

5.6 Recipe Templates

As explained above, a new recipe is created by duplicating an existing recipe template file. This section contains the recipe templates of the Model 7100 and the cut maps based on these templates.

All the Model 7100 templates have the **Taught** parameter (**Align** category) set to "**Yes**". The user can create a cut map (see Figures 5-24, 5-25, 5-26 and 5-27) in three steps given below:

- 1 Load a workpiece.
- 2 Press the Auto Align button.
- 3 Follow the wizard instruction.

5.6.1 APC Standard Template

	Angle 0	Angle 90
Parameters		
Workpiece Shape	Rectangular	
Workpiece Size	100 x 100 mm	
Thickness	1 mm	
Blade	00777-6045-010-QIP	
Align type	Manual	N/A
Spindle speed	20 krpm	
Index	18 mm	15 mm
Sub index	N/A	
Cut count	5	6
Cut speed	6 mm/sec	20 mm/sec
Loop offset	NA	
Loop count	NA	
Depth	3 mm	

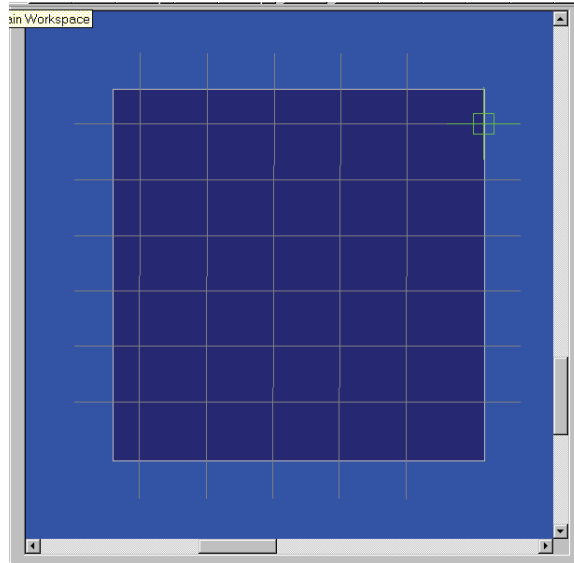


Figure 5-24: APC Standard Cut Map

5.6.2 APC Loop Cut Template

	Angle 0	Angle 90
Parameters		
Work piece Shape	Rectangular	
Work piece Size	100 x 100 mm	
Thickness	1 mm	
Blade	00777-6045-010-QIP	
Align type	Manual	N/A
Spindle speed	20 krpm	
Index	3 mm	20 mm
Sub index	N/A	
Cut count	5	5
Cut speed	10 mm/sec	10 mm/sec
Chop velocity	0.5 mm/sec	N/A
Loop	From Ang.1	to Ang.1
Loop offset	X=20mm	Y=22mm
Loop count	5	
Depth	3 mm	

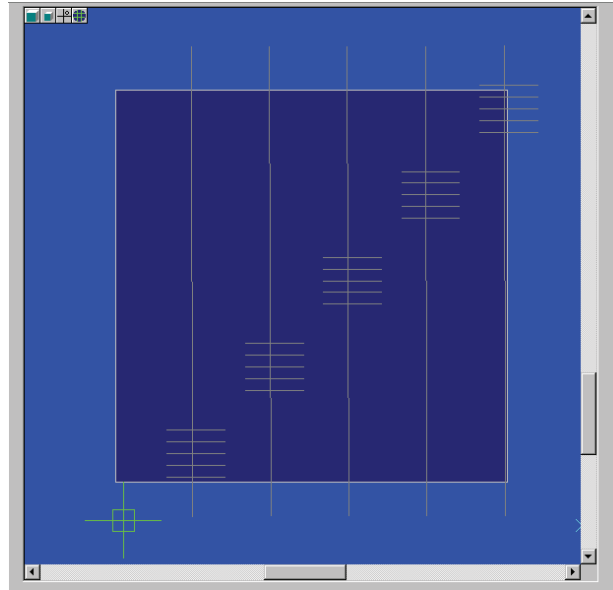


Figure 5-25: APC Loop Cut Map

5.6.3 GPC Standard Template

	Angle 0	Angle 90
Parameters		
Work piece Shape	Circular	
Work piece Size	150 mm	
Thickness	0.635 mm	
Blade	00777-6045-010-QIP	
Align type	Manual	
Spindle speed	20 krpm	
Index	18 mm	15 mm
Sub index	N/A	
Cut count	5	6
Cut speed	6 mm/sec	20 mm/sec
Loop offset	NA	
Loop count	NA	
Depth	3 mm	

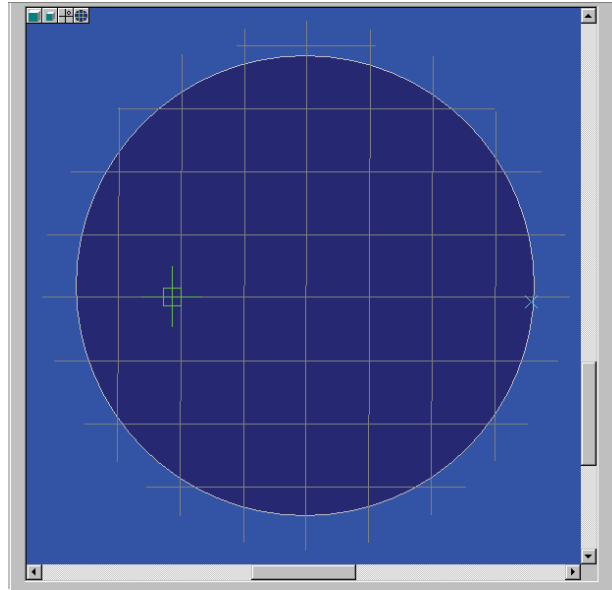


Figure 5-26: GPC Standard Cut Map

5.6.4 GPC Multi Die Size Template

	Angle 0	Angle 90
Parameters		
Workpiece Shape	Circular	
Workpiece Size	150 mm	
Thickness	0.635 mm	
Blade	00777-4300-050-BLO	
Align type	Manual	
Spindle speed	30 krpm	
Index	20 mm	20 mm
Sub index	5	N/A
	5	N/A
Cut count	5	6
Cut speed	45 mm/sec	
Loop offset	NA	
Loop count	NA	
Depth	3 mm	

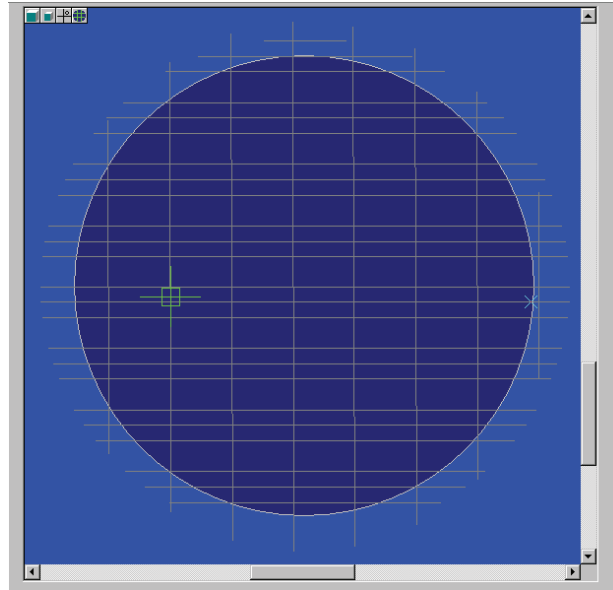


Figure 5-27: GPC Multi-Die Size Cut Map

5.6.5 Standard Dressing Template

	Angle 0	Angle 90
Parameters		
Workpiece Shape	Rectangular	
Workpiece Size	75 mm	75 mm
Thickness	0.635 mm	
Blade	00777-4300-050-BLO	
Align type	Manual Dress	
Spindle speed		
Index		
Sub index		
Cut count		
Cut speed		
Loop offset		
Loop count		
Depth		

5.6.6 GPC Dressing Template

	Angle 0	Angle 90
Parameters		
Workpiece Shape	Rectangular	
Workpiece Size	100 mm	100 mm
Thickness	1 mm	
Blade	00777-4300-050-BLO	
Align type	Manual	
Spindle speed	40 krpm	
Index	18 mm	15 mm
Sub index	N/A	
	N/A	
Cut count	5	6
Cut speed	30 mm/sec	
Loop offset	NA	
Loop count	NA	
Depth	3 mm	