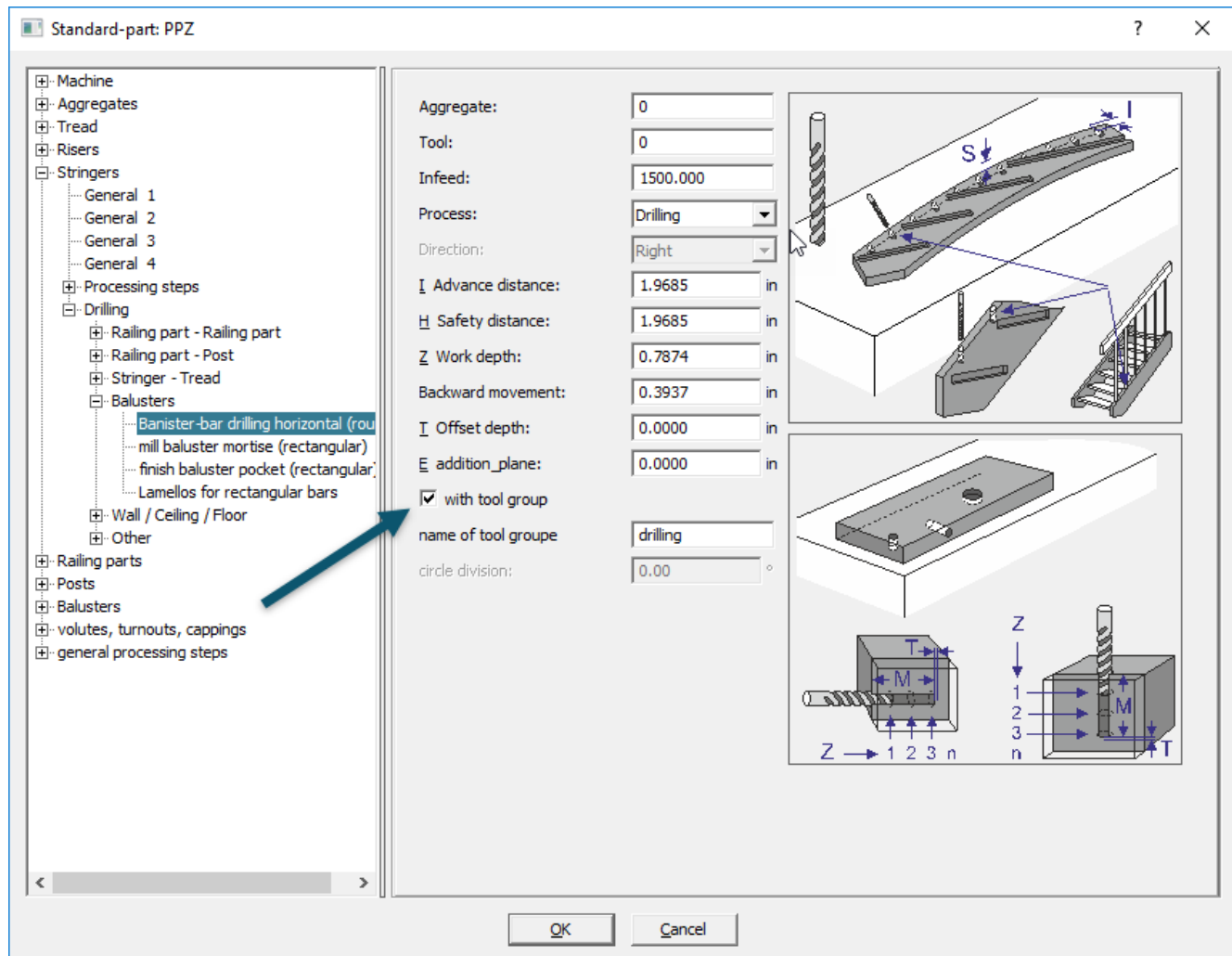


Working with the Drilling Lists

To activate the drilling list, you have to save a file called „liste“ in the path:
 "<current drive>\CNCPROGR\B-Listen"

An additional menu in the CAM predefinitions of the drillings will appear:



You have to select **Drilling (1)** under process.

Check the box **with tool group (2)**.

Last, input a name with a maximum of 8 characters under **name of tool group (3)**.

Here you can choose a file which includes the different drillers you can use.

In this file you can define drillers with different diameters, as shown in the example below.

This file includes the real list of drilling tools which the system choses automatically depending on the diameter.

Working with the Drilling Lists

Example:

File Name: bliste

The file name must not be more than 8 characters.

The file exists of two blocks: tools used for drilling of horizontal pockets and tools for drilling vertical pockets.

0.001 0.1	1. line: upper tolerance, lower tolerance
8 Horizontal	2. line: number of tools for horizontal drillings
30 31 32 33 34 35 36 37	3. line: tool numbers (quantity = number of tools)
30 31 32 33 34 35 36 37	4. line: related aggregate numbers
0.001 0.1	5. line: upper tolerance, lower tolerance
8 Vertikal	6. line: number of tools for vertical drillings
40 41 42 43 44 45 46 47	7. line: tool numbers (quantity = number of tools)
40 41 42 43 44 45 46 47	8. line: related aggregate numbers
ENDE	9. line: end statement

The format of the file must be exactly as shown above, that is number of lines and sequence.

The number of tools and their numbering are variable.

The used aggregates must be installed in the CAM settings for aggregates. The system automatically chooses the most fitting driller for the drilling using the tolerance values.