

# New features Connected Manufacturing

## Release Version 5.12

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# Tool Management

## Filtering tools and table setting

In order to make it easier for the user to work on the tool overview, the filters and the search have been extended.

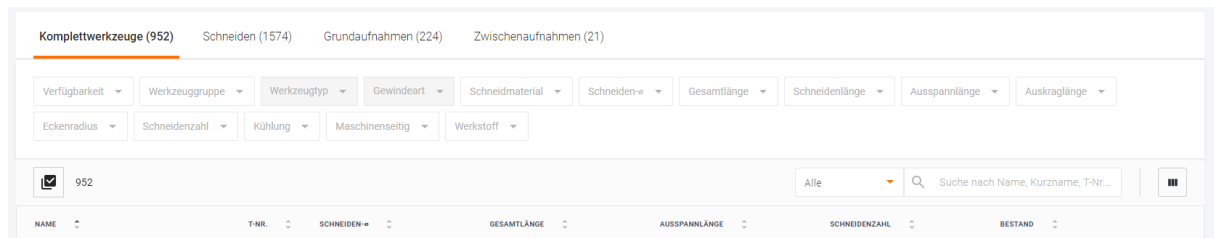


Figure 1 Tool Filter

The new filter elements are all listed above the tool listing.

Another customization is the configurability of the table columns. Here you can individually set which tool properties are to be displayed. A separate menu has been implemented for this purpose. You can do this by clicking the button next to the search field (see also **Find** ).

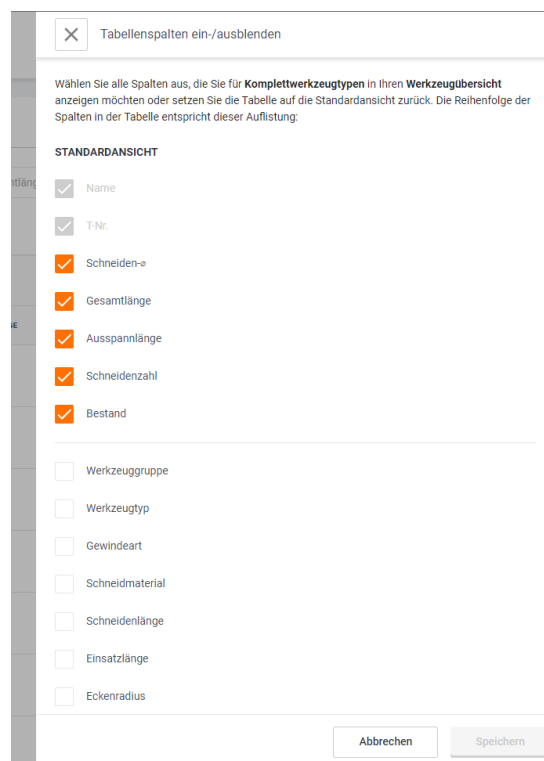


Figure 2 Example "Complete Tool Column Setting"

This function is also available in the "cutting", "Basic" and "Intermediate" areas with modified parameters.

**Find tools**

The search can be specified by the following values:

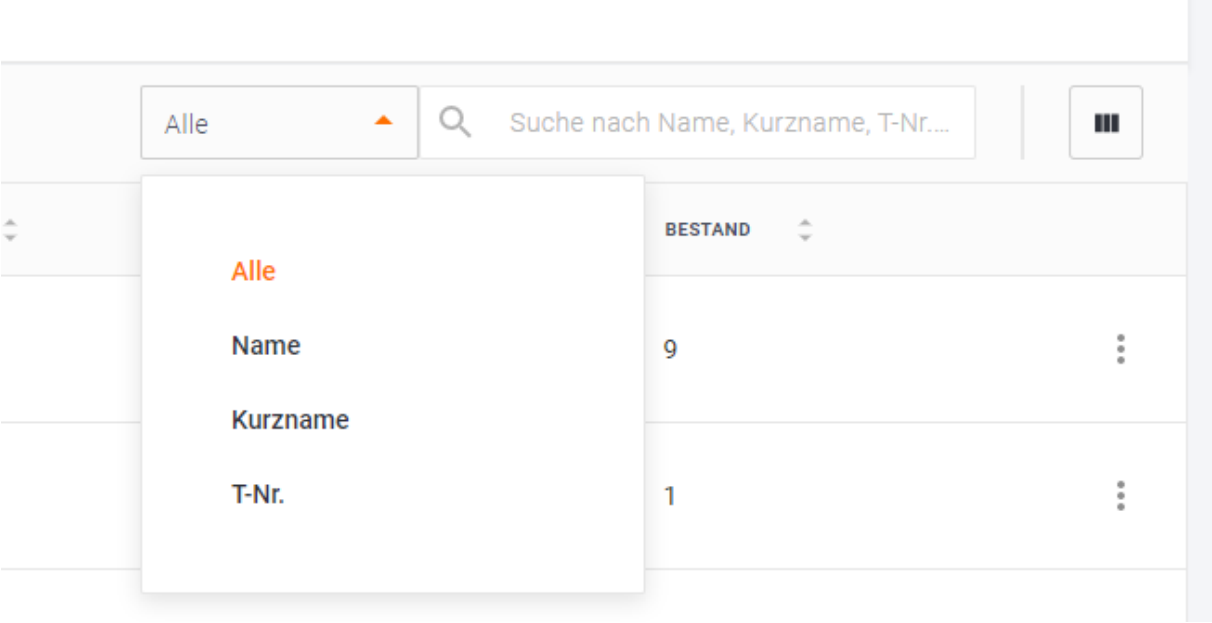


Figure 3 Example "Search Complete Tool"

This function is also available in the "cutting", "Basic" and "Intermediate" areas with modified parameters.

# Order Management

## Copying items - General

Currently, only completely completed jobs can be copied and re-created.

In order to facilitate the creation of orders, components and operations , individual elements (component, assembly, etc.) can now be copied. The function can be accessed as usual via the well-known "3-point-menu".

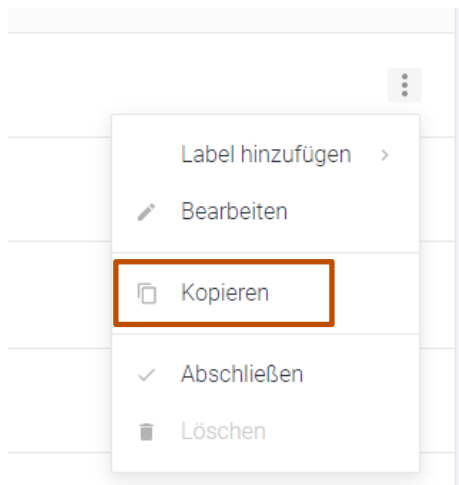


Figure 4 Copy function via 3-point menu

## Copy function/logic

If an item was selected and "Copy" was clicked, a separate menu opens.

This is divided into three sections:

### New Order Creation

If you want to copy a complete job (open or closed), a new job is created and all stored elements (e.g. components, work plans) are transferred accordingly. The user now has the option of storing order details and adjusting them.

Figure 5 Job details for new job creation with copied elements

### File Carry

A further part of the menu is the query for file handling. The user can decide which are to be transferred for the copying process.

Figure 6 Copy Setting

This can be selected by means of the switches (ON/OFF). If one or more options are selected, attachments are copied , for example, if they also exist.

Example – copying optimized NC programs:

**"Optimized only" NC program selected** → *If no optimized files are available, no NC programs are copied.*

### Assignment (Copy to ...)

If objects such as components are copied, they are copied to the job that has already been opened by default. In the lower part of the menu, you can also copy this object to an existing order or to a newly created order.

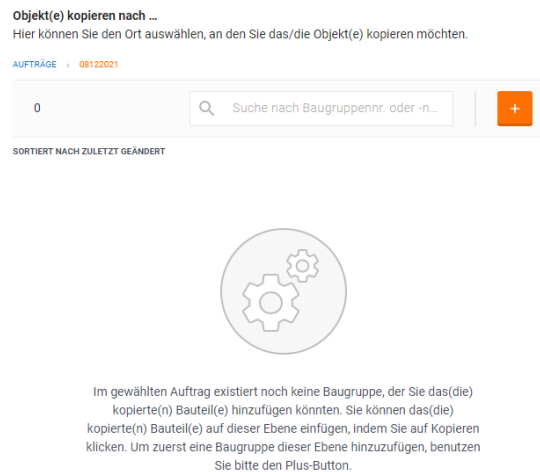


Figure 7 Copy, assign, and recreate

### Copy to an existing order

In the upper part of the area, the location of the copy operation can be determined and navigated accordingly.

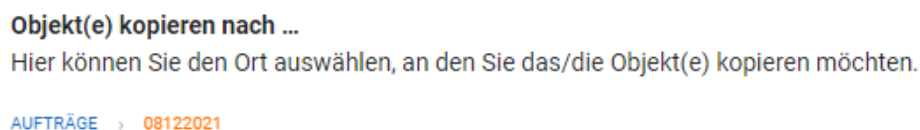


Figure 8 Copy to job "08122021"

Click on "Orders" to return to the order overview. And all open orders are now listed. A corresponding search function is also available here.

**08122021\_1 - Testteil**

AUFTRÄGE [Neuen Ort zurücksetzen](#)

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SORTIERT NACH ZULETZT GEÄNDERT

Zuletzt geändert - 15.12.2021, 10:02	>
<b>UAT_12_2021 HON</b>	
Zuletzt geändert - 13.12.2021, 15:51	>
<b>UAT_12_2021</b>	

Figure 9 Overview of open orders

The sorting is carried out over the last change date for better orientation.

If you now select an order, you can confirm this by clicking on "Copy".

### Copy and create a new job

Another option is to create a new order. Just click on the "plus" symbol.

The query is then made via the corresponding order details such as the order number and the customer.

The copy process is then performed as for "Copy function/logic".

## Customs

### Saving of measuring program, measuring mode and focus

The following values for each complete tool can now also be stored on the Zoller presetting device: Measuring program, measuring mode and focus. The first time a tool is left on the device, the fields are set to default settings and can be changed if necessary. These values are then applied to all instances of the complete tool and are transferred to the customs unit when a tool is left again.

The screenshot shows the 'Messdaten' (Measurement Data) interface on a Zoller presetting device. The 'Maschinenspezifisch' (Machine-specific) tab is selected. The following parameters are visible:

- Adapter: 1
- Pos. im ERB: 1 [1]
- Ident-Nr.: 4655
- T-Nr.: 203015
- Stufe: 1 [1]
- Schneidenform: 100
- Fokus: Nein
- Messmodus: Projek...
- Messbereich: 3,6 X 3,6
- Schneiden Umfang: 4
- PW: [ ] Abs.
- Messprog.: 17
- Theoretische Spitze über Schneidenform: [ ]

Parameter	Value	Unit
Z	90,000	R A G
X	5,000	R A G
Radius Soll	0,000	G
Winkel 1 Soll		G
Winkel 2 Soll		G

Figure 10 Measurement Data Zoller Presetting Device

## Machine Connection

### File paths on machines: New parameters for path structure possible

For files that are sent to a machine, a folder structure can also be created from the following values: **Creation date and time of the operation, name of the operation** and **position number**. Thus, the path structure can consist of the combination of the following blocks.

### New data fields on Heidenhain controllers

The following data on Heidenhain controls can now be written on the controller per tool and stored in the background of CM. This means that these values must be set manually on the controller at the first "left" and their value is stored in Connected Manufacturing.



It is important to note that the values are stored for each individual physical tool and not for each complete tool.

In addition, the required field must be set up for the first time by the service technician.

List of new fields: TIME2, DOC, PLC-VAL, KINEMATIC, AFC, DR2TABLE, LAST\_USE, LTOL, RTOL, R2TOL, TYPE, ACC, TP\_NO, AFC-LOAD, AFC-OVLD1, AFC-OVLD2, OVRTIME

## **Cam systems**

### **Import**

- Cross-version hyperMILL import improved, subsequent adaptations to the export file (.xml) are no longer necessary.