

# What's New in COPRA Release 15.0



data M Software

## **COPRA 15.0 can be used with**

- AutoCAD 14 / Mechanical Desktop 2/3
- AutoCAD 2000 / Mechanical Desktop 4

### **1) General**

- COPRA-Environment will be automatically set by starting AutoCAD 2000 with the COPRA 15 Start-Icon
- When displaying the flower the current pass and number is shown in a different colour (standard colour is yellow).
- If the flower has been created with the module Tubemill, the type of station is shown in the numbering of the rolls.
- The new Shortcuts "1+" and "1-" are in accordance to the Shortcuts "+" and "-" to scroll the passes. (In AutoCad 2000 a "+" at the beginning of a command has its own meaning. The "+" will be cut off when command is repeated).

### **2) COPRA Settings**

- A prefix for the roll number can be set (applies to all projects).

### **3) Project manager**

- Apart from the project name, the directory of the project group is also shown in the project list.
- The project list can be sorted either by project name, project group or chronologically.
- The drawing number in the dialogue box info is used in a specific project for the roll number.

### **4) Strip with calculation**

- There are 2 different tables for the user specific calculation.

### **5) Flower**

- Plane of unfolding
  - ⇒ automatic recommendation for the element sequence:  
open profile: from left -> right  
closed profile: Spin is in counter clockwise direction (mathematically +)
- Flower dynamically
  - ⇒ different ankle increment for positive and negative arc angle is adjustable.

### **6) Shaped tube / Drawing ring**

- Profile editing
  - ⇒ The distribution of the strip width to the single elements can be changed.
  - ⇒ The length of the single elements can be changed absolute or proportional.
  - ⇒ Length compensation can take place in any element through different options.
  - ⇒ Thus all calibrating methods except 'Track Holding' can be applied (also 'Tube profiling').
- With 'Angle Modification' the Distribution of Compression in the profile is adjustable.

### **7) Simulation**

- Colour chart and diagram are shown at the same time
- the current model (Top, Centre, Bottom) is shown in the colour chart
- Text in diagram can be edited as text
- Existing axes can be used for definition of rolls  $\emptyset$
- For the setting of the horizontal centres and the allocation pass number to station number are shown

### **8) Downhill forming**

- New method 'Lower edge of profile in point of unfolding'

### **9) Roll tools**

- Automatic axes construction
  - ⇒ Side axes possible
  - ⇒ Option create axes yes/no/leave-unchanged
  - ⇒ "Advanced" revised
  - ⇒ Free choosing of reference point for axes
- Automatic Roll Design
  - ⇒ for trapezoidal profile possible
- possibility to copy multiple rolls

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## 10) Dimensioning of rolls

- For dimensioning of the radii the zoom factor will be automatically determined. An adjustment of the zoom factor for radii in the COPRA settings is not necessary anymore (not possible)

## 11) Roller Weight

- When the COPRA Roll Data Base CRDB is activ, the numbers for the rolls are used from the database.

## 12) Sawing list

- When the COPRA Roll Data Base CRDB is activ, the numbers for the rolls are used from the database.

## 13) COPRA Tubemill

- Tubemill selection
  - ⇒ If you copy a tube mill, existing mill (also current ones) can be overwritten
  - ⇒ As option all top-/und bottom rolls can be splitted
- Tubemill flower
  - ⇒ Additions: Parameter is factor for reduction addition  $RA = \text{Factor} * \text{sheet thickness}$
- Tubemill machine data
  - ⇒ Bottom edge of roll in the side rolls of the calibration can be set like in the welding roll
- Tubemill rolls
  - ⇒ Gap setting for Breakdown Typ1 is OK
  - ⇒ Relief radius is the next profile radius multiplied by factor

## 14) COPRA Roll Data Base CRDB

- In the modules "roller weight" and "cutting list" roll numbers from the COPRA Roll Data Base CRDB is applied when CRDB is active.
- If you copy or mirror CRDB-Rolls, the new rolls will get the roll number of the copied roll from the data base, if in the COPRA-Settings in the lower dialog window CRDB the option "Skip rolls in roller technology " is not set.