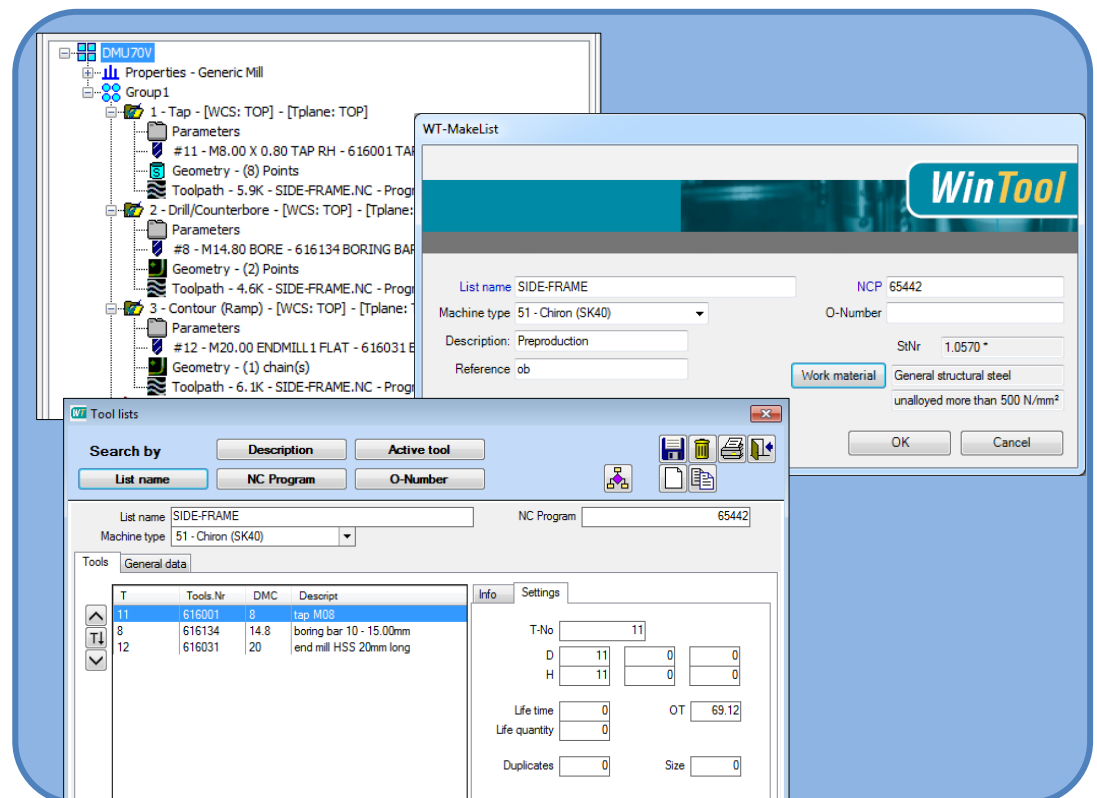


WT-MakeList



Manual

WT-MakeList 3.9.5

WT-MakeList imports externally made (e.g. by 3rd party applications) tool list data into a *WinTool* tool list.

Requirements:

- *WinTool* Professional 2011 or later

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Specifications

Files

WT-MakeList is an executable (.exe) file. Language resources are handled in an ASCII file. Configuration parameters can be included in an ASCII configuration file.

- Executable: WTMakeList.exe
- Resource file: WT-MakeList.res
- Configuration file: WT-MakeList.cfg

Main Functionality

The main functionality is to generically import externally made (e.g. by 3rd party applications) tool list data into a *WinTool* Tool List.

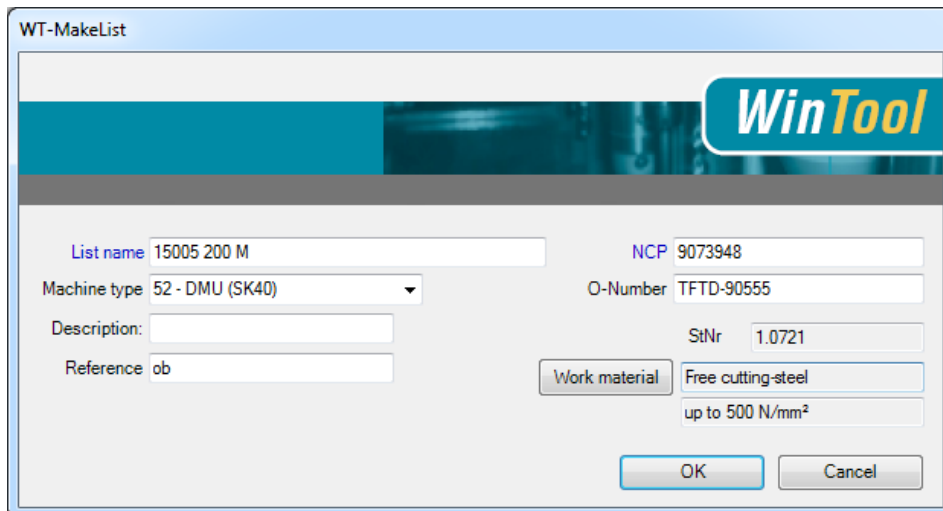
Application Usage

Requirements

- *WinTool* Professional 2011 or later is required
- *WinTool* must be started

User Interface

If QuietMode is set to false (default) in the config file, the following dialog shows up:



The dialog box, titled "WT-MakeList", features a "WinTool" logo in the top right corner. It contains several input fields and buttons:

- List name:** 15005 200 M
- NCP:** 9073948
- Machine type:** 52 - DMU (SK40) (dropdown menu)
- O-Number:** TFTD-90555
- Description:** (empty text field)
- StNr:** 1.0721
- Reference:** ob
- Work material:** Free cutting-steel
- Material properties:** up to 500 N/mm²
- Buttons:** OK and Cancel

- List Name:** *WinTool* Tool List name
- NCP:** *WinTool* NC Program name
- O-Number** *WinTool* Order number
- MachineType:** corresponding *WinTool* machine type
If a *WinTool* machine type with the name of the machine chosen in the CAM system exists, it will be suggested, else it has to be selected manually.
If no machine type is specified and the Tool List already exists in *WinTool*, the already stored machine type is preserved
- Material:** Selected material. The button "Material" opens the material selection window (material norm, number and description is displayed)
- Description:** Tool List description
- Reference:** Reference (specified in TLS file)
(If not specified, the Windows user name is used)

Importing a ToolList

By pressing the OK button the Tool List will be imported into *WinTool*.

If the selected machine type is configured as "T-Number = Ident-Nr", the Ident-Nr is filled in as T-Number as well.

Configuration

WT-MakeList can be configured in the file **WT-MakeList.cfg**.

If installed with a CAM-Interface, WT-MakeList.cfg it is located in

[Public Documents]\[WT-CAM-Interface]\WT-MakeList.cfg

Otherwise it is located in the same folder as WTMakeList.exe. If WT-MakeList.cfg doesn't exist, the default settings are used.

Open the file with a text editor.

Interface operation control

T-Prefix

Default: empty

If this Parameter is set, the given prefix is subtracted from the beginning of the imported tool ID.

Example:

T-Prefix = ID

When importing a Tool Assembly Named "ID616121" from the CAM-system it is imported into WinTool as "616121".

QuietMode

QuietMode = false

If QuietMode is set to false, the Interface shows up. (Default)

QuietMode = true

If at least ToolListsIdent is supplied in the .tls-file the Interface is suppressed.

QuietMode = append

Same as QuietMode = true – additionally if a ToolList already exists, the Tool Assemblies are appended

QuietMode = overwrite

Same as QuietMode = true – additionally if a ToolList already exists, the Tool Assemblies are overwritten

ExecCmd

If a valid path to an executable file (.exe, .bat) is set, WT-Makelist starts this file with the parameter

"ToolListNr" after successfully creating/modifying the tool list. This is useful if a CAM-Interface must be started immediately after a tool list is created or modified.

Example:

To start a WinTool CAM-Interface and export the created/modified tool list, make a batch file by creating a text file and adding the following line:

```
"c:\Program Files (x86)\WinTool\WT-VERICUT-Interface\WT-VERICUT-Interface.exe" /L %1
```

This command starts the CAM-Interface program (in this case WT-VERICUT) with the parameter /L and the tool list number, which is taken from the first call parameter.

Save the file as "startToolListExport.bat" and set the location of this file in the configuration:

```
ExecCmd ="c:\WT-CAM-Interface\startToolListExport.bat"
```

Tool list data configuration

The value of the tool list data fields **List Name**, **NCP**, **O-Number**, **Material**, **Description** can be configured to use the data in the [Data] section of the tls file. This section contains variables which come from the CAM system, e.g CAM_Process_Number=1234_567

Note: Setting the configuration only makes sense if the tls file contains a [Data] section. See chapter "Input File Definition" on page 6 for more details.

The configuration uses the following syntax:

- Strings (character sequence): "AString"
- Variable from [Data] section. The names are case insensitive: [CAM_Process_Number]
- Substring of a variable when using the function "Sub":
 - Sub(Variable, *StartIndex*, *EndIndex*). The indexes start with 1.
 - *StartIndex*= Position of first character for the new string. Value is > 0
 - *EndIndex* = Position of last character for the new string. Value is > 0
 Example: Sub([CAM_Process_Number], 1, 5) returns the string "1234_"
 - Sub(Variable, *SubstringIndex*, '*SplitCharacter*').
The variable data is divided by the *SplitCharacter* into substrings. The *SubstringIndex* selects the substring. It starts with 1.
 - *SubstringIndex* = Selects the substring to return. Value is > 0
 - '*SplitCharacter*' = A single character which splits the variable data
 Example: Sub([CAM_Process_Number], 2, '_') returns the string "567"
- Concatenation of strings, variables and function "Sub": &

If activated, the following parameters are used to fill the data fields in WT-MakeList:

ToolListsIdent

Configuration of List Name

ToolListsDescript

Configuration of Description

ToolListsNCP

Configuration of NCP

ToolListsOrder

Configuration of O-Number

MaterialNorm

Configuration of MaterialNorm (e.g "StNr"). Used in combination with MaterialNormValue.

MaterialNormValue

Configuration of MaterialNormValue (Material number, e.g 1.0037).

Example:

ToolListsIdent = [WORK_NR] & "-" & [POS_NR] & "-" & Sub([CAM_Operation], 1, '_') & "_" &
Sub([ProgName], 1, 10)

Program specific variables

NC Program specific variable support is activated if the variable [ProgName] ends with "_#", where the # stands for a number >0. In this case, if a variable ends with the same number "_#", it will be used.

The configuration of the tool list data doesn't have to be adjusted to use the program specific variables, this happens automatically.

RemoveProgNumber

- True: Remove the "_#" in the variable [ProgName]. It won't be visible in WT-MakeList
- False (**Default**): Doesn't remove the "_#".

Input File Definition

Abbreviations

WT: WinTool application

WinToolDB: WinTool database which can be accessed via the local WinTool.mde file. It contains linked tables to either an Access database file (.mdb) or a SQL Server database.

Exchange File Format (.tls)

The **decimal point** is always written as a point “.”. Other (locale specific) decimal characters need to be converted from/to a point “.”.

As a **delimiter** “;” (semicolon) is used.

Each tool will be written on a **new line**.

The file **ends with the last valid character** (additional spaces may cause a failure).

The file contains a tool list area and a tool assemblies’ data area. The tool list area is reserved for versioning and WinTool tool list data. The tool assemblies’ data area will be used for the specific tools data.

Tool List Area Specification

```
*-----WinTool MakeList File-----
FileVersion:"2.2.1"
```

Comment Line

Used for telling the application the format version the exchange file is written in. The format for files written using this specification is 2.2.1

```
[Data]
<VariableName> = <Value>
[DataEnd]
```

Optional. The [Data] section contains variables which are used with the configuration file.

```
*-----WinTool Tool List-----
ToolListsIdent:"<ToolLists.Ident>"
```

Comment Line

Optional.
ToolLists identification as in WinToolDB.ToolLists.Ident. Usually put together out of the part description, production method and operation number.

```
ToolListVersion:"<ToolListVersion>"
```

Optional.
The specific version of the tool list (not used yet)

```
ToolListsDescript:"<ToolLists.Descript>"
```

Optional.
ToolLists description as in WinToolDB.

```
DATOSMaterialCode:"<MatClasses.DMC>"
```

Optional.
The Datos Material Code is the three digit code of the material definitions in WinToolDB.

```
MachineName:"<Machines.Name>"
```

Optional.
Machine name as in WinToolDB.

```
MachineNr:"<ToolLists.MachineNr>"
```

Optional.
Machine number as in WinToolDB
(if used, has priority over MachineName)

```
ToolListsWho:"<ToolLists.Who>"
```

Optional.
(if empty, the Windows User is used)

```
ToolListsNCP:"<ToolLists.NCP>"
```

Optional.

```
ToolListsOrder:"<ToolLists.Order>"
```

Optional.

```
MaterialNorm:"Norm column in Materials"
```

Optional. If used with MaterialNormValue, DMC is ignored, unless MaterialNormValue is invalid. If DMC is empty, "Selection materials 1" is used.

```
MaterialNormValue:
```

Optional. Used with MaterialNorm.

Tool Specification

The header `Tools:` is required.

```
*-----WinTool tool assemblies -----
* Ident; Ver; T; D; H; Turret No; Operating Time; Station ID; Mounting Orientation
Tools:
<ToolNr>; <ToolVersion>; <T Number>; <D value>; <H value>; <Turret No>; <Operating
Time>; <Station ID>; <Mounting Orientation>; <ToolRemark>
```

where

<code><ToolNr></code>	corresponds to <code><WinToolDB.ToolList.ToolNr></code> (mandatory)
<code><ToolVersion></code>	not used in yet (optional)
<code><T number></code>	corresponds to <code><WinToolDB.ToolList.T></code> (optional)
<code><D value></code>	corresponds to <code><WinToolDB.ToolList.D></code> (optional)
<code><H value></code>	corresponds to <code><WinToolDB.ToolList.H></code> (optional)
<code><Turret No ></code>	corresponds to <code><WinToolDB.ToolList.Revolver></code> (optional)
<code><Operating Time></code>	[Seconds]. Corresponds to <code><WinToolDB.ToolList.OperatingTime></code> can be used in the future for tool replacement time calculations (optional)
<code><StationID></code>	corresponds to <code><WinToolDB.ToolList.Station></code> (optional)
<code><MountingOrient.></code>	corresponds to <code><WinToolDB.ToolList.Orientation></code> (optional)
<code><ToolRemark></code>	corresponds to <code><WinToolDB.ToolList.Rem></code> (optional)

Examples

Full example:

```
*-----WinTool MakeList File-----
FileVersion:"2.2.1"
[Data]
ProcessDISnumber=2323455
ProcessDIStype=RTE
ProcessDISpart=123
ProcessDISvers=456
ProgName=098765,300.100.03-T
[DataEnd]
*-----WinTool Tool List-----
ToolListsIdent:"300.100.03-T"
ToolListVersion:
ToolListsDescript:"club short"
DATOSMaterialCode:"122"
MachineName:"Schaublin (VDI-20)"
MachineNr:"2"
ToolListsWho:"Clancy /night shift"
ToolListsNCP:"5002"
ToolListsOrder:"345-olw-9"
MaterialNorm:"StNr"
MaterialNormValue:"0.6680"
*-----WinTool tool assemblies -----
* Ident; Ver; T; D; H; Turret No; Operating Time; Station ID; Mounting Orientation; Tool
Comment
Tools:
616006;;2;2;2;0;540;;;face mill entire surface
616008;;1;1;1;0;360
616009;;3;3;3;0;360
```

Minimal example:

```
*-----WinTool MakeList File-----
FileVersion:"2.2.1"
*-----WinTool Tool List-----
*-----WinTool tool assemblies -----
* Ident; Ver; T; D; H; Turret No; Operating Time; Station ID; Mounting Orientation; Tool
Comment
Tools:
616006
```

Launching WTMakelist

WTMakelist can use the path and file name of a .tls file in its start command line. The command line looks like this:

<PathToWTMakeList.exe>WTMakelist.exe <TLSFileName>

e.g.:

"c:\Program Files\Datos\Common\WTMakelist.exe" "c:\Program Files\Datos\Exchange.tls"

If no filename is given, WTMakelist shows an open file dialog pointing to the environment variable "WTMakeListPath" or to the executable path if the environment variable doesn't exist.

History

Version 3.9.5 (10.04.14)

- #4489: Compatible with *WinTool* 2011 – 2014
- #4490: Fixed: Tool list data window appears behind other windows

Version 3.9.4 (30.10.13)

- #4291: Fixed error if *WinTool* uses SQL Server database
- Corrected tool list data configuration processing

Version 3.9.3 (01.10.13)

- #4217: Compatible with *WinTool* 2013
- #4219: Fixed errors when tls file contains a large amount of tools
- #4223: Showing more machines at once in dropdown list
- #4224: Filtering out non numerical tool ident-numbers in tls file
- #4226: Added configuration file parameter "ExecCmd" which starts an executable file with the tool list number as parameter after successfully creating/modifying a tool list
- #4229: Fixed incorrect reading of configuration file
- #4231: Tls file data is cut off automatically if it is too long

Version 3.8.2 (22.05.12)

- #3594: Fixed error when overwriting tool list on SQL Server database

Version 3.8.1 (30.04.12)

- #3550: Updated and fixed QuietMode: Only "ToolListsIdent" is required in tls file to suppress the interface
- #3552: Adjusted material selection button size
- #3553: Showing message if resource file "WT-MakeList.res" is missing

Version 3.8 (26.01.12)

- #3225: Tools appended to an existing tool list with identical Ident-Nr, T-Nr and turret nr. are updated with the data in the input file
- #3226: Multiple tools with identical Ident-Nr and T-Nr are now allowed if the turret nr. is different
- #3227: Added field ToolList.Rem ("Tool Comment") to tls format
- #3228: Adjusted WTMakelist window to show correctly at higher dpi settings
- #3230: *WinTool* 2010 and higher: Checking if current *WinTool* user has sufficient rights to edit or create tool lists
- #3231: Correction: Strings ("...") in the tool list data configuration are not converted to uppercase anymore
- #3232: Using translations in *WinTool* database if available
- #3233: Added input file definition to manual
- #3262: Appended tools are added at the end of the tool list
- #3271: *WinTool* 2010 and higher: *WinTool* username is used for creation/modification user field
- #3274: Changed caption "User" to "Reference"

Version 3.7 (14.01.11)

- #2640: Corrected reading of UI strings
- #2641: Added fields O-Number and Material to tls format
- #2762: Added material selection window
- #2763: Added license check for *WinTool* 2010
- #2764: Setting field "Recorded" if *WinTool* 2010 is used
- #2765: Removed cfg settings for *WinTool* database connection
- #2766: Checking if tls file version is suitable for WT-MakeList
- #2768: Added support for configurable tool list data fields
- Supporting tls file version 2.2

Version 3.6 (21.06.10)

- #2539: Updated to ensure compatibility with *WinTool* 2010

Version 3.5 (24.02.09)

- #1723: Field "Description" of ToolList won't get overwritten if updated
- #1724: Revolver, Station und Orientation are imported correctly now
- #1725: Code change in Language Resource handling

Version 3.4 (21.10.08)

- #1560: reading ToolList Position
- #1561: Fields for Station, Turret and Orientation read if available in database
- #1562: WT-MakeList shown in Taskbar

Version 3.3 (30.07.07)

- #1145: changed user / password reading from config-file
- #1146: "ToolListsWho" now imported
- #1147: if no machine is given in tls-file, the first one is used

Version 3.2 (19.06.07)

- If no machine is set in tls-file, T-Nr is used. IF T-Nr isn't set either, Ident is used

Version 3.1 (08.02.07)

- Corrected runtime errors because of missing dlls
- If both who and machine is used they weren't correctly read
- Manually changed description was not written to Tool List
- Improved material selection
- Improved english translation
- Empty lines at end of tls-file caused errors
- Changed design
- Only available machines are being listed
- Integrated status-checking
- Cfg-parameter handling changed from „:“ to „=“
- Implemented QuietMode
- Additional QuietModes: append / overwrite
- Changed Copyright information

History of input file definition

Version 2.2.1

- Extended exchange format including "Tool Comment" (ToolList.Rem)

Version 2.2

- Added material selection button and O-Number text field
- Extended exchange format including Tool list "O-Number" and "Material". Added data section

Version 2.1

- Extended exchange format including "StationID" and "Mounting Orientation"

- Sequence of Tools is saved in the WinTool tool list

Version 2.0

- Full exchange format including turret and operation time
- Window for interactive input of Tool List name and material selection

Version 1.0

- First Standard module version with list of tool ID's only.