Variables for Wop-Systems

This document describes how variables from the imos FXM Header are correctly entered in the CNC-Output.

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.
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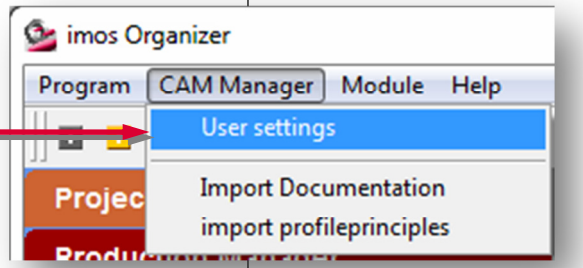
Creation date: June 2015
Used Version: 12.0; Standard CAM Installation with an CNC Weeke Venture machine

Content

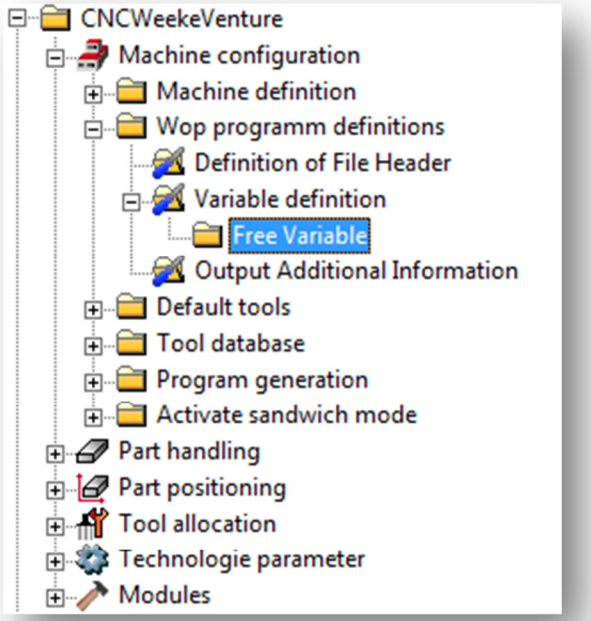
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1. Navigation

For setting the variables, the user interface in the CAM Manager must be switched to **Service**-Mode (Usergroup=9).



It is only then possible to find the folder for the die **Wop- Program definitions** in the profile class **machine configuration**.
The function **define variables** is in this folder as well. Here the settings for the variable can be made.



2. Settings for the System variables

The following settings can also be defined in the **configuration settings** if **define variables** is selected in the structure tree.

Option	Explanation
Separator, which separates the comment of the value	The Separator is for separating name, value or comments in a line. Only one separator can be shown (e.g.. ;,.:). 
Removing special characters	Defines which special characters should be removed to not appear in the transfer. 

2.1 Definition and composition of variables



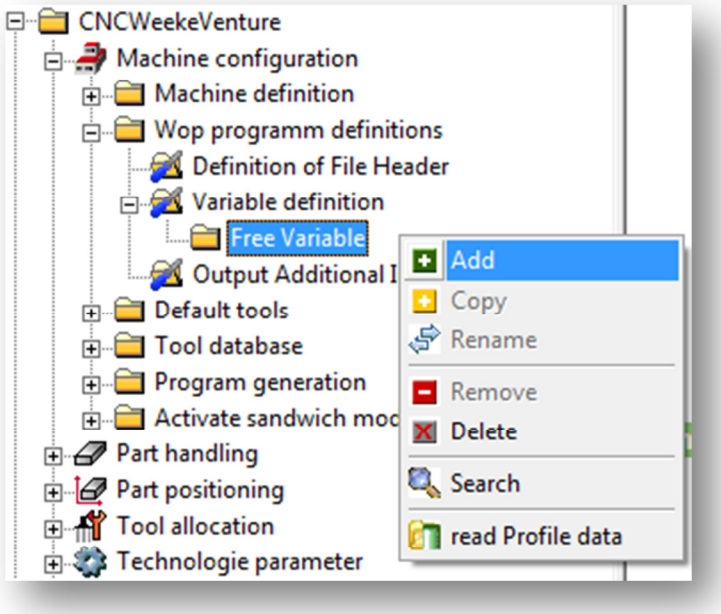
If a variable has to be written out, then the name of the variable must be written in the field first.
Via the previous defined separator (in this case it is **;**) the name of the variables can be separated and then a comment can be written behind it and later both are written in the CNC-File. If the field is empty, no entry is written in the CNC-File.

3. Settings for own variable

If an own variable should be assigned for the CNC- Program, then this can be created via the **free variable**.
These variables are written in every program.

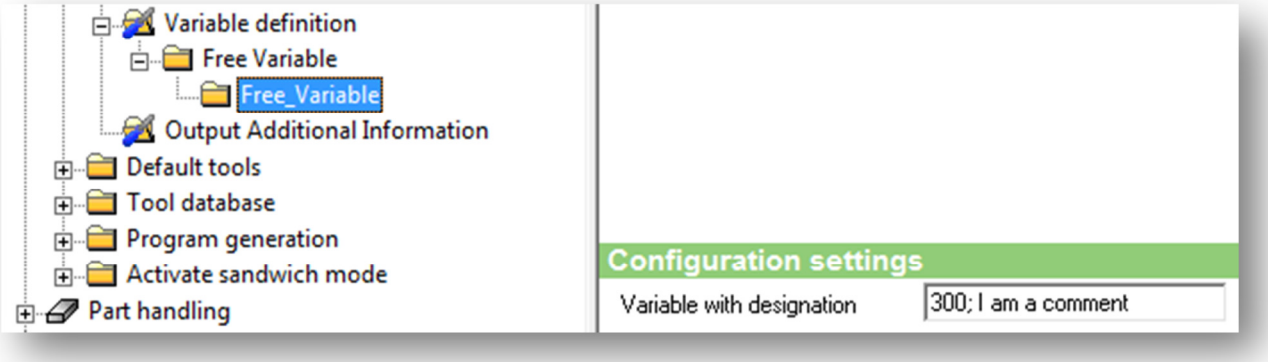
3.1 Data sytem of free variables

For creating a free variable, the entry **free variable** must be selected in the structure tree by right clicking and then select **add** in the menu.
Confirm the entry of the variable names with the green checkmark. The name entered here is written in the CNC-File later.



When the new entry is marked, the variable can be written via the configuration setting.

First enter the value of the variables in the field **variable definition**. Then the comment is separated via the separator. The entered comment is written in the CNC-File as well.



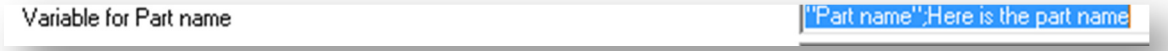
4. Special features with NC Hops

4.1 Variable Export

If the function **Variable Export YES** is required, the checkbox must be activated in the variable definition.
This applies for all variables!



4.2 Output of texts for the Hops Variables



For transferring character strings in Hops, the variable name must be set in **“ “**.
Only then the value is written in the file as follows:

Part name:= ‘Side‘; *VARREF* Here is the part name**

5. Special features with SCM

5.1 Switch from L to PAR Variable type

If no variable of the type L should be output, then the variable of **Type PAR** can be output.
For this purpose, the following checkbox must be activated.
This function applies for all variables which are configured in the profile class **define variables**.



5.2 Variable list

With the support of the variable list a variable list can be attached to SCM Header. Enter the complete path with the file name.
Please, omit “, because this mounts to the postprocessor!

