MT113

Subprogram call and repetition

This document shows how to call and repeat a subprogram within a main program with a Milling application example.

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Description of the document:

Method for calling and repeating subprograms within a main program, multiple times.

- Benefits of subprogram call
- Functions and Syntax with meaning

Applicability:

- Technology   **Turning and Milling**
- SINUMERIK controllers   802Dsl, 810D, 840D powerline,

                                         808D, 828D, 840Dsl & SINUMERIK ONE

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Subprogram call
and repetition

Subprograms are a really convenient as one could have an incremental program and call it in multiple times. They ensure:

• Easy in repeating the subprograms

• Shorten programs

• If required, they can also be called at different positions in a main program.

Function: Subprograms can be executed n number of times in a main program

Syntax: Subprogram_name Pn ; **e.g. SUB_TEST P4**

Definition:

Subprogram_name - Name of the subprogram file (It is recommended to make the subprogram under the subprogram folder)

Pn   - Subprogram repetition n times (e.g. If we want to call subprogram 10 times, mention P10)

Procedure:

1. Create subprograms under **SUBPROGRAMS** folder. Example: SUB_TEST
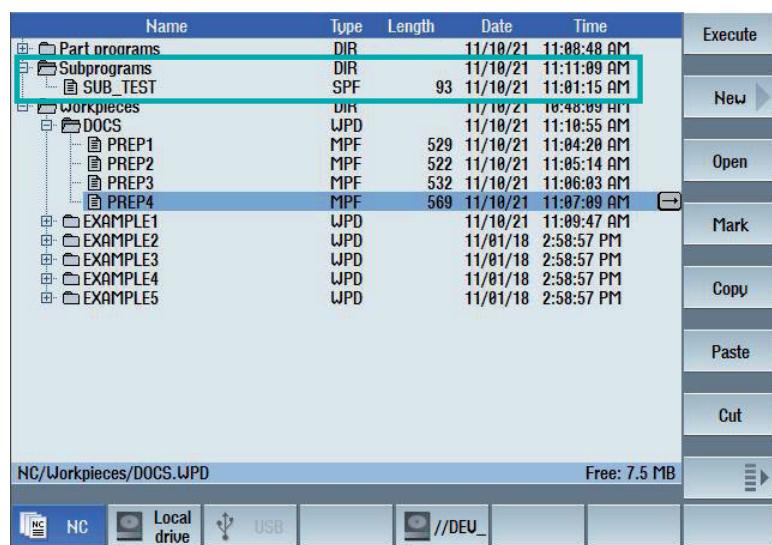
2. Write the subprograms based on your requirement
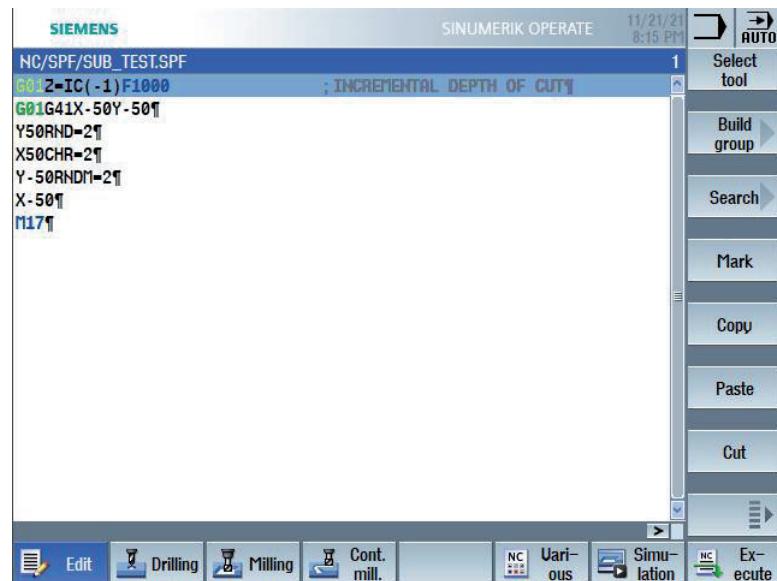
3. Create the Main program in **part programs** or in **workpieces** directory.
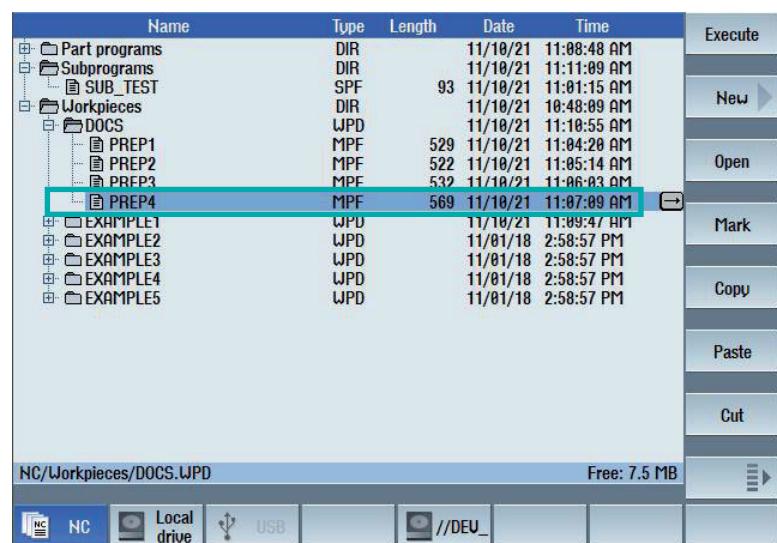

Example: PREP4.MPF

4. Write the main program and call the subprogram in the required block and define the no. of repetitions.

Example: If the subprogram has to be repeated 10 times then mention:

SUB_TEST P10

Note: Space is mandatory between program name and repetition

Result :
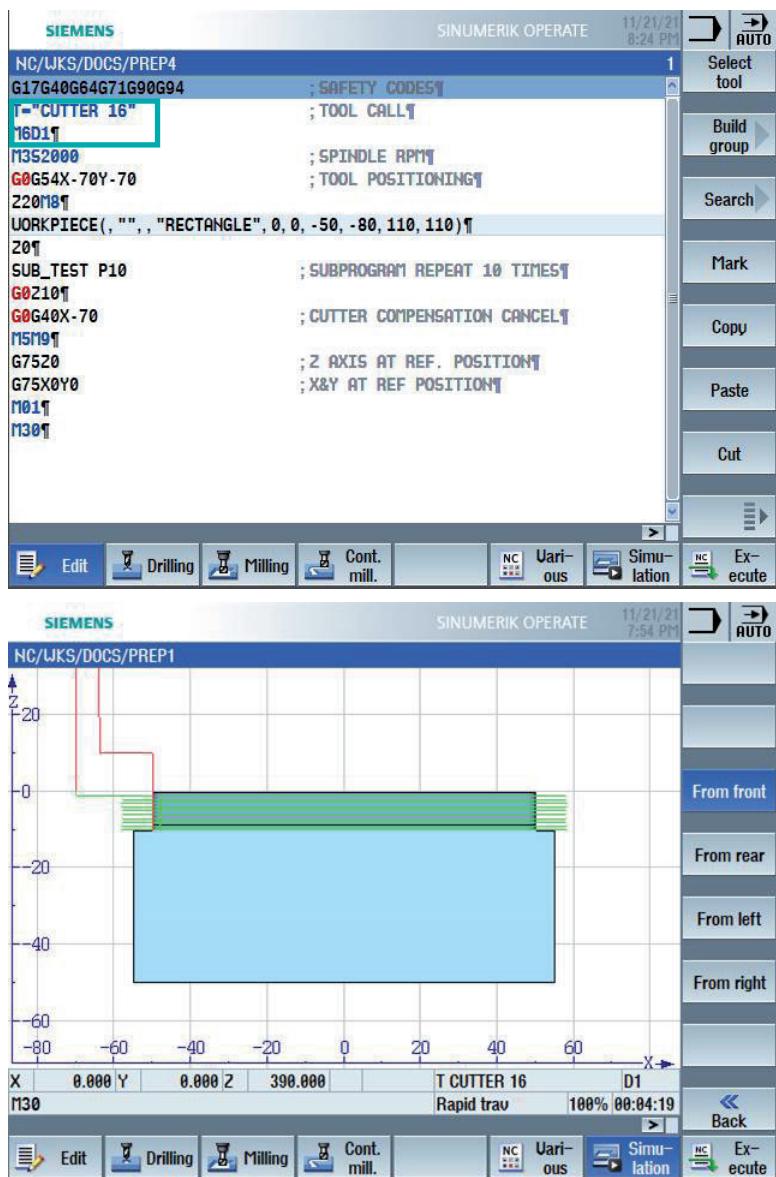
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