# Pocket cycle

This document explains the configuration settings of the pocket cycles **CAMCenter- contour train (Opt. 3) with correction** and **CAMCenter- contour train (Opt. 4) without correction**.
The pocket cycles are available for rectangular pockets and circular pockets from imos CAM 11.0.

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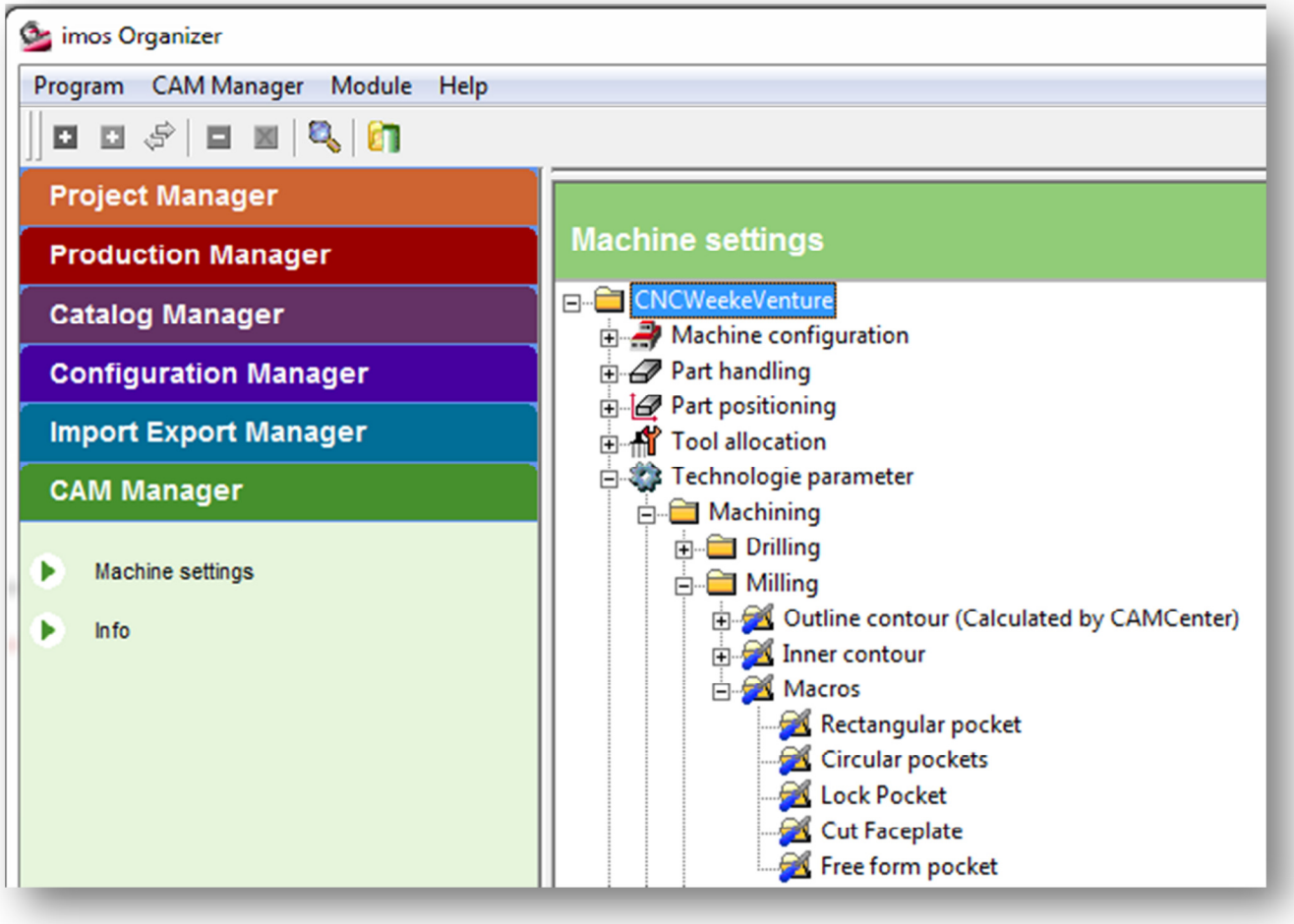
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Used Version: 12.0; Standard CAM Installation mit einer CNC Weeke Venture Maschine

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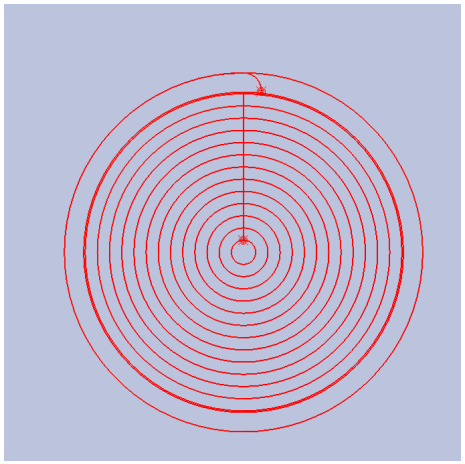
# 1. Navigation

The area for **macros** is in the **technology-parameters** under **machining** / **milling**. This area consists of rectangular pockets as well as circular pockets.

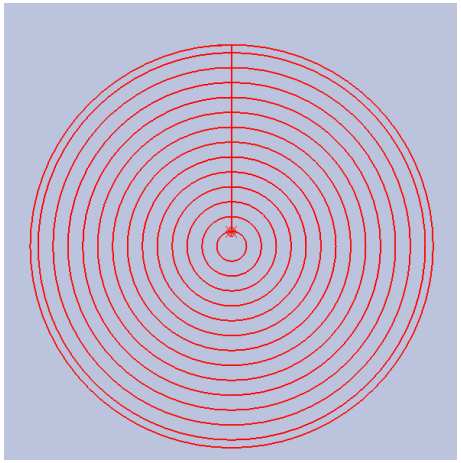



Pocket cycles in the CAM Manager

# 2. General description



With the **CAMCenter- contour train (Opt. 3) with correction** the pocket is first cleaned out and later the pocket is cleanly circled with the tool with correction.



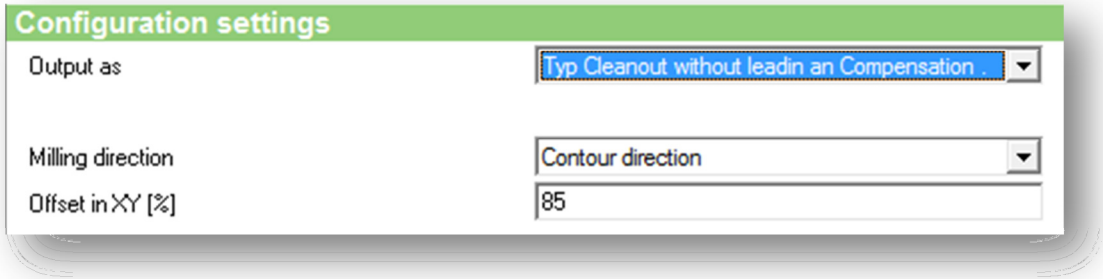
With the **CAMCenter- contour train (Opt. 4) without correction** the pocket is cleaned out in the middle of the path (without correction).

# 3. Pocket cyclesCAMCenter- contour train (Opt. 3) with correction and CAMCenter- contour train (Opt. 4) without correction

## 3.1 Rectangular pockets and circular pockets

In the configuration settings the default settings take place for the output.

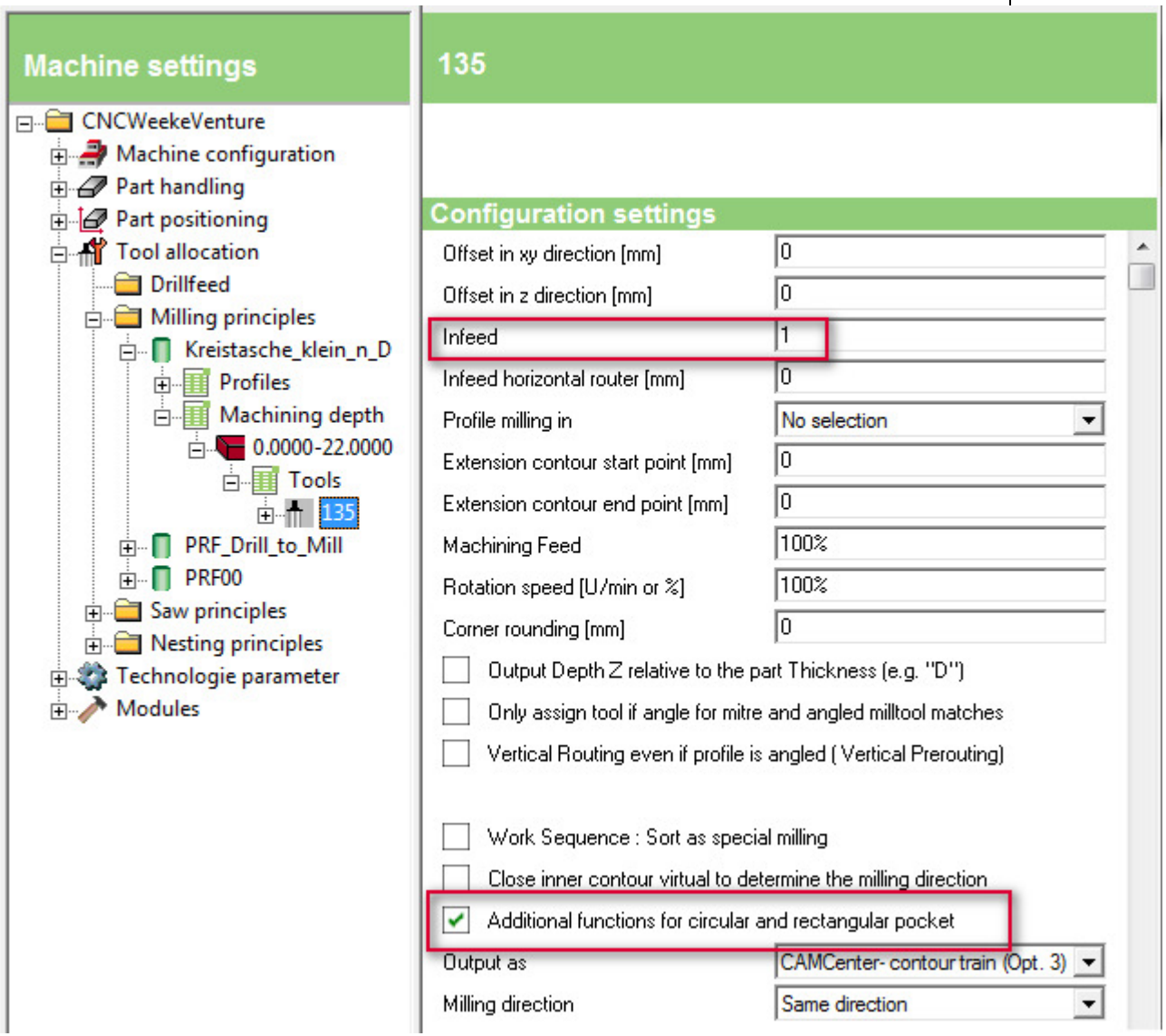
As output the pocket cycles **CAMCenter- contour train (Opt. 3) with correction** and **CAMCenter- contour train (Opt. 4) without correction** can be set here.




| Description | Explanation |
|---|---|
| **Routing direction** | With the routing direction you can decide if the milling should be in **prescoring** or in **scoring.**<br><br>In addition to that it is important how the direction of rotation is set in the **tool database**. |
| **Infeed XY [%]** | The infeed defines how fine a pocket is cleaned out. |

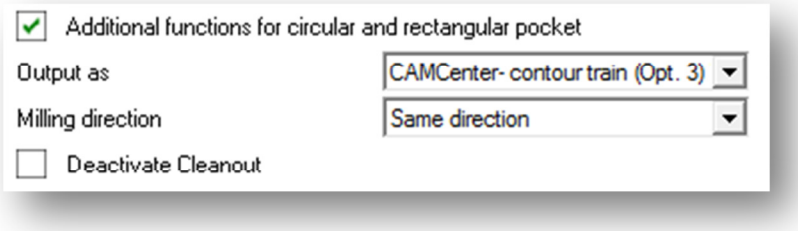
## 3.2 Configuration in milling principle

In the milling principles of the **tool allocation** additional fine settings for the pocket cycles **CAMCenter- contour train (Opt. 3) with correction** and **CAMCenter- contour train (Opt. 4) without correction** can be made in addition to the technology parameters.




Pocket cycles in the CAM Manager

| Description | Explanation |
|---|---|
| **Infeed** | For the cycles **CAMCenter- contour train (Opt. 3) with correction** and **CAMCenter- contour train (Opt. 4) without correction** an own infeed can be deposited for every tool assigned with a milling principle.<br>For example, following allocations can be defined for the infeed:<br>**1:1** => The pocket can be divided in two infeeds<br>**3mm:1** => first infeed is 3mm and then it is milled on pocket depth |




If the checkbox **additional functions for circular and rectangular pocket** is activated, then further configuration settings for the milling principles appear.

With the activated function only the following configurations take effect and not the configurations from the technology parameters anymore.

| | |
|---|---|
| **Output as** | Here you can select between the pocket cycles **CAMCenter- contour train (Opt. 3) with correction** und **CAMCenter- contour train (Opt. 4) without correction.** |
| **Deactivate Cleanout** | The cleanout of the pocket is deactivated. |

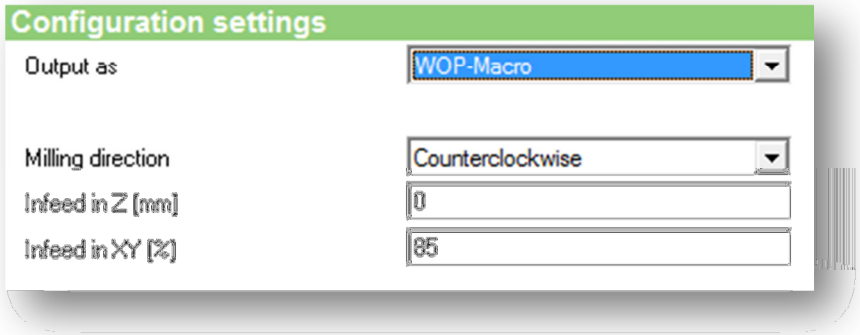
# 4. Pocket cycles as WOP-Macro

## 4.1 Rectangular pocketsand circular pockets

In the configuration settings the default settings take place for the output.

**WOP-Macros** can be defined for the output here as well.

This configuration setting cannot be applied for all manufacturers!




| Description | Explanation |
|---|---|
| **Milling direction** | With the milling direction you can decide if the milling should be in **prescoring** or in **scoring.**<br>In addition to that it is important how the pocket is cleaned out. |
| **Infeed in Z [mm]** | Defines the standard infeed of the pocket in Z-direction. If no infeed is defined in CAD, then this infeed is activated. |
| **Infeed XY [%]** | The infeed defines how fine a pocket should be cleaned out. |

## 4.2 Infeed for Wop-Macros for different pockets

If the output as **Wop-Macro** is executed, an **infeed** can be deposited in CAD in addition to the default infeed.
These are in the **methods rectangular pockets or circular pockets** under the **technology data**.

