

Question/Issue

Control Definition: Can I override the Control Definition settings in a post processor?

Answer/Solution

The short answer is yes. First you must remember that the CD settings tied to pre-defined post variables only override the variable initialization. If the pre-defined variable is used throughout the post to change back and forth between options the CD setting will have no effect on this.

To override a CD setting in the Post Processor all you need to do is use the pre-defined variable in a formula or assignment. To override the initial value from the CD we suggest adding the pre-defined postblock PPREP\$ to the post and adding your variable assignments in this postblock.

In this example we will override the enable canned drilling cycles for a Mill post (.PST) or Setup sheet (.SET) from what is shown here in the Control Definition.

Control definition: C:\mcamx\cnc_machines\DEFAULT.control

Existing definitions: Control type: Mill Manufacturer: Generic Default

Post processors: C:\mcamx\mill\Posts\MPFAN.PST Description: Generic Default

Control topics:

- Tolerances
- Communications
- Files
- NC Dialog
- NC Output
- Misc. Int/Real Values
- Work System
- Tool
- Linear
- Arc
- Rotary
- Feed
- Cutter Compensation
- Machine Cycles
- Mill
- Mill Drill Cycles
- Subprograms
- Operation Defaults
- Text

Check to enable canned drill cycle:

- Simple drill - no peck
- Peck drill - full retract
- Chip break - incremental retract
- Tapping - feed in, reverse spindle - feed out
- Boring #1 - feed out
- Boring #2 - stop spindle - rapid out
- Misc #1 drill - uses simple drill
- Misc #2 drill - uses simple drill

Note: Custom drill cycles do not produce long code drilling

Machine Cycles Drill - Select if a drill cycle is to output as a machine control cycle or long hand code.

This is an image from the initialization section showing the settings of the enabled canned drilling variables. Notice they are all enabled just like in the CD image above.

```
# -----  
# Enable Canned Drill Cycle Switches  
# -----  
usecandrill$ : yes$ #CD_VAR Use canned cycle for drill  
usecanpeck$ : yes$ #CD_VAR Use canned cycle for Peck  
usecanchip$ : yes$ #CD_VAR Use canned cycle for Chip Bre  
usecantap$ : yes$ #CD_VAR Use canned cycle for Tap  
usecanbore1$ : yes$ #CD_VAR Use canned cycle for Bore1  
usecanbore2$ : yes$ #CD_VAR Use canned cycle for Bore2  
usecanmisc1$ : yes$ #CD_VAR Use canned cycle for Misc1  
usecanmisc2$ : yes$ #CD_VAR Use canned cycle for Misc2
```

If you were to change the initialization of these variable to disable the canned cycles by replacing the yes\$ above with a no\$, the CD settings will be used and the cycles will be enabled. To override the CD settings we would add the ppreps postblock and the following assignments. The lines of code below will override the enable canned drilling settings in the CD and disable the canned cycles for drilling, peck drill and chip break.

```
pprep$ #Pre-process postblock - Allows post instructions after the pos  
#is parsed but before the NC and NCI file are opened.  
usecandrill$ = no$ #Turn off canned drill  
usecanpeck$ = no$ #turn off canned peck  
usecanchip$ = no$ #turn off canned chip break
```