

## Biesse CNC Machine and ArtCAM

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The new Biesse post “Biesse – XP600, NC1000, XNC (mm) (\*.ISO)” will run the following machines:

\* \* \* Any machine that has a CNI control XP600, NC1000, XNC \* \* \*

These are the current models produces by Biesse:

Rover A:

-Rover A 3.30 ATS, Rover A 3.65 ATS, Rover A 3.40 FT

Rover B:

-Rover B 4.35 ATS, Rover B 4.65 ATS,  
-Rover B 7.50 ATS, Rover B 7.65 ATS,  
-Rover B 4.40 FT, Rover B 4.65 FT, Rover B 4.40 FTK, Rover B 4.65 FTK,  
-Rover B 7.40 FT, Rover B 7.40 FTK, Rover B 7.65 FT, Rover B 7.65 FTK,

Rover C

-Rover C 6.40 FT, Rover C 6.50 ATS, Rover C 9.40 FTK, Rover C 9.50 ATS, Rover C 9.65 FT, Rover C 9.65 ATS

Rover S CTS All models.

Rover Skill 300 All models

The following older machines below will also accept this post granted they have a CNI control. The Rover 23, 20, 22, are the only ones that could have either and HSD/nc500 control or the CNI control. It must have the CNI controller to use the new post.

Rover 35, Rover 22, Rover 23, Rover 24, Rover 37, Rover 20

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In the past, Biesse have been a complicated machine to write post processors for. We’ve run into many different problems with various machines. Currently there are several post processors for the different Biesse machines. Every machine had a variety of custom calls out in Italian. During research for the latest post, we contacted Biesse directly. As it turns out, all their current machines operate using the same code. The Majority of the custom calls out are subroutines which are not needed. The subroutines were actually produced specifically by the Biesse Works software (Biesse’s basic machining program

OEM's with the machine). The majority of the sample code we received from customers had been taken from Biesse Works.

With the aid of Biesse, we re-constructed the Biesse post processor with only the necessary call outs.

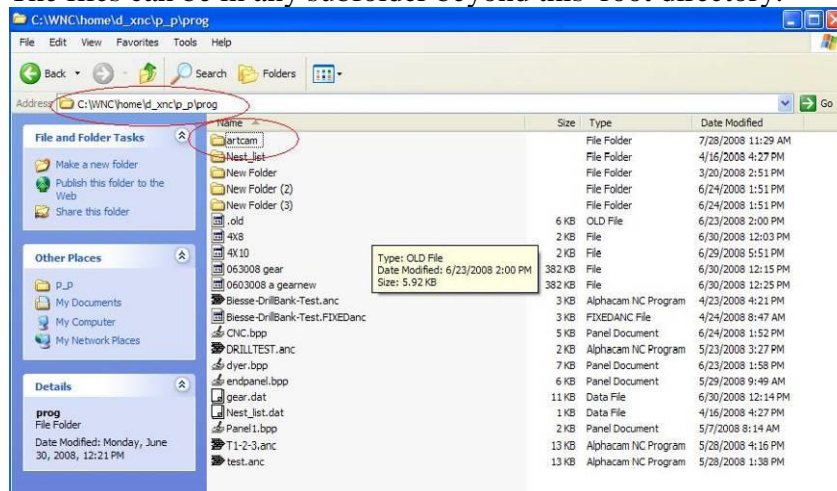
This new post will run all the machines manufactured over the last few years. So this will remove the need for most of our Biesse posts.

Special Biesse / ArtCAM setup notes:

1. \* Origin must be in top left corner \*
2. \* Must adjust tool description name in tool database to match tool names at machine \*
3. To save the file to Biesse machines there are two directories depending on which numerical control you have. Start with the first if you cannot find it go on to the next one.  
CNI NC1000 control C:\cn\home\d\_xnc\p\_p\prog

CNI WRT control C:\WNC\home\d\_xnc\p\_p\prog

The files can be in any subfolder beyond this root directory.

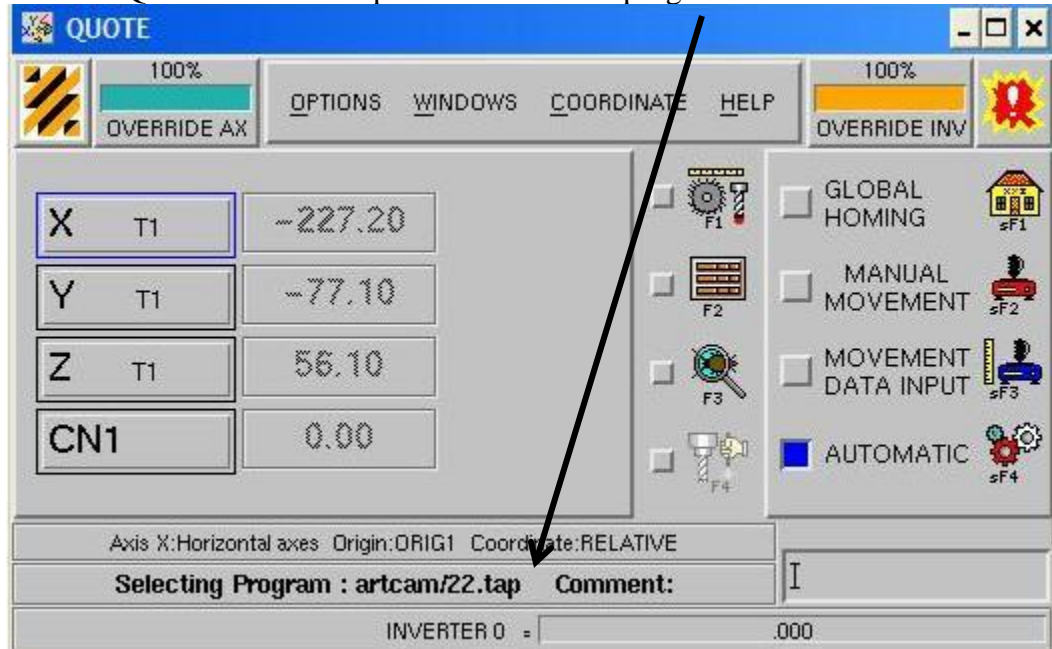


Then go to the Quote screen. Using the mouse select F1 you will see a screen like this



Simply select the program you wish to run and click the green check mark to confirm.

Now the Quote screen will update with the new program to be run as shown below.



Additional Notes:

4. Notes on origin:

-0, 0 XY is the top left corner then you have x+ moving toward the right y+ moving toward the operator

- Y and Z are multiplied -1 in the post

5. Notes on tool names:

-each customer can set their tools in the changer to whatever they want, the name does not matter as long as the ArtCAM name matches the one used at the machine.

6. The Biesse can take in a variety of file types including files with no extension, we have decided to use ISO since this what Biesse customer are familiar with due to Biesse Works.

7. In the START section, you will see the following:

We output zeros following the name, and then Biesse inserts the numbers for each section

PARAMETRI=000000247  
UTENSILI=000000664  
LABELF=000001916  
LABELC=000001903  
FORATURA=000001870  
CONTORNATURA=000000687  
TABELLEFORI=000001885  
CONFASSIST=000001929  
ATTREZZAGGIO=000001946  
CUSTOMSEZ=000001965