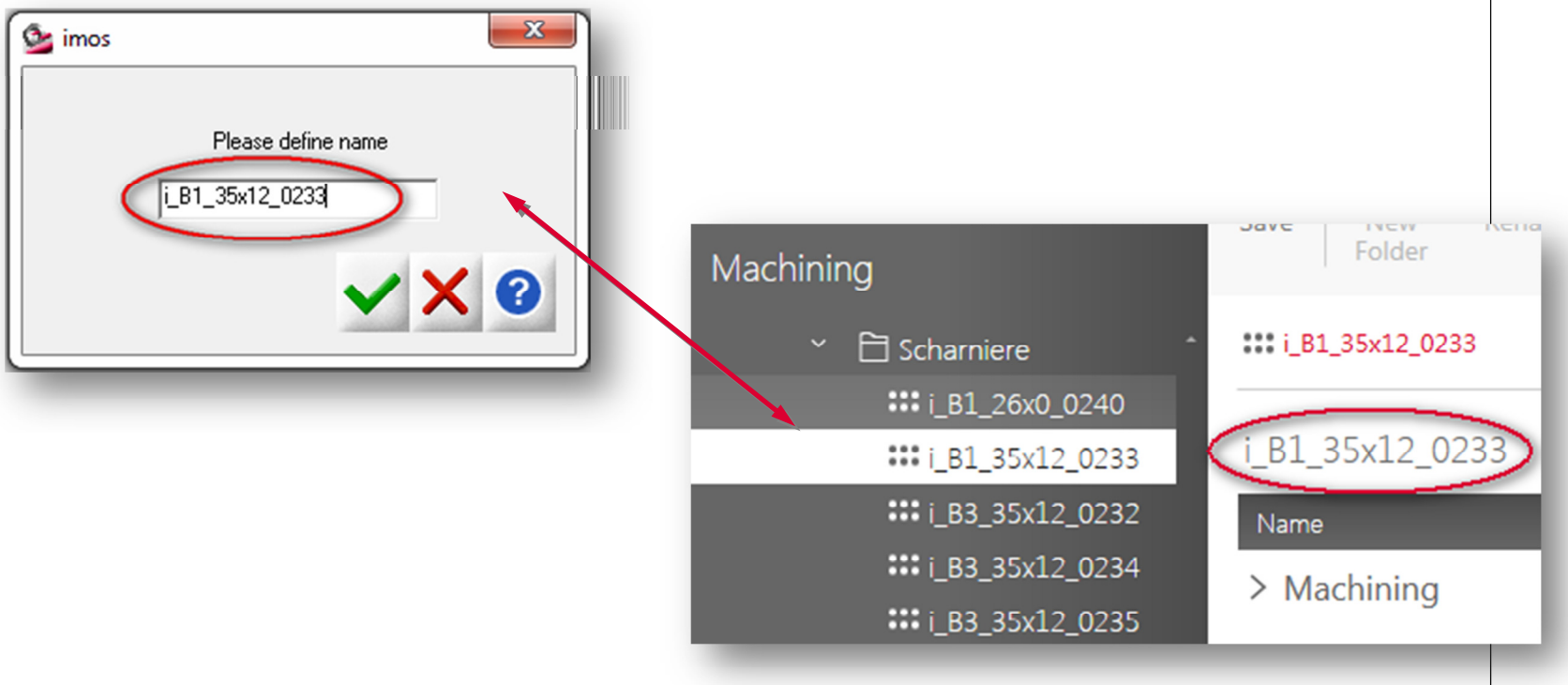
- **Consider workgroups exceptions** means that the part with the settings under **workgroups exceptions** is not valid for this property.

. By right clicking with the mouse button on the entries **workgroups** and **workgroups exceptions**, single workgroups can be added.

The element name must be manually entered here.

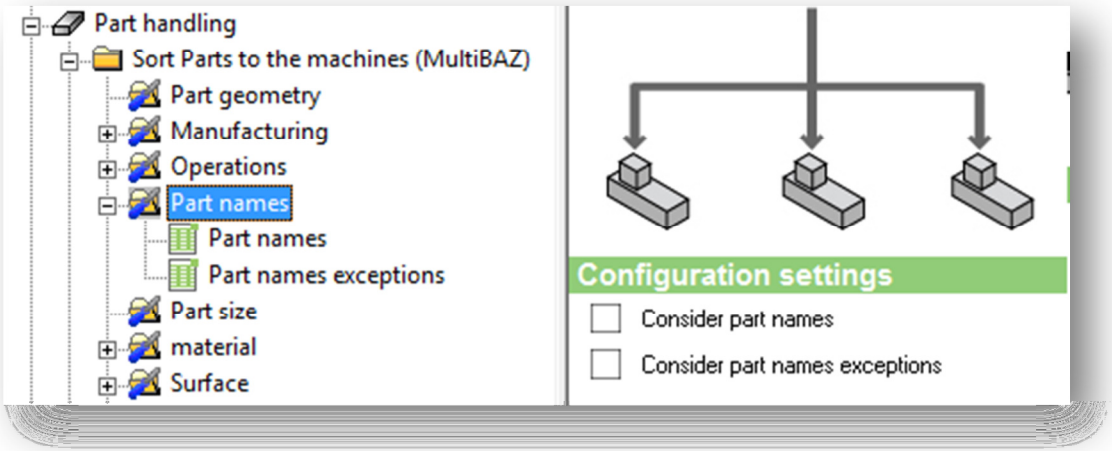
The settings under **workgroups** and **workgroups exceptions** are only effective if the checkbox is activated.

It is important that the name matches exactly with the element name of the workgroup.
Please pay attention to the lowercase and capital letters as well!



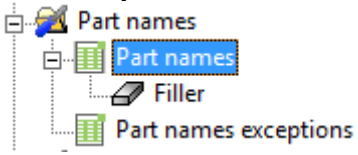
2.4 Part names

Via the function **part names** parts based on their names can be assigned to individual machines.

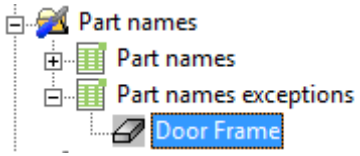


This includes:

- **Consider part names** means that the part with the settings under **part names** is valid for this property.

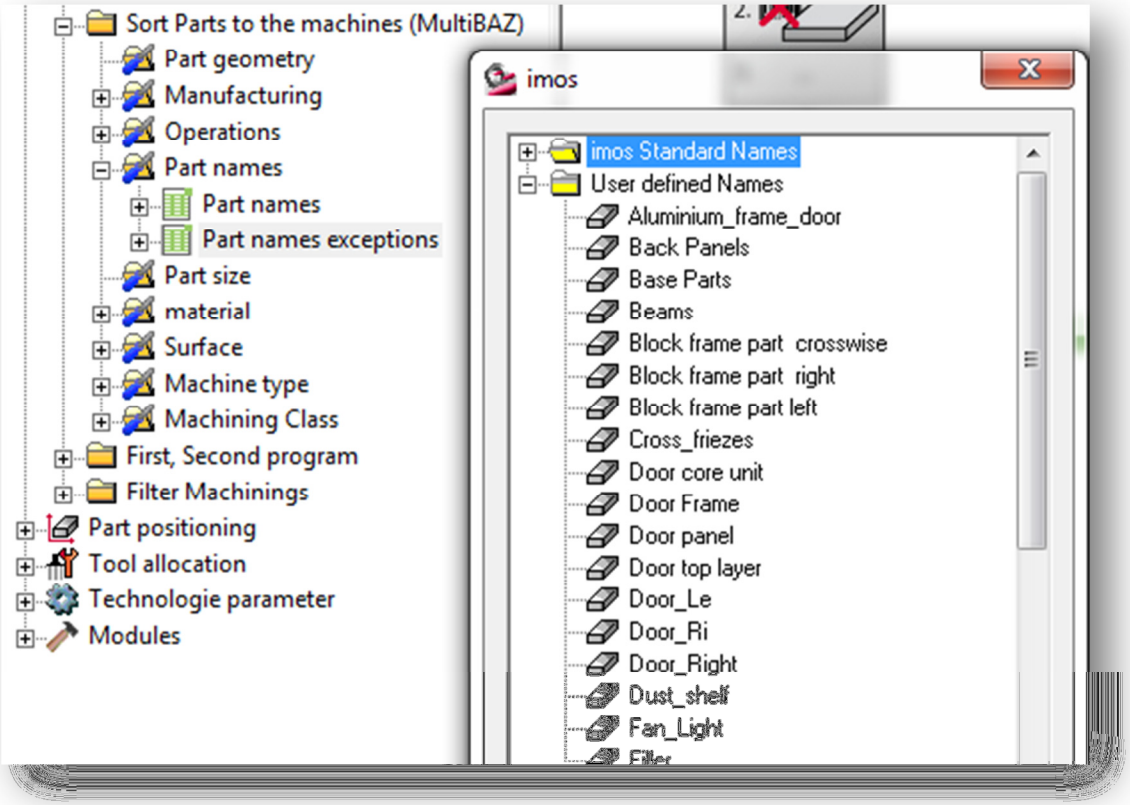


- **Consider part names exceptions** means that the part with the settings under **part names exceptions** is not valid for this property.
-



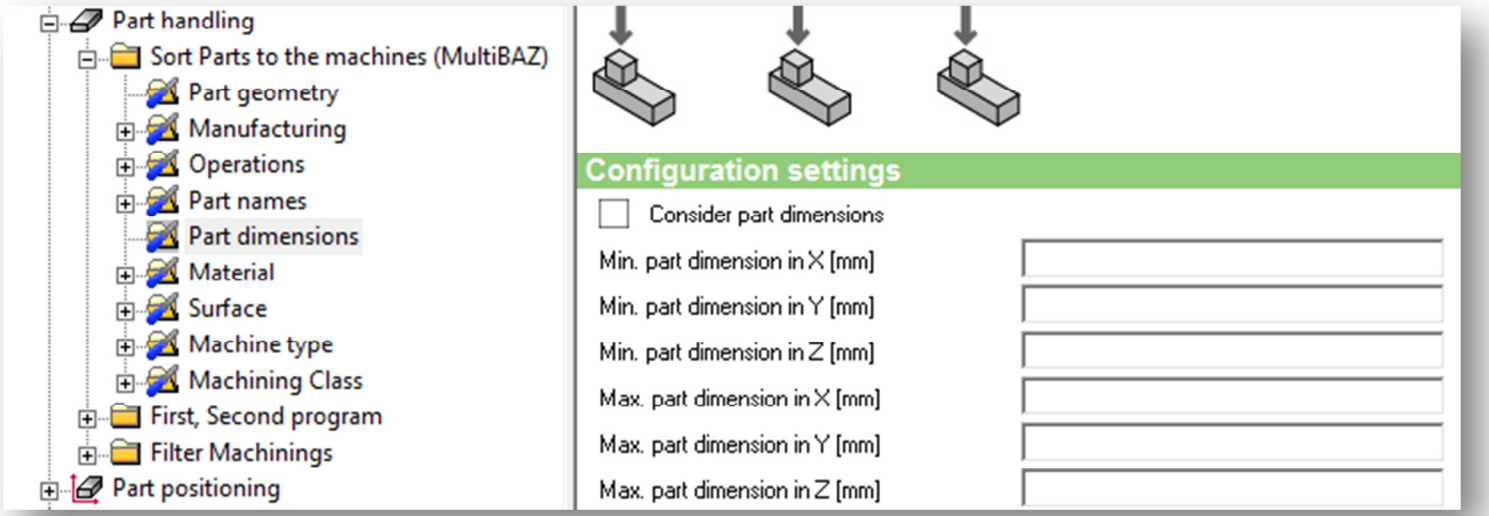
The settings under **part names** and **part names exceptions** are only then effective if the checkbox is activated.

By right clicking with the mouse button on the entries **part names** and **part name exceptions,** the individual names can be added. In addition you can select an **imos Standard names** or the **user defined name** from the **manufacturing information**.



2.5 Part dimensions

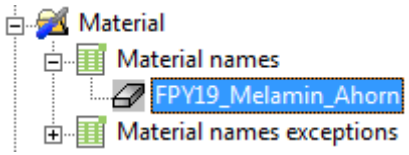
If the checkbox **consider part dimensions** is activated, parts based on the set dimensions of a machine can be assigned. At the same time before generating the program, it is checked if the part is in this area of the defined dimension. If the part is not in the dimension, then no program is generated for this part.

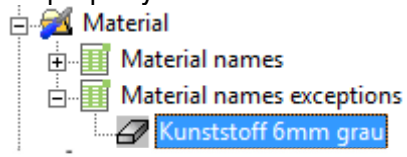


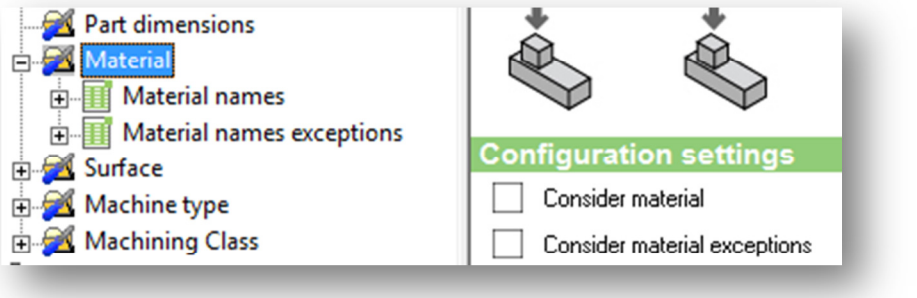
2.6 Material

With the function **material** parts based on the material names (name 1) can be identified and assigned to a machine.

This includes:

- **Consider material** means that the part with the settings under **material names** is valid for this property.
- 

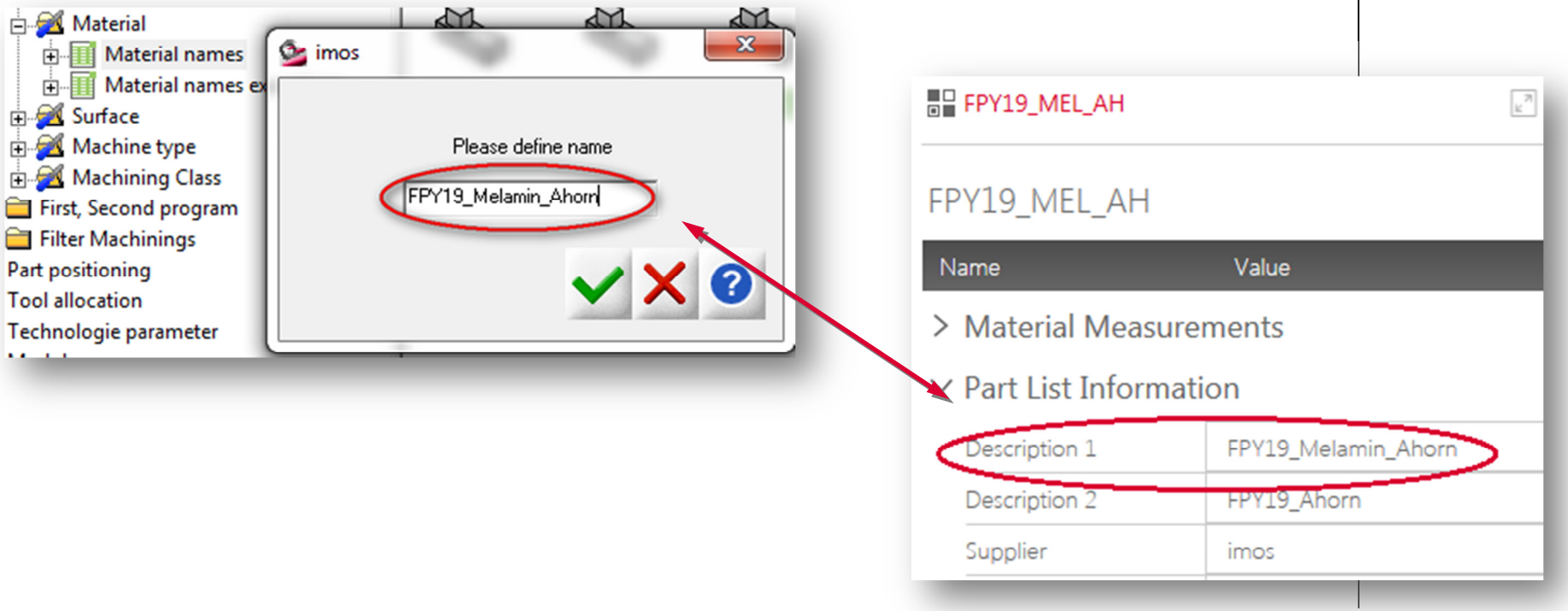
- **Consider material exceptions** means that the part with the settings under **material names exceptions** is not valid for this property.




The settings under **material names** and **material names exceptions** are only then effective if the checkbox is activated.

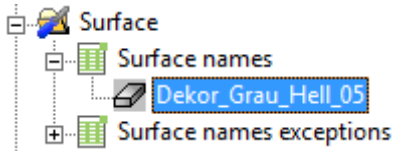
By right clicking with the mouse button on the entries **material names** and **material names exception name 1** of the desired material can be added.
The element name must be manually entered here.

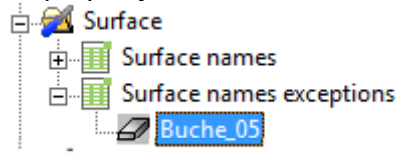
It is important that the name matches exactly with the name 1 of the material.
Please pay attention to the lowercase and capital letters as well!

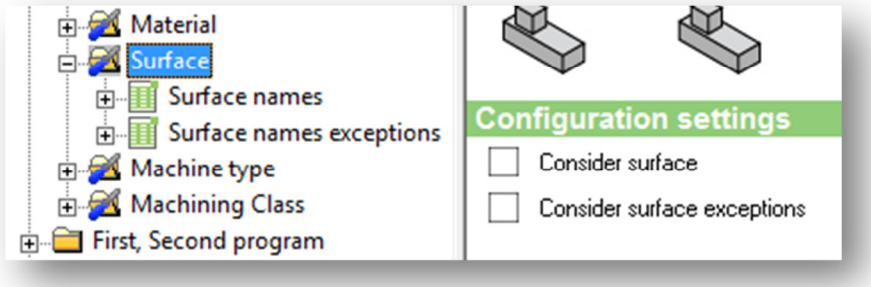


2.7 Surface

With the function **surface** parts based on surfaces (name 1) can be identified and assigned to a machine.
This includes:

- **Consider surface** means that the part with the settings under **surface names** is valid for this property.
- 

- **Consider surface exceptions** means that the part with the settings under **surface names exceptions** is not valid for this property.


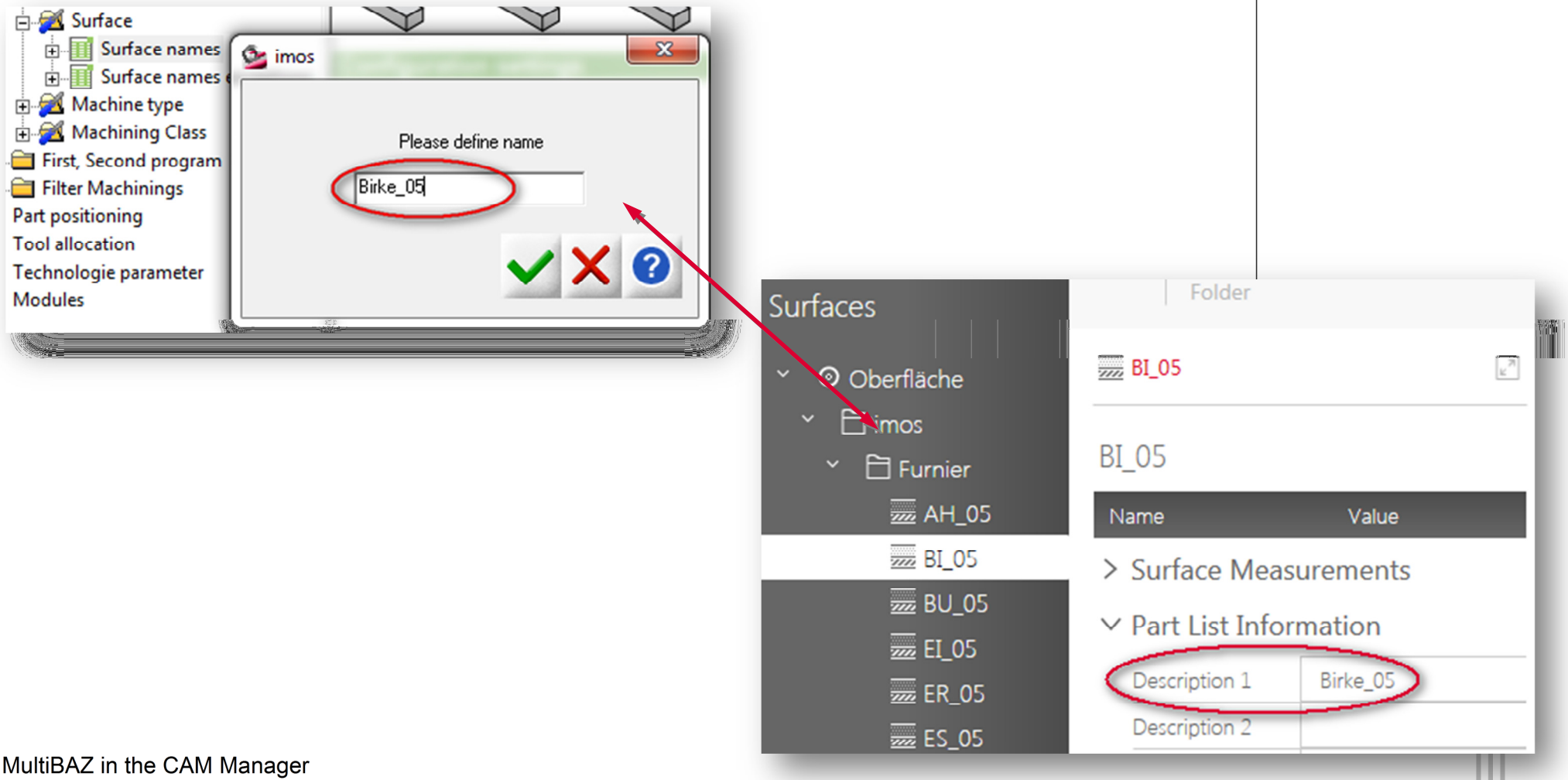


The settings under **surface names** and **surface names exceptions** are only then effective if the checkbox is activated.

By right clicking with the mouse button on the entries **surface names** and **surface names exception name 1** of the desired material can be added.

The element name must be manually entered here.

It is important that the name matches exactly with the **name 1 of the surface**.
Please pay attention to the lowercase and capital letters as well!

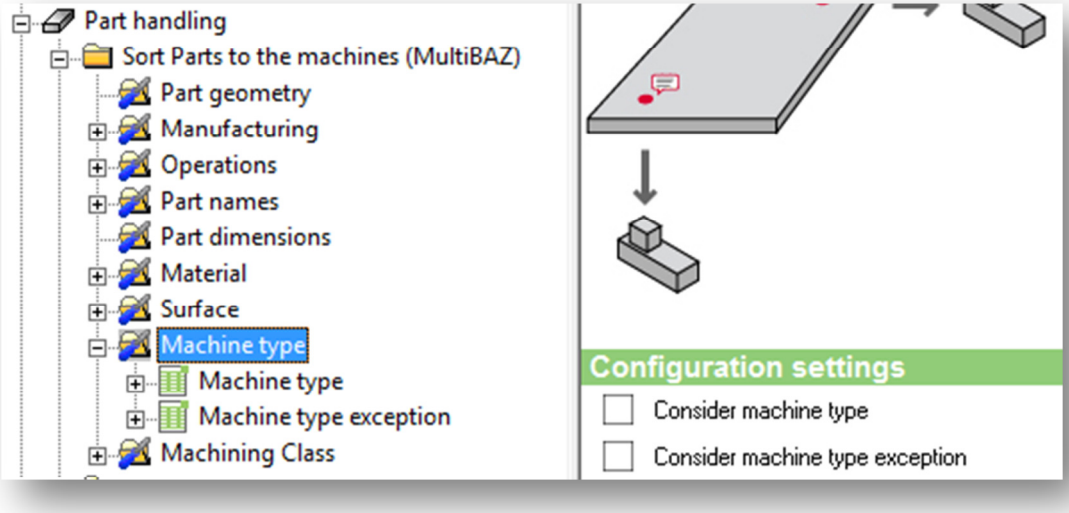


2.8 Machine type

With the function **machine type** parts based on machine types can be identified and assigned to a machine

This includes:

- **Consider machine type** means that the part with the settings under **machine type** is valid for this property.
  Consider machine type exception means that the part with the settings under **machine exception** is not valid for this property.



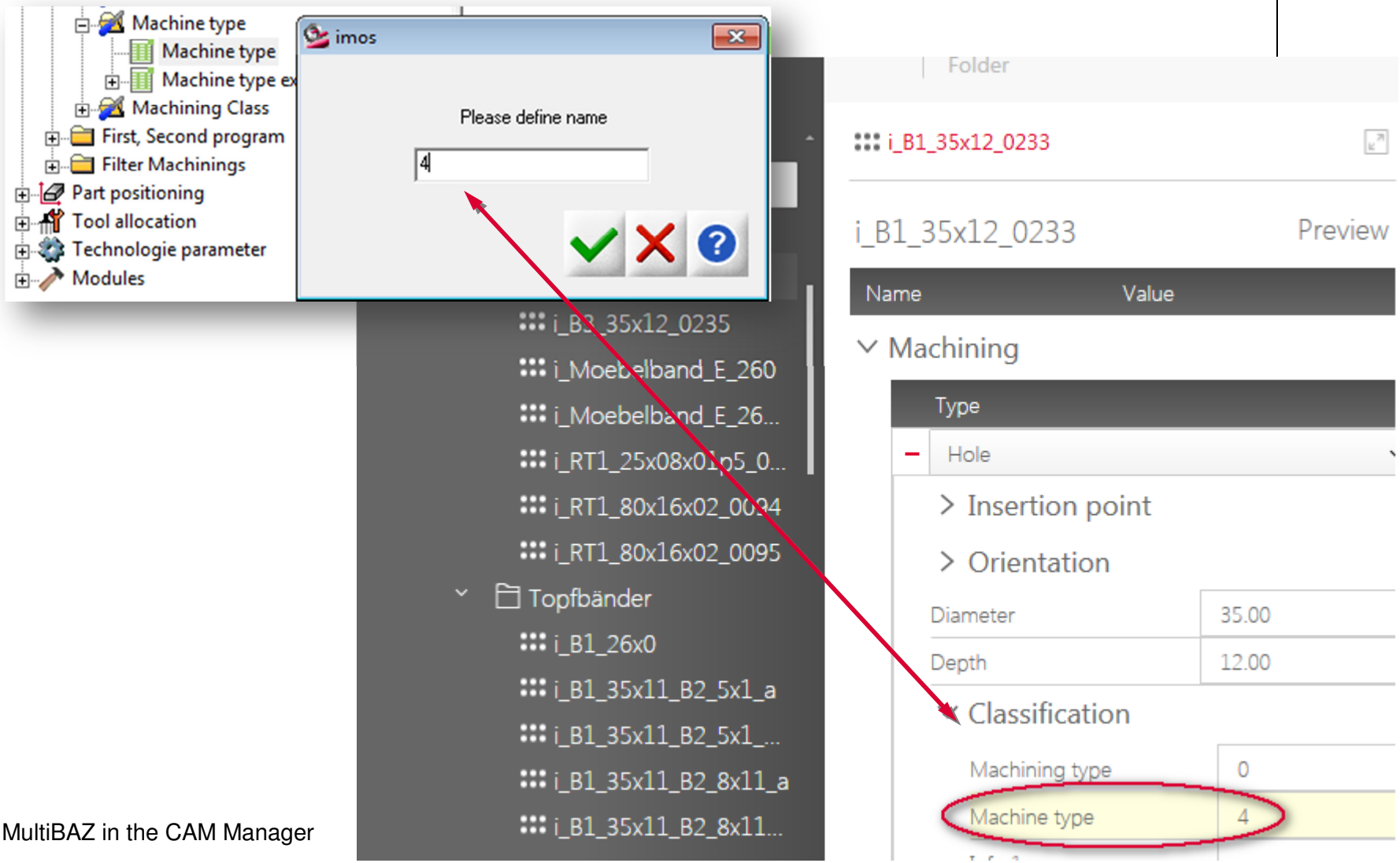
The settings under **machine type** and **machine type exception** are only then effective if the checkbox is activated.

By right clicking with the mouse button on the entries **machine type** and **machine type exception** the **machine type** of the desired workgroup can be added.

The type must be manually entered here.

It is important that the names match exactly!

Only positive numbers can be defined!



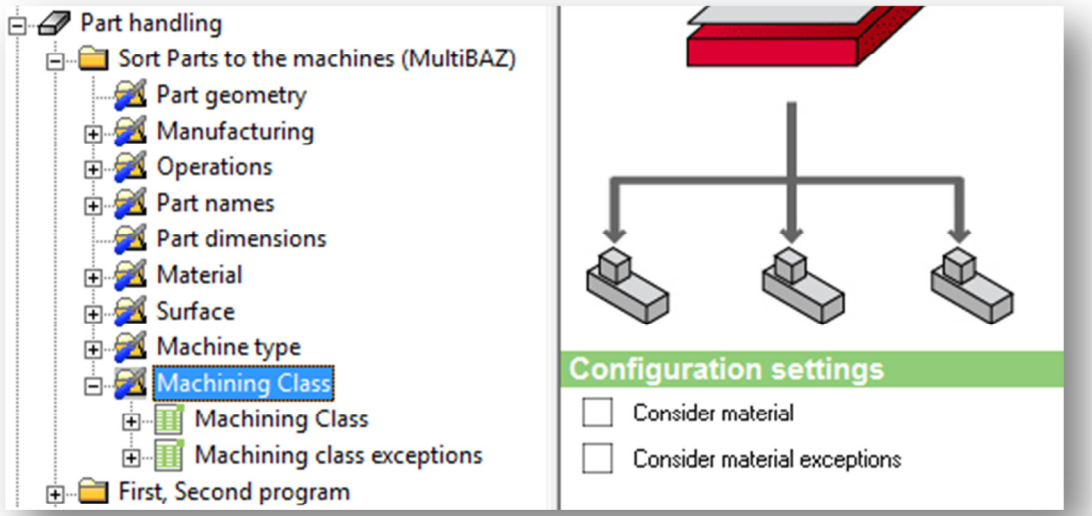
MultiBAZ in the CAM Manager

2.9 Machining class

With the function **machining class** parts based on the machining class of a material can be identified and assigned to a machine.

This includes:

- **Consider material** means that the part with the settings under **machining class** is valid for this property.
- **Consider material exceptions** means that the part with the settings under **machining class exceptions** is not valid for this property.



The settings under **machining class** and **machining class exception** are only then effective if the checkbox is activated.

By right clicking with the mouse button on the entries **machining class** and **machining class exceptions** the **machining class** of the desired material can be added.

