



EXAPT EASYPP

Postprocessor generator

EXAPT EASYPP is used for the user-modifiable adaption of the results of the EXAPT programming to all valid NC and CNC controlled processing machines. For that the most different characteristic of machine, controller as well as optional the application strategy in the shop floor are considered.

Besides the fast and easy adapted preparation of the NC data records for the machining with EXAPT EASYPP without manual additional expenditures all important information can be formatted that are required for the efficient throughput of manufacturing orders. E. g. that refers to the times for machining and set up, required tools and devices as well as processing requirements of the production process.

EXAPT EASYPP provides good preconditions for the disposition of manufacturing resources and the set up of the machine and consequently for the

organisational inclusion into the information flow of the production process. Therewith is contributed to the efficient throughput of production orders from the planning to the shop floor.

Performance features

- mapping of NC record formats in accordance with DIN 66025 or fulfil the individual requirements of standard CNC systems
- Consideration of CNC cycles with optional dissolution for calculation of time and CNC subprogram technology
- Adaptable to most different functions of the CNC or NC machine for all valid machining processes
- Consideration of the kinematic basic conditions also for multi-axes machines with up to 5 axes simultaneously, multi-turret, multi-spindle use (x-, y-, z-, a-, b-, c-, u-, v-, w-axes)
- Adaptable to the use of change aggregates

- Alignment to the practice-related requirements concerning the tooling, set up and operation of NC machines
- Automatic generation of tables, lists or data as for tools, devices, correction switches, times, tabulated NC lists and the like
- easy generating and functional expansion of postprocessors by configuration tables (user-configurable)
- generating of tabulated NC lists
- Integrated use within the EXAPT NC programming with direct production and display of the NC data records
- optional the compound use with EXAPT.pdo, the EXAPT production data organisation system, including the production communication between planning, setting up and shop floor.

NC-Programm: CACHSE1.NC

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%MPF1234
[ ]
[ ]
[ DATUM: 17.10.95 ]
N0050 M03
N0060 G18
N0070X320.0Z335.0T000001G00G53
N0080Z0.0G59
N0090S6500.0
[DREHWEREUG - DNR.: 111610]
N0110Z0.0I0.0K0.0G00
N0120T000002M08
N0130S515.0M04M41
N0150X98.046Z103.0G00
N0160Z28.391F0.4G01
N0170S568.0F0.2
N0180X100.0Z27.414
N00190S515.0F0.4
N0200Z19.0
N0210S511.0F0.4
N0220X110.0
N0230S576.0
N0240Z20.0G00
N0250Z103.0
N0260X86.091
N0270Z30.0F0.4G01
N0280S572.0F0.4
N0290X94.828
N0300X98.046Z28.391
N0310S654.0
N0320X99.46Z29.098G00
N0330Z103.0
N0340X74.137
N0350Z20.0F0.4G01
N0360S650.0F0.4
N0370X86.091
    
```

Output of EASYPP-generated NC records

EXAPT Einrichteblatt Nc-Programm : 000001 SpNr: 1 07.08.97

Zeichnungsnr.: 5206247786-A Maschinennr.: 123-678
 Zeichnungsindex: 0 Maschinenzust.: Werkstatt WNC 500 S
 Ersteller: SYSADM Steuerung: Sinumerik 880

Spannmittel-id: 1 Spannfüter:
 Bezeichnung: 10.00
 Länge: 221.00
 Durchmesser: 0.00
 Anschlaglänge: 10.00
 Spanndruck: 10.00

WERKZEUGLISTE

Schnr	S-Nr	Werkzeugbezeichnung	Mag.-P Istz	D1 / RS	XS	K1	K2	SL	Soßmaß L	Istmaß L	Soßmaß G	Istmaß G	Adapter	Meßbasis
154928	1	AUSSENSTAHL LINKS LAENG-S-	1	0.80	92.20	1	201		50.00		100.00		SK50	hft
109528	1	AUSSENSTAHL NEUTRAL	2	0.80	92.20	2	202		100.00		-60.00		SK50	hft
218956	1	SPIRALBOHRER	3	0.80	300.00	3	203		300.00		0.00		SK50	hft
354928	1	BDHRSTAHL LINKS LAENG-PL	4	0.80	192.20	4	204		200.00		-27.00		SK50	hft

EXAPT Zeitblatt Nc-Programm : 001073 Sp : 1 21.08.97

TUH (Schnittzeit bzw. Vorschubbewegung)	-	1.75
TUN (Positionierzeit bzw. Eilgangbewegung)	-	0.15
TUN2 (Schaltzeiten und Übrige)	-	0.00
TBN1 (Spannzeit)	-	0.00
TBN3 (Mess- bzw. Prüfzeit)	-	0.00
TBN5 (Anteilige Wechselzeit für Schneidplatten)	-	0.00
TG (Grundzeit = Summe aller TUH,TUN,TBN)	-	1.90
TV (Verteilzeit bei % ZV)	-	0.23
TE (Vorgabezeit je Einheit = TG + TV)	-	2.13
Z (Zuschlag 25 % auf alle TUH und TUN)	-	0.48
TEB (Vorgabezeit Je Einheit bezahlt= TE + Z)	-	2.61

Automatically generated supplementary information

EXAPT EASYPP

(Art.-no. 17620)

Supplementary modules

- sample data records: configuring data for turning (Art.-no. 17624)
- sample data records: configuring data for drilling/milling (Art.-no. 17626)
- CNC cycle interpretation for turning/drilling/milling to get time determination and simulation (Art.-no. 17628)
- activating of unnested CNC subroutines
- disposition of set-up data, equipment data and time data for paperless manufacturing data management with EXAPTpdo FDO (Art.-no. 17629)