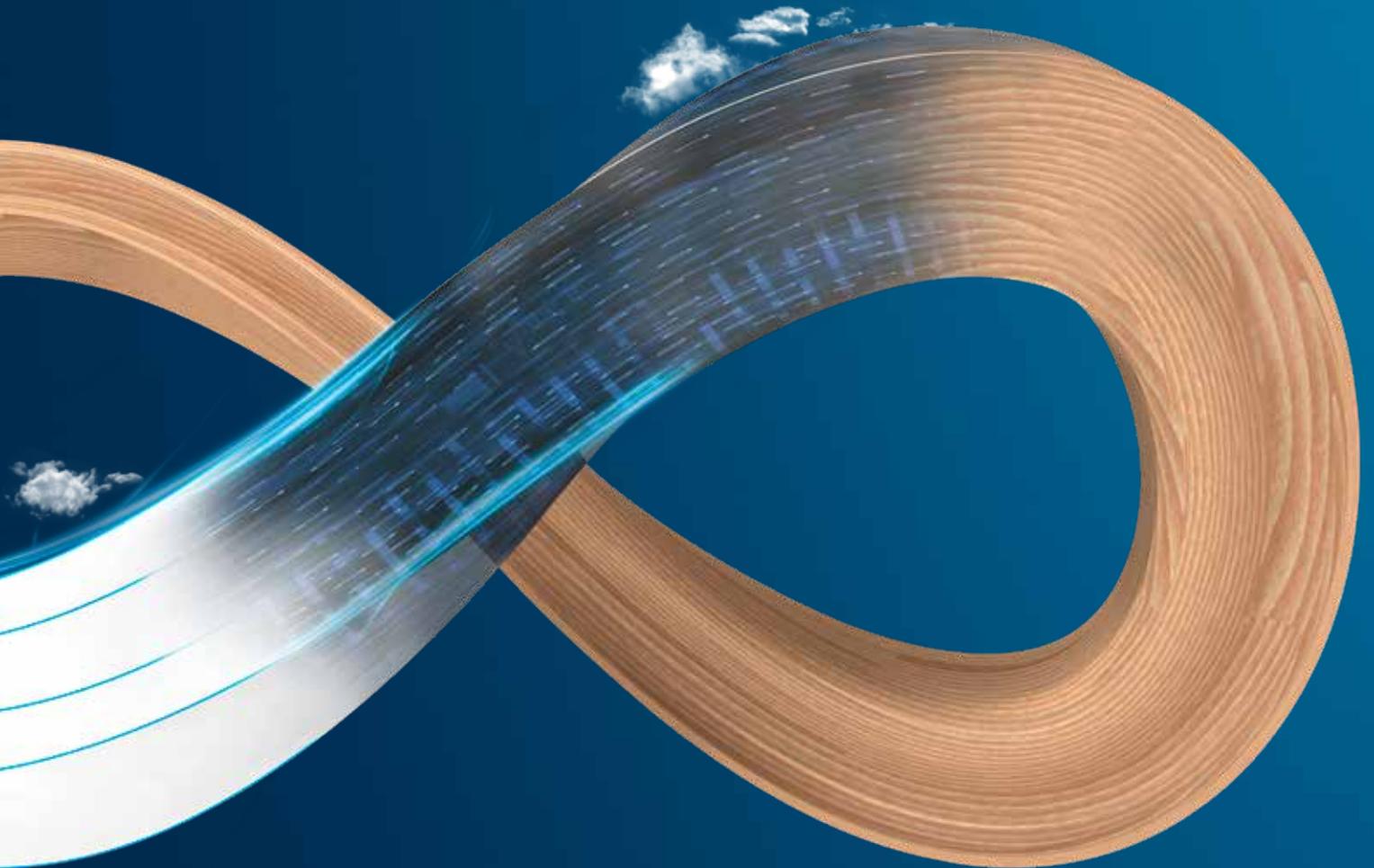


# WOODWOP<sup>8</sup> CNC programming

**New Functions. Infinite possibilities.**  
Software from HOMAG.



The woodWOP success story began exactly 30 years ago. The basic principle of woodWOP has not changed to this day. In the latest version woodWOP 8, HOMAG offers users a large number of new functions and endless possibilities.

- 1991    **woodWOP 1**    Premiere at LIGNA 1991:  
First workpiece-oriented programming in the wood industry
- 1994    **woodWOP 2.5**    First version under MS-DOS for work preparation workstations
- 1997    **woodWOP 4.0**    First Windows version with unlimited number of contour elements
- 2002    **woodWOP 5.0**    Wizard technology for edge processing programming
- 2009    **woodWOP 6.0**    3-dimensional representation of workpiece, tool and clamping device
- 2012    **woodWOP 6.1**    CAD functions
- 2015    **woodWOP 7.0**    CAM plugin for 5-axis programming
- 2017    **woodWOP 7.1**    Feature detection
- 2019    **woodWOP 7.2**    Extension routing macros, 3D Model Wizard
- 2021    **woodWOP 8.0**    New wizard, contour templates, Formula Wizard, MPRXE exchange format

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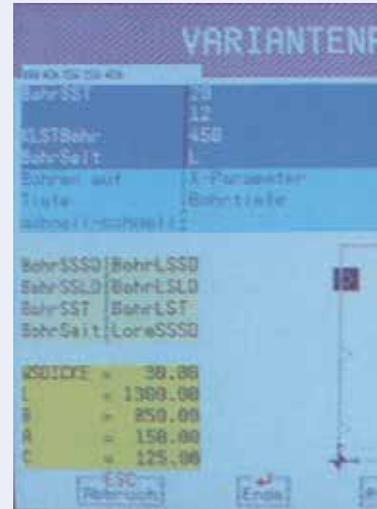


Free download of woodWOP components

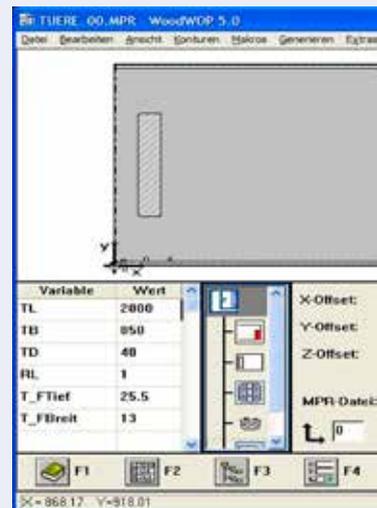
**FORUM.HOMAG.COM**



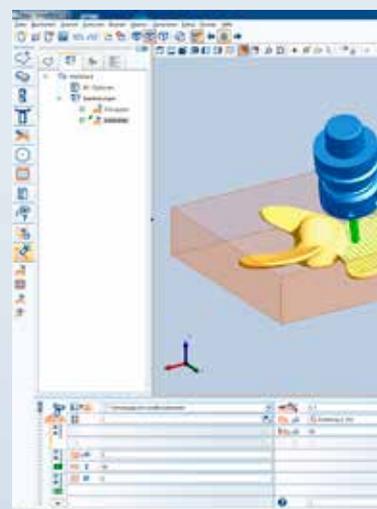
The world's largest forum on the subject of woodWOP



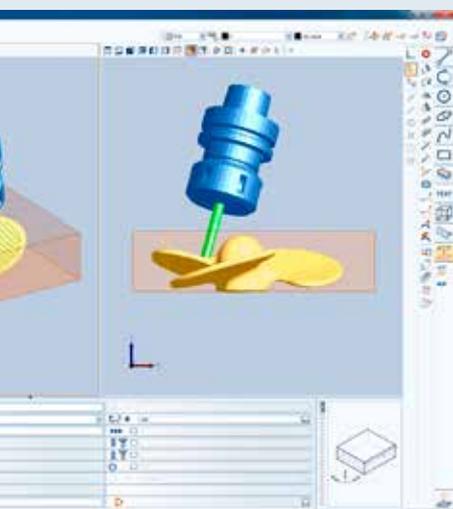
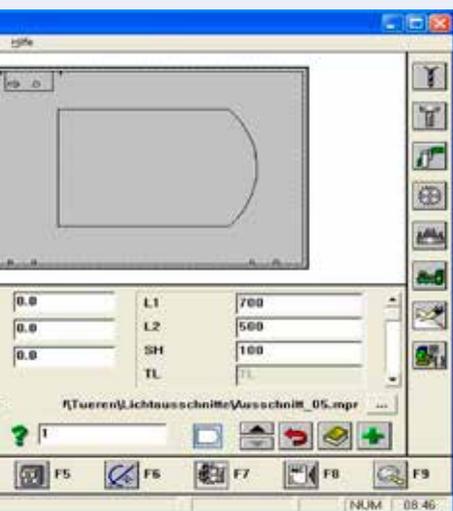
1991 woodWOP 1.0



2002 woodWOP 5.0



2015 woodWOP 7.0



## woodWOP – the CNC programming system from HOMAG

woodWOP is the CNC programming system from HOMAG. The centerpiece of the innovative user interface is the large graphic area in which the workpiece is displayed three-dimensionally. Routing, drilling or saw cuts are programmed quickly and easily by entering the processing parameters and displayed realistically in the graphic. This guarantees maximum programming reliability and constant control during program creation.

### YOUR SOLUTION

### MORE ON HOMAG.COM



### CONTENT

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- 05 Mass changes | 3D visualization of units
- 06 woodWOP templates
- 07 Variable table | Navigation cube
- 08 CAD and CAM plugin
- 09 Wizard
- 10 Technology database "TechEdit" | Nesting plugin
- 11 Import formats

## Enhancements in operation and in the WOP area

The screenshot displays the 'woodWOP Formula editor' window. The main area shows a multi-line formula being edited:

```

1 IF MATERIAL = "MDF" OR MATERIAL = "CHIPBOARD"
2 THEN
3 101
4 ELSE
5 102

```

The formula components are color-coded: 'IF', 'OR', and 'CHIPBOARD' are in red; 'THEN' and 'ELSE' are in blue; and the numbers '101' and '102' are in black. A yellow highlight is under the 'ELSE' line.

On the right side, there are two panels:

- Formelelemente:** A list of mathematical functions including '&', 'ABS(<Zahl>)', 'AND', 'ARCCOS(<Zahl>)', and 'ARCSIN(<Zahl>)', along with a 'Paste' button.
- Variables:** A table with columns 'Name', 'Value', and 'Comment'.
 

Name	Value	Comment
_BHX	1	Maschine 1 - BHX500
_ABD	0	keine ABD
_mirror	0	gespiegelt
_nonmirror	1	nicht gespiegelt
		gespiegelt in Y
		nicht gespiegelt in Y
		kleiner Kreisbogen ccw
		kleiner Kreisbogen cw

At the bottom right, there are buttons for 'Formel prüfen', 'Paste', 'OK', and 'Cancel'.

### Formula assistant

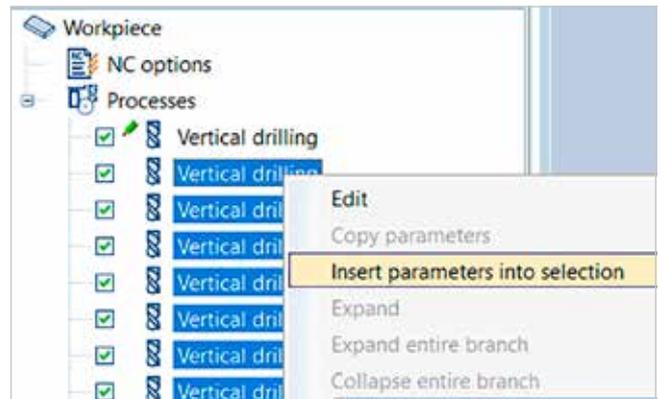
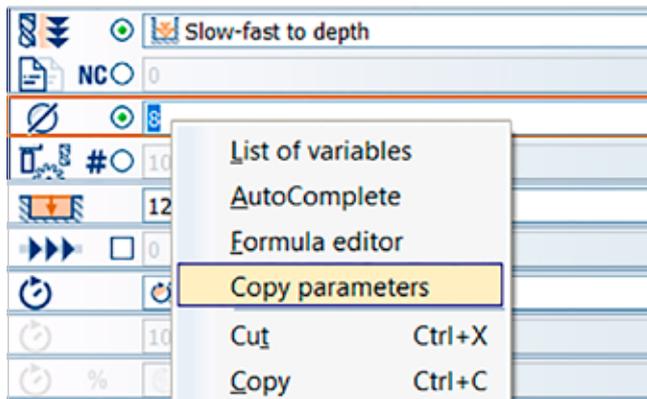
The new formula assistant makes the creation of formulas extremely simple. The user has everything in view in the multi-line formula field. Building blocks such as mathematical functions, variables and conditions are at the user's fingertips for assembling their formulas. The formula components are highlighted in color. This makes even complex formulas easy to understand. Not only the formula result, but also partial results can be calculated.

### ADVANTAGES:

- Convenient operation due to modular principle
- Support for complex formulas

### Mass changes of parameter values

With the transfer of parameter values, mass changes to macros can be made quickly and easily with just a few clicks.



#### The way it works:

- Making changes in a macro
- Transfer of one or all parameters to the parameter clipboard
- Selection of all other macros to be changed
- Insertion of one or all parameter values

#### ADVANTAGES:

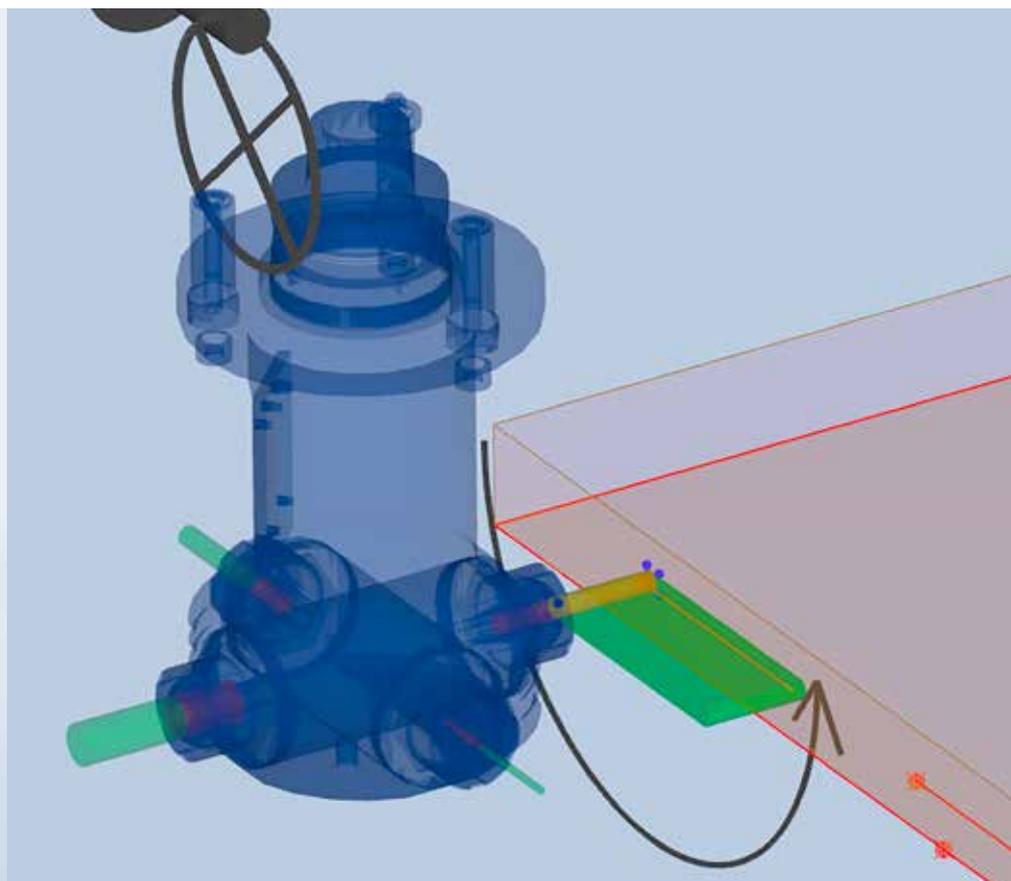
- Time saving when creating or modifying programs
- Convenient and fast correction, e.g. of incorrect or incomplete values from CAD data transfer

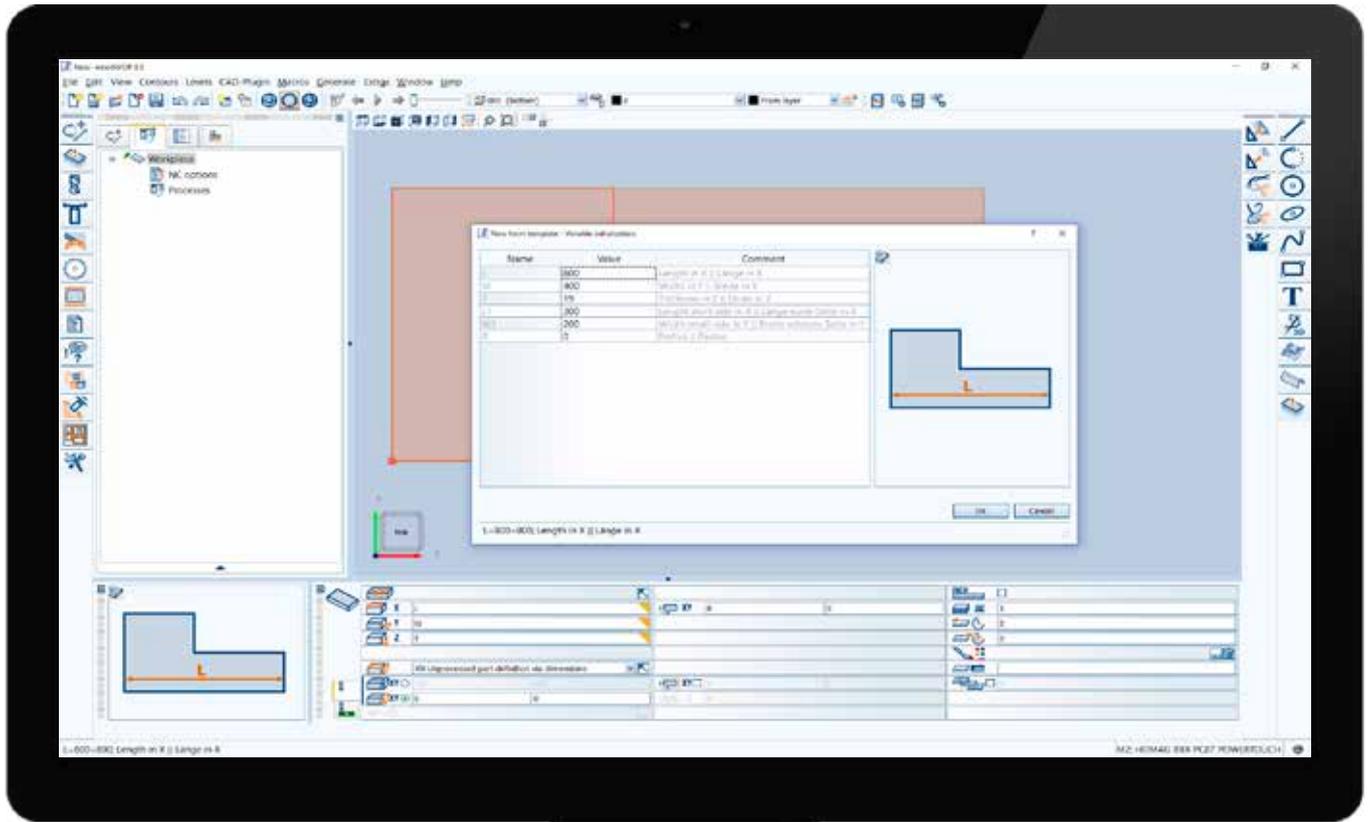
### 3D visualization of units

Display of the 3D unit model directly in woodWOP

#### ADVANTAGES:

- Better recognition of the programmed processing
- Ensuring error-free programming





### woodWOP templates with basic outlines

The woodWOP templates with basic outlines make programming new workpieces a lot easier. After selecting the basic form, order-related variable values can be filled in and processing operations can be stored. The templates can also already contain processing operations such as formatting. The template library can be extended by the user with their own templates.

### ADVANTAGES:

- Programming of new workpieces without contour train programming
- Time saving for standard forms

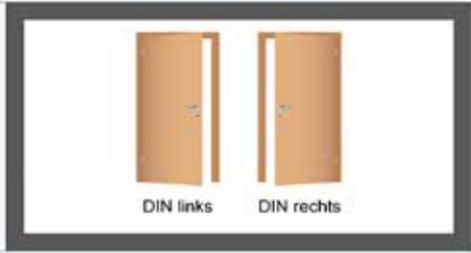


**OLD**

Name	Value	Comment	Result
l	2165	Length in X	2165
b	1042	Width in Y	1042
d	74.3	Thickness in Z	74.3
boden	0	Bodenschliesser Ge...	0
din	"left"	Door direction	"left"
dinl	IF din="links" THEN 1 E...	DIN Links	0
dinr	IF din="rechts" THEN 1 ...	DIN Rechts	0
secsbr	0	Hardware Security S...	0
seca	1	Hardware Security ...	1
secm4	0	Hardware Security ...	0
rustu	1	Lock setting Security	1
fh	54	Height rebate (47 ...	54
fh1	fh-37	Height rebate (10 ...	17
df	1	Rebate	1
dr	1	Drill handle hole	1
bu	259	Hinge 259 normal	259
bm	l/2+10	Hinge center l/2+1...	1092.5
bo	l-239	Hinge center l-239 ...	1926
la	0	Cutout	0
rad	0	Radius	0
kfv3	0	KFV Getriebe 3 - fa...	0
abst	0	Distance	0
sonder	0	Groove 5mm	0
bsch	0	Lock	0
tas	0	Pocket below	0
dih	0	Handle height 105...	0
sx	0	Schallex	0
kue	0	Dorma LANG ( onl...	0
hue	430	Height 3-pol Kont...	430
its	0	Door lock ITS Boxer	0
pol	0	Mill 3-pol	0
kuesty	0	Cable Winkhaus	0
kuekl	0	Cable Dorma	0
bss	0	Hinge setting	0

**NEW**

Name	Value	Comment
l	2165	Length in X
b	1042	Width in Y
d	74.3	Thickness in Z
boden	<input type="checkbox"/>	Bodenschliesser Geze
din	"left"	Door direction
secsbr	"left"	Hardware Security SB/R (Nicht KPV)
seca	"right"	Hardware Security mit A-Defner oder SH ... III S...
secm4	<input type="checkbox"/>	Hardware Security MR4
rustu	<input checked="" type="checkbox"/>	Lock setting Security
fh	54	Height rebate (47 mm bis 68 mm dicke) (54 bei ...
df	<input checked="" type="checkbox"/>	Rebate
dr	1	Drill handle hole
bu	259	Hinge 259 normal
la	<input type="checkbox"/>	Cutout
rad	0	Radius
kfv3	<input type="checkbox"/>	KFV Getriebe 3 - fach
abst	0	Distance

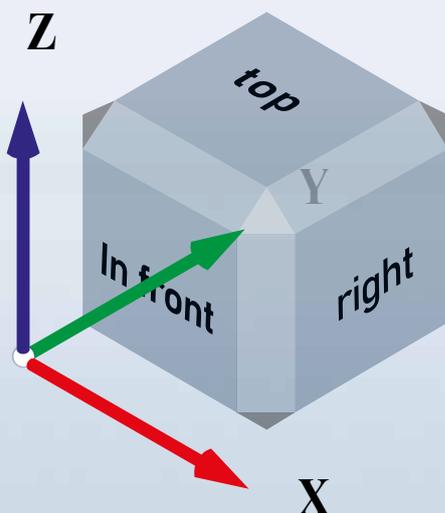


**The variable table is extended by some new possibilities:**

- New attributes „Hide“ (hide row) and „Boolean“ (checkbox)
- Predefine selection list
- Define minimum and maximum value
- Define auxiliary graphics
- Two views: List view and form view

**ADVANTAGES:**

- Easier operation due to clear variable table
- Simpler component programming

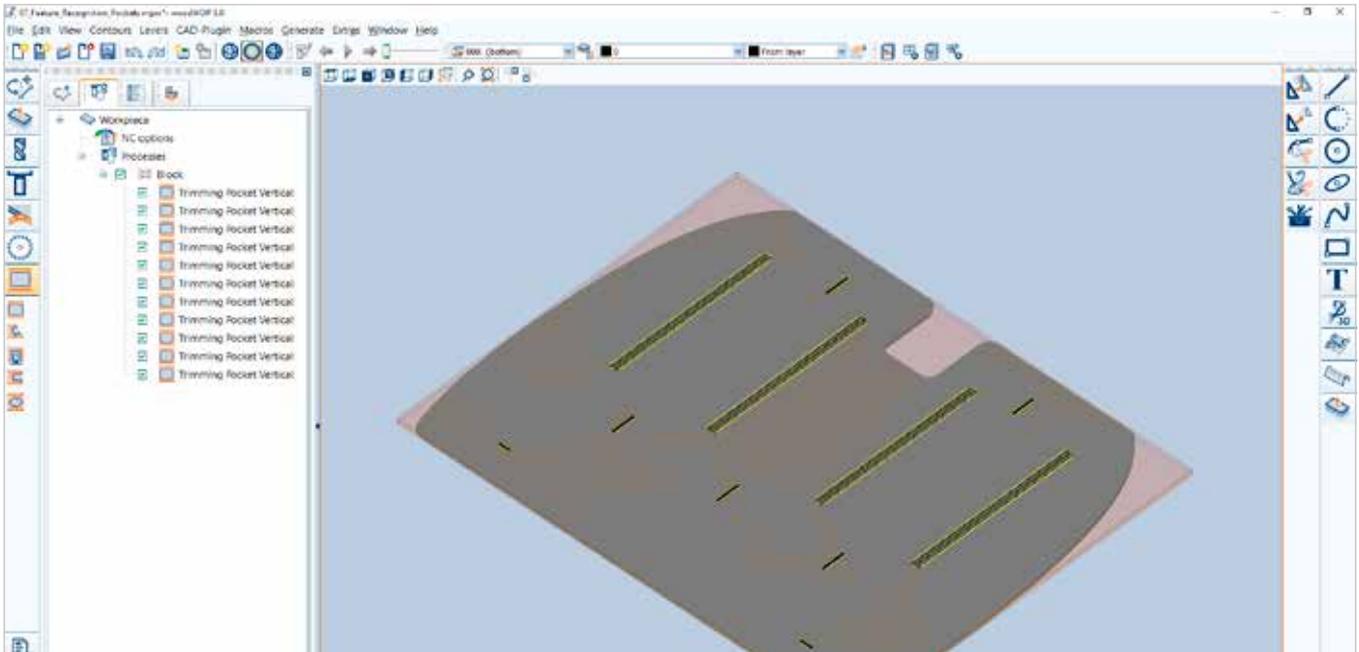


Navigation cube (ViewCube)

**ADVANTAGES:**

- Fast rotation of the workpiece
- Easy orientation for 3D display of workpieces

## Enhancements in CAD and CAM plugin

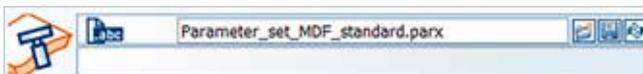


### Feature detection

As of woodWOP 8, feature detection also detects grooves and rectangular pockets. After analyzing the 3D model, the appropriate processing macro is generated automatically. The user can define the templates himself in the conversion profile.

### ADVANTAGES:

- Faster conversion from CAD import to the processing program
- Avoid double data entry



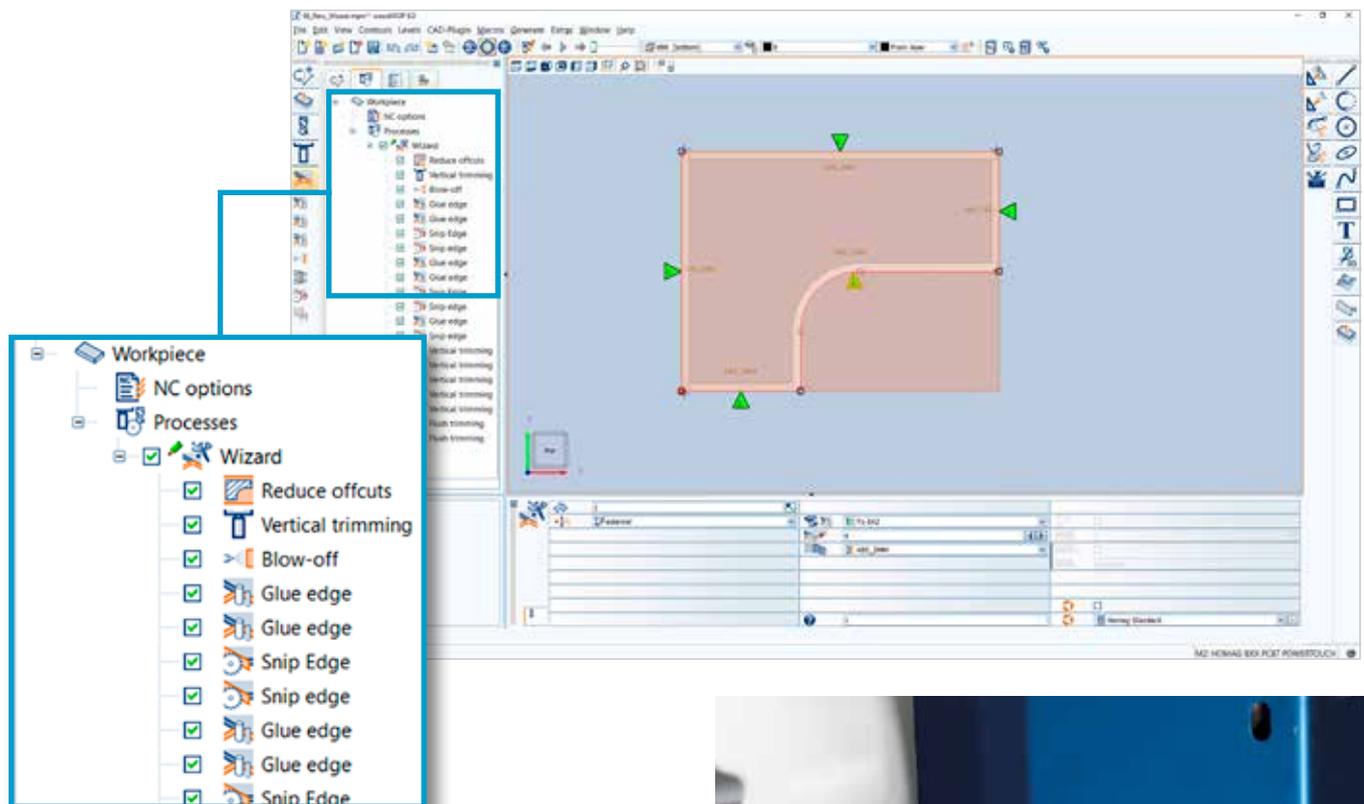
### Parameter sets for CAM plugin macros

Proven values for tool, feed, routing strategy, etc. can now be saved in parameter sets. For new programs with similar application these parameter sets can be reloaded.

### ADVANTAGES:

- Faster programming of new workpieces, fewer tests
- Easy reuse of proven settings

# Programming edge banding with woodWOP



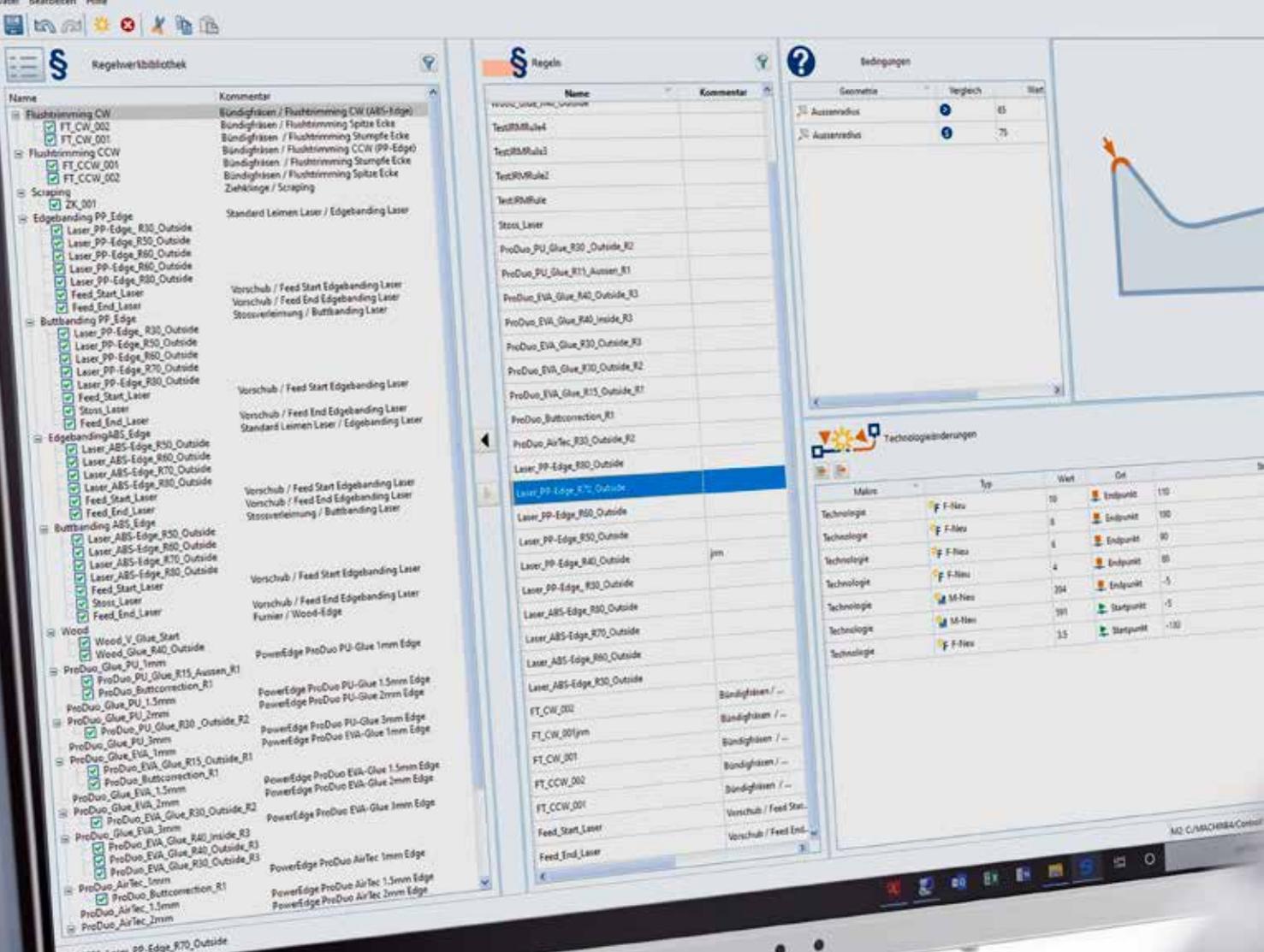
## Wizard

The new wizard for programming edge banding is fully integrated into woodWOP. Instead of a separate application, the Wizard macro is now opened. The edgebanding type, sequence and other important parameters are defined directly on the workpiece. The generation run is started with a mouse click and the individual processing macros are automatically inserted in the macro list. The generation run can also be started automatically when the workpiece is loaded on the machine.

## ADVANTAGES:

- Faster creation of programs for machines with edge banding
- Wizard macro controllable from external CAD/CAM solutions



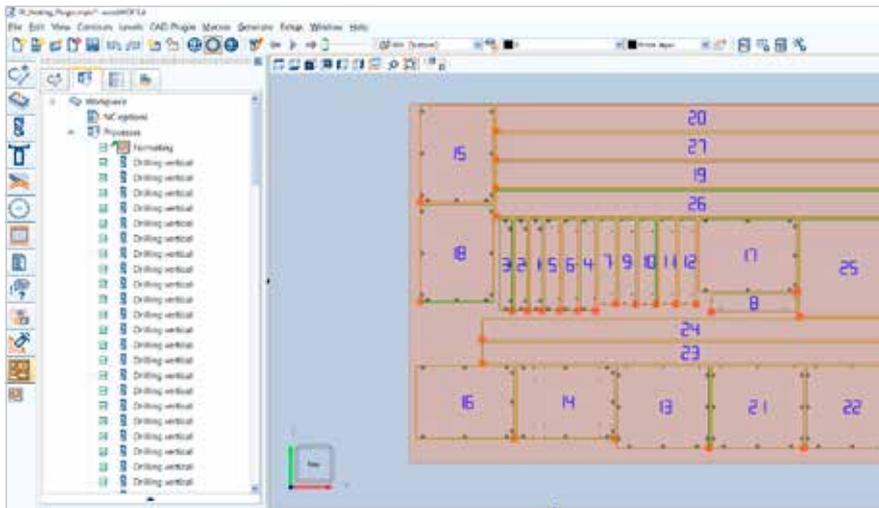


**Technology database „TechEdit**

As a knowledge database for technology changes, e.g. for edge banding on the CNC machine, the new technology database „TechEdit“ offers an intuitive solution. The user has all settings at a glance in the new user interface. The technology database makes it possible to „store“ process engineering know-how for later use on the basis of rules and conditions.

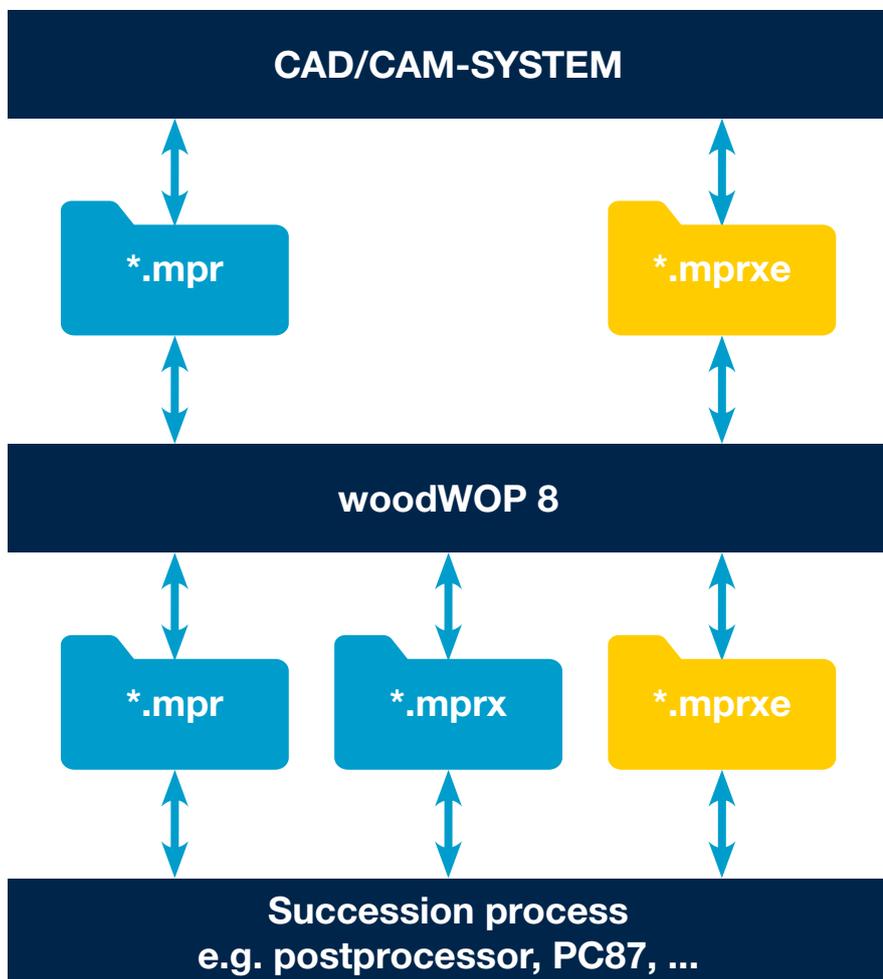
**ADVANTAGES:**

- Easy reuse of proven settings
- Central point for collecting process engineering know-how



**Nesting plugin**

The Nesting plugin provides a new format macro for formatting multiple parts in the nest. After the contour analysis, the nesting plugin automatically generates the routing paths. Depending on the requirements, the workpieces are routed out individually or processed in the so-called staydown or commonline processes. The nesting plugin can be controlled by optimization software such as intelliDivide Nesting.



**New import format MPRXE**

The new MPRXE memory format offers new possibilities both internally and externally. The reduced memory size and faster loading/saving make the MPRXE memory format significantly more performant, especially for large and complex programs. External CAD/CAM systems can use the MPRXE memory format to control the new wizard macro or string variables, for example.



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