

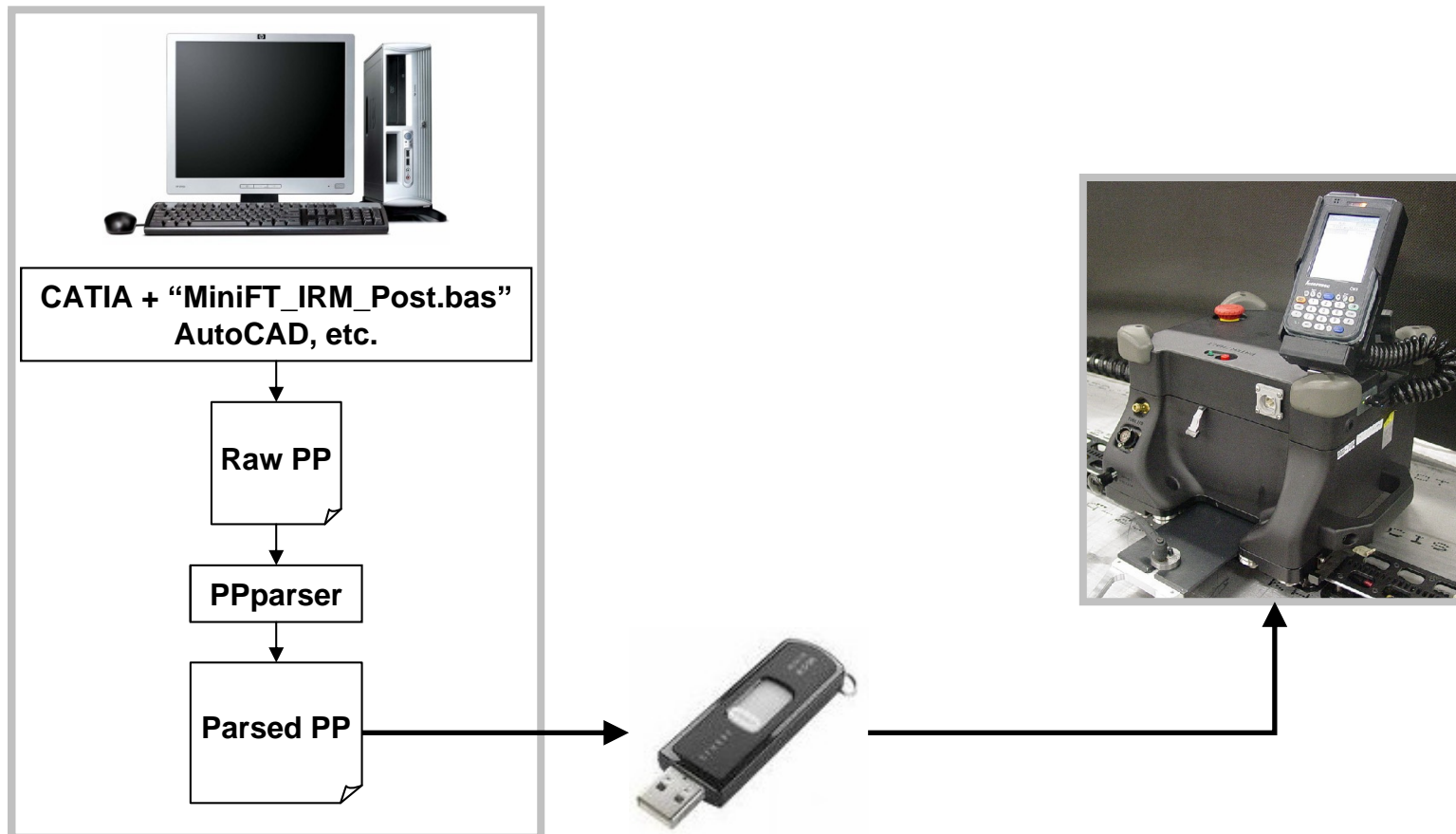
# Creating Part Programs for the MiniFT

## Contents

1. Creating Part Programs--Overview
2. Part Programs--“Raw” Format
3. Using PPparser, Steps 1-4

## Creating Part Programs -- Overview

- Part Programs (PP's) begin in a “raw” format.. This raw format is created from a CAD application (such as CATIA and the “MiniFT\_IRM\_Post.bas” macro, or AutoCAD, etc.).
- The raw PP must be parsed to work on the MiniFT. The parsing is done with “PPparser”.
- The parsed PP is then transferred to the MiniFT using a USB flash drive.
- A parsed PP cannot be edited directly because it contains checksums to maintain file integrity and configuration control. If a PP needs to be changed, the raw PP must be changed and then re-parsed.
- The overall process is depicted below.



## Part Programs – “Raw” Format

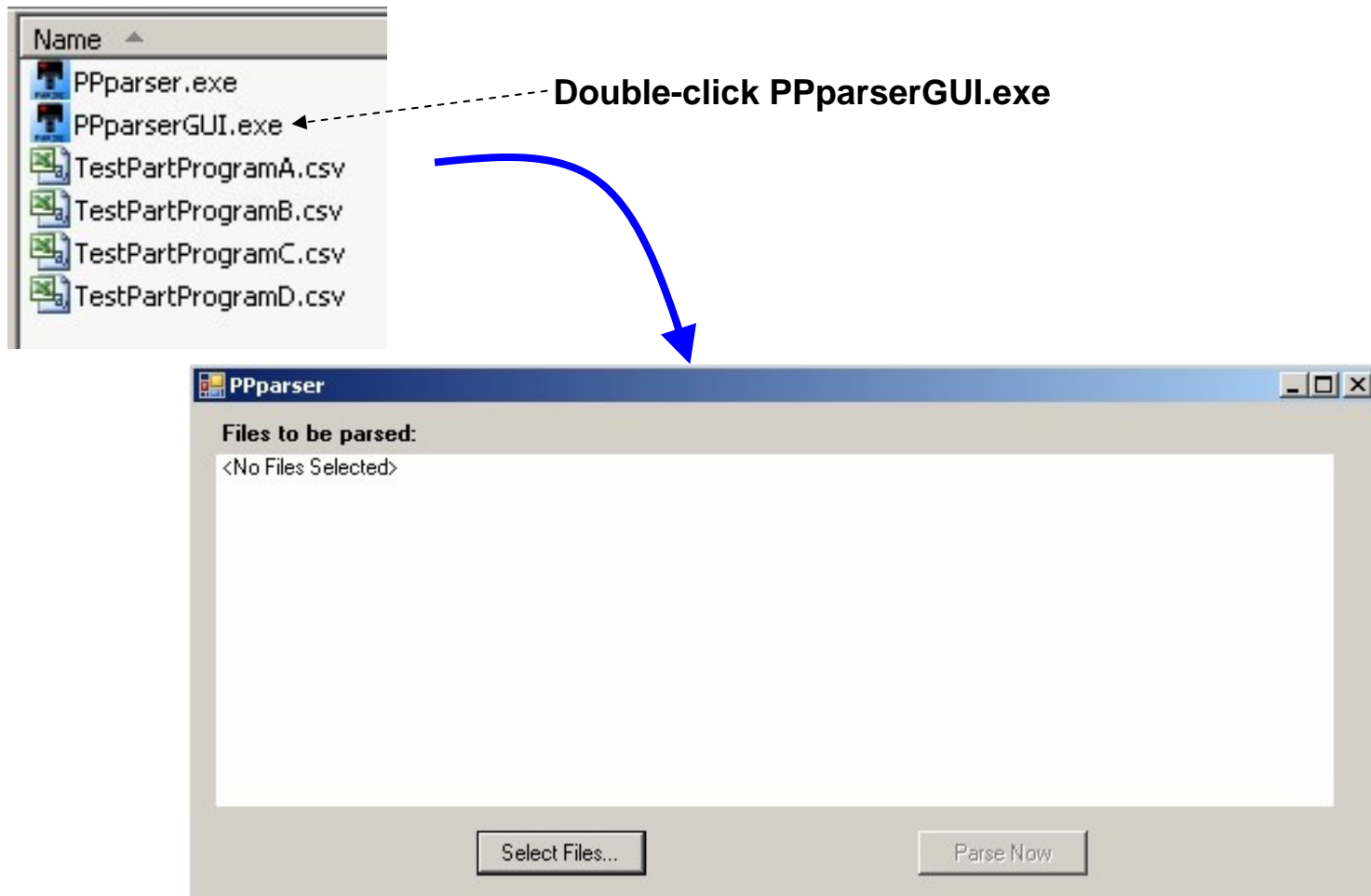
- **Part program requirements, raw format.**
  - » **Column A – Hole ID (alphanumeric)**
  - » **Column B – Flat X**
  - » **Column C – Flat Y**
  - » **Column D – Hole Diameter**
  - » **Column E – Pattern number (alphanumeric)**
- **Must be in Comma-Separated Value (CSV) format.**
- **Dataset must be sorted by pattern numbers in ascending order. Any number or numbers can be skipped for pattern number.**
- **K-holes are designated by having a zero in column D in which case the operator will not be given the option to drill out K-hole. They can also be designated by adding 9 to the k-hole diameter (i.e. 9.1875) in which case the operator will be given the option to reposition at K1 and K2 to drill out k-holes if desired.**

### Excerpt of an Example Raw Part Program

	A	B	C	D	E
1	1000101	0	0	0	1
2	1000001	0	0	0.1875	1
3	1000002	4	4	0.1875	1
4	1000003	8	0	0.1875	1
5	1000004	12	4	0.1875	1
6	1000005	16	0	0.1875	1
7	1000006	20	4	0.1875	1
8	1000007	24	0	0.1875	1
9	1000008	28	4	0.1875	1
10	1000009	32	0	0.1875	1
11	1000010	36	4	0.1875	1
12	1000011	40	0	0.1875	1
13	1000012	44	4	0.1875	1
14	1000013	48	0	0.1875	1
15	1000014	48	4	0.1875	1
16	1000015	44	0	0.1875	1
17	1000016	40	4	0.1875	1
18	1000017	36	0	0.1875	1
19	1000018	32	4	0.1875	1
20	1000019	28	0	0.1875	1
21	1000020	24	4	0.1875	1
22	1000021	20	0	0.1875	1
23	1000022	16	4	0.1875	1
24	1000023	12	0	0.1875	1
25	1000024	8	4	0.1875	1
26	1000025	4	0	0.1875	1
27	1000026	0	4	0.1875	1
28	1000027	48	0	0	1
29	2000101	0	0	0	2
30	2000001	1	0	0.1875	2
31	2000002	6	0	0.1875	2
32	2000003	11	0	0.1875	2
33	2000004	6	0	0.1875	2
34	2000005	1	0	0.1875	2

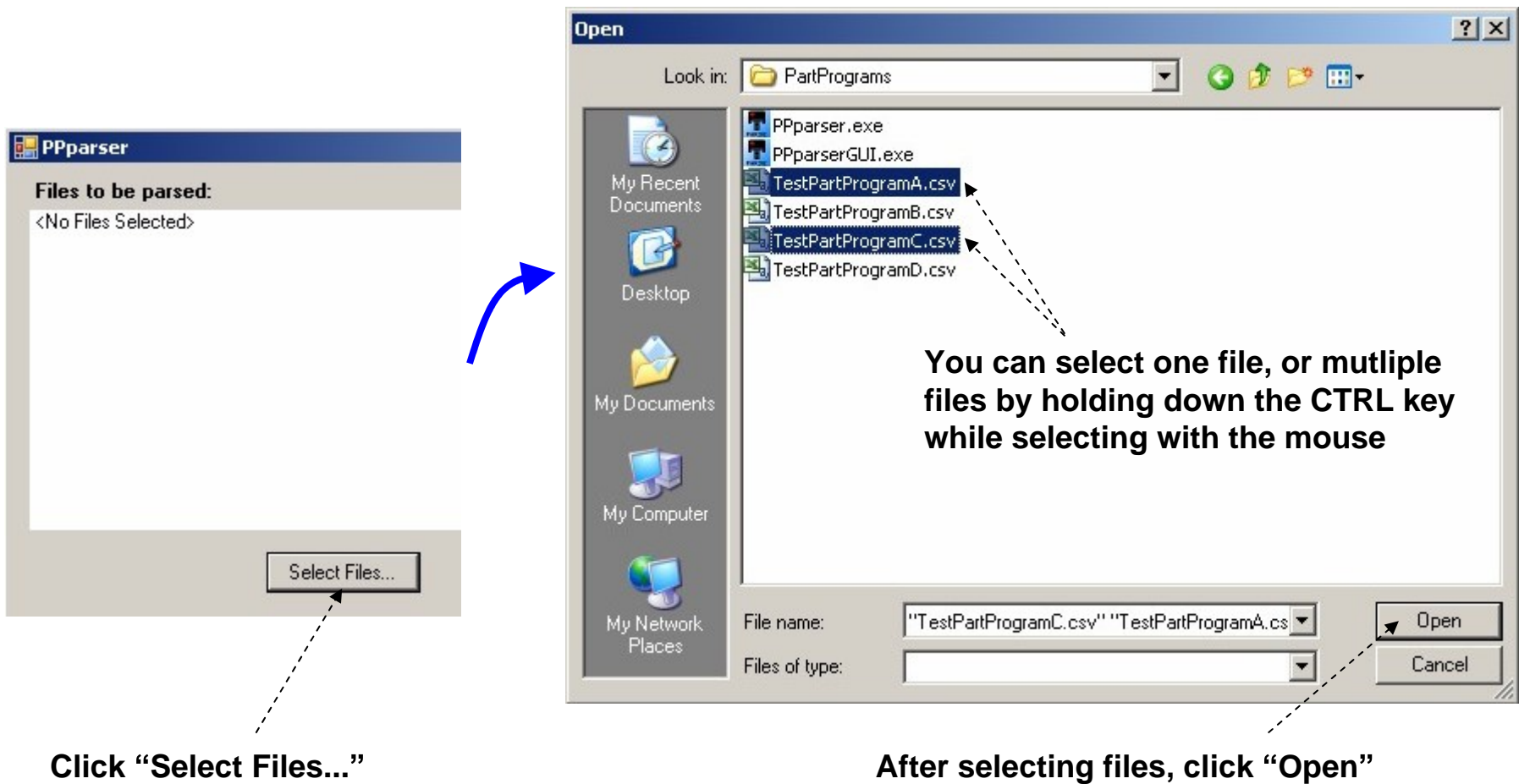
# PPparser, Step 1

- There are two components to PPparser.
  1. PPparser.exe
  2. PPparserGUI.exe
- To install these on your PC, simply copy them to any desired folder.
- Double-click on the PPparserGUI.exe application.



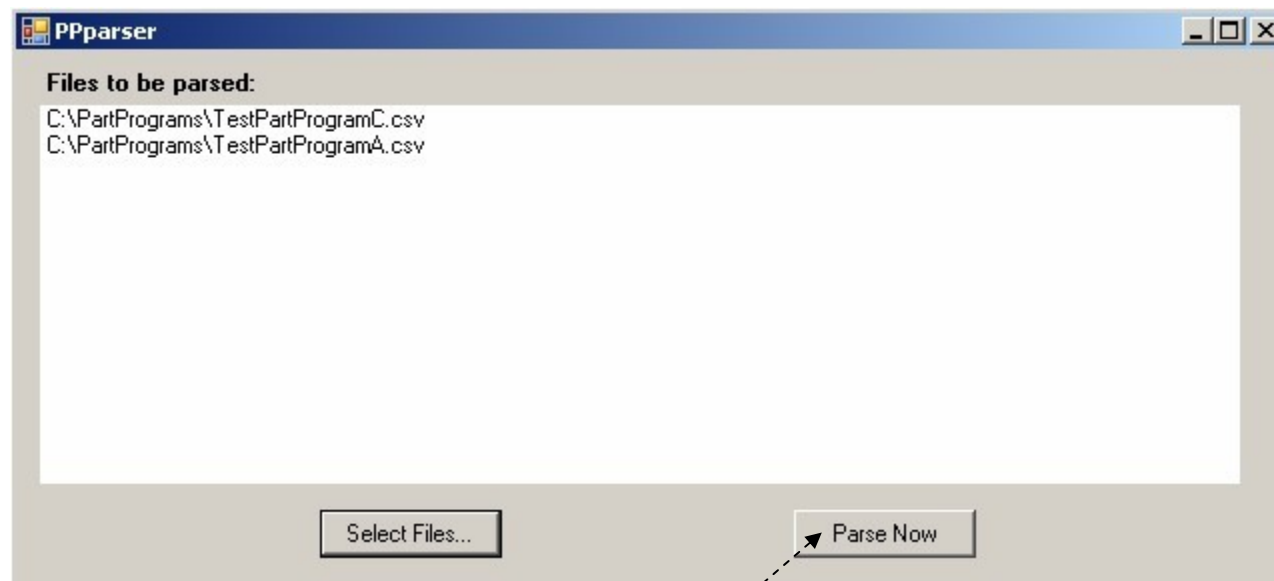
## PPparser, Step 2

- Click “Select Files...” to choose the raw PP’s to be parsed.
- In the “Open” dialog box, select one or more raw PP’s, then click “Open”.



## PPparser , Step 3

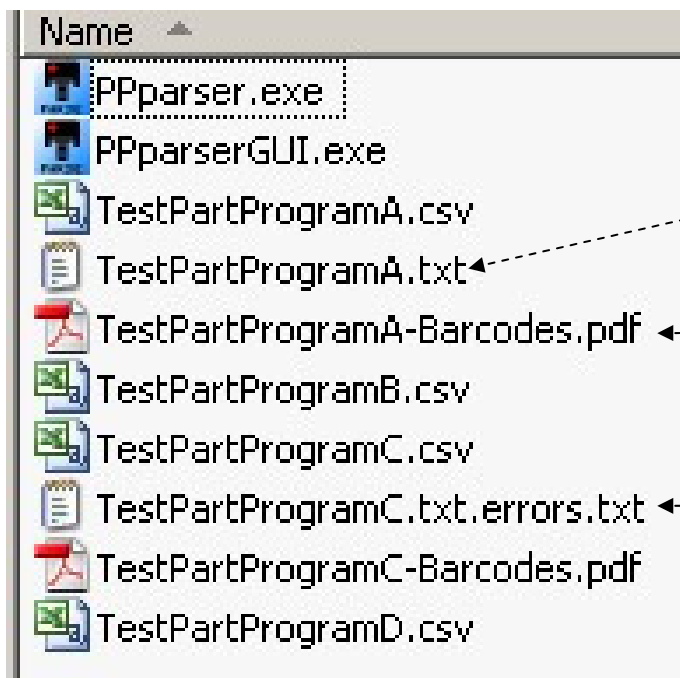
- After selecting the files, click “Parse Now”.
- The parsed PP’s are created in the same folder as the raw PP’s.



Click “Parse Now”

## PPparser , Step 4

- After clicking “Parse Now”, there are two files created for each raw PP selected
  1. The parsed PP (with a “.txt” extension...***load this file onto the MiniFT using a USB drive***). This file cannot be edited directly because it contains checksums to maintain file integrity and configuration control. If a PP needs to be changed, the raw PP must be changed and then re-parsed.
  2. A file containing barcodes for all pattern and K-hole names (in PDF format). This file is ***not*** needed for operating the MiniFT, but is provided for convenience.
- If there are errors during the parsing process, the output filename will contain a “.errors” extension. The specific errors can be investigated by opening this output file and reading the error descriptions at the very end of the file.



TestPartProgramA.txt was created successfully.  
***Load this file onto the MiniFT using a USB flash drive.***

A PDF file with barcode images is created for each PP

TestPartProgramC.txt encountered errors. Open this file and look at the end of the file to investigate the errors. For example, the errors might appear as follows:

```
ERRORS:  
30:Extra Khole for Pattern 12215101.  
32:Extra Khole for Pattern 12215101.
```