IMPORT Vector Files \$\$\$ or S2B

(FARO or ROMER)

To adequately import Vector files we are importing (reading from) a basic TXT file. They are saved on the Vector measuring unit as \$\$\$ (Romer) s2b (FARO)

They can be imported as inch on mm files.

You must know the Measuring machine settings that were set to measure the part so we can adequately "create" a bend ide to properly import the file. If the die is not exactly as indicated on the exported file, it will not work.

Create a bend-die file as follows:

20 mm ONE stack	Number of Stacks	1 Stack -	Stack 1		
Profile		1- Round 🔹 🏠	Bend die Code 20 mm CLR k	ower stack	
Tube Diameter	mm	20.00	Bend-die Typology		1- Mandrel
Wall Thickness	mm	0.10	CLR	mm	20.00
Tube Stop present		\checkmark	Development/deg	mm/*	0.349
Depth Tube Stop	mm	25.00	Actual Dev/degree	mm/*	0.349
Positioner Length	mm	750.00	Minimum Value	mm	120.0
Mandrel Present			Interference Value	mm	205.0
Safety offset (only for PD)	mm	5.00	Bend die Height	mm	80.00
Side Shift for stack change	mm	5.00	Type of Pressure die		0-Mobile
Tube in collet	mm	25.00	Pressure Die	mm	200.0
Axis-Y Max Limit	•	0.00	Pressure die Piston Travel	mm	300.0
Position Stack 1	mm	40.00	K to calculate useful PD length		2.0
Bend Shaft Height	mm	200.00	Pressure die useful length	mm	160.00
Bend Shaft Diameter	mm	40.00 🗸	Max Y angle on PD useful Length	•	458.3
Note			Min Length of Pressure die for last bend	mm	40.0
N* Element Message			Clamp	mm	30.0
1 0 [1] VALIDATION OK - Tooling Transferred Correctly			Wiper Die Present		
			Wiper Die	mm	0.0
			Clamp Spacere	mm	0.0
			Note		1
ET New 🌞 Load 🔮 Delete 👄 Rename 🗔 Copy 🧐				VALIDATE	🥢 Transfer 🛛
				Star HMI	1261

This below is a TYPICAL LRA file created by the Vector measuring device:

\$clra 4 200.419300 0 0 0 0.000000 0 0 0 20.045890 0 0 0 **20.000000** 112.398323 0 0 0 -179.531673 0 0 0 100.117644 0 0 0 20.000000 115.033581 0 0 0 -179.993625 0 0 0 45.087940 0 0 0 20.000000 107.994572 0 0 0 179.729945 0 0 0 46.064276 0 0 0 20.000000 76.039951 0 0 0

From the information above, we can confirm the part was measured with 20 mm die as being used to fabricate the part. We also can read the DBB, the rotations and bend angles from this file.

RTS MANAGEMENT								+- 0
	Part Name :	≪ Q <mark>⊕</mark> D : :	Standard		Tooli + Stack Elec	ig : X Axis Radius (mm) (mm)	Y Axis Elasti (*) Retu	icity Z Axis im (°)
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				_				
В О	PLC O Tooling : Bend-Die : Part Name :						Star HMI: v 3.6.	. ¹ mm 5:02

After creating the die, OPEN the Program Part page:

Click on [Import \$\$\$] radio button:

	Part Name :		Standard			Т	fooling :					
		4 Q # 5 :::			+	Stack	Element	X Axis	Radius	Y Axis	Elasticity	ZA
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This PC	STAR pics July 22 2016	7/22/2016 9:03 AM	File1									
Autodesk 360	Star translation	7/15/2015 12:50 PM	File1									
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Select the file TYPE SSS or s2b by clicking the pull down tab. Select the file we just measured [Tube1.\$\$\$] CLICK OPEN

	Part Name :	Standard		Tooling :		
		ିର୍ Q <mark>∰</mark> D : :				
	₩ Element Message	Part Name : TUBE 12345 - Bename		X	Program	
		Toolin: 20 mm ONE stack Client Codes : Standard Save	Cancel 🔀		riugiess	
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	PIC O Tooling : Rend Die : Part Name				Star HMI: v 3.6.1 mn	m 5-14 P

This window opens, and here we insert the part name and select the tooling.

Once the Name is written and the tooling is selected, hit the [SAVE] button, and this will open a part page and will be populated with the information from the \$\$\$ file.

	Part N	ame : TUBE 12345 - Rename		Standard				Tooling : 20	mm ONE sta	ck]
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After changing the parameters to suit the part, we must validate the part.



Validation yields that the back part is short; however, since this part can be easily started from the opposite end, we can invert the part by clicking the radio button as shown below:

	r							[5005]					
	0	Part Name : 1108E 123	Standard	-	• +	Stack Level	Tooling Eleme	: 20 m nt	M ONE star X Axis (mm)	ck Radius (mm)	Y Axis (*)	Elasticity Return	Z Axis (°)
82/0				V	1 1	1	Line Bend	<u> </u>	200.42	>	20.0459	2.0000	0.00
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•	Part Name : TUBE 123	St	itandard			Tooling : 20) mm ONE sta	ck			
0		Q + 💆 🗄	-	+	Stack Level	Element	X Axis (mm)	Radius (mm)	Y Axis (°)	Elasticity Return	Z Axis (°)
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Once inverted, we must VALIDATE again and change any parameter we deem needing changing.



After changing the parameters, use only the CORR \$\$\$ Icon:

Assuming we changed some of the default parameters, we must proceed with importing corrections correctly, or the parameters will revert back to "default", see below:



· 🗆	Part Name : TUBE 123	Standard				Tooling : 2	0 mm ONE sta	ack			
		Q + 🖸 : :	-	+	Stack Level	Element	X Axis (mm)	Radius (mm)	Y Axis (*)	Elasticity Return	Z Axis (°)
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If importing the correction with the appropriate radio button, all the parameters will remain untouched:



Conce the CORR \$\$\$ is selected, the above window opens, select the "corrected" file, open it and the previous part will be re-populated and will only replace the part entries and no other change will occur, nor will you be prompted for name or bend-die changes etc.

Please remember, that if the part was inverted to permit its fabrication, YOU must measure the bent part from the opposite end so the importation of the correction will occur correctly. However if it was not, remember to invert the part again prior to validation.