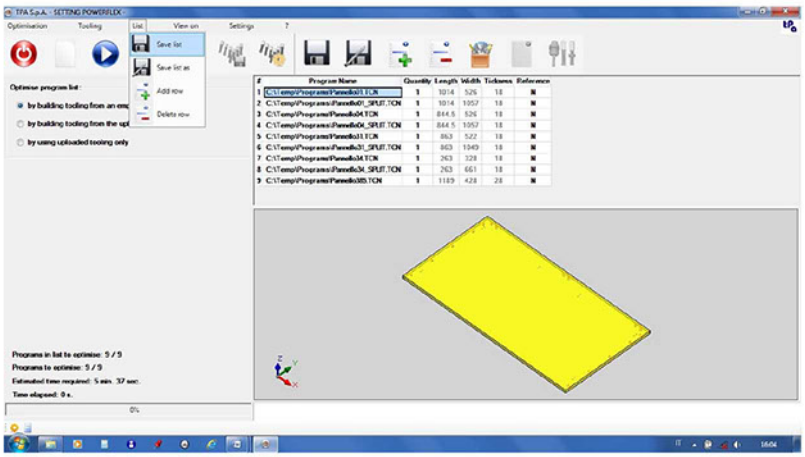
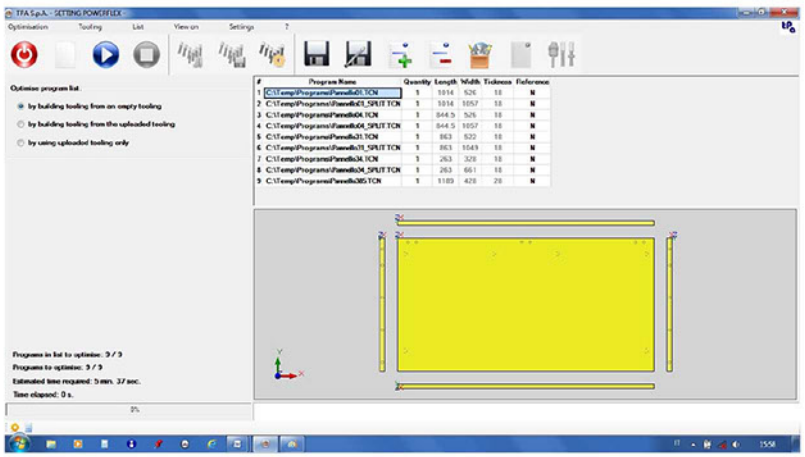
Setting

GENERAL FEATURES

A widespread problem on machines dedicated to drilling and insertion of ironmongery on panels consists in the necessity to dispose of the best configuration of tooling of the operating heads, in order to reduce as much as possible the working time and to ensure a greater production efficiency. "Setting" allows you to properly equip the spindles on the operating heads of single machines or plant so that all pieces planned during processing can be performed by choosing to take the least number of possible strokes, the smaller number of replacement bits and the fewest execution time, by aggregating the largest number of bits to each lowered and ensuring rational distribution of workload in the case of a line of several machines.

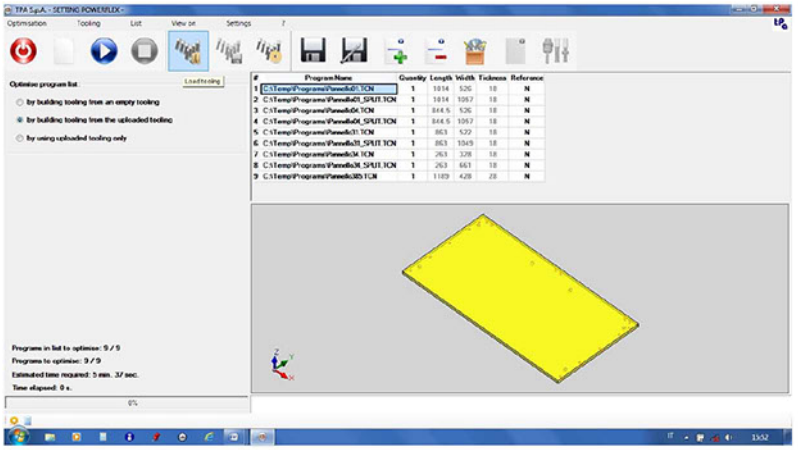


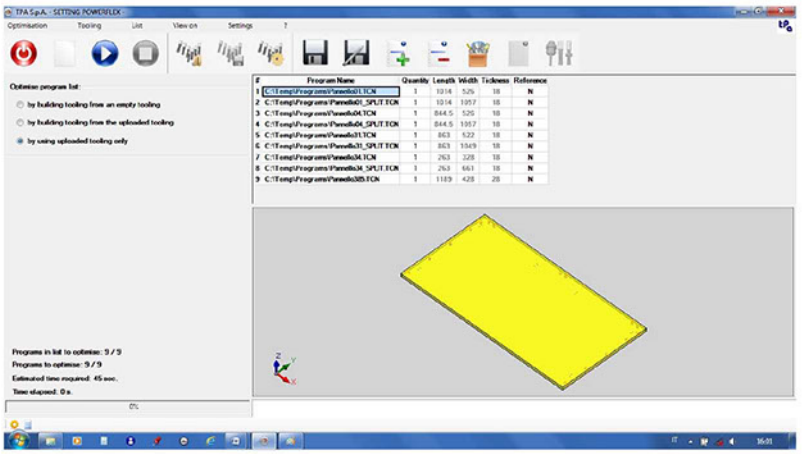


FUNCTIONAL CHARACTERISTICS

List of programs Creation

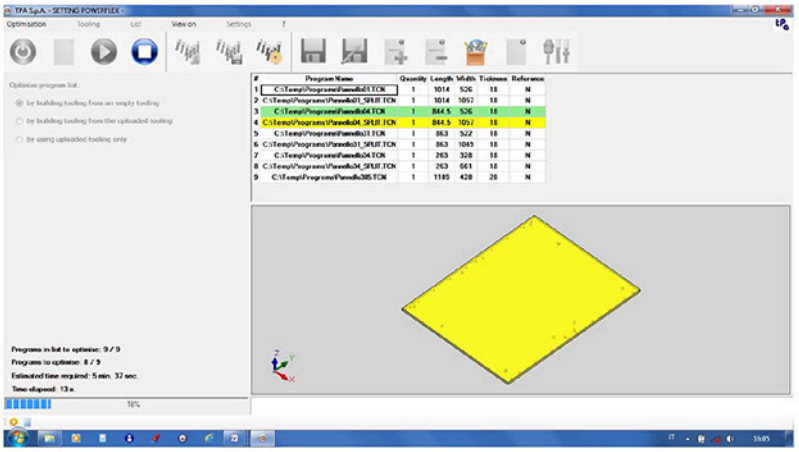
The creation of a list of programs that has to be optimized can be achieved by loading one or more TpaEdi file (file with extension. TCN) or by uploading a file to the file list TpaEdi for Setting, already filled. The created list can be edited and saved.





Selecting the type of optimization of tooling

The optimization of tooling to perform a list of programs can be performed starting from a vacuum tooling, from an initial tooling that has to be completed or from a complete and not modifiable tooling.



Starting the optimization process

The optimization of tooling starts analyzing every single program that is in the list, defining for all groups of each machine the optimum arrangement of the bits to run each program in the fewest number of strokes and time as possible.

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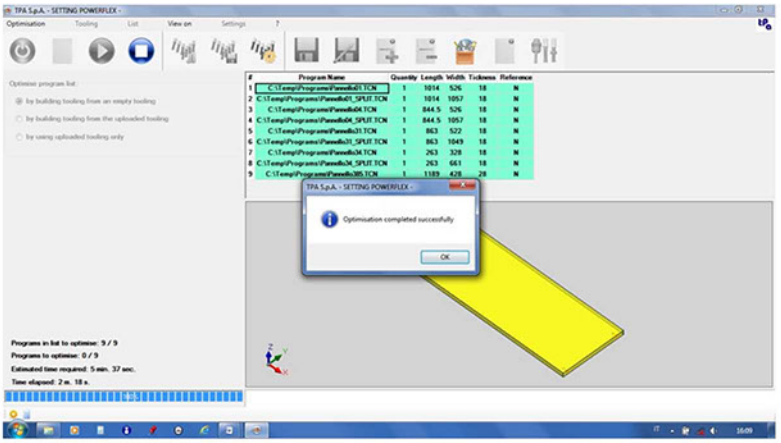
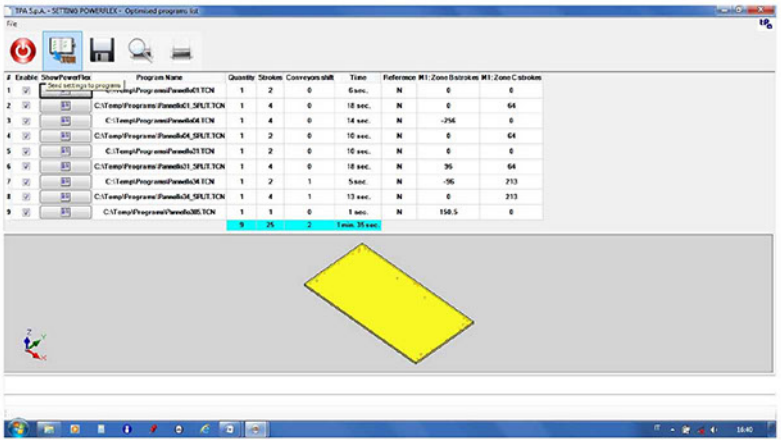


End of the optimization process tooling

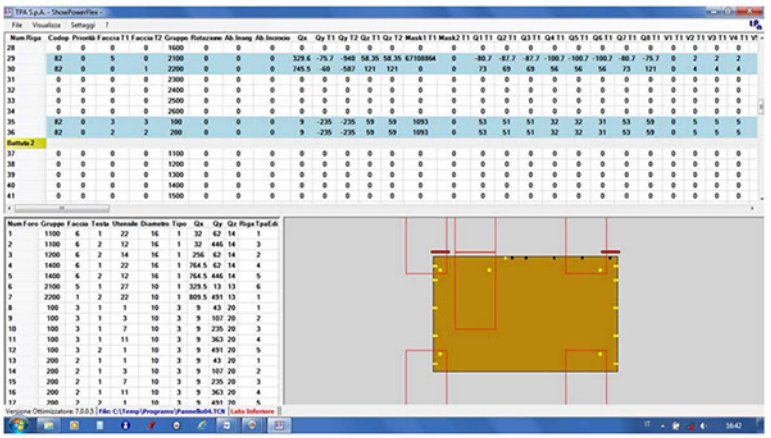
A message indicates that the optimization process has been completed successfully.



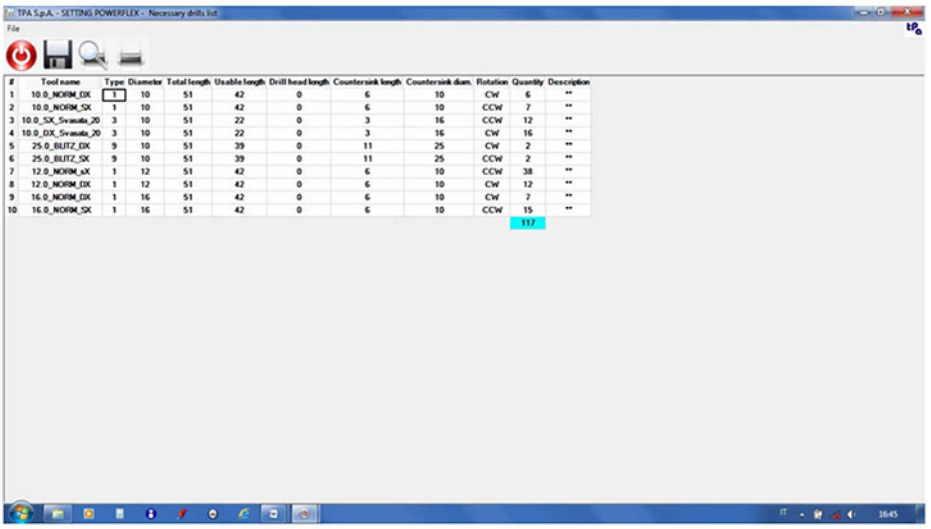
ANALYSIS OF THE RESULTS OF THE OPTIMIZATION PROCESS TOOLING

At the end of the optimization process, you can view, save and print the results for each panel (such as the number of beats and the time required to run it).

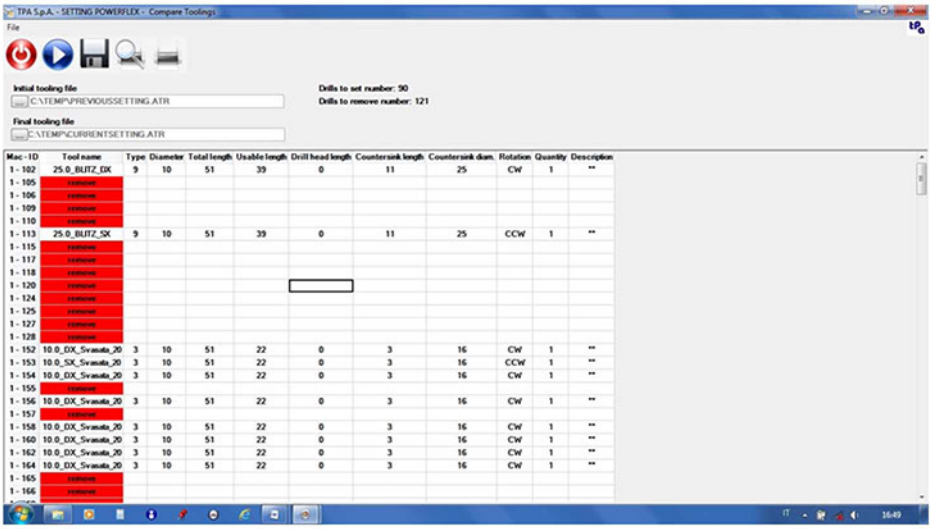
It's possible to send some optimization parameters directly to the program .TCN.



It's possible to observe how the panel will be done through the 2D simulation program that allows you to see the layout of groups and the holes drilled in every bar.



#	Tool name	Type	Diameter	Total length	Usable length	Drill head length	Countersink length	Countersink diam.	Rotation	Quantity	Description
1	10.0_NORM_DX	1	10	51	42	0	6	10	CW	6	**
2	10.0_NORM_SX	1	10	51	42	0	6	10	CCW	7	**
3	10.0_SX_Svasata_20	3	10	51	22	0	3	16	CCW	12	**
4	10.0_DX_Svasata_20	3	10	51	22	0	3	16	CW	16	**
5	25.0_BLITZ_DX	9	10	51	39	0	11	25	CW	2	**
6	25.0_BLITZ_SX	9	10	51	39	0	11	25	CCW	2	**
7	12.0_NORM_xX	1	12	51	42	0	6	10	CCW	38	**
8	12.0_NORM_DX	1	12	51	42	0	6	10	CW	12	**
9	16.0_NORM_DX	1	16	51	42	0	6	10	CW	7	**
10	16.0_NORM_SX	1	16	51	42	0	6	10	CCW	15	**
										117	



Mac - ID	Tool name	Type	Diameter	Total length	Usable length	Drill head length	Countersink length	Countersink diam.	Rotation	Quantity	Description
1 - 102	25.0_BLITZ_DX	9	10	51	39	0	11	25	CW	1	**
1 - 105	remove										
1 - 106	remove										
1 - 109	remove										
1 - 110	remove										
1 - 113	25.0_BLITZ_SX	9	10	51	39	0	11	25	CCW	1	**
1 - 115	remove										
1 - 117	remove										
1 - 118	remove										
1 - 120	remove										
1 - 124	remove										
1 - 125	remove										
1 - 127	remove										
1 - 128	remove										
1 - 152	10.0_DX_Svasata_20	3	10	51	22	0	3	16	CW	1	**
1 - 153	10.0_SX_Svasata_20	3	10	51	22	0	3	16	CCW	1	**
1 - 154	10.0_DX_Svasata_20	3	10	51	22	0	3	16	CW	1	**
1 - 155	remove										
1 - 156	10.0_DX_Svasata_20	3	10	51	22	0	3	16	CW	1	**
1 - 157	remove										
1 - 158	10.0_DX_Svasata_20	3	10	51	22	0	3	16	CW	1	**
1 - 160	10.0_DX_Svasata_20	3	10	51	22	0	3	16	CW	1	**
1 - 162	10.0_DX_Svasata_20	3	10	51	22	0	3	16	CW	1	**
1 - 164	10.0_DX_Svasata_20	3	10	51	22	0	3	16	CW	1	**
1 - 165	remove										
1 - 166	remove										

A list of the types and amount of bits needed to complete the tooling required to run the program list is provided. This list can be saved and printed.
Two types of tooling can be compared, in order to know how many and which bits need to be replaced on the machine.

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