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:

| MPC350 Restore Defaults targetname New MPC350 targetID 001 bevel1 37.0000 Cancel Done To create a PCD file, select Tools/Create PCD file for HGG machine. | Parameter Name | Parameter Value | | | | | |
|---|---|-----------------|------------------|--|--|--|--|
| argetname New MPC350 argetID 001 bevel1 37.0000 Cancel Done Done Cancel | argettype | MPC350 | Restore Defaults | | | | |
| o create a PCD file, select Tools/Create PCD file for HGG machine. | argetname | New MPC350 | | | | | |
| o create a PCD file, select Tools/Create PCD file for HGG machine. | argetID | 001 | | | | | |
| Done | pevel1 | 37.0000 | Cancel | | | | |
|) create a PCD file, select Tools/Create PCD file for HGG machine. | | | | | | | |
| Virtual D\AcornClients2015-04-08\AECONB\UNION\PMP | To create a PCD file, select Tools/Create PCD file for HGG machine. PCD files will be written to CWirtual D\AcorrClients2015-04-08\AECONB\UNION\PMP | | | | | | |

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>

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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*.

| S AcomPipe Batch Operation on 4 dwgs | |
|---|--|
| Print Use pricing view, update dwg prices in Status table, put pricing data on clipboard. Generate Pipe Machine Programs (PMP files) for Vernon Machine Generate PCD files for HGG Profiling Machine Make Revision Summary Resave dwgs, updating Status, Item and Labor databases Change Checked Bulpitials | Control Numbers 000004 000005 000026 000027 4 total |
| Change Priority | Cancel |
| Change Hydrotest Pressure | Proceed |
| Change PWHT Option | |

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 <u>AcornPipe@gmail.com</u>.

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

| 1"x 10" 3,000# Sockolet on 00001C | × |
|---|--------------|
| Branch hole diameter not found. The branch pipe OD will be u Contact Acorn tech support if you need a more precise result. | sed instead. |
| | ОК |

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:

| S Data file BSF3.AC3 | | | | | | | | |
|-------------------------------|-----------|-------------|---------|-----------|----------|--|--|--|
| F | ile 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 | × | 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 | | | |
| | | | | | | | | |

| F | File Edit | | | | |
|---|-----------|-------------|---------|-----------|-----------|
| | Dimensi | | | | |
| | 1 | | | | |
| | | | | | |
| | 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 | 1-1/2 40 | | 0.875 | 1.940 |
| | 2 | 50 | X | 1.438 | 2.750 |

Data file BSF6.AC3

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

| • | O Data file BSK3.AC3 | | | | | | | | |
|---|--------------------------------|-----------|-----|---------|-----------|----------|--|--|--|
| F | ile Edit | | | | | | | | |
| | Dimensions for 3000# Thredolet | | | | | | | | |
| | Nom. Size | Metric Si | ize | In Use? | Dimension | Hole dia | | | |
| | 1/8 | 3 | | Х | 0.500 | 0.625 | | | |
| | 1/4 | 6 | | Х | 0.375 | 0.625 | | | |
| | 3/8 | 9 | | X | 0.500 | 0.750 | | | |
| | 1/2 | 12 | | X | 0.500 | 0.906 | | | |
| | 3/4 | 20 | | Х | 0.863 | 1.156 | | | |
| | 1 | 25 | | X | 0.688 | 1.438 | | | |
| | 1.1/4 30 1.1/2 40 2 50 | | × | 0.688 | 1.750 | | | | |
| | | | | X | 0.688 | 2.000 | | | |
| | | | | Х | 0.750 | 2.563 | | | |
| | 2-1/2 | 65 | | X | 0.938 | 3.000 | | | |
| | 3 | 75 | | X | 1.000 | 3.688 | | | |

| 0 |) Data file B | SK6.AC3 | | | | | |
|--------------------------------|---------------|----------|-----------|--------|--------|----------|--|
| F | ile Edit | | | | | | |
| Dimensions for 6000# Thredolet | | | | | | | |
| 1 | Nom. Size | Metric S | ize In Us | e? Dim | ension | 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 | × | | 0.875 | 1.313 | |
| | 1-1/4 | 30 | X | | 0.938 | 1.500 | |
| | 1-1/2 | 40 | X | | 1.000 | 1.938 | |
| | 2 | 50 | × | | 1.313 | 2.750 | |

Dimension file for STD Weldolets, including hole diameters:

| (| 🚯 Data file BWJ.AC3 | | | | | | | | |
|---|---------------------|-----------------|---------|----------|--------------|----------|----------|--|--|
| ſ | File Edit | | | | | | | | |
| | Discourt | | | | | | | | |
| | Dimensi | ons for STD WUL | - | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | 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 | Х | .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 | Х | 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 | | |
| | | | | | | | | | |

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Dimension file for XH Weldolets, including hole diameters:

| • |) Data file B | WK.AC3 | | | | | | |
|---|---------------|----------------|---------|----------|--------------|----------|----------|--|
| F | ile Edit | | | | | | | |
| | | 4 10111-001 | | | | | | |
| | Dimensi | ons for XH WUL | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | 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 | Х | 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 | Х | 102. | 4.424 | 4.188 | 15.875 | |
| | 18 | 450 | Х | 130. | 4.875 | 4.375 | 17.938 | |
| | 20 | 500 | Х | 158. | 5.000 | 4.688 | 20.063 | |
| | 24 | 600 | Х | 290. | 5.500 | 5.500 | 24.188 | |
| | 26 | 650 | Х | 350. | 5.750 | 5.750 | 27.250 | |

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

| • |) Data file B | WL.AC3 | | | | | • X |
|---|---------------|-----------------|---------|----------|--------------|----------|----------|
| F | ile Edit | | | | | | |
| | Dimensi | ons for 160/XXH | WOL | | | | |
| | | | | | | | |
| | | | | | | | |
| h | Nom Size | Matric Size | In Use2 | Weight # | Size on Size | Reducing | Hole dia |
| | 1/2 | 12 | IX | 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 | × | 3.4 | 2.438 | 2.438 | 2.125 |
| | 3 | 75 | × | 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 |