Closed Loop Programming using the STEP-NC Explorer

Demo 2

- **Closed Loop demo 1 shows how to read measurements and adjust setups.**

- **Demo 2 shows how to add compensation workingsteps to a STEP-NC data set.**

Define Workpieces using CAD		Define tool paths using CAM		Define compensations using STEP-NC Machine
CAD	→ STEP →	**CAM**	→ STEP-NC →	**CNC**
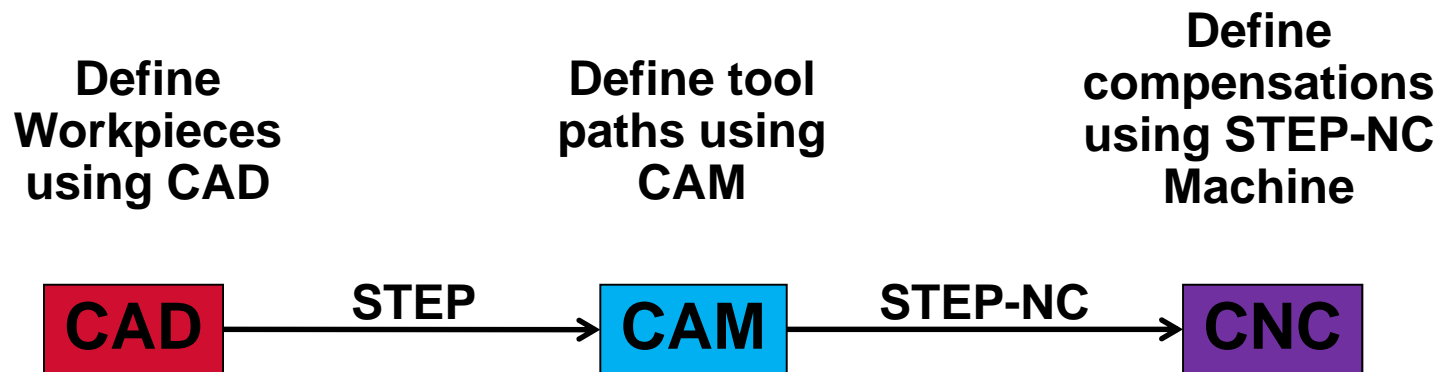
- ## A frame measures part of the machine against three datum's.
    - ### First we add a Frame Definition workingstep to the program
        - » **Give it a name**
        - » **Pick three faces on the part**
    - ### Second we put the workingstep in the correct location
        - » **Move it down to the correct point in the sequence**
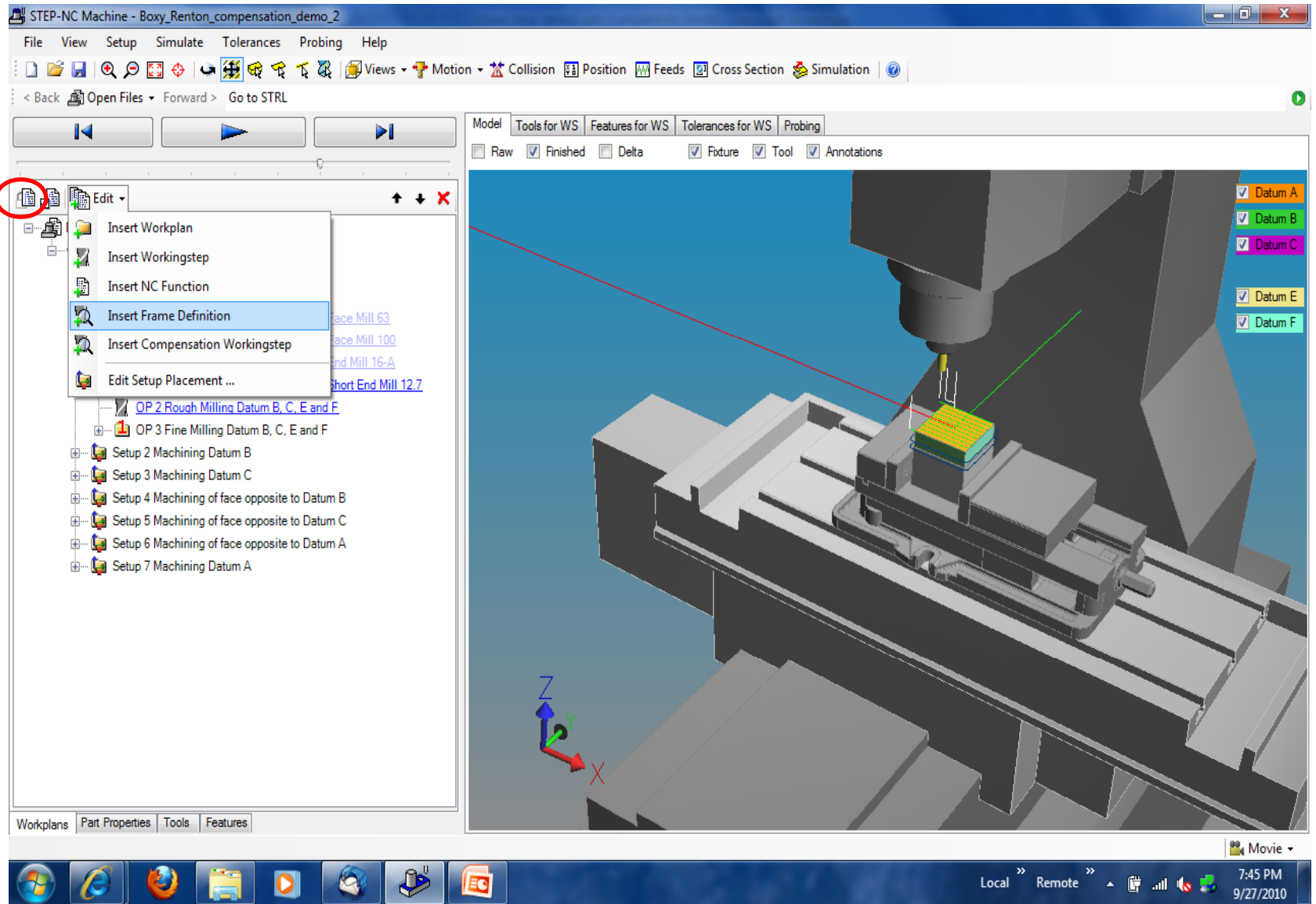
Load the demo_2 data set
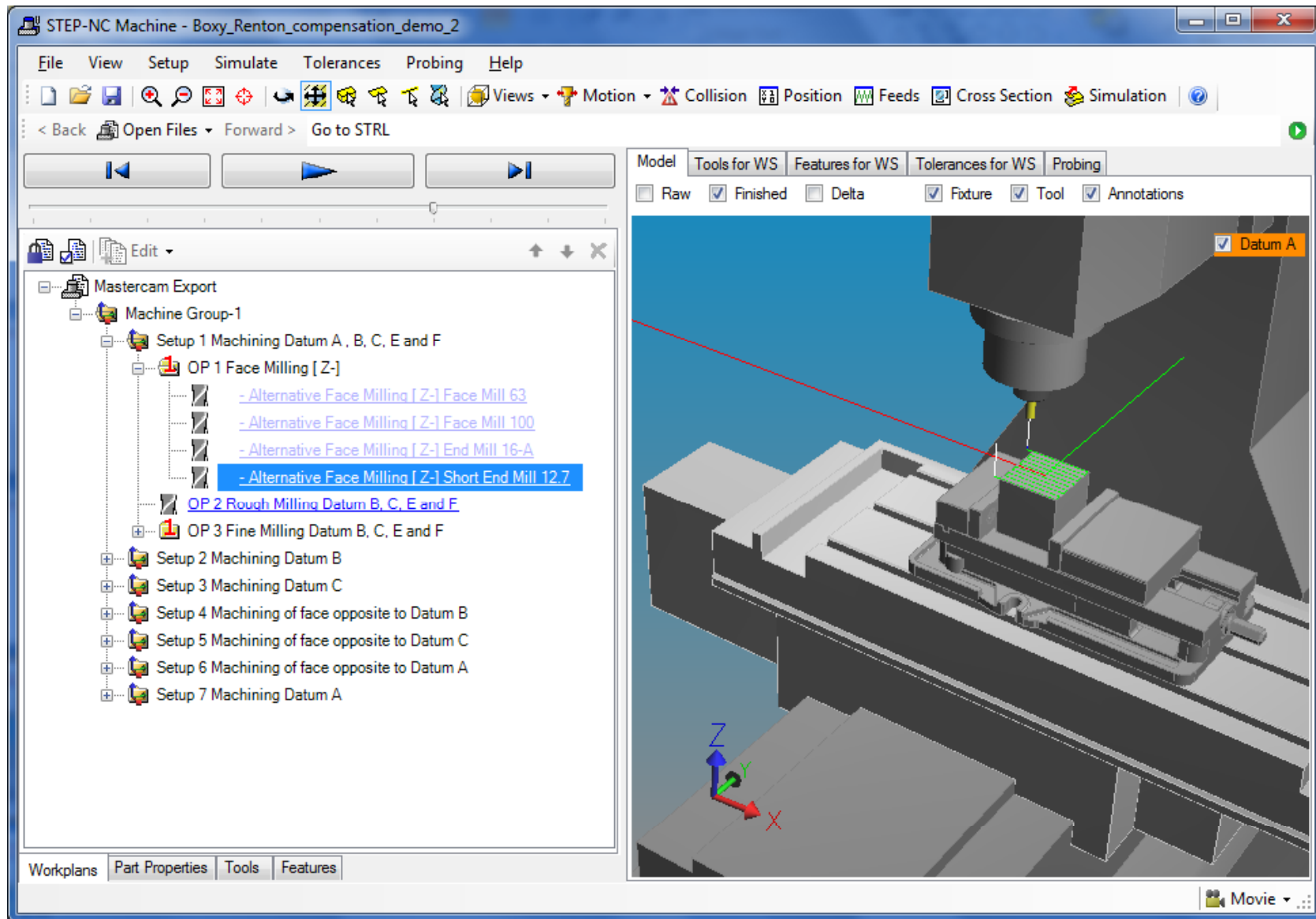
Pick the first setup
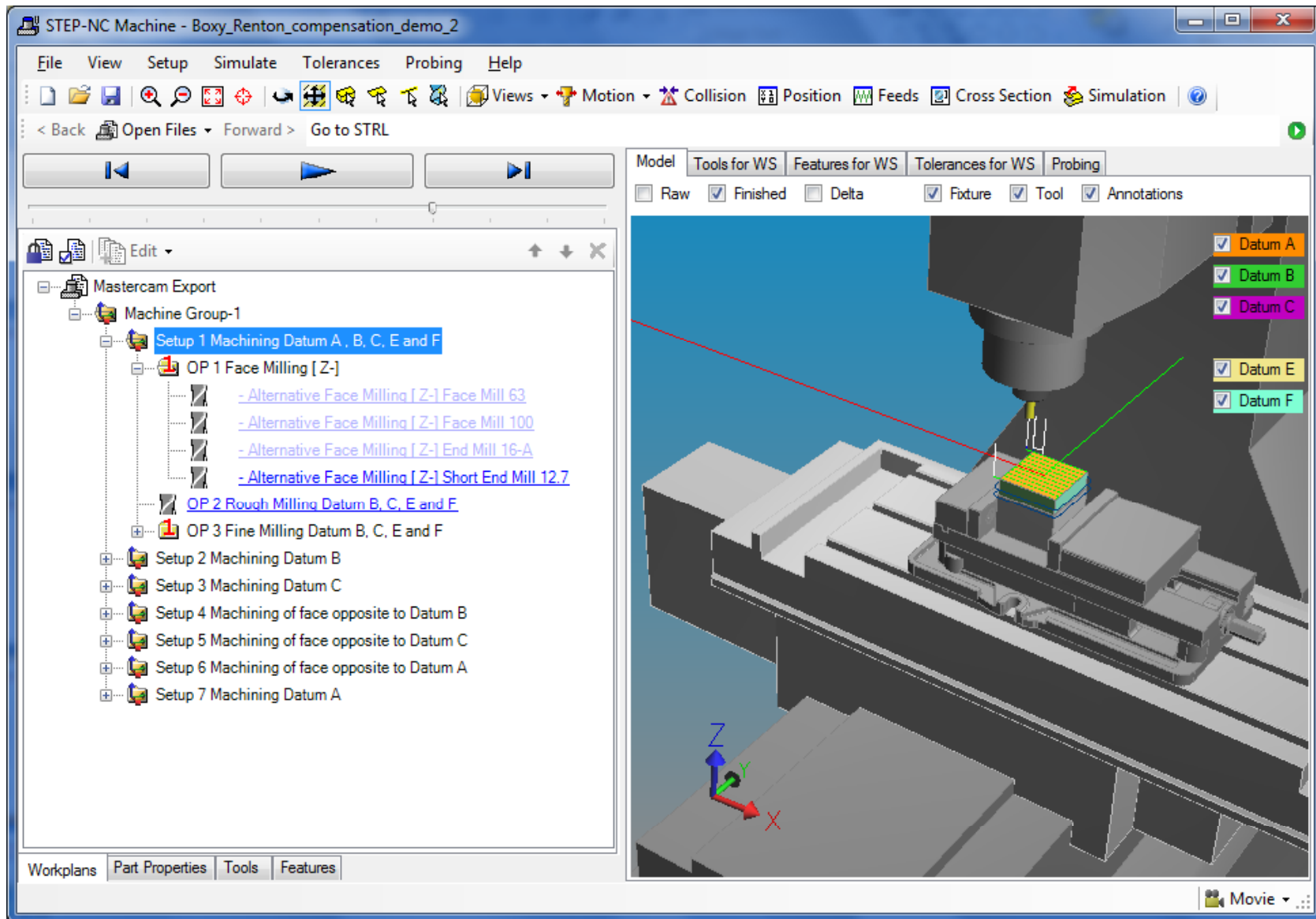
Unlock the editor and pick insert frame   STEP Tools, Inc.
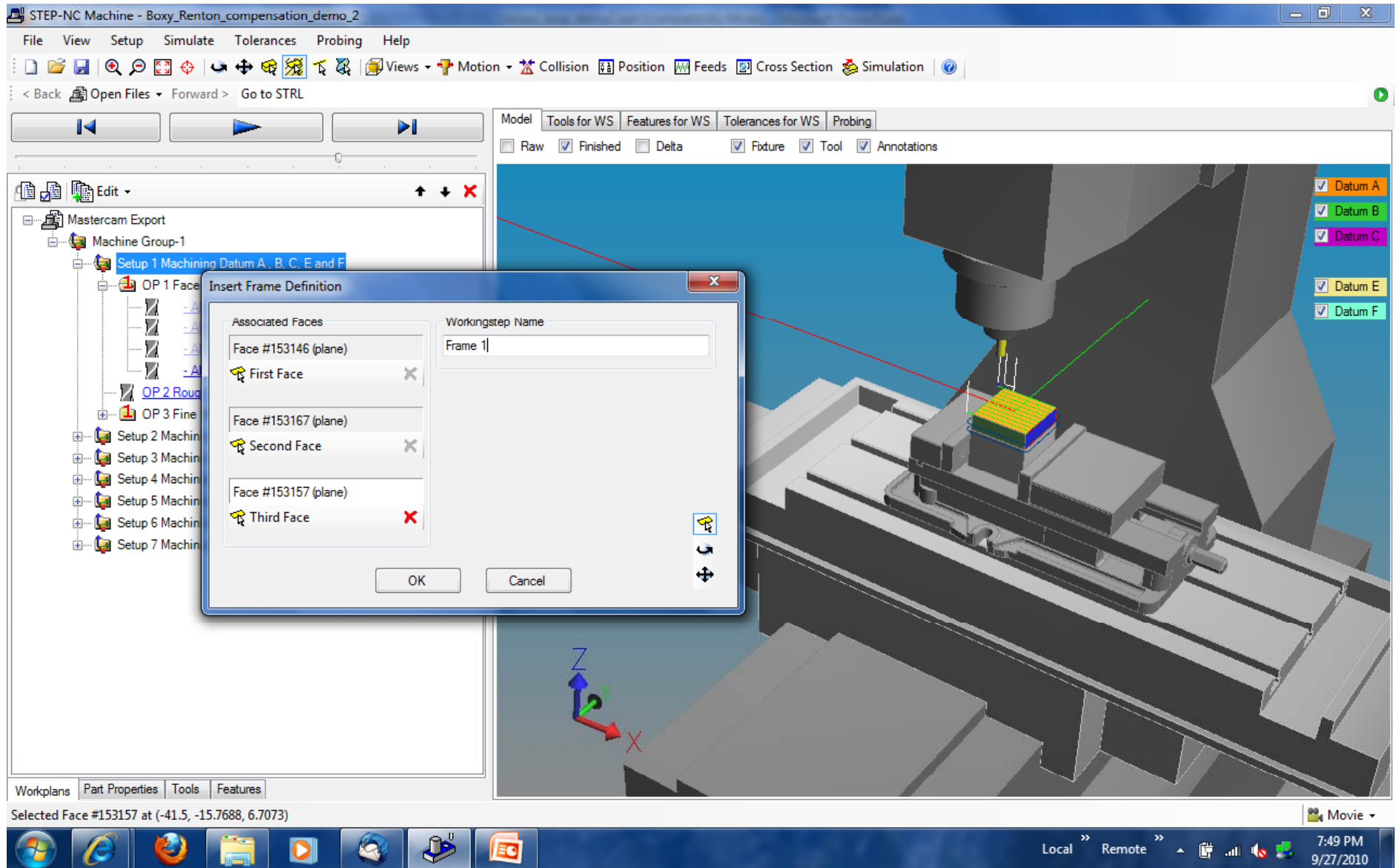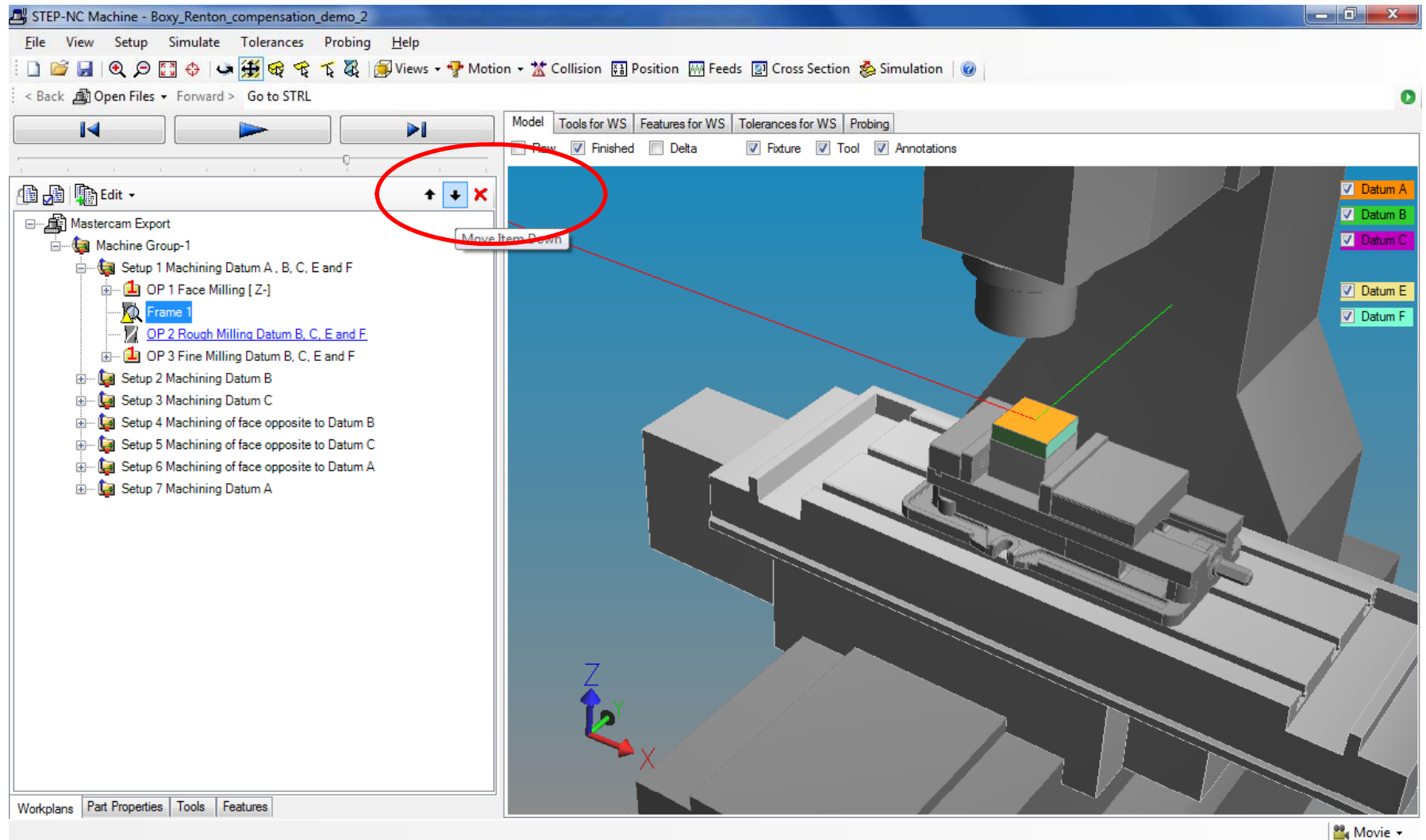
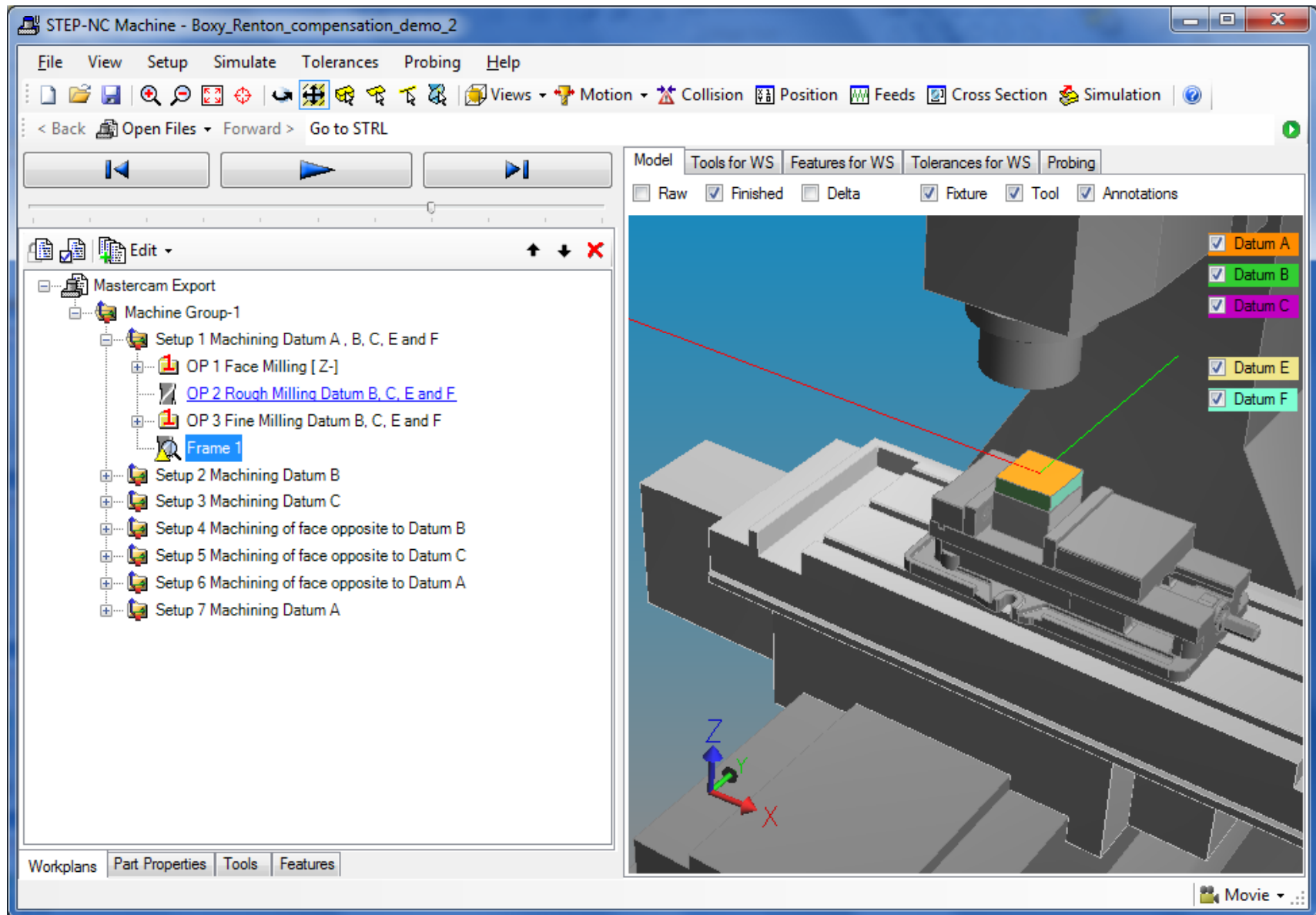# Pick three faces (top, front and right)   STEP Tools, Inc.

# Pick move item down to move it down   STEP Tools, Inc.

Keep moving until it is at the end of the setup STEP Tools, Inc.

- **A compensation uses a frame to define the new location of a part**
  - **Pick the workpiece model that is going to be measured**
    - » **Select the second setup**
    - » **Select the as-is model (before machining)**
  - **Insert a compensation workingstep**
    - » **Give the step a name**
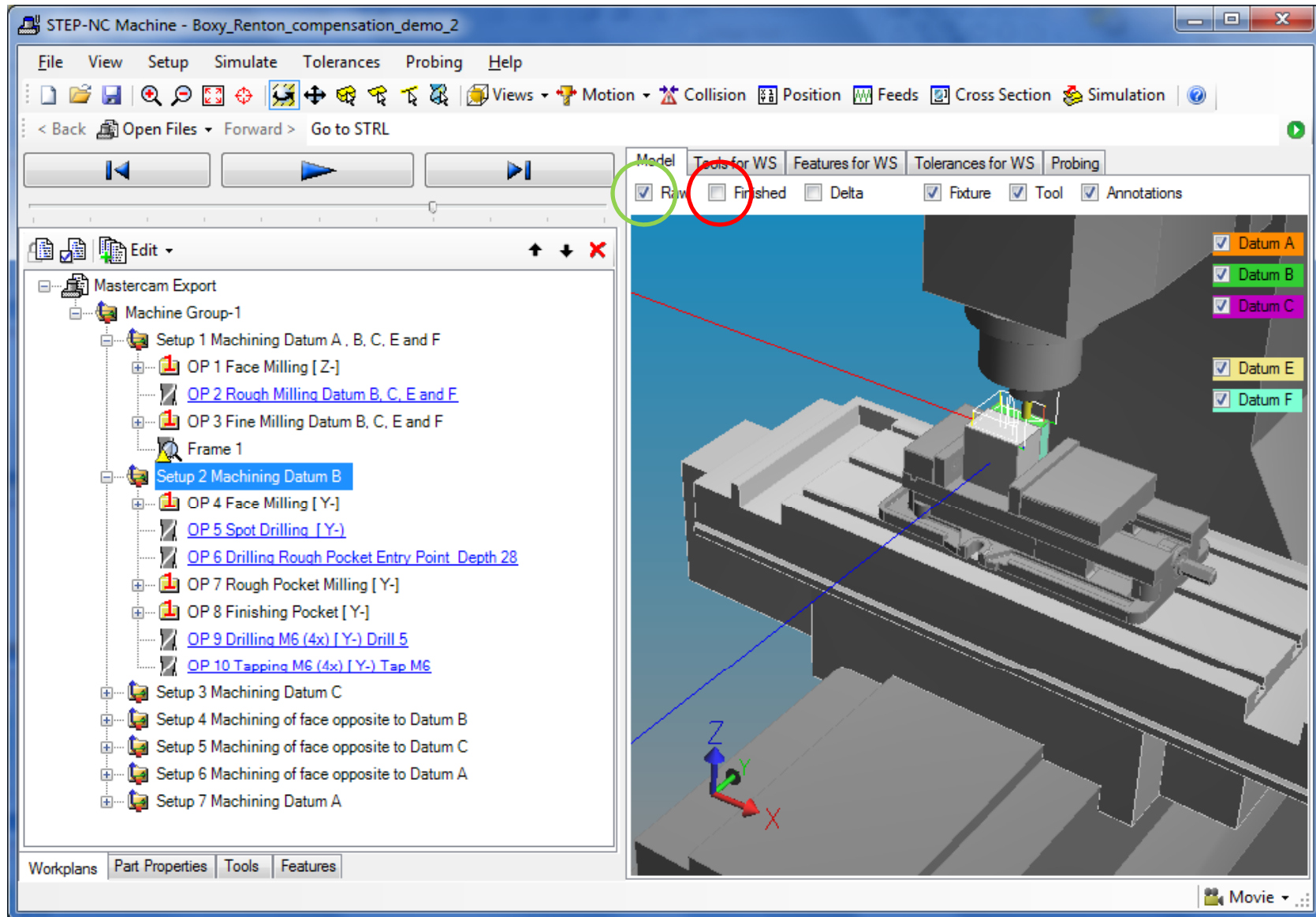   - » **Pick three faces on the workpiece**

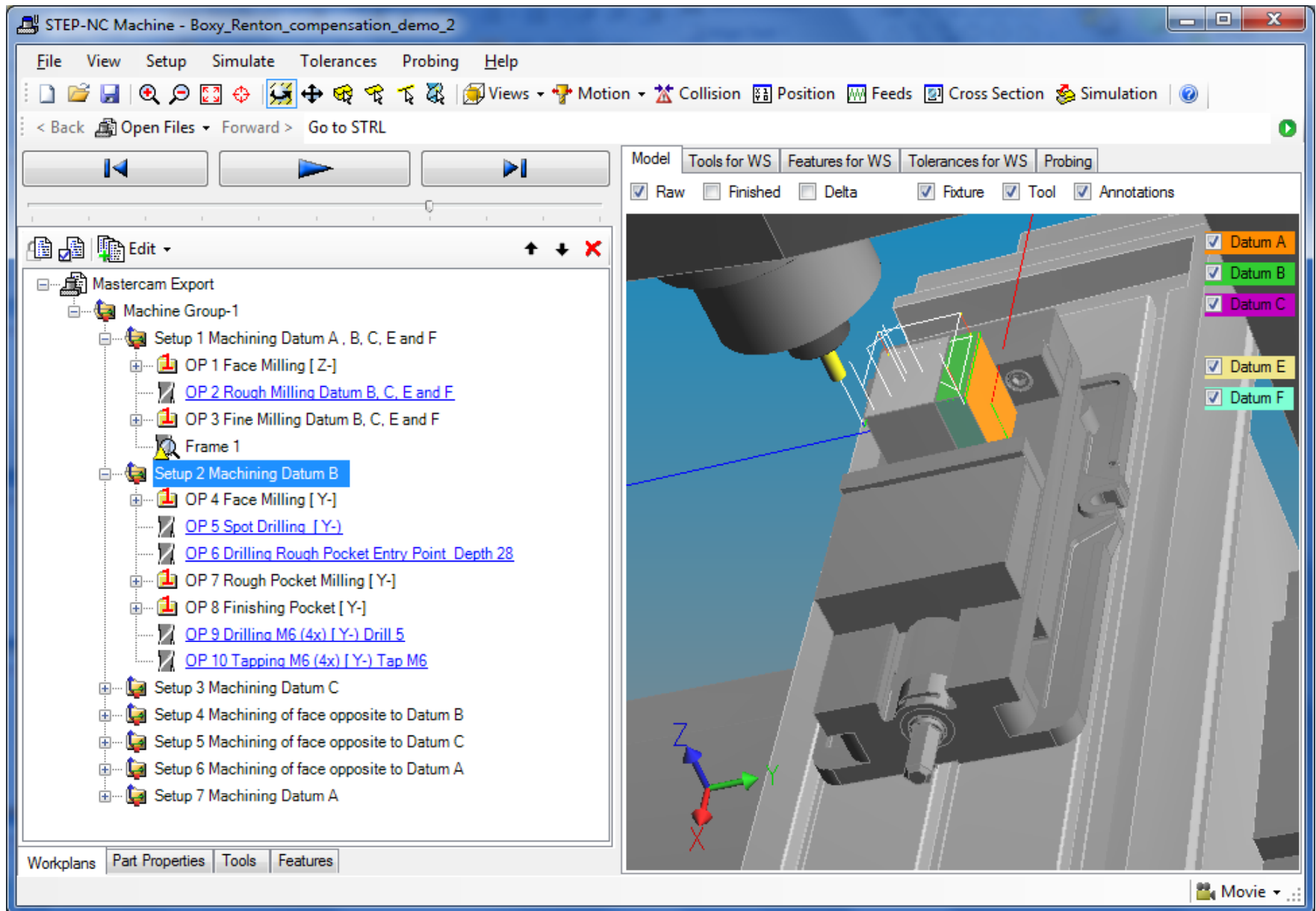# Pick the second setup
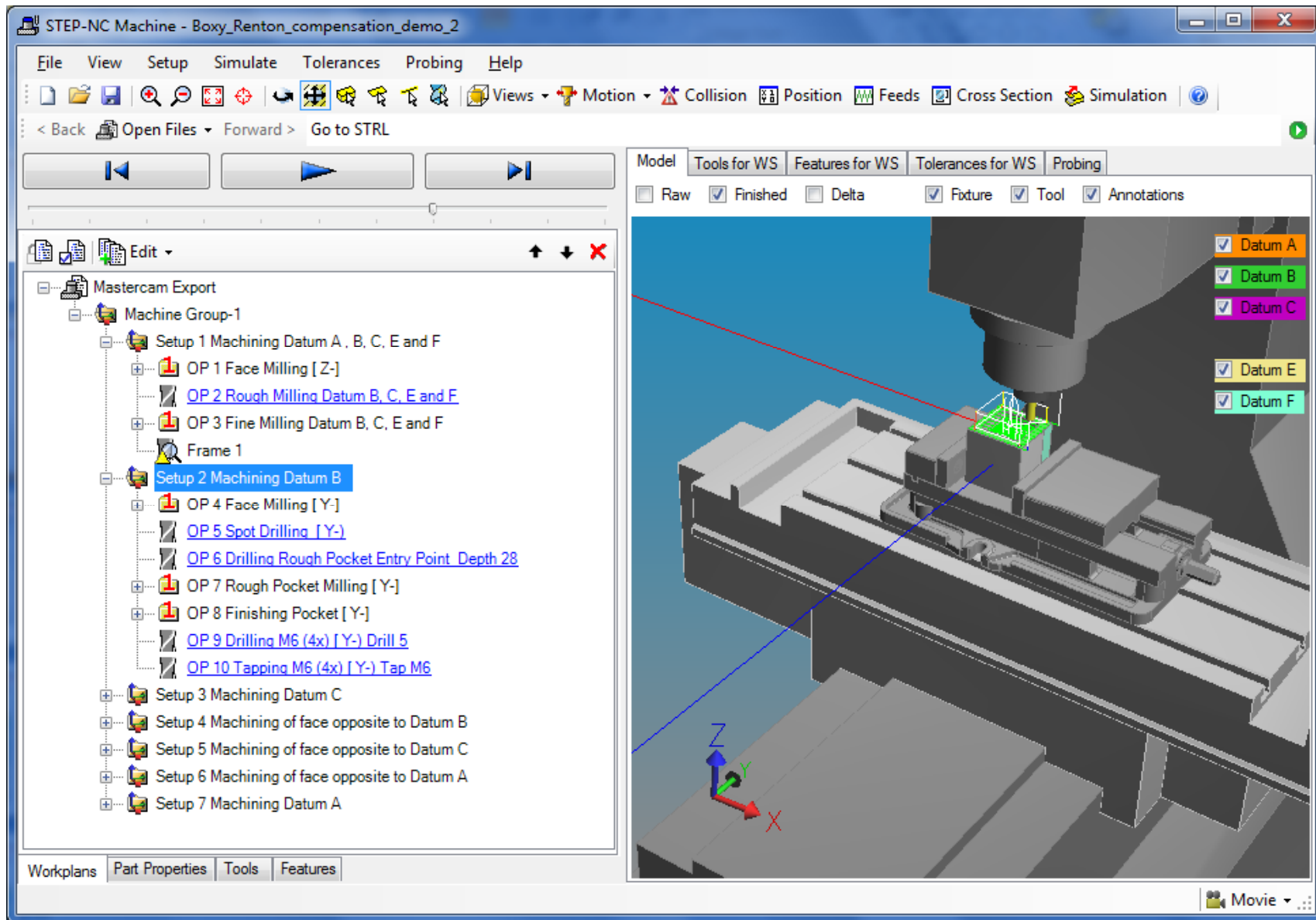
Turn Raw on and Finished off   STEP Tools, Inc.
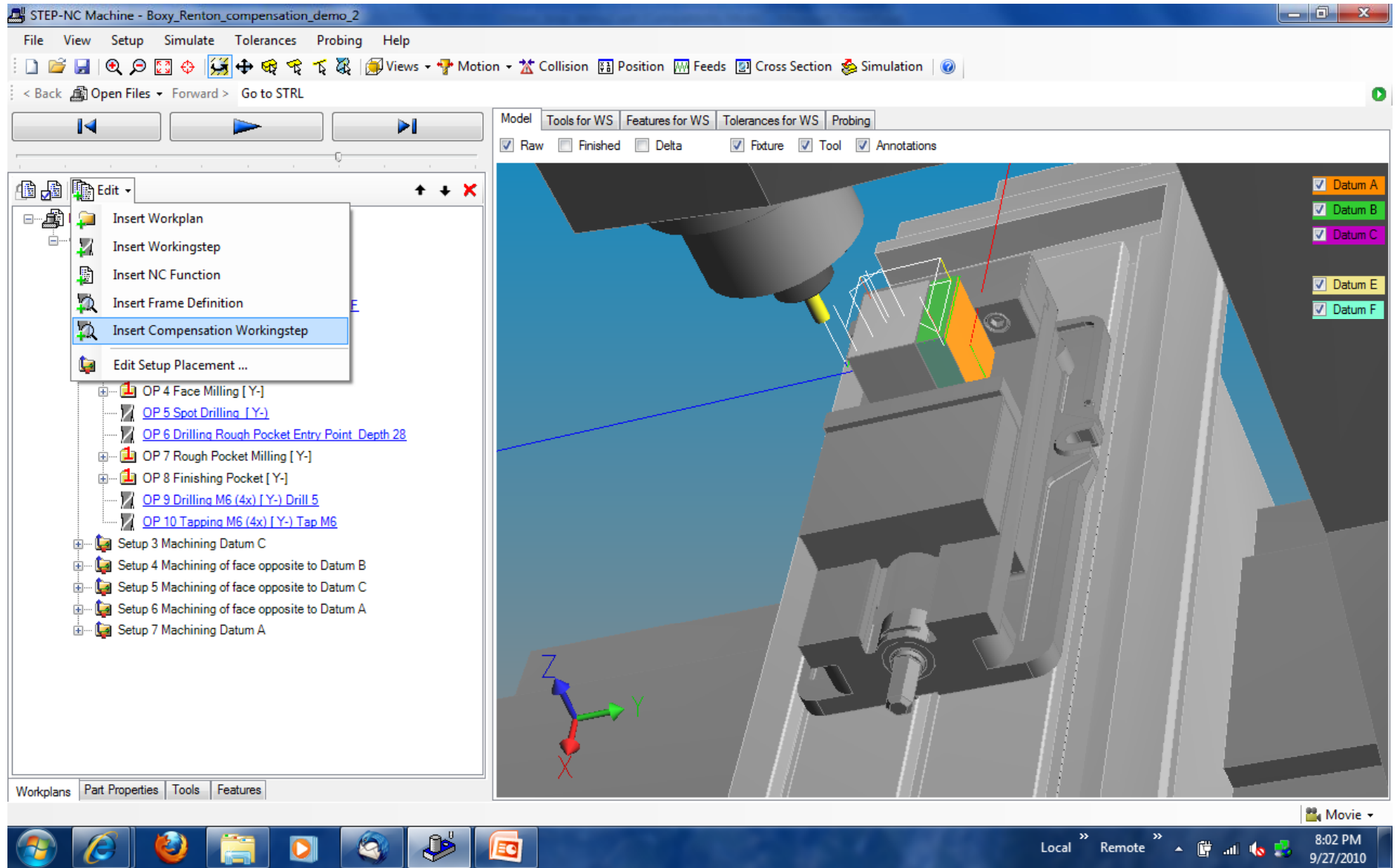
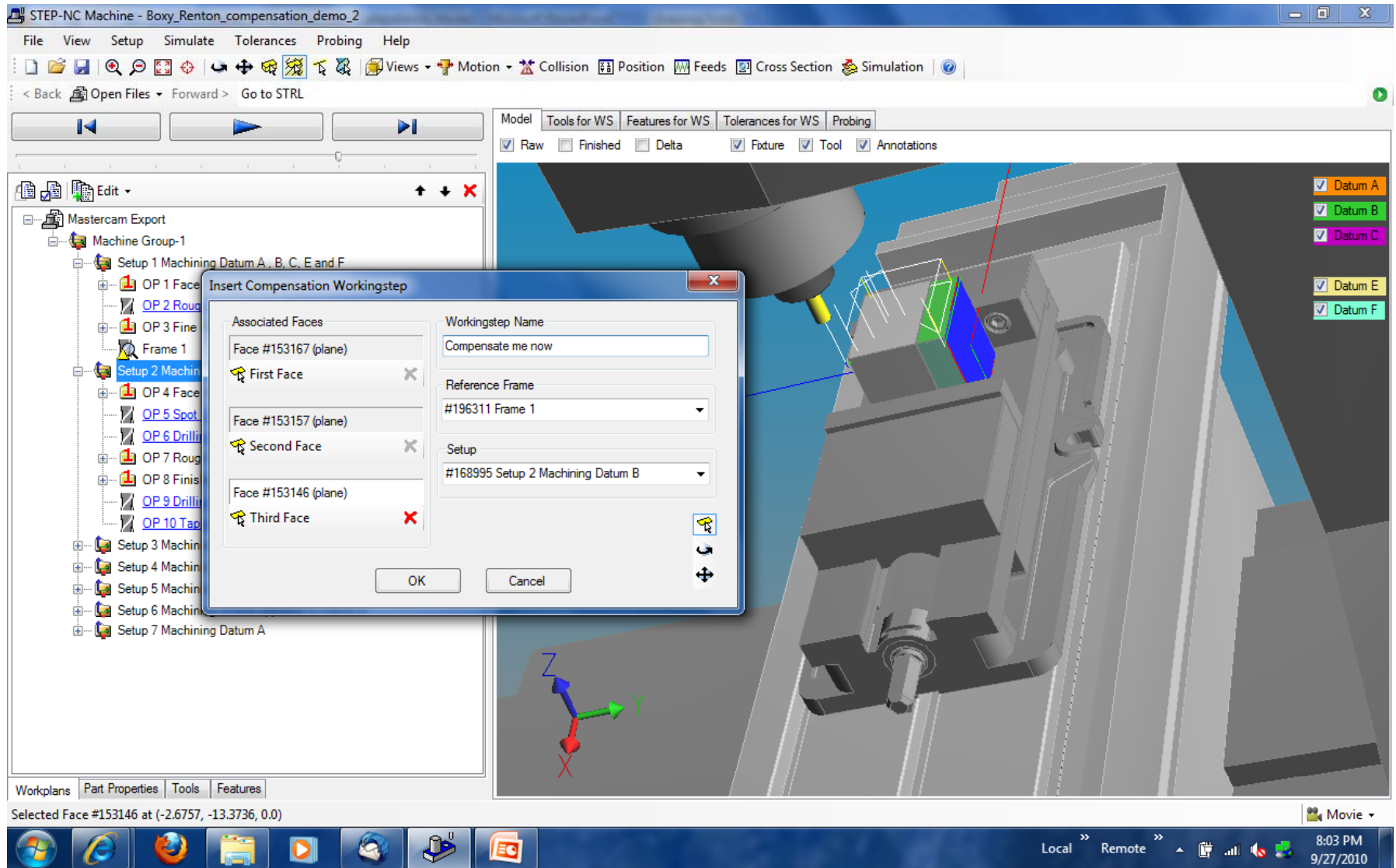# Rotate so that you can see three datum's   STEP Tools, Inc.

Pick Edit and Insert Compensation   STEP Tools, Inc.

Pick the three faces in the order they will be measured

STEP Tools, Inc.

Congratulations you have made demo 2 into demo 1

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