WFL M65 S840D

Machine tool support kit for NX CAM and CAM Express

fact sheet

▶ ## Summary

A machine tool support kit is a package consisting of post-processor, simulation driver, machine tool model, CAM templates, documentation, etc. that enables out of the box post processing and simulation for a specific machine tool using NX™ CAM or CAM Express software. This machine tool support kit is tailored for the WFL Mxx series 5 axis milling machine tools with Siemens 840D controllers.

Content of the machine tool support kit:

- Post-processor
- Machine Tool Driver for Simulation
- Schematic 3D Machine Tool Model
- Machine specific NX CAM template
- Machine specific NX CAM UDE's
- Example data (part, setup, operations)
- Documentation (installation, usage)
- Installation routine (only for Microsoft Windows)
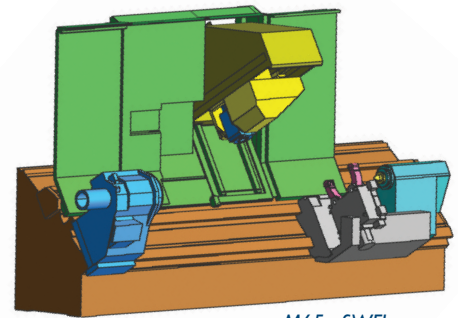
M65 of WFL

Supported software version

- NX 5

Prerequisites

- NX CAM Base
- NX Post Exec
- ISV – Adv. Simulation

These prerequisites are for example met with the MACH 2, 3 and 4 bundles of NX.

Technology used

- Post-processor: TCL based
- Simulation driver: TCL based
- Simulation support for external NC-Programs (programs containing the same syntax as the programs generated by this machine kit)

Supported machine tool configuration

- WFL M65 S840D

Unit

- Metric

The supported units influence: post-processor output, simulation driver, contained NX part files.

NX SIEMENS

Supported capabilities

Turning processes – highlights (not all inclusive)

• B-axis turning

Canned drilling cycles for live rotary tools

BC-axis milling

• 5 axis positioning (3+2)   • 5 axis simultnesous (MILL5AON, MILL5AOF)

Preparatory G-code support list

G0	Rapid move
G1	Linear move
G2/G3	Circular move clw/cclw
G4 F	Delay time (not in cycle mode)
G40/41/42	Cutter compensation (valid for milling tools)
G54-G57	MCS fixture offset value
G94	Feedrate per min
G95	Feedrate per rotation
G96	Constant cutting speed
G97	Constant rpm

Preparatory G-code canned cycle support

DRILL	Axial Z drill cycle
DRILL	Axial Z drill dwell cycle
DRBREAK	Axial Z drill brakchip cycle
DRDEEP	Axial Z drill deep cycle
DRTAP	Axial Z tapping
DRTURN	Axial Z bore no drag cycle
DRGUN	Axial Z bore cycle
DRFCH	Axial Z bore back cycle

Miscellaneous M-code support list

Process/method allocation master codes

M00	UDE stop
M01	UDE opstop
M30	End of program
M1=3	
M1=4	
M1=5	
M3=3	
M3=4	
M3=5	
M3=7	Coolant
M3=8	Coolant
M13	Quill forward
M14	Quill backward

▶ **Contact**

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