**BECKHOFF** New Automation Technology

# Functional description | EN TF5200 | TwinCAT 3 CNC

Contour look-ahead



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- 1. Indicates an action.
- ⇒ Indicates an action statement.

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## **Restriction or error**

This icon describes restrictions or warns of errors.



## Tips and other notes

This icon indicates information to assist in general understanding or to provide additional information.

## General example

Example that clarifies the text.

#### NC programming example

Programming example (complete NC program or program sequence) of the described function or NC command.



## Specific version information

Optional or restricted function. The availability of this function depends on the configuration and the scope of the version.

# **Table of contents**

	Notes on the documentation		
	Gene	eral and safety instructions	. 4
1	Overview		
2	Description		
	2.1	Mode 1 – Request via index	11
	2.2	Mode 2 - Request via distance from program start	13
	2.3	PLC interface	15
		2.3.1 User data	16
	2.4	Examples (graphic)	18
3	3 Programming		19
	3.1	Contour look-ahead and real-time loops	19
4 Parameter		meter	21
	4.1	Overview	21
	4.2	Description	22
	4.3	PLC parameters	24
5	Support and Service		25
	Index	٢	26

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# List of figures

Fig. 1	Example of a programmed contour with tool radius compensation	9
Fig. 2	Schematic diagram of a PLC request	10
Fig. 3	PLC request via index	11
Fig. 4	Example of a logged programmed contour	12
Fig. 5	Schematic diagram - distance and CLAH start_position	13
Fig. 6	Representation of the reply in PLC to distance request	14
Fig. 7	Handshake - contour look-ahead control unit	15
Fig. 8	Examples (graphic) of PLC requests	18

# 1 Overview

## Task

The "contour look-ahead" function of the CNC provides the PLC with programmed contour elements on the HLI in advance.

## **Effectiveness / possible applications**

Process parameters, such as velocity, can be optimised based on the information about the future contour.

This function is an additional option requiring a license.

## Parameterisation

The "contour look-ahead" function must be configured with the following parameters:

- P-CHAN-00650 (alternatively P-STUP-00070) and
- P-CHAN-00658 (alternatively P-STUP-00076).

## Programming

In order to command the CNC to provide future contour elements on the HLI,

- program sequences can be marked using the commands <u>#CONTOUR LOOKAHEAD LOG ON/OFF</u>
   [<u>19]</u> or
- the PLC can send a request via the <u>control unit [) 15]</u>.

## Mandatory note on references to other documents

For the sake of clarity, links to other documents and parameters are abbreviated, e.g. [PROG] for the Programming Manual or P-AXIS-00001 for an axis parameter.

For technical reasons, these links only function in the Online Help (HTML5, CHM) but not in pdf files since pdfs do not support cross-linking.

# 2 Description

When optimising processes, it can be and advantage to know future contour elements in advance. The CNC can supply them using the contour look-ahead function.

The PLC can use these elements to optimise the process parameters. Data provision is either programmed by NC commands or by request from the PLC.

The data provided for future contour elements are:

- Type of contour element: Linear block, circular block, polynomial block
- Block number
- Start position of the contour element
- · Length of the contour element
- · Swept angle, programmed and compensated radius
- Program line number
- · Length of the scales geometry for die sinking EDM



Fig. 1: Example of a programmed contour with tool radius compensation

## Sequence of a PLC request

The PLC sends a request to the CNC. The request contains either an index that belongs to a motion block ore a distance based on the program start.

There are 2 modes for these two different requests:

- Mode 1: <u>Request via the index [▶ 11]</u>.
- Mode 2: <u>Request via distance from program start [> 13]</u>.

The CNC then sends the reply information to this request for each motion block. The process looks like this:



Fig. 2: Schematic diagram of a PLC request

## 2.1 Mode 1 – Request via index

This mode is available as of CNC Build V3.1.3105.01.

To use Mode 1, a suitable value must be set for the parameter P-STUP-00033 [> 22].

In this mode, the PLC reads the look-ahead buffer of NC blocks of the CNC previously marked with the command <u>#CONTOUR LOOKAHEAD LOG ON/OFF</u> [▶ 19].

The information is provided before these blocks are actually executed. The PLC can set synchronisation with any stop conditions (e.g. M functions) to ensure that the PLC has all the necessary data.

The command #CONTOUR LOOKAHEAD LOG [**PARAM=<val>**] is used to provide the PLC with an additional parameter value within a flagged area.



Fig. 3: PLC request via index



Fig. 4: Example of a logged programmed contour

![](_page_11_Picture_4.jpeg)

In index mode, the individual elements can be requested multiple times, including backward motion on the path. The elements starting from the specified index are always output to the end.

# 2.2 Mode 2 - Request via distance from program start

## This mode can only be used if <u>P-CHAN-00658 [> 23]</u> is parameterised.

Every contour element is identifiable by the path distance covered.

By default the distance starts at program start and is re-initialised with zero at every program start.

The distance can also be reset in the NC program with the NC command #DISTANCE PROGRAM START CLEAR.

While an NC program is in process, the distance covered is aggregated and displayed as the current distance.

The start position of a contour element (CLAH<sub>start position</sub>) is defined as:

$$CLAH_{start\_position,n} = \sum_{k=0}^{n-1} block_{length_{k}}$$

If the PLC requests contour elements via distance, the correct distance must be specified for the blocks.

The figure below is a schematic diagram of a programmed contour using tool radius compensation (TRC) and the relationship between distance and  $CLAH_{start_position}$ .

![](_page_12_Figure_12.jpeg)

Fig. 5: Schematic diagram - distance and CLAH start\_position

## Properties of the look-ahead function:

- The maximum look-ahead distance available in the CNC is supplied by the HLI in each cycle and can be requested by a PLC. This information can be used to detect and request new available contour elements (start distance of the last element + length of the last element < maximum look-ahead distance).
- The maximum look-ahead distance depends on the internal buffer size of the interpolator and the block supply of the path preparation.
- The maximum look-ahead distance is independent of feedhold, override, synchronised M functions or G04.

![](_page_13_Figure_6.jpeg)

Fig. 6: Representation of the reply in PLC to distance request

## 2.3 PLC interface

The following data is available on the HLI to use the function:

- 1. The current distance from program start on the path corrected for tool radius compensation is displayed on the channel-specific HLI area (see <u>bahn\_state.dist\_prog\_start\_high</u> [▶ 24]). This distance can be used to request future contours in Mode 2.
- 2. The contour look-ahead control unit is provided to request and read out contour elements. The PLC requests information with increasing semaphore. The CNC supplies the information and deletes the semaphore afterwards.

![](_page_14_Figure_6.jpeg)

Fig. 7: Handshake - contour look-ahead control unit

Contour look-ahead			
Description	The PLC can use this control unit to request and read out information on contour elements from the CNC. The PLC can use this information to plan the look-ahead process.		
Data type	HLI_CONTOUR_LOOKAHEAD		
ST path	gpCh[ <i>channel_idx</i> ]^. <b>contour_lookahead</b>		
Command data	Command data		
ST Element	.request		
Data type	HLI CONTOUR LOOKAHEAD_REQUEST [ ] 16]		
Access	Access PLC writes request		
Return data			
ST element .response			
Data type	HLI_CONTOUR_LOOKAHEAD_RESPONSE [ ] 16]		
Access	Access PLC reads		
Flow control of commanded value			
Telement .semaphor_rw			

Data type	BOOL		
Value range [TRUE, FALSE]			
Special features Consumption data item			
Access	TRUE : PLC triggers on new request		
	FALSE : CNC has read new request		
Status value			
ST Element .state			
Data type HLI_CONTOUR_LOOKAHEAD_STATE [ ] 16]			

## 2.3.1 User data

Contour look-ahead request data			
Description	Data to request the contour elements from the CNC		
ST path	gpCh[channel_idx]^.contour_lookahead.request		
ST name HLI_CONTOUR_LOOKAHEAD_REQUEST			
ST element	.start_position		
Data type	LREAL		
Description/ special features	The meaning of the element is dependent on the mode of the contour look-ahead function used.		
	Mode 1: Index of the contour element in the marked area		
	Mode 2: Start distance from which the distance of the "length" parameter applies		
ST element	.length		
Data type	LREAL		
Description/ special features	A distinction is made whether mode 1 or 2 should be used depending on the entry of this element.		
	Value = 0 : Request contour element by index, mode 1		
	Value != 0: Request contour element by distance, mode 2 This mode indicates the distance up to which contour element is to be requested		

Contour look-ahead status data			
Description	Status data of the contour look-ahead control unit		
ST Path	gpCh[ <i>channel_idx</i> ]^.contour_lookahead <b>.state</b>		
ST name	T name HLI_INSERT_CMD_STATE		
ST element	.max_dist_prog_start		
Data type	LREAL		
Description	Manimum la chi		

Description	ription Maximum look-ahead distance from program start in [0.1 µm].		
ST element .count_logged_blocks			
Data type	UDINT		
Description	Number of available contour elements that can be read out.		
ST element	.f_log_is_active		
Data type	BOOL		
Description	This flag signals whether logging is still active for the marked area and all contour elements were read in.		
	TRUE : not all contour elements were read in		

Contour look-ahead return data				
Description	Contour information supplied by the CNC			
ST Path	gpCh[ <i>channel_idx</i> ]^.contour_lookahead. <b>response</b>			
ST Path	gpCh[ <i>channel_idx</i> ]^.contour_lookahead <b>. response</b>			

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ST name	HLI_CONTOUR_LOOKAHEAD_RESPONSE	
ST Element	.block[i]	
Data type	HLI CONTOUR LOOKAHEAD BLOCK [ 17]	
Description		

Structure HLI_CONTOUR_LOOKAHEAD_BLOCK			
Description	Information on a contour element that was supplied to the PLC by the CNC		
ST Element	.block_type		
Description	Block type		
	0 – no element exists		
	1 - linear contour element		
	2 - circular contour element		
	3 - #CONTOUR LOOKAHEAD LOG ON		
	4 - #CONTOUR LOOKAHEAD LOG [PARAM]		
	5 - #CONTOUR LOOKAHEAD LOG OFF		
	6 – Polynomial contour element		
ST Element	.block_number		
Description	Programmed NC block number		
ST Element	.block_count_r		
Description Unique NC block ID number Corresponds to the displayed number of block_count_r Status information of a channel.			
ST Element .start_position			
Description Start distance of the contour element from program start			
ST Element .length			
Description Length of the contour element of the programmed value of the PARAM.			
ST Element .programmed_radius			
Description Programmed radius of the circular element			
ST Element .compensated_radius			
Description Compensated radius of the circular element			
ST Element .circle_angle			
Description	Swept angle of the circular element.		
	Clockwise [-2*pi,0)		
	Counter-clockwise (0,2*pi].		
ST Element .length_min			
Description With die sinking, the length of the contour element is displayed on the scaled contour (radius = R_MAX_SCALE).			
ST Element .tangent_variation			
Description	End angle to the previous motion block. (0,pi)		

![](_page_17_Figure_2.jpeg)

![](_page_17_Figure_3.jpeg)

# 3 Programming

- Mode 1: Modifications required to the NC program.
- Mode 2: Only controlled by the PLC.

#### Syntax:

# #CONTOUR LOOKAHEAD LOG [ON | OFF | CLEAR] [ [ PARAM=.. ] ] ON Activate logging of contour elements by the NC command. OFF Deactivate logging of contour elements by the NC command. CLEAR The logging buffer is cleared at every program start. Use this NC command if the buffer needs to be cleared while the program is running to log a new area. Every time the buffer is cleared, decoding and execution are synchronised by an

implicit #FLUSH&WAIT. Clearing can be executed while logging is active or inactive.

PARAM=.. This parameter allows the user to add an user-defined additional parameter (8 byte floating value) in the log entry.

If #CONTOUR LOOKAHEAD LOG ON is detected several times while a program is running, only the first marked area is provided. The command #CONTOUR LOOKAHEAD LOG CLEAR can be used to delete the last marked area. The next area is then supplied again with #CONTOUR LOOKAHEAD LOG ON.

## 3.1 Contour look-ahead and real-time loops

There are two programming options to obtain contour elements in a real-time loop (#RT WHILE/ ENDWHILE) in Mode 1:

- Only one geometry is provided when programming #CONTOUR LOOKAHEAD LOG ON/OFF within a real-time loop. It has the properties of the entry loop, which means the parameter "<u>tangent\_variation</u>
   17]" has the angle to the motion block before the loop.
- 2. If #CONTOUR LOOKAHEAD LOG ON/OFF is programmed outside the real-time loop, the elements are supplied three times to obtain all the properties of the possible transitions. The transitions are:
  - start of loop
  - loop-loop
  - end of loop

## NOTICE

# Do not program the NC command #CONTOUR LOOKAHEAD CLEAR within a real-time loop.

If the command is programmed within the real-time loop, error ID 22073 is output.

## Behaviour of contour look-ahead within a real-time loop

In this programming example, the contour look-ahead function is programmed within a real-time loop. The contour of the motion blocks 80 - 120 is logged once.

N060 #RT WHILE N070 #CONTOUR LOOKAHEAD LOG ON [PARAM=1] N080 G1 X4 Y4 ... N120 G1 X0 Y0 N130 #CONTOUR LOOKAHEAD LOG ON [PARAM=8] N140 #RT ENDWHILE

## Behaviour of contour look-ahead outside a real-time loop

In this programming example, the contour look-ahead is programmed outside a real-time loop. The contour of the motion blocks 80 to 120 is logged three times.

N060 #CONTOUR LOOKAHEAD LOG ON [PARAM=1] N070 #RT WHILE N080 G1 X4 Y4 ... N120 G1 X0 Y0 N130 #RT ENDWHILE N140 #CONTOUR LOOKAHEAD LOG ON [PARAM=8]

# 4 Parameter

## 4.1 Overview

ID	start-up parameters	Description
P-STUP-00033	fb_storage_size[i]	Memory size for backward motion
ID	Channel parameters	Description

P-CHAN-00650	function	Activating functions (alternative to P-STUP-00070)
P-CHAN-00658	contour_lookahead_log	Maximum number of logged contour elements in the look-ahead
	_max	area. (alternative P-STUP-00076)

# 4.2 Description

## Start-up parameters

P-STUP-00033	Memory size for backward motion
Description	This parameter defines the memory size in bytes used for backward motion on the path. During start-up, the NC checks whether the required minimum size is available. If this is not the case, a warning is output and the memory size is set to the required minimum value. If the size is set to 0, the "forward/ backward motion on the path" function is not available. The maximum size is only limited by the resources available on the PC.
Parameter	fb_storage_size[i] where i = 0 to 11 (maximum number of channels: 12, application-specific)
Data type	UNS32
Data range	0 MAX(UNS32)
Dimension	
Default value	0
Remarks	

## **Channel parameters**

P-CHAN-00650	Definition of interpolator functionalities
Description	This parameter defines individual functionalities and the size of the look-ahead buffer in the interpolator, i.e. it defines the number of blocks required to calculate deceleration distance and dynamic planning.
Parameter	configuration.interpolator.function
Data type	STRING
Data range	See Description [ 23]
Dimension	
Default value	FCT_IPO_DEFAULT
Remarks	

## Interpolation function table

Identifier	Description
FCT_IPO_DEFAULT	FCT_LOOK_AHEAD_STANDARD
FCT_LOOK_AHEAD_LOW	30 blocks
FCT_LOOK_AHEAD_STANDARD	120 blocks
FCT_LOOK_AHEAD_HIGH	190 blocks
FCT_LOOK_AHEAD_CUSTOM	Any number of look-ahead blocks in the interval [ 0; 200]. Specification by parameter P-CHAN-00653.
FCT_SYNC	Synchronisation of an axis on a path group. Example: FCT_IPO_DEFAULT   FCT_SYNC
FCT_LOOK_AHEAD_OPT	The path velocity curve can be further improved for HSC machining by additional calculations. This generally reduces machining time. The additional calculations place greater demands on the controller hardware.
FCT_LIFT_UP_TIME	Automatic lifting/lowering of an axis (time-based coupling). Example: FCT_IPO_DEFAULT   FCT_LIFT_UP_TIME
FCT_SHIFT_NCBL	Path-controlled offset of M functions (dwell time). Example: FCT_IPO_DEFAULT   FCT_SHIFT_NCBL
FCT_CALC_STATE_AT_T	Calculation of path velocity at a time in the future. Function only available in combination with HSC slope and only as of V3.1.3057.0 Example: FCT_IPO_DEFAULT   FCT_CALC_STATE_AT_T
FCT_CALC_TIME	Calculation of interpolation time to next feed block (G01,G02,G03). Example: FCT_IPO_DEFAULT   FCT_CALC_TIME
FCT_CONTOUR_LAH	Contour look-ahead: advance output of motion blocks to the PLC as of V3.1.3104.07
FCT_DYN_POS_LIMIT	Dynamic limitation of axis positions
FCT_EXTENSION_EQUIDIST	Die-sinking EDM Planetary expansion

The look-ahead buffer size values specified above apply as of CNC Builds V2.11.2800 and higher; the following settings apply to CNC Build V2.11.20xx:

FCT_LOOK_AHEAD_LOW	30 blocks
FCT_LOOK_AHEAD_STANDARD	70 blocks
FCT_LOOK_AHEAD_HIGH	120 blocks

P-CHAN-00658	Maximum number of logged contour elements in the contour look-ahead.	
Description	This parameter can be used to set the maximum number of stored motion blocks that can be supplied to the PLC in advance.	
	The CNC command #CONTOUR LOOKAHEAD LOG [] can be used to activate the save function.	
FCT_CONTOUR_LAH must be enabled in P-CHAN-00650 [ 22] for this functionalit		
	configuration.interpolator.fct_enable[0] FCT_IFO_DEFAULT  <b>FCT_CONTOUR_LAH</b>	
Parameter	configuration.interpolator.contour_lookahead_log_max	
Data type	UNS32	
Data range	0 <= contour_lookahead_log_max < MAX_UNS32	
Dimension		
Default value	128	
Remarks	Parameter available as of V3.1.3107.10	

# 4.3 PLC parameters

Currently covered path in the NC program (PCS)	
Description	Reads the current distance covered in the NC program since program start or since the last # DISTANCE PROG START CLEAR NC command. The calculation is based on the current position in the current NC block.
Signal flow	$CNC \rightarrow PLC$
ST path	gpCh[ <i>channel_idx</i> ]^.bahn_state. <b>dist_prog_start</b>
Data type	UDINT (* LREAL)
Unit	0.1 μm
Access	PLC is reading
Special features	* As of CNC Build V3.1.3104.01 the data element is provided in LREAL forma.

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# Index

## С

Contour look ahead	
control unit	15
request	16
response	16
state	16
covered path	
current:NC program	24

## K

Kontur-Look-Ahead	
Anforderungsdaten	16
Kontur-Look-Ahead Control Unit	15

## Ν

NC program	
covered path:current	24

## Ρ

P-CHAN-00650	22
P-CHAN-00658	23
PCS	
covered path:NC block:to go	24
P-STUP-00033	22

## R

Rückgabedaten	
Kontur-Look-Ahead	16

## S

```
Statusdaten Kontur-Look-Ahead 16
```

More Information: www.beckhoff.com/TF5200

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![](_page_27_Picture_2.jpeg)