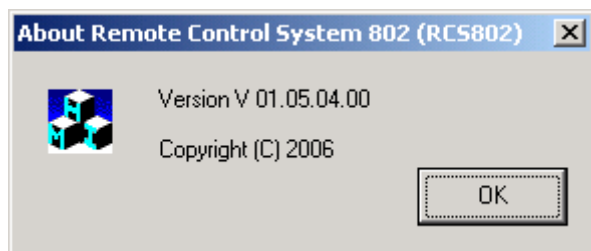


802Dsl 标准循环的制作

版本信息

802Dsl : V01.40.21.00 (Pro/Plus/Value)

RCS802:



循环的制作

一、循环画面的定义

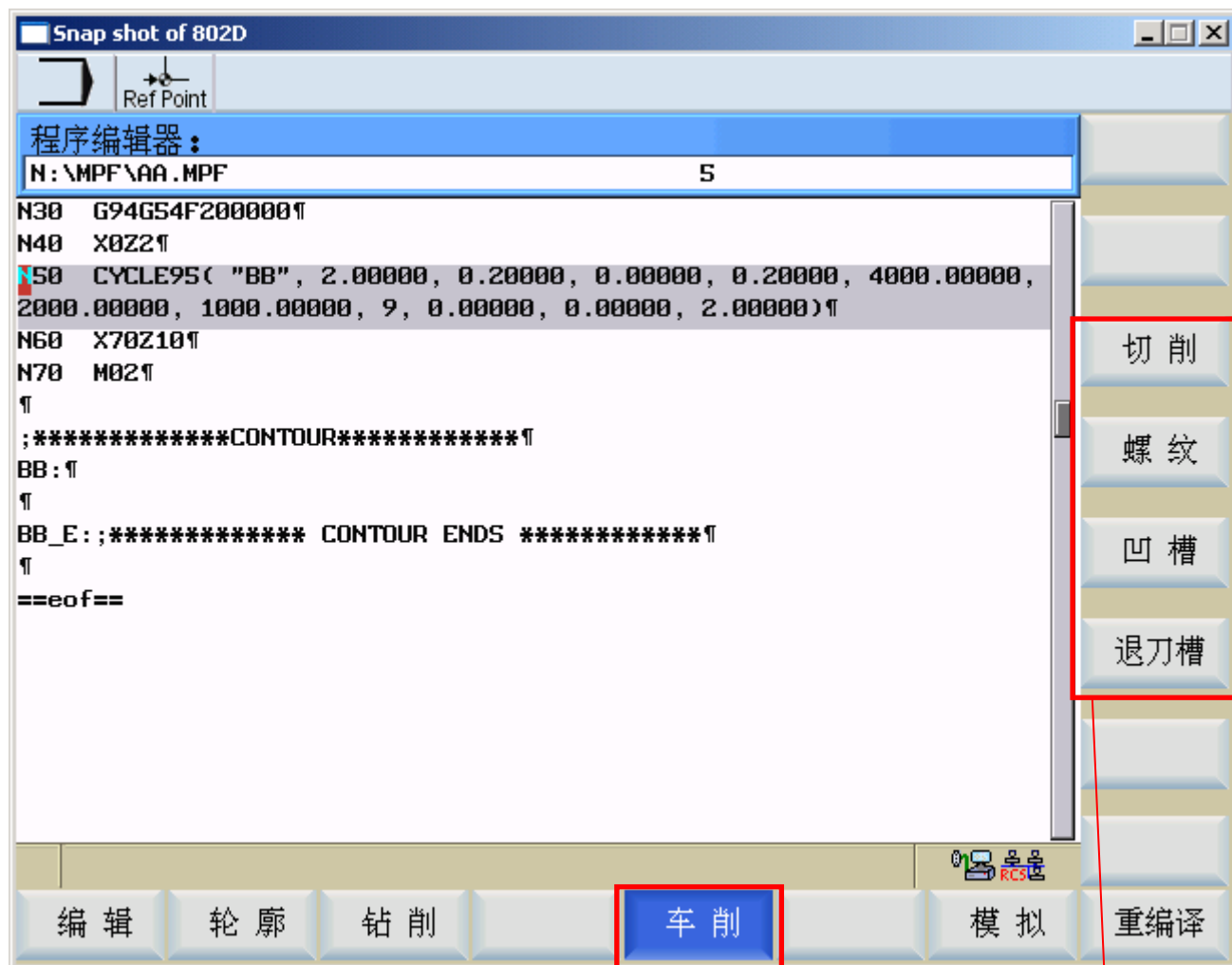
Diagram illustrating the definition of a cycle screen in the 802Dsl software interface. The interface is titled "Snap shot of 802D" and includes a "程序编辑器:" (Program Editor) section.

The interface is divided into several key areas:

- 循环名称① (Cycle Name):** Located at the top left, showing "CYCLE95".
- 参数注释② (Parameter Annotation):** Located at the top center, showing "轮廓子程序名称" (Contour Subprogram Name).
- 参数值③ (Parameter Value):** Located at the top right, showing a list of parameters and their values under the heading "3B:BB_E".
- 循环或参数位图④ (Cycle or Parameter Bitmap):** Located on the left side, showing a 2D plot of a cycle path with a blue area labeled "NPP" and a green path.
- 参数名称⑤ (Parameter Name):** Located in the center, showing a list of parameters: NPP, MID, FALZ, FALX, FAL, FF1, FF2, FF3, VARI, DT, DAM, and _VRT.
- 参数类型是字符串时自动增加(-) (Parameter Type is String, Automatically Increase (-)):** Located at the bottom right, indicating that string parameters are automatically incremented.

The interface also includes a "新建" (New) button, a "轮廓附加" (Contour Attach) button, and a "中断" (Interrupt) button with a red X icon. A "确认" (Confirm) button with a green checkmark icon is also present.

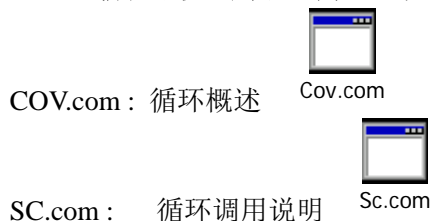
Parameter	Value
MID	2.00000
FALZ	0.20000
FALX	0.00000
FAL	0.20000
FF1	4000.00000
FF2	2000.00000
FF3	1000.00000
VARI	9
DT	0.00000
DAM	0.00000
_VRT	2.00000



二、循环支持文件的说明(cyclesm.spf)

水平菜单⑥

垂直菜单及子菜单⑦



以上两文件均可以用 wordpad.exe 打开

1、COV.com 文件的说明（循环软键的设置）

举例:

```
;VERSION: 04.01.15.00 Oct 11, 2007
;CHANGE : 04.01.01.00 Apr 27, 2004
;Zyklenauswahl_fuer_802D_P2
S3.0.0\§80271\
S3.1.0\§80282\CN2(CYCLE81)[MCALL]
M17
```

```
Auswahl: "Bohren"
Zyklus: "Bohren Zentrieren"
```

格式:

S3.1.0\§80282\CN2 (CYCLE81)[MCALL]

Zyklus: "Bohren Zentrieren"

循环名称①

注释

循环调用的位图④

菜单的名称⑥⑦:

菜单的位置⑥⑦:

S3: 水平的位置

x.1.x: 垂直的位置

x.x.2: 垂直的子位置

2、SC.com 文件的说明（循环参数的设置）

举例：

```
//CN21(CYCLE95)
(S///$80260)[$80261/NPP]
(R/0 99999.999// $80209)[$80206/MID]/B cn21_4
(R/0 99999.999// $80195)[$80190/FALZ]/B cn21_4
(R/0 99999.999// $80196)[$80190/FALX]/B cn21_4
(R/0 99999.999// $80194)[$80190/FAL]
(R/0.001 999999.999// $80120)[$80121/FF1]
(R/0.001 999999.999// $80122)[$80123/FF2]
(R/0.001 999999.999// $80118)[$80119/FF3]
(I/*1 2 3 4 5 6 7 8 9 10 11 12/9/$80039)[$80039/VARI]/B cn21 cn21_3 cn21_8 cn21_11 cn21_1
cn21_7 cn21_9 cn21_12 cn21_2 cn21_6 cn21_10 cn21_13
(R/0 99999.999// $80036)[$80037/DT]
(R/0 99999.999// $80250)[$80251/DAM]/B cn21_5
(R/0 99// $80370)[$80371/_VRT]
```

格式：

//CN21(CYCLE95)

循环名称

循环调用的图形

(R/0 99999.999/ /\$80209)[\$80206/MID]/B cn21_4

调用参数位图④

参数名称⑤

????

参数的注释②

参数的预置值

参数范围：最小值 最大值

参数类型：

R：实数

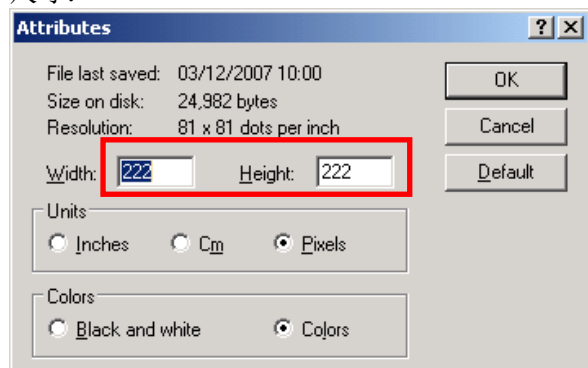
I：整数

C：字符（单个字符）

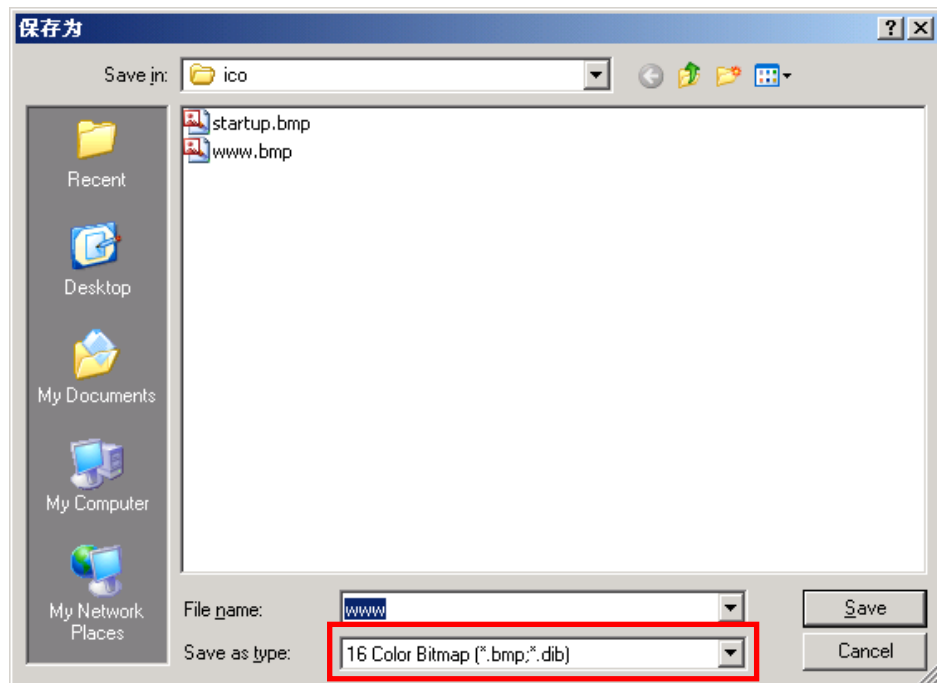
S：字符串(-)

三、循环图形

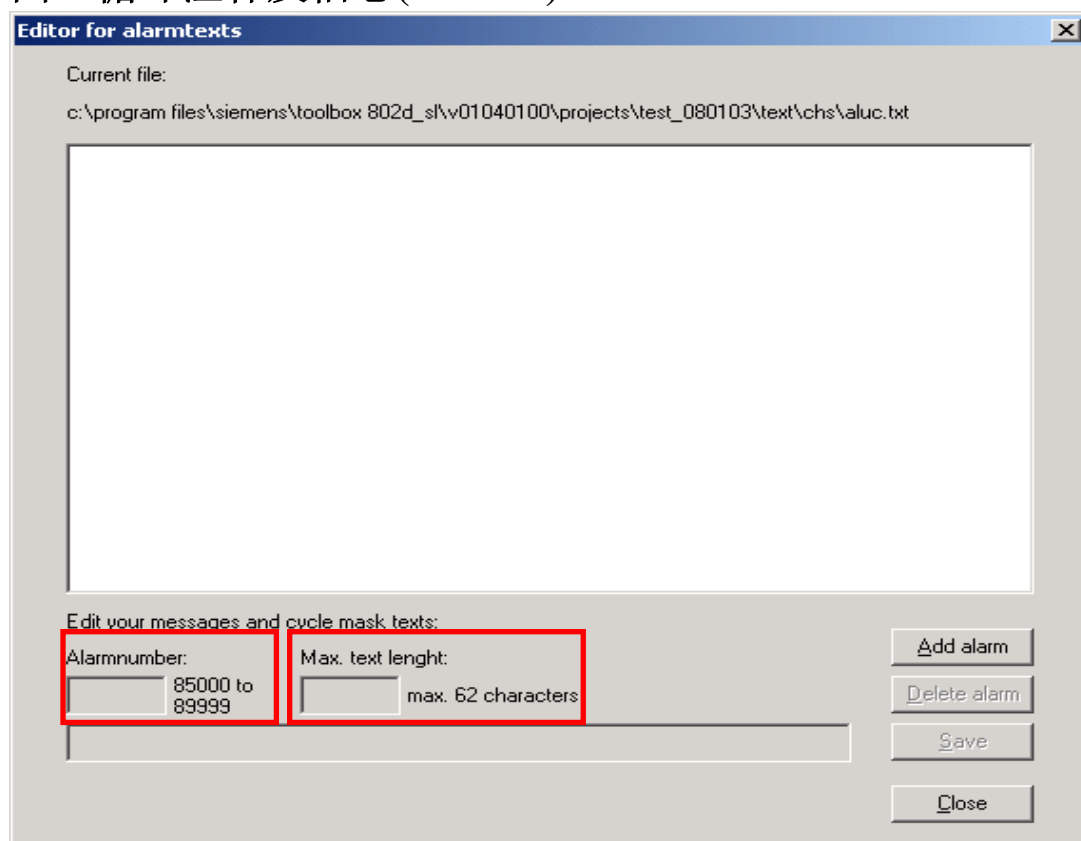
尺寸：



属性：



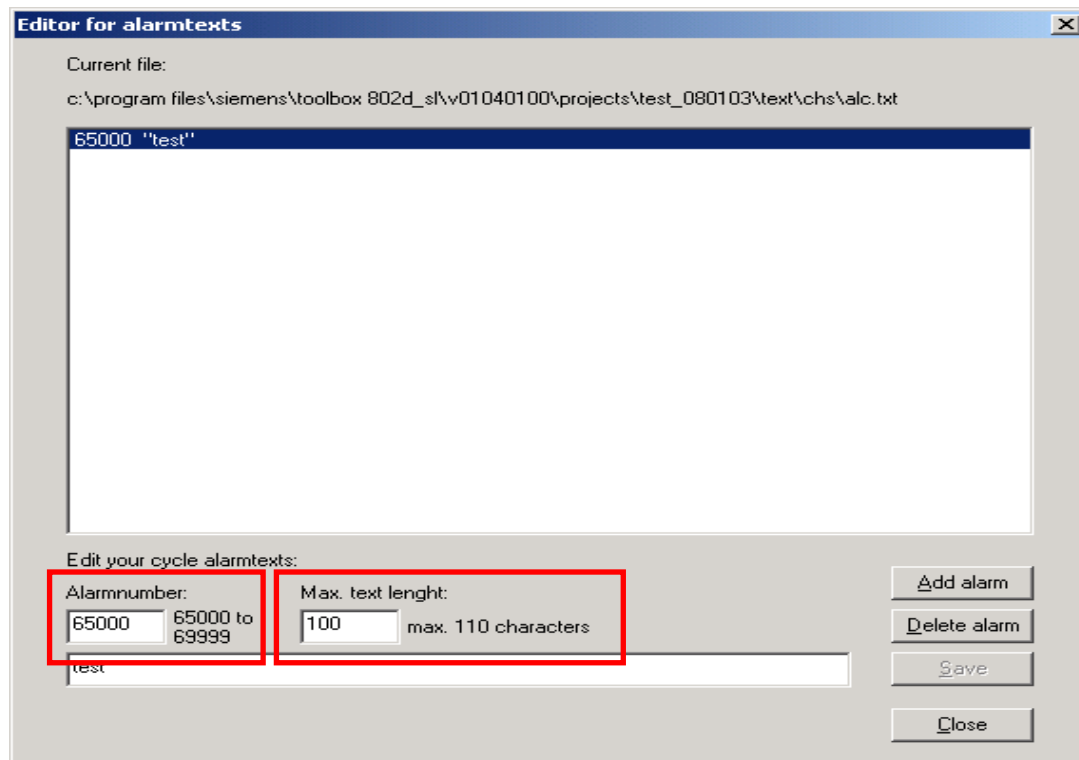
四、循环注释及信息(aluc.txt)



注：报警号 80000～84999 为标准循环占用

五、循环报警(alc.txt)

1、报警号范围及报警内容的长度



2.循环报警的处理

报警号	清除级	报警响应
61000...61999	NC_RESET	NC中程序段预处理终止
62000...62999	清除键	程序段预处理中断；报警清除后，使用NC START继续执行循环

报警号可以按如下分类：

6	_	X	_	_
---	---	---	---	---

- X=0 共同的循环报警
- X=1 钻削循环、钻削图循环和铣削循环报警
- X=6 车削循环报警

六、辅助循环子程序

meldung.spf：循环时信息显示

STEIGUNG.spf：

cyclesm.spf：循环支持文件，包括 Cov.com 和 Sc.com