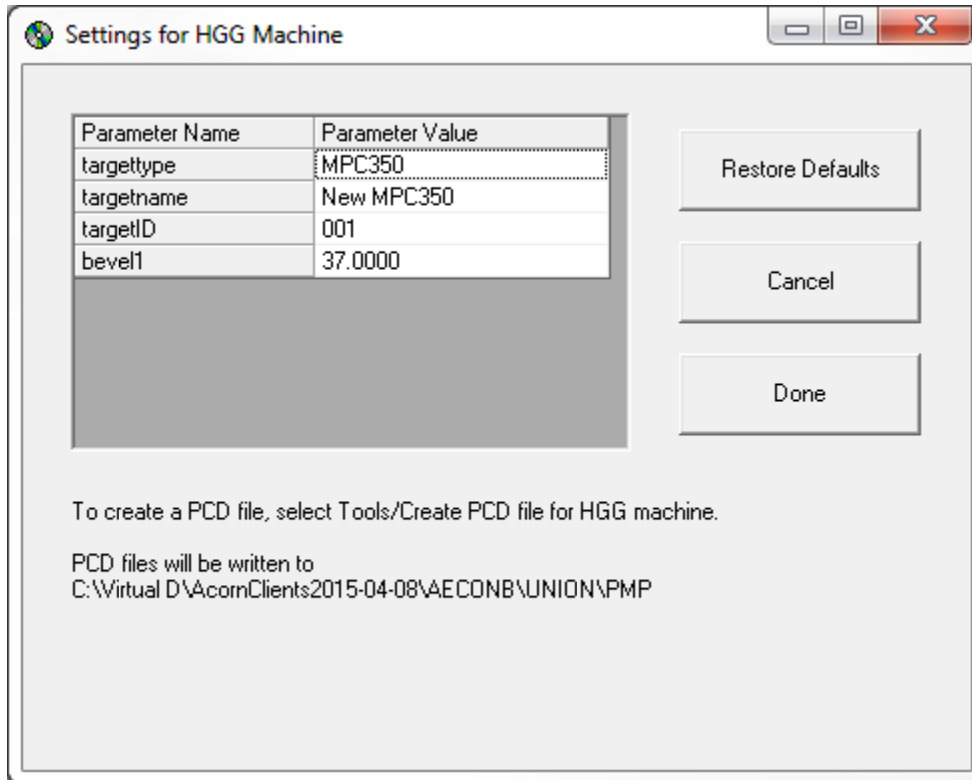


Using HGG machines with AcornPipe

AcornPipe can generate PCD files for use with HGG machines. To start, get into fabrication drawings and select *Tools/Machine Settings/Settings for HGG Machine*. Then set up your machine details along the lines of the following:



To test your setup, display a fabrication drawing and select *Tools/Create PCD file for HGG machine*. AcornPipe writes a PCD file that includes all pipes on the drawing in a single PCD file. The file takes its name from the drawing's control number and has the extension .PCD. Every pipe is included, regardless of size.

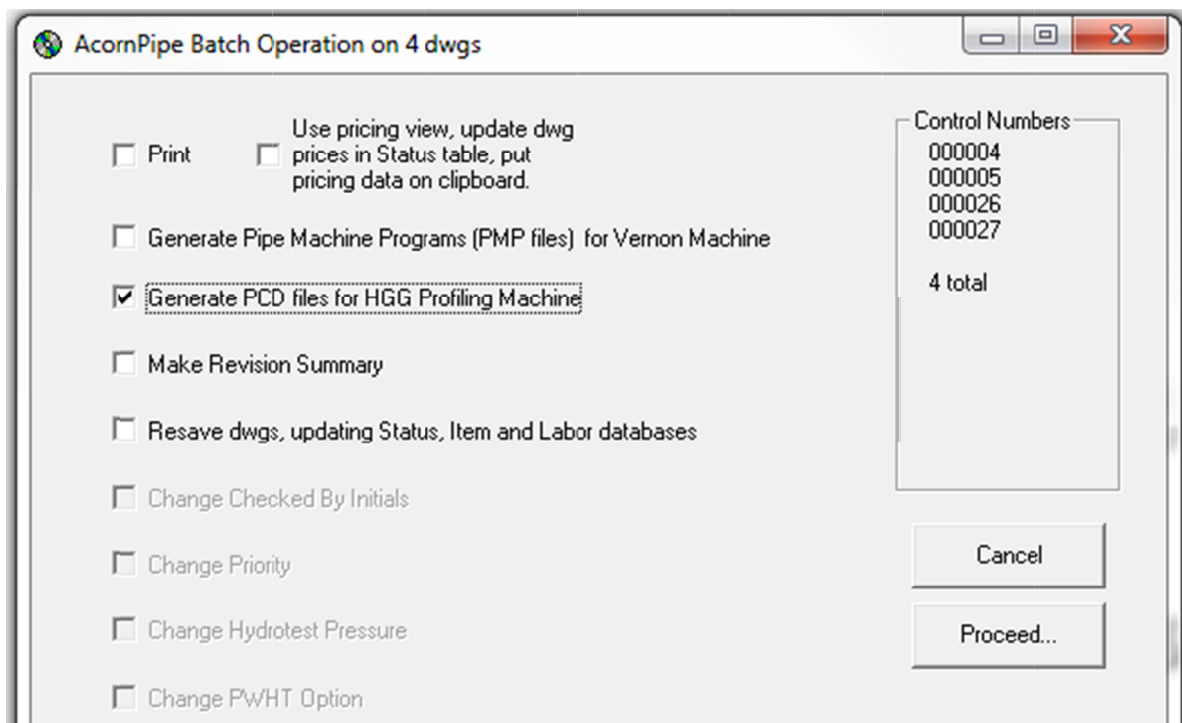
The generated file is displayed in NotePad as shown:

```
PIPES1.PCD - Notepad
File Edit Format View Help
<?xml version="1.0" encoding="utf-8"?>
<!--
This standard is developed by HGG Profiling Equipment software development.
Name: ProCAM XML
Year: 2011
Internet: www.hgg.nl
Address: p.O.Box 66
1775 ZH Middenmeer
The Netherlands
info@ hgg.nl
-->
<dnc version="4.2" xmlns="http://www.hgg.nl/schemas/procam/v4.2">
  <projects>
```

For actual production work, you will probably want to generate PCD files for many drawings at once. Start by selecting which drawings you want to process. There are two main ways to make this selection:

1. Directly from the fabrication drawing window, select *File/Make New List* and select the desired control numbers. This is convenient provided you know which control numbers you want.
2. Make your selection from Fabrication Material Control. This lets you sort drawings based on status headers, and is probably the most frequently used method.

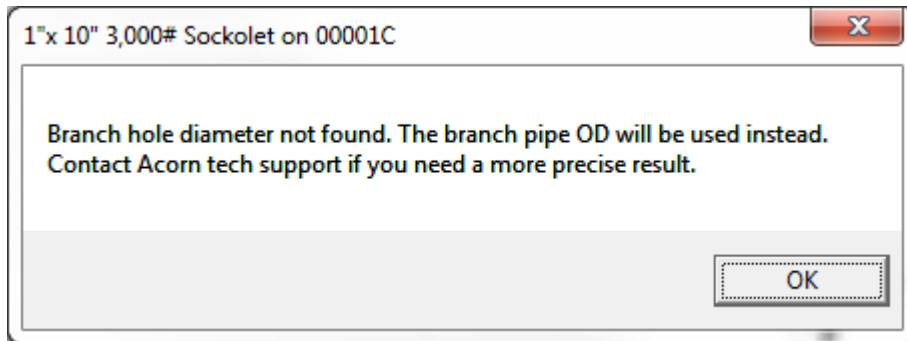
To generate the PCD files for the selected drawings, from Fabrication Drawings, select *File/Batch Operation*.



Check the box for *Generate PCD files for HGG Profiling Machine*, and click Proceed. The files are written to a folder called PMP under the current job.

For help with generating HGG files, send email to AcornPipe@gmail.com.

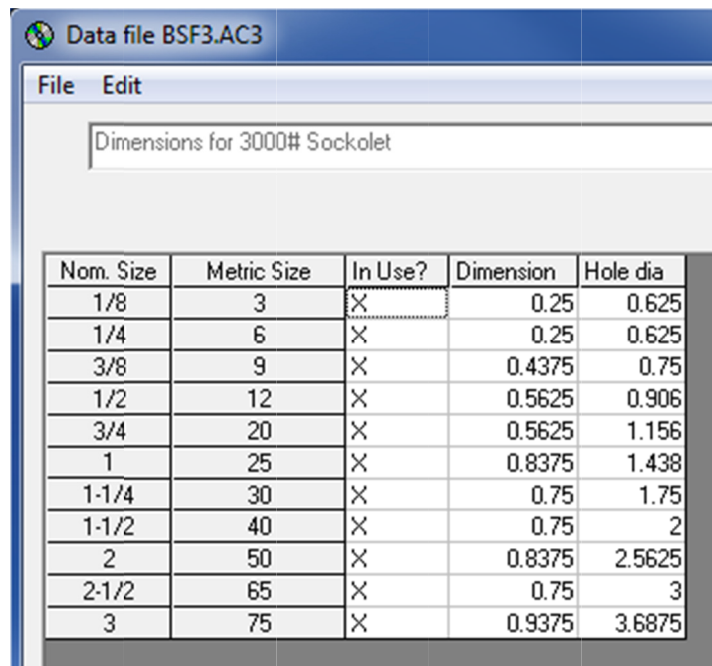
When generating PCF files that involve olets, you may get a message



This happens when the dimension files for olets are older than 2014 and do not include hole diameter information. Seven updated master files for olets are available on request. Their contents are listed on the following pages.

Before adopting the replacement files, you may want to compare them with your existing settings and take note of any required edits.

Dimension files for 3000# and 6000# Sockolets, including hole diameters:

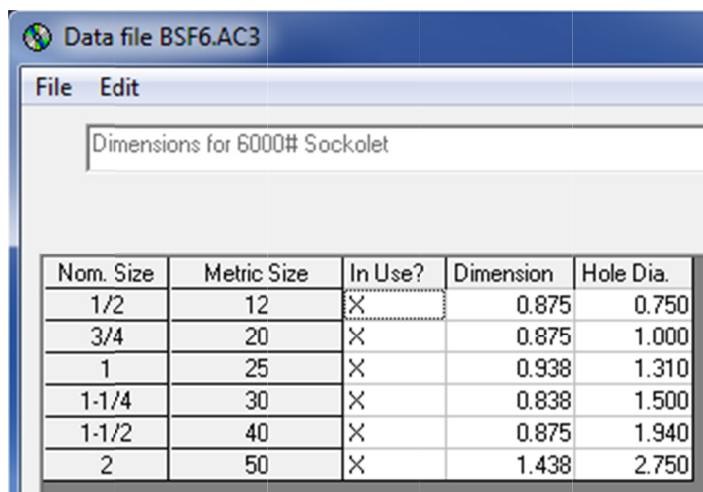


Data file BSF3.AC3

File Edit

Dimensions for 3000# Sockolet

Nom. Size	Metric Size	In Use?	Dimension	Hole dia
1/8	3	X	0.25	0.625
1/4	6	X	0.25	0.625
3/8	9	X	0.4375	0.75
1/2	12	X	0.5625	0.906
3/4	20	X	0.5625	1.156
1	25	X	0.8375	1.438
1-1/4	30	X	0.75	1.75
1-1/2	40	X	0.75	2
2	50	X	0.8375	2.5625
2-1/2	65	X	0.75	3
3	75	X	0.9375	3.6875



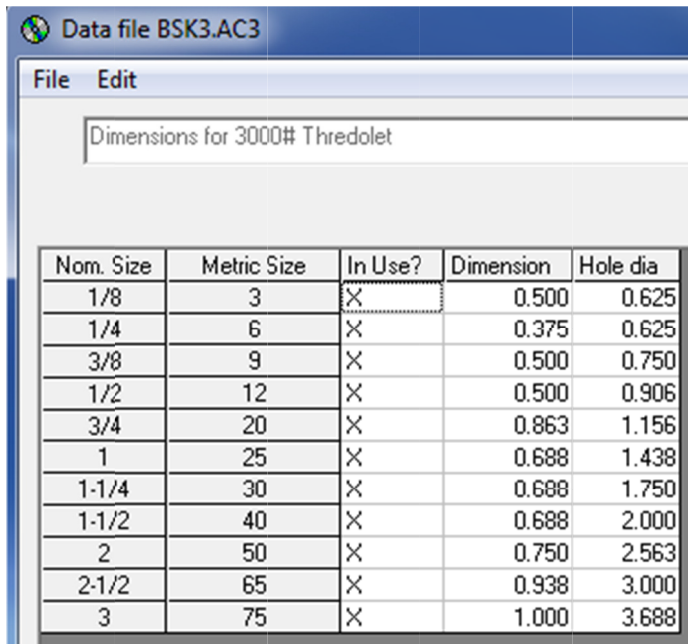
Data file BSF6.AC3

File Edit

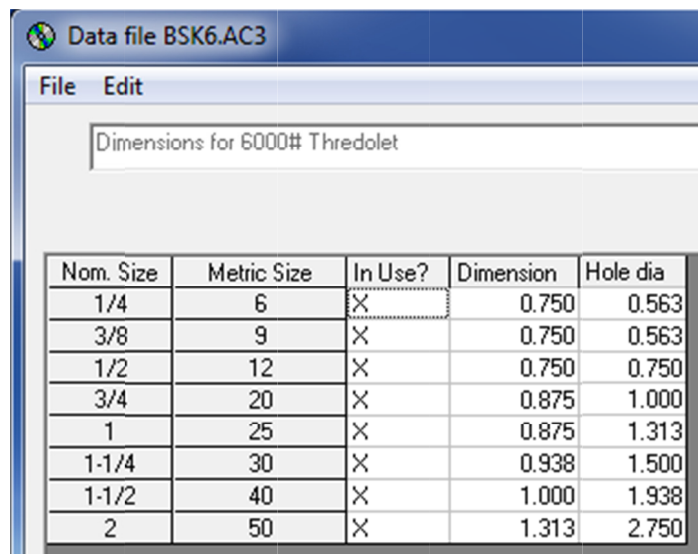
Dimensions for 6000# Sockolet

Nom. Size	Metric Size	In Use?	Dimension	Hole Dia.
1/2	12	X	0.875	0.750
3/4	20	X	0.875	1.000
1	25	X	0.938	1.310
1-1/4	30	X	0.838	1.500
1-1/2	40	X	0.875	1.940
2	50	X	1.438	2.750

Dimension files for 3000# and 6000# Thredolets, including hole diameters:



Nom. Size	Metric Size	In Use?	Dimension	Hole dia
1/8	3	X	0.500	0.625
1/4	6	X	0.375	0.625
3/8	9	X	0.500	0.750
1/2	12	X	0.500	0.906
3/4	20	X	0.863	1.156
1	25	X	0.688	1.438
1-1/4	30	X	0.688	1.750
1-1/2	40	X	0.688	2.000
2	50	X	0.750	2.563
2-1/2	65	X	0.938	3.000
3	75	X	1.000	3.688



Nom. Size	Metric Size	In Use?	Dimension	Hole dia
1/4	6	X	0.750	0.563
3/8	9	X	0.750	0.563
1/2	12	X	0.750	0.750
3/4	20	X	0.875	1.000
1	25	X	0.875	1.313
1-1/4	30	X	0.938	1.500
1-1/2	40	X	1.000	1.938
2	50	X	1.313	2.750

Dimension file for STD Weldolets, including hole diameters:

Data file BWJ.AC3

File Edit

Dimensions for STD WOL

Nom. Size	Metric Size	In Use?	Weight #	Size on Size	Reducing	Hole dia
1/8	3	X	.1	0	0.625	0.625
1/4	6	X	.1	0	0.625	0.625
3/8	9	X	.2	0	0.625	0.750
1/2	12	X	.2	0.750	0.750	0.938
3/4	20	X	.3	0.875	0.875	1.188
1	25	X	.5	1.063	1.063	1.438
1-1/4	30	X	.8	1.250	1.250	1.750
1-1/2	40	X	1.2	1.313	1.313	2.000
2	50	X	1.9	1.500	1.500	2.563
2-1/2	65	X	2.7	1.625	1.625	3.000
3	75	X	4.2	1.750	1.750	3.688
3-1/2	85	X	5.5	2.000	1.875	4.000
4	100	X	7.1	2.000	2.000	4.750
5	125	X	10.3	2.125	2.250	5.563
6	150	X	12.	2.375	2.375	6.688
8	200	X	23.	2.750	2.750	8.688
10	250	X	36.	3.063	3.063	10.813
12	300	X	59.	3.375	3.375	12.813
14	350	X	66.	3.500	3.500	14.063
16	400	X	75.	3.688	3.688	16.063
18	450	X	97.	4.063	3.688	18.063
20	500	X	118.	4.625	4.000	20.000
24	600	X	220.	5.375	4.568	24.188

Dimension file for XH Weldolets, including hole diameters:

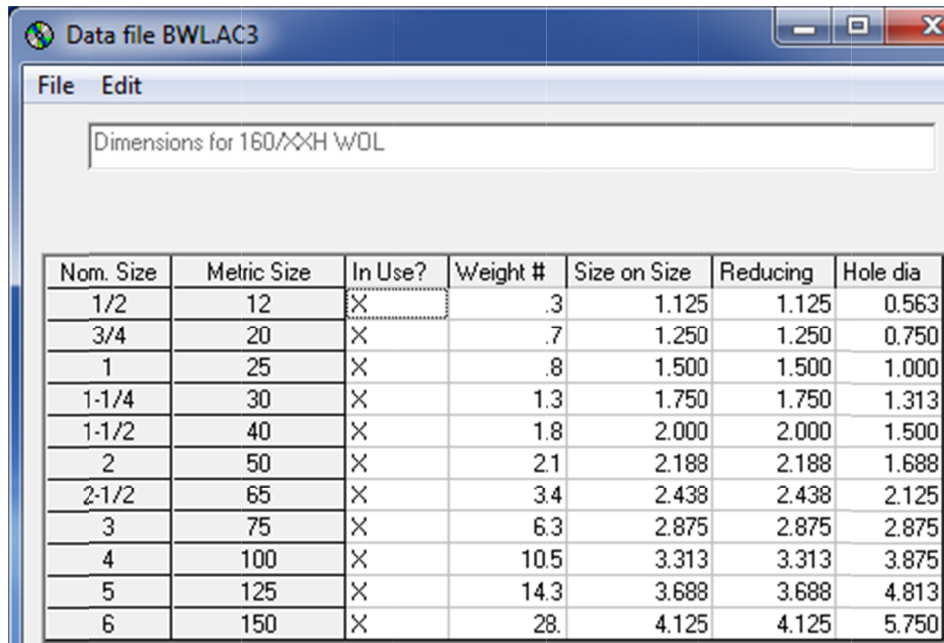
Data file BWK.AC3

File Edit

Dimensions for XH WOL

Nom. Size	Metric Size	In Use?	Weight #	Size on Size	Reducing	Hole dia
1/8	3	X	.1	0	0.625	0.625
1/4	6	X	.1	0	0.625	0.625
3/8	9	X	.2	0	0.625	0.750
1/2	12	X	.2	0.750	0.750	0.938
3/4	20	X	.3	0.875	0.875	1.188
1	25	X	.5	1.063	1.063	1.438
1-1/4	30	X	.9	1.250	1.250	1.750
1-1/2	40	X	1.3	1.313	1.313	2.000
2	50	X	1.9	1.500	1.500	2.563
2-1/2	65	X	2.7	1.625	1.625	3.000
3	75	X	4.2	1.750	1.750	3.688
3-1/2	85	X	5.6	2.000	1.875	4.000
4	100	X	7.1	2.000	2.000	4.750
5	125	X	10.4	2.063	2.250	5.563
6	150	X	23.	3.063	3.063	6.688
8	200	X	37.	3.875	3.875	8.688
10	250	X	46.	3.500	3.688	10.438
12	300	X	61.	3.938	4.063	12.500
14	350	X	70.	4.125	3.938	13.188
16	400	X	102.	4.424	4.188	15.875
18	450	X	130.	4.875	4.375	17.938
20	500	X	158.	5.000	4.688	20.063
24	600	X	290.	5.500	5.500	24.188
26	650	X	350.	5.750	5.750	27.250

Dimension file for 160/XXH Weldolets, including hole diameters:



Dimensions for 160/XXH WDL

Nom. Size	Metric Size	In Use?	Weight #	Size on Size	Reducing	Hole dia
1/2	12	X	.3	1.125	1.125	0.563
3/4	20	X	.7	1.250	1.250	0.750
1	25	X	.8	1.500	1.500	1.000
1-1/4	30	X	1.3	1.750	1.750	1.313
1-1/2	40	X	1.8	2.000	2.000	1.500
2	50	X	2.1	2.188	2.188	1.688
2-1/2	65	X	3.4	2.438	2.438	2.125
3	75	X	6.3	2.875	2.875	2.875
4	100	X	10.5	3.313	3.313	3.875
5	125	X	14.3	3.688	3.688	4.813
6	150	X	28.	4.125	4.125	5.750