5.4.3 **General and Angle Parameters**

Certain parameters in a Recipe are defined for each angle to be cut in the Workpiece, while others are considered general because they apply to the Workpiece as a whole. Angle parameters appear in the Angle tabs, and general parameters appear in the General tab. Before specifying parameters, define the angles along which the Workpiece will be cut.

**Note:** If a parameter is defined under both General and angle tabs, the value under an angle tab is the effective one.

5.4.3.1 **Defining Angles**

When defining a Recipe, the User must define the angles along which the Workpiece will be cut. The User can define as many angles as needed. Angles can be redefined or deleted at any time.

**Note:** Only positive values can be used to define the angles.

5.4.3.1.1 **Adding New Angles**

New angles can be added to the Recipe by performing the procedure described below.
To Define New Angles:

1. In the Programming Workspace, right-click on any existing Angle tab to display the following popup menu:

   ![Figure 5-14: Angle Tab Popup Menu](image)

2. Click **Insert** to display the following dialog box:

   ![Figure 5-15: PP Insert Dialog Box](image)

3. Enter the desired angle and select whether to have the parameter tab for the angle added **Before** or **After** the parameter tab selected in the text box.

4. Click **OK**. A tab for the angle is added to the Parameter Table, as shown below.

   ![Figure 5-16: Angle Tab Added](image)

The parameters defined in the tab will be the same as those for the existing angle. The parameters can then be modified, as described below in section 5.4.3.2.

5.4.3.1.2 Moving Angle Tabs

The order in which Angle tabs are displayed in the Parameter Table can be modified by performing the procedure described below.

**Note:** The order in which Angle tabs are displayed in the Parameter Table has no affect on the functionality of the Recipe.
To Move Angle Tabs in the Parameter Table:

1. In the Parameter Table, right-click the tab to be moved to display the popup menu (see Figure 5-14).
2. Click Move to display the following dialog box:

   ![](Figure 5-17: PP Move Dialog Box)

3. Select the place to move the tab by selecting one of the parameter tabs displayed and then clicking After or Before.
4. Click OK. The Angle tab is moved to its new location in the Parameter Table.

5.4.3.1.3 Modifying Angles

The angles defined for the Recipe can be modified at any time by performing the procedure described below.

To Modify Angles:

1. In the Parameter Table, right-click the tab to be modified to display the popup menu (see Figure 5-14).
Specifying Recipe Parameters

2 Click **Change** to display the following dialog box:

![Figure 5-19: PP Change Dialog Box](image)

3 Enter the new angle, then click **OK**. The angle is redefined in the Parameter Table. The parameters defined in the tab remain the same as before.

5.4.3.1.4 Angle Access Rights

Users with read-write access can determine which Users can add, move and modify angles by limiting access to the popup menu (see Figure 5-14). For further information on limiting access rights, refer to Chapter 4.

5.4.3.2 Specifying Parameters

After defining the cutting angles, Users with read-write access to parameters can add, modify and delete the parameters for each angle as needed. The User can also add, modify and delete the parameters in the General tab, which are applicable to all angles. The values defined for each parameter determine the way the algorithms in the Recipe control the operation of the System.

5.4.3.2.1 Adding Parameters

Parameters are added to the Recipe by selecting them from the relevant parameter category and adding them to the Parameter Table, as described below. It is recommended that parameters first be defined for the General tab, before adding parameters for each defined angle.

**To Add Parameters to the General and Angle Tabs:**

1 In the Parameter Table, click the General tab. The General tab displays those parameters that were defined for the Recipe from which this new Recipe was created (see section 5.2).
2 In the **Parameter** area below the Parameter Tree, select a parameter category from the **Category** drop-down list, as shown below:

![Parameter Category List](image1)

3 Select a parameter from the **Parameter** drop-down list, as shown below:

![Parameter List](image2)

4 Click **Add**. The parameter is added to the Parameter Table with the default value for the parameter assigned. (For more information about default parameter values, see Appendix 1. To modify these values, see section 5.4.3.2.2.)

5 Repeat steps 2-4 until all the parameters required for the tab have been added.

6 Click **Save**. The new settings are saved to the Recipe.

7 Click the first Angle tab and repeat steps 2 through 6 to define the parameters that are specific to that angle.

8 Repeat steps 2 through 6 for all additional Angle tabs.

### 5.4.3.2.2 Modifying Parameters

Users with read-write access can modify the values of parameters in the Recipe at any time by performing the procedure described below.
To Modify Parameter Values:

1. In the Parameter Table, double-click the Value cell of the parameter to be modified. If the User can choose from among a list of preset values, a drop-down list with those values appears in the cell. Otherwise, a blinking cursor appears.

2. Select a value from the drop-down list or enter the value directly. Only values within the min and max range are valid.

3. Click . The new settings are saved to the Recipe.

5.4.3.2.3 Deleting Parameters

Parameters can be deleted from the Recipe by performing the following procedure.

To Delete Parameters from the Recipe:

1. Select a parameter in the Parameter Table. Any cell on the line, including the parameter name, can be selected.

2. In the Parameter area, click Delete. The selected parameter is deleted from the Parameter Table.

   If more than one index was defined for the parameter, clicking Delete deletes the value for the selected index. (Click Delete additional times to delete other indexes, where applicable.)

3. Click to confirm the deletion of the parameter or to cancel the procedure and restore the parameter to its previous value.