NC-Stop for WOP-Systems

This document describes how to configure a NC-Stop in imos CAM correctly. A NC-Stop can be stored to individual drilling diameters, milling profiles and saw profiles.

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.

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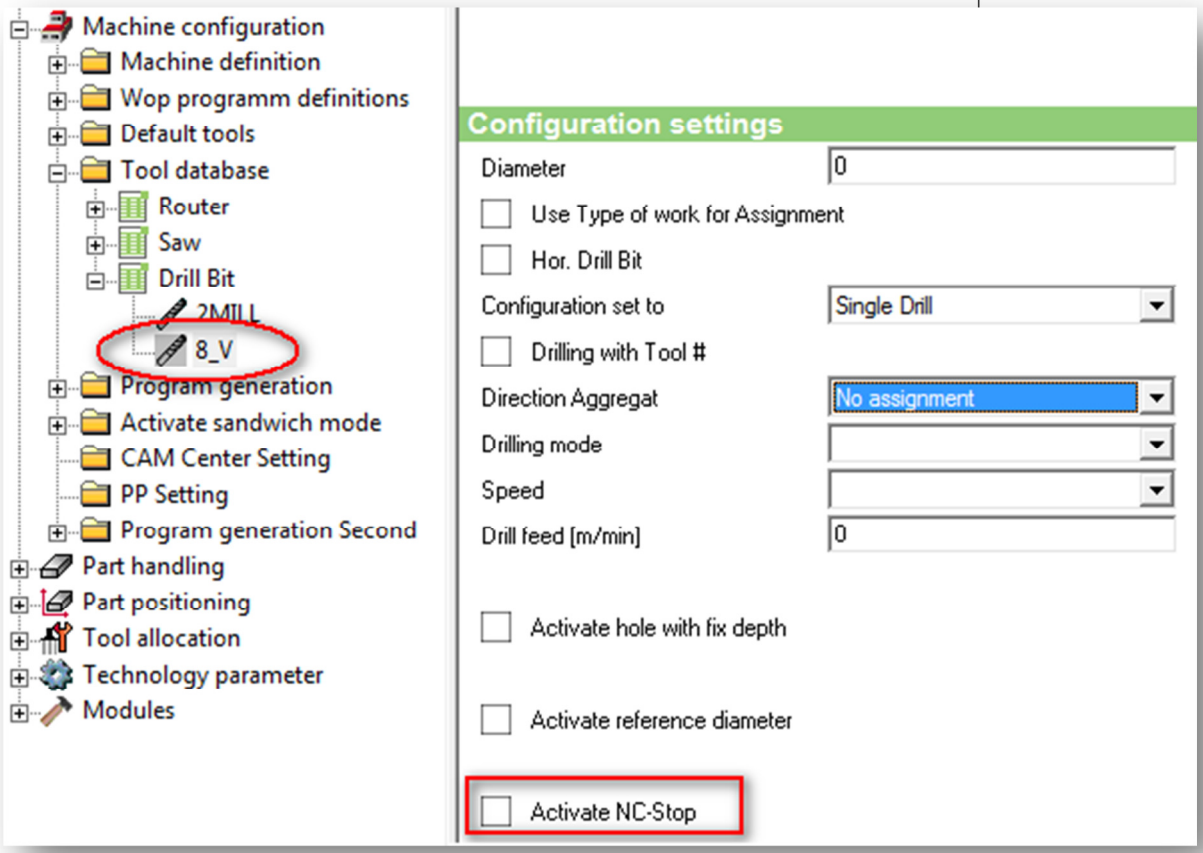
1. Drillings

1.1 Navigation

If a NC-Stop has to be stored on the basis of drilling diameters, change to the tool database first and choose or create the desired drill there.

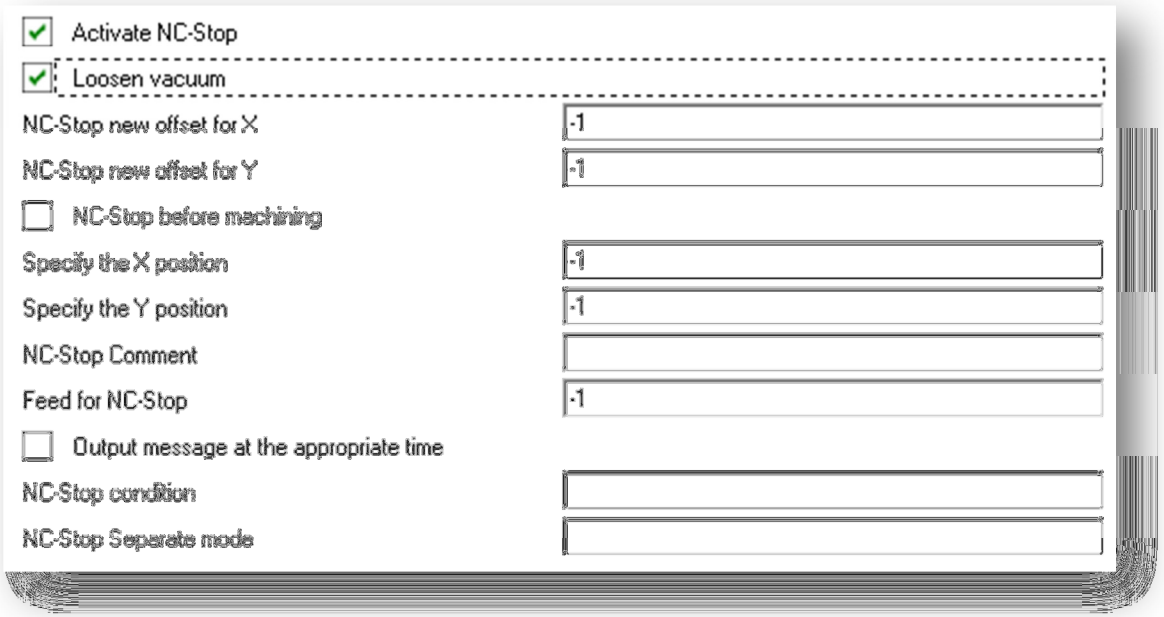
For creating a new drill, right click on drill bit and then **add**.

If the drill is marked in the list, then checkmark the function **activate NC-Stop** in the **configuration settings** on the right side. After activating the checkbox, the NC-Stop for this drilling diameter is set.



1.2 Explanation of individual parameters

With the activated function **activate NC-Stop** the following functions appear below.



Not all parameters are required for every manufacturer. Therefore deviations can occur with some machine configurations.

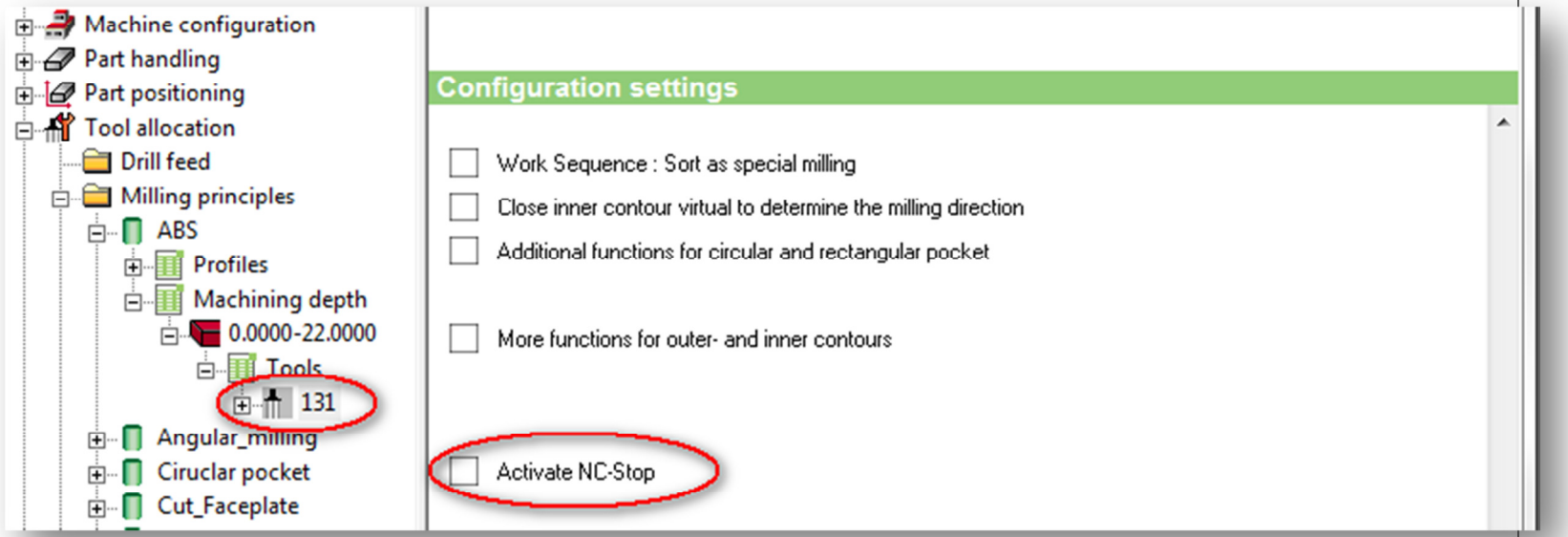
Name	Explanation
Activate NC-stop	If the checkbox is activated, the NC-Stop for this function is written out.
Loosen vacuum	If the checkbox is activated, loosen vacuum is activated.
NC-Stop new offset for X	If the checkbox **loosen vacuum** is activated, an offset can be defined that is later written in the CNC-File.
NC-Stop new offset for Y	If the checkbox **loosen vacuum** is activated, an offset can be defined that is

	later written in the CNC-File.
NC-Stop before machining	If the checkbox is activated, the NC-Stop is set before machining.
Specify the X position	Parameter is required for the alternative position X. If **-1** is entered here, then the complete parameter is not written in the file.
Specify the Y position	Parameter is required for the alternative position Y. If **-1** is entered here, then the complete parameter is not written in the file.
NC-Stop comment	Comment which is later written in the NC-Stop.
Feed for NC-Stop	Defines the feed which is later written in the NC-Stop.
Output message at the appropriate time	If the checkbox is activated, then the checkbox in the NC-Stop for **output message at the appropriate time** is activated.
NC-Stop condition	Condition which is later written in the NC-Stop.
NC-Stop separate mode	The parameter for the ”separate” mode can be defined here.

2. Milling

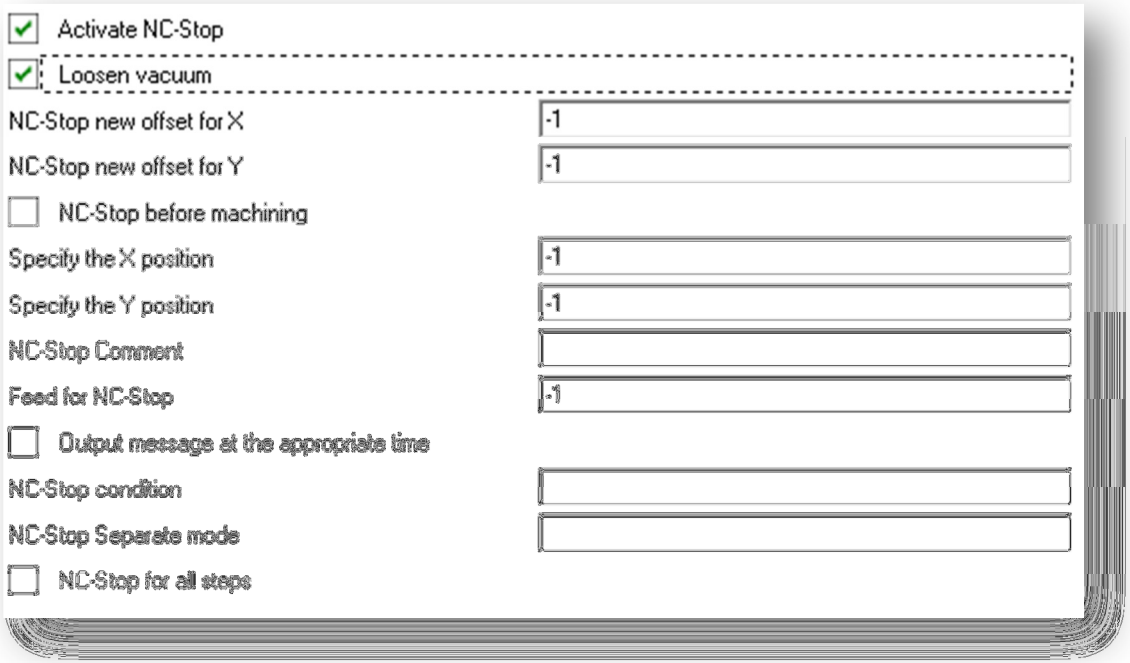
2.1 Navigation

A NC-Stop can be attached to every router of a milling principle. For this purpose, the relevant milling principle must be marked and then checkmark the function **activate NC-Stop** in the configuration settings. Now the NC-Stop is inserted in the NC-Program for this situation.



2.2 Explanation of individual parameters

With the activated function **activate NC-Stop** the following functions appear below.



Not all parameters are required for every manufacturer. Therefore deviations can occur with some machine configurations.

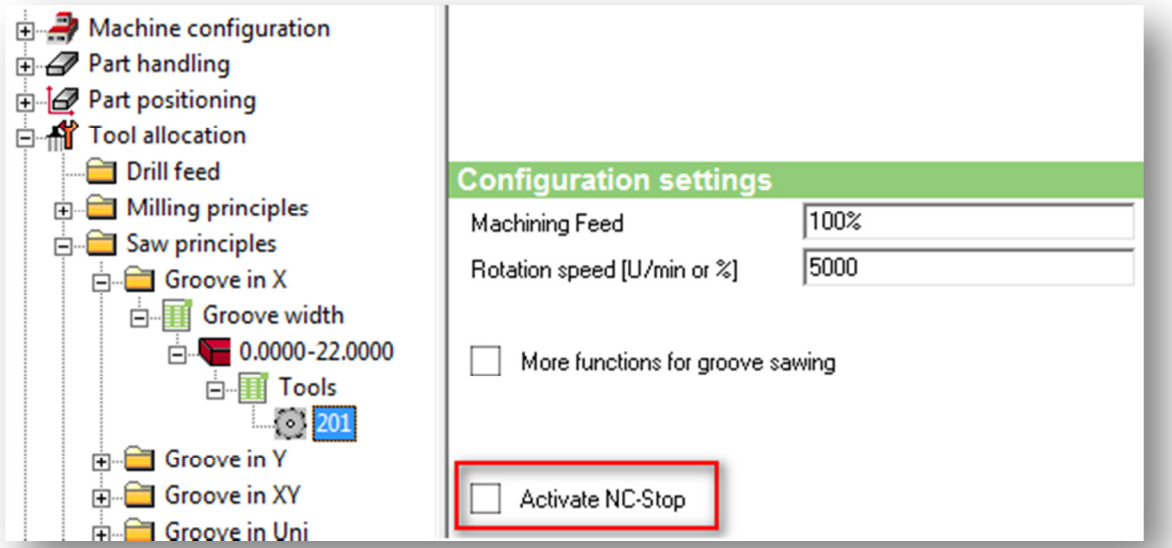
Name	Explanation
Activate NC-Stop	If the checkbox is activated, the NC-Stop for this function is written out.
Loosen vacuum	If the checkbox is activated, loosen vacuum is activated.
NC-Stop new offset for X	If the checkbox **loosen vacuum** is activated, an offset can be defined that is later written in the CNC-File.

NC-Stop new offset for Y	If the checkbox **loosen vacuum** is activated, an offset can be defined that is later written in the CNC-File.
NC-Stop before machining	If the checkbox is activated, the NC-Stop is set before machining.
Specify the X position	Parameter is required for the alternative position X. If **-1** is entered here, then the complete parameter is not written in the file.
Specify the Y position	Parameter is required for the alternative position Y. If **-1** is entered here, then the complete parameter is not written in the file.
NC-Stop comment	Comment which is later written in the NC-Stop.
Feed for NC-Stop	Defines the feed which is later written in the NC-Stop.
Output message at the appropriate time	If the checkbox is activated, then the checkbox in the NC-Stop for **output message at the appropriate time** is activated.
NC-Stop condition	Condition which is later written in the NC-Stop.
NC-Stop Separate mode	The parameter for the “separate” mode can be defined here.
NC-Stop for all steps	If the checkbox is activated and an infeed in Z has been defined, then the NC-Stop is set for every infeed.

3. Sawing

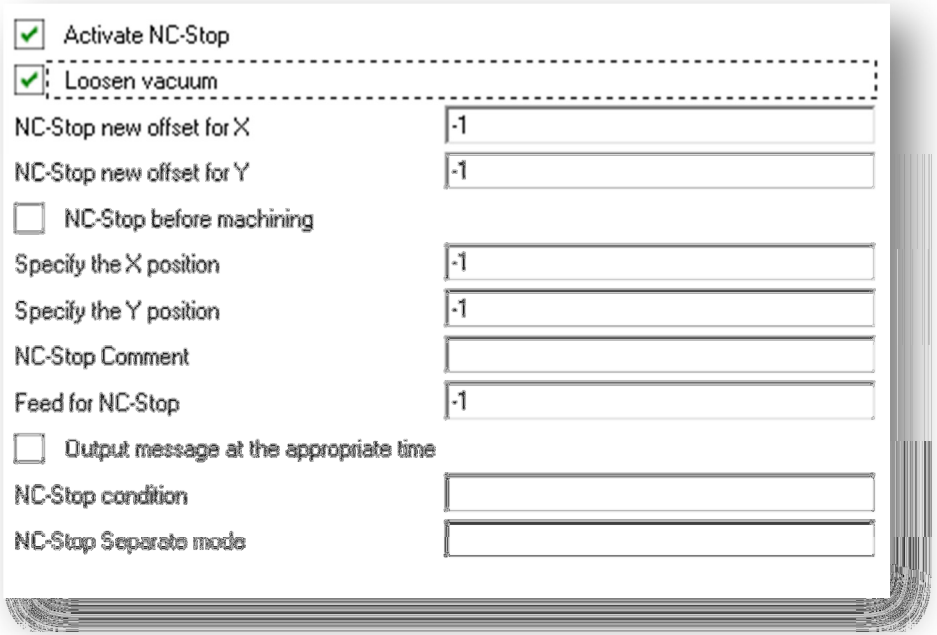
3.1 Navigation for sawing

If a NC-Stop has to be output for sawing, this can be configured via the **sawing principles**. For this purpose, the relevant sawing principle must be clicked in the **tool allocation** and then checkmark the function **activate NC-Stop** in the configuration settings.



3.2 Explanation of individual parameters

With the activated function **activate NC-Stop** the following functions appear below.



Not all parameters are required for every manufacturer. Therefore deviations can occur with some machine configurations

Name	Explanation
Activate NC-Stop	If the checkbox is activated, the NC-Stop for this function is written out.
Loosen vacuum	If the checkbox is activated, loosen vacuum is activated.
NC-Stop new offset for X	If the checkbox **loosen vacuum** is activated, an offset can be defined that is later written in the CNC-File.
NC-Stop new offset for Y	If the checkbox **loosen vacuum** is activated, an offset can be defined that is later written in the CNC-File.

NC-Stop before machining	If the checkbox is activated, the NC-Stop is set before machining.
Specify the X position	Parameter is required for the alternative position X. If **-1** is entered here, then the complete parameter is not written in the file.
Specify the Y position	Parameter is required for the alternative position Y. If **-1** is entered here, then the complete parameter is not written in the file.
NC-Stop comment	Comment which is later written in the NC-Stop.
Feed for NC-Stop	Defines the feed which is later written in the NC-Stop.
Output message at the appropriate time	If the checkbox is activated, then the checkbox in the NC-Stop for **output message at the appropriate time** is activated.
NC-Stop condition	Condition which is later written in the NC-Stop.
NC-Stop Separate mode	The parameter for the “separate” mode can be defined here.

4. Specific Features of SCM

4.1 Output for additional parameters and comments

Via the field **additional Parameter Xilog** the call can be supplemented and comments can be inserted or a call can be added. With **additional commands** comments or a call can be added behind every call.
If a line break has to be made, then a ## must be written in between.
Additionally, existing commands can be added. In order to do this, the parameters must be entered in the relevant parameter line.

