

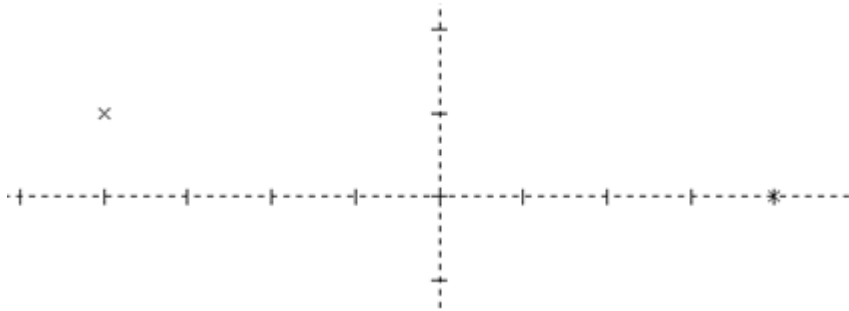
BobWIRE V19 DEMO LESSON:

Basic Open Shape Program.

We are going to begin this basic lesson by opening the BobWIRE software and making sure that you have a NEW drawing screen.

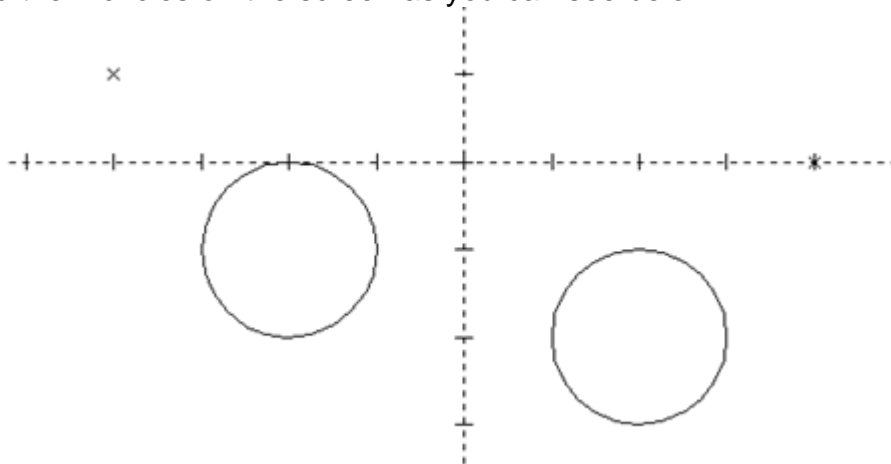
STEP 1

Select the POINT menu and then COORDINATES from the drop down menu that appears. For the X value enter 4 and for the Y value we leave at 0. Now select CONTINUE and enter in -4 for the new X value and 1 for Y. Then select OK. There should be two points on the screen as you see them below.



STEP 2

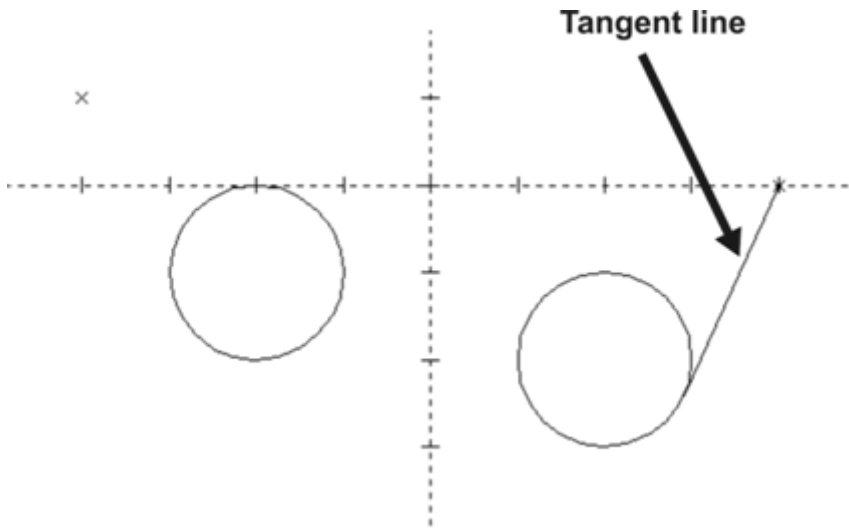
Now select the ARC menu and then COORDINATES. Enter 2 for X and -2 for Y and a RADIUS of 1. The Start Angle should be 0 and the end angle should be 360. Now click CONTINUE. You will now have a circle on the screen and the Circle Coordinates box will reappear on the screen. Enter in a NEW X of -2 and Y of -1. The radius will remain at 1 and the start angle as 0 as well as the end angle as 360. Click OK. You will now have the 2 points and the 2 circles on the screen as you can see below.



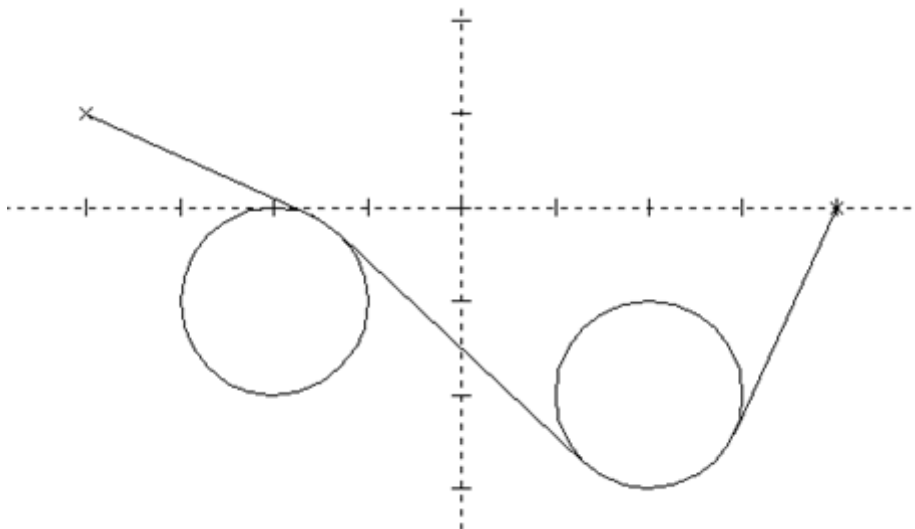
STEP 3

Select the LINE menu and then TANGENT. What we are doing here is joining the circles with the points that will then give us a rough shape to cut. One you have selected TANGENT, click on the furthest point to the RIGHT of the screen and then select the bottom part of the RIGHT circle.

A line should now appear that joins the point tangent to the right circle as you can see below.



Next click on the bottom of the same circle and then the TOP of the circle to the LEFT. Finally, click on the TOP of that same circle and then the point to the far LEFT. Click your LEFT mouse button when finished to exit the tangent function. Your screen should look like the example below.

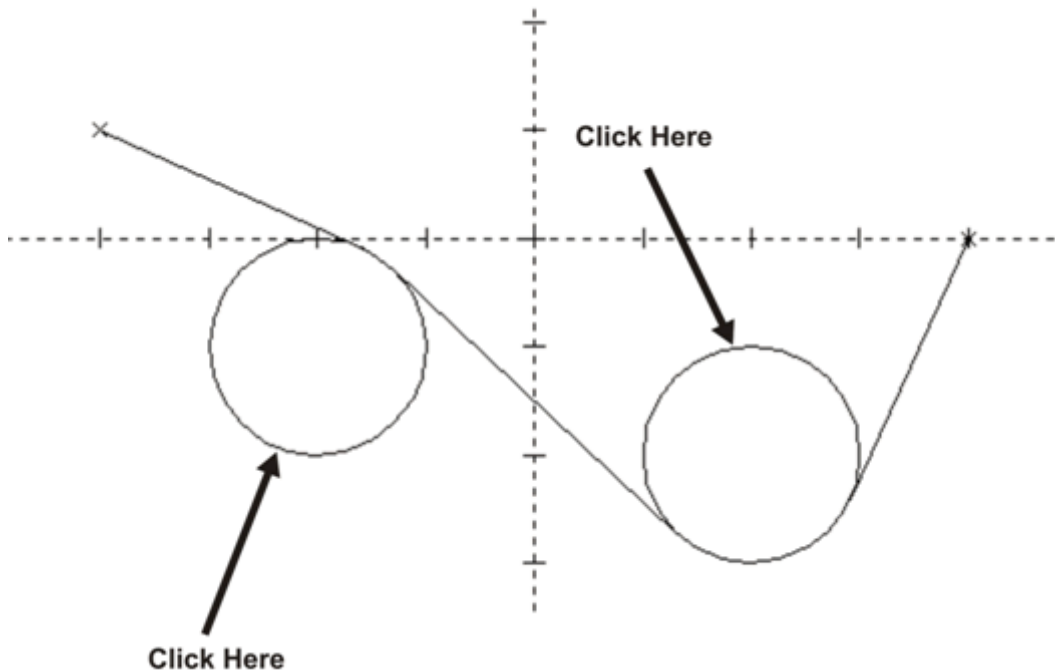


STEP 4

We can't have the wire follow these circles around so we will need to edit them from our drawing. Select the CHANGE menu and then select BREAK, followed by BREAK MANY from the submenu. A box will appear with several options and you will choose ALL. Your geometry will now be broken and possibly selected. Click your mouse in an empty area of the drawing screen to deselect everything.

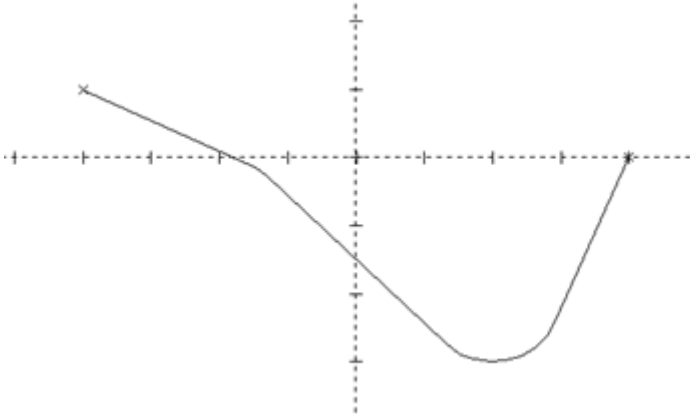
STEP 5

Now select the EDIT menu and choose SELECT ENTITIES, then SINGLE. Now click on the pieces of the circle that we want to delete as you can see below.



Once the pieces of the circle have been selected, hit the DELETE key on your keyboard or the trashcan icon on the main toolbar. You may need to select two more small pieces of arc to get the final result that we want.

Your drawing should look like the example below now.

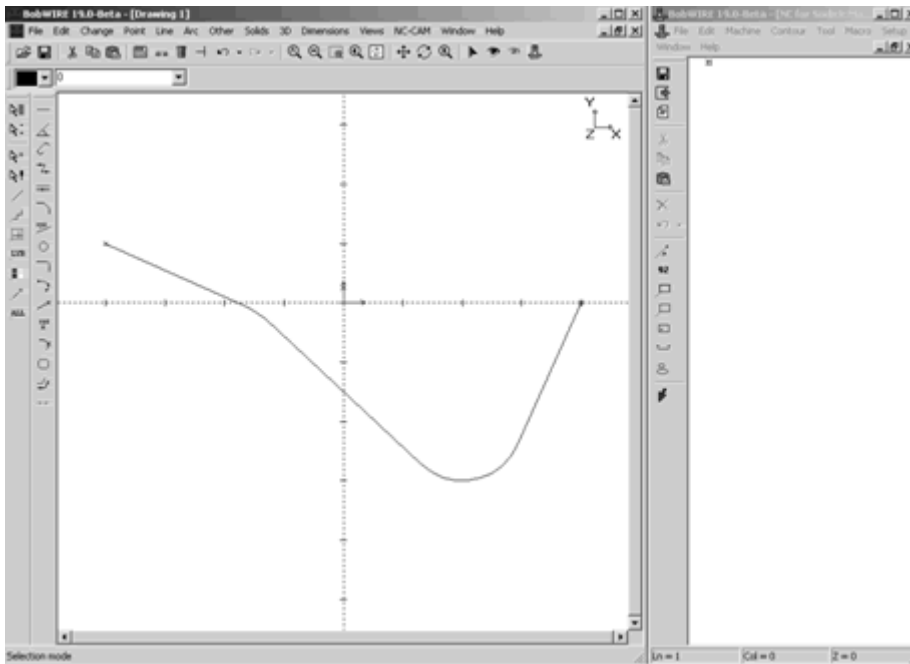


Now select the REPAINT THE VIEW button and the screen will be refreshed.



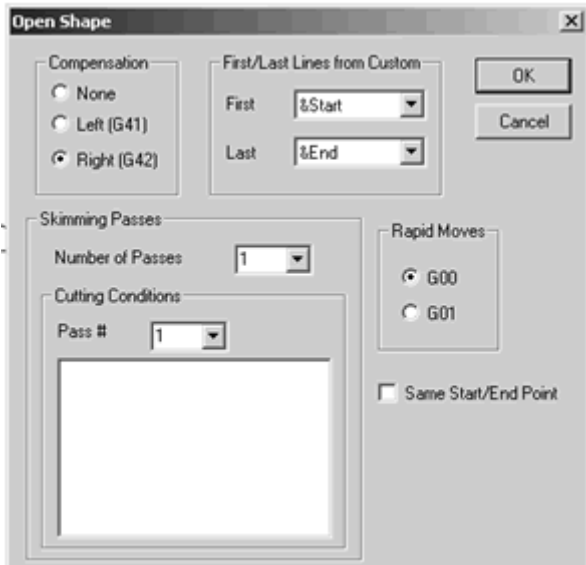
STEP 6

Now we are going to open the cam side and proceed with the open shape part program. Select NC CAM from the main menu. This will open the Insert NC Data box so that you can select a post processor. Select the ROBOFILL 390 post processor as an example for this lesson and then click OK to open the CAM side of BobWIRE.



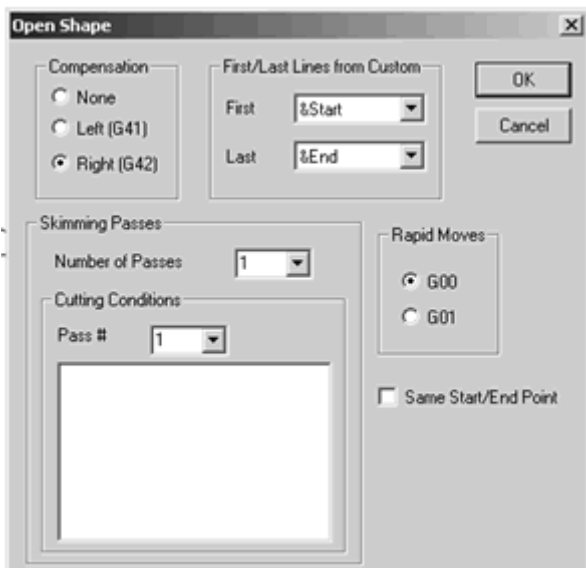
STEP 7

Now select the OPEN SHAPE button from the CAM menu or select the MACHINE menu and then OPEN SHAPE. This will bring up the open shape dialog box as you can see below.



Under COMPENSATION, select RIGHT-G42. Under FIRST LINES, select PROGRAM START and then PROGRAM END for LAST.

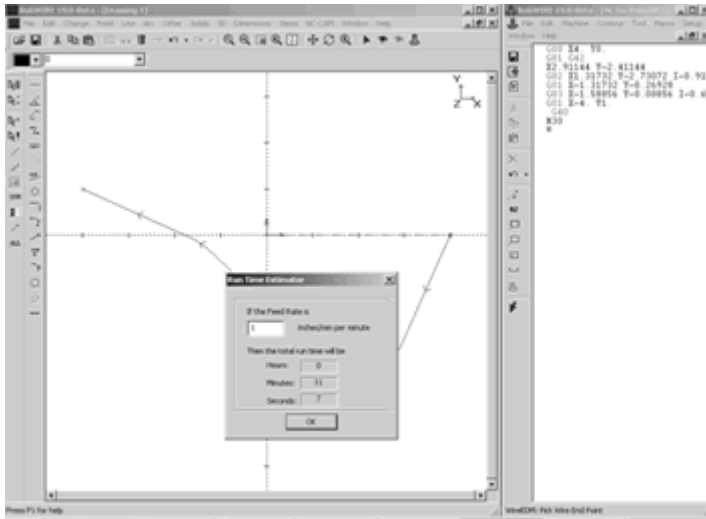
Select 1 for NUMBER OF PASSES and make sure that your RAPID MOVES has G00 selected. See the example box below to verify that you have made the correct selections.



Do not check the "Same Start/End point" option.

STEP 8

Now select OK. Now you will need to select the START POINT for the program which is going to be the point that is on the RIGHT end of the open shape. Now select the geometry just below that point. Now you will have an arrow asking to define the direction of the chain. Point this arrow to the LEFT by moving your mouse left and once that you have the arrow pointing in the correct LEFT direction, click your mouse button one time. Once you have done this, click on the far LEFT end point. When the selection box appears, click YES. This will generate your g-code program and you will see a Run-Time box appear.



That completes this lesson.



417 Plaza Drive
Dunedin, FL 34698
Toll FREE: 877-262-2231
Fax: 727-442-1773