Converting various Cam File formats to Manufacturing Style formats

Important: You need the Cam Grinder version to do some of the steps in this process.

Locate and Open the CPP file. or whatever format of file you want to convert.

The program will sense it is a CPP file and will ask some questions about how you want the data presented. If you are making a file of the cam profile itself (tappet lift), most of these inputs are not critical. They are used for producing Valve Lift data.

You are returned to the main screen with the CPP data. This particular CPP file had both an intake and exhaust profile. Let's assume you want to make a manufacturing file of just the intake lobe.

🖾 Cam A

🖻 Open Test File	
4 Tests in Library	Chosen File: Ex-CamPP.cpp
Ex-CamPP.cpp Ex-CamPP.cpp 001 Ex-CamPP.cpp 001 virt Ex-CamPP.cpp conv to Cam An	Preview: Cam File Type: Cam Pro Plus
	Cam Pro Plus File
List All Files by File Name	Folders
 List by File Name (include Cam #) List by Cam # (include File Name) List by Date File way Last Saved Files Not File (all files listed) 	Chris Gilbert Combine Int and Exh Files COMBO Copy of EEEEEE CPP Compare CPP Conversion
Open Filter (find) Advanced (browse) Cancel Help Delete	Delete Tip: Click on a different Folder name to display all the tests saved under that Folder Name Add Right click in list above for more Folder Options

Ex-CamPP.cpp 001

•

CPP Conversion

🖻 Cam File Options **Options for Reading Cam Pro Plus File** Cam File Name & Folder Lifter Type Mild Solid Roller File Name • Keep File Lobe Sep. No Folder -Lobe to Use Lobe 1, Int 2, Exh 2 -Int Rocker Arm Ratio 1.6 Int Valve Lash .02 Notes: Int Centerline 105.1 Select or enter the specs you want to use for this cam file. All specs must be entered before you Exh Rocker Arm Ratio 1.5 can click on the 'Make File' button. (For Cam Pro Exh Valve Lash E

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This CPP file must be converted into a Cam Analyzer file type called "Measured with Electronics", like it was measured on the Cam Test Stand. This process going into the Test/ Cam Setup screen and changing the "Type of Cam Data" from "From Cam Pro Plus" to "Measured with Electronics". The program will then walk you through several steps, where you typically just answer Yes or OK as shown in the screens below.

	Test/Cam Setup	
est & Valv	Back (ok) Print Valve Springs Help Refresh	
est Time/	Test Setup	lift for Poting Eugente
am Numb	Type of Cam Data Den Stens	J.050 inch (1.25 mm
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.6 / .02	Lifter (profile) Type For Cyl #	
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est Data		45 45
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66.9.6	Actual Valve Lash, in .02 .022	
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62.9 E		₹ 45 45 🖌
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54.9 E	Max Lobe Lift, in .421 .411	Holp: Notes on Highlighted Item
52.9 E	Gross Valve Lift in 674 617	Click on the down arrow button to select how the
50.9 E		cam lift data was generated. If you select 'Generate
0 48.3 E	Keep Urig File's Lobe Seperation No -	from Cam Specs', you can also specify the tappet lift
2 44.9 F	Total Cam Advance O Straight Up 👻	measured. American aftermarket standard is .050".
- 44.5	Lobe Seperation deg 105.1	Metric and motorcycles use .040" (1 mm). Seat
3 42.9 H		

Change Type of Cam Data Anyway?

The program will now convert your data to a format much like it was Measured with Electronic Sensors (800 crank degrees, 2 deg increments, etc). This will be a major change to the data, but will allow you to do additional types of analysis. After this change, you will NOT be able to return to the original data.

It is recommended you save this data, and then save again to a New Name before you continue. That way you CAN go back to your old data file if need be.

Are you sure you want to make this change to the Type of Cam Data now?



		-
	Convert to 'Measured by Hand' Now?	
	To convert from this data type will require 2 steps. First, the data must be	converted to 'Measured by Hand'. Do you want to do that now?
	(<u>Y</u> es	No
		Cam Analyzer 🛛 🔀
The by	e process must first convert to the Type of "Measured Hand"	This first conversion may take 5 to 15 seconds. Please wait.
<i>b</i> y		ОК
	Cam Analyzer	X
	The conversion to 'Measured by Hand' has been completed. Now you ca	an select 'Measured with Electronics' to complete the conversion.



Now you can set the "Type of Cam Data" to "Measured with Electronics" to finish the conversion.

(After this conversion you will click on the "See Virtual Follower Details" as described on the next page.)

Test/Cam Setup	×
Back (ok) Print Valve Springs Help Refresh	
Test Setup	Lift for Rating Events .050 inch (1.25 mm 💌
Type of Cam Data	Degree Wheel
Measured with Electronics	Type TDC-90-BDC-90-TDC
Lifter (profile) Type	
Solid	трс
Intake Exhaust	45 45
Rocker Arm Ratio 1.6 1.5	
Actual Valve Lash, in .02 .022	
Electronic Measurement Settings	90 90
TDC Method User finds TDC with Stops 💌	
Click here for info on why items are disabled.	45 45
Cam Design Custom	BDC
Number of Cylinders To Test	
Lifter Bore Angle Details Sayer	Help: Notes on Highlighted Item
Camshaft Layout Details pen	Click on the down arrow button to select how the
See Virtual Follower Details	from Cam Specs', you can also specify the tappet lift
Adv/Ret	from which duration and opening/closing events are measured. American aftermarket standard is .050".
	Metric and motorcycles use .040" (1 mm). Seat timing is also called 'advertised' duration and is not as
Measure Cam On Cam Test Stand	accurate a method. p 21 IMPORTANT: Select
More Options Options NOT set to std	Test Stand.
Defaults	

Change Type of Cam Data Anyway?

The program will now convert your data to a format much like it was Measured with Electronic Sensors (800 crank degrees, 2 deg increments, etc). This will be a major change to the data, but will allow you to do additional types of analysis. After this change, you will NOT be able to return to the original data.

It is recommended you save this data, and then save again to a New Name before you continue. That way you CAN go back to your old data file if need be.

Are you sure you want to make this change to the Type of Cam Data now?



Base circle is critical to producing accurate results so enter it accurately. Typically you can measure this with a dial caliper measuring across the cam from the nose to base circle. Then subtract out the max tappet (cam) lift

measured on the stand, or as indicated in the CPP and now Cam Analyzer file.

line of	Dage	Colored I	
	THE P		
	0.000		

Yes

Do you want a base circle included with this conversion?

No

×

Cancel

 Enter Base Circle
 Image: Circle diameter for this cam, a number from .2 to 10 inches ?

 If you do not know, enter 1.2 .
 Cancel

 1.266
 Image: Circle diameter for this cancel

Now that the data is in the same format as one Measured with Electronics, you can perform more advanced analysis. For example you can do graphs, like Radius of Curvature, or Virtual Follower simulations.

First, select a Follower Type of one of the Virtual Followers. Typically I recommend Virtual Roller because it was measured on a stand without a rocker arm system, and measured with some type of follower with a spherical end.

The most critical setting is the Probe Radius (remember radius, not diameter). Choose one of the pre-programmed types or enter the radius when this cam was measured on the CPP stand. Note: It is not recommended you use data which was measured with a flat follower.

Now click on Back/OK and the conversion will take place.

🖻 Lifter/Follower Details Back (OK + save) Recalculate Results Cancel Help File Exhaust (matches intake) Intake Intake Advanced Specs Exhaust Specs Exactly Match Intake Specs Cam Lobe Base Circle Dia, in 1.266 View from Front of Engine Follower Type Virtual Roller Follower Body Diameter, in .842 Follower Roller Diameter, in .750 Probe Radius, in Std (small) Ono Sokki tip Std (small) Ono Sokki tio Intake Help Std .750" dia universal roller Pick one of the standard probe radiuses, or enter most any value you want. This is the diameter of the "probe" placed on the cam lobe during a measurement and is CRITICAL to enter correctly when doing any type of a virtual follower calculation. Intake Virtual Follower Specs Cam End Pivot Angle Clc Valve End Pivot Angle Clc Cam Location Angle Clc Cam End Pivot Distance Valve End Pivot Distance **Cam Location Distance** Cam End Pivot Radius Valve End Pivot Radius Valve Stem Distance Valve Stem Diameter Stack Up Error .051 Load Defaults Copy from Exh Cam Rotation Clockwise Clear Fix Stack Up Error -



This note does not really Car apply to this conversion process. Just click OK.



To illustrate what has happened, click on Graph at the top of the main screen. You do not need to go through these steps, but it is very helpful to show you want the program is doing in this conversion.



Select "Pick from List" and "Cam Lift" and "Actual Cam Profile" as the Data Types, then click Make Graph. Also select to do just the Intake lobe to keep things simple. Then click Make Graph.



You will see 2 graphs. The "fatter" graph is Cam Lift. The thinner graph is the data for the Actual Cam Profile, if you would have measured it with a very sharp "knife edge" type of follower. This is the data you want for producing the manufacturing type file.



Now click on Graph Type at the top of the Graph. Now select to just graph Actual Cam Profile. You will see a new option appear. Select Yes for "Show End View of Cam" and "Graph Absolute Lift". Then click Make Graph.

Graph Specs			'Pick from List' Data Types
Lobes to Graph	take	-	Cam Lift
Type Pick from List		-	Cam Velocity
Graph Lift	Yes	-	Cam Acceleration Cam Jerk
Graph Velocity	No	Ξŀ	Valve Lift
Graph Acceleration	NL-		Valve Velocity Valve Acceleration
Creek led	INO	<u></u>	Valve Jerk
Graph Jerk	No		Actual Cam Profile
Velocity Scale Factor	20	-	Cam Radius of Curvature
Accel, Scale Factor	1000	-	Valve Accel Frequencies
Jerk Scale Factor	5000	-	Valve Jerk Frequencies Cam Rearing Journals
X Axis	Degrees	극비	Cam Journals and Lobes
Joran	. Dogioco		Contact Point
Filter Specs			'Pick from List' Details
Lift Filtering None		-	Show End View of Cam
Vel/Accel/Jerk Filtering	Some	Ţ	Magnify Journal Differences
	1		Graph Absolute Lift
Cylinders to Graph			Cooph we Net Free DDM
Cyls to Graph All		-	Graph vs Nat. Freq. HPM
Picked Cyls 1			
Picked Cyls			



This is what the actual profile looks like from the end of the cam. The accuracy of this profile depends on you accurately entering data in the Virtual Follower specs, especially the Probe Radius and Base Circle Diameter.

In the Graph screen, click on File then Export.. And choose one of the Export options.

The program will present a browse window for you to save this file where ever you want and to any name you want. We recommend a .txt extension to make it easy to open with other programs. Then click "Save" button.





	CPP-Export.txt - Notepad	
	<u>File Edit Format View H</u> elp	
Here's what that file looks like when opened in Notepad.	Int Cam Profile-inches X, Int Cam Profile-inches Y 353970,524782 3344756,530879 335439,536815 326619,542587 316560,548194 306884,553634 297175,558986 287376,568987 267517,573693 257464,578274 247336,586095 226858,590985 216509,594854 206098,594854 206098,602857 185083,602857 185083,614236 142403,614236 142403,61815 131616,619207 120790,621409 1099029,625246 099029,625246 099129,628322	
		Ln 1, Col 1

Now that you can visualize what is happening, another method to produce a file, which has more options is to click File at the Main Screen, then Export Manufacturing Style Cam File.

🗧 Cam	Analyze	r v4.3 '(Cam Grinder' I	Performa	nce Trer	ıds
ile Edit	Graphs	Reports	Test/Cam Setup	Find TDC	Settings	He
EZ Star	t Wizard (i	new, EZ m	ethod for New Tes	t)		
New (d	assic way	to start ne	w test)	Ctrl+N		
Open (l	from all sa	ved tests)		Ctrl+O	st Con	me
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Save				Ctrl+S		
Save A	s			Ctrl+A		
Open fi	rom Floppy	/CD Drive	(A:\ Drive)			
Save to	Floppy/C	D Drive (#	A:\ Drive)			~ 1
Import					→ se: 57.0	3
Export	as Cam Dr	File (and o	other formats)			
Export	Manufacti	uring Style	Cam File			Sh
Email Tl	his Cam Te	st File				
Backup						
Restore	e from a Ba	ackup			•	
Print M	ain Screen				<u> </u>	

Choose the options you want and file "Format" and click the "Make File" button to produce the file. Check the User's Manual for more info on these various settings and their applications.

🛢 Export Mfg File Options 🛛 🛛 🖢					
Mfg Cam File Spec	:\$				
Format IGES file (***.igs)					
File Name CPP-IGES.igs					
File Destination Path Browse					
C:\VB98\projects6\C	am-anzr				
Separator	Commas (,)				
Lobe to Use Lobe Int #1					
Make Master Cam? No					
Diameter					
Zero Out Runout?					
Follower OD on Grinder					
Note: The manufacturing file current cam measuren (the screen behind thi for the actual cam pro 'knife edge' follower, r roller follower. This da	e created is based on the nents on the Main Screen s screen). This data will be file as if measured by a not a rounded pointer or ata is most accurate if				

measured with a linear encoder pointer directly on the cam lobe, because less correction for a

Help

Cancel

Print

radius is required.

Make File

Cam Analyzer

C:\VB98\projects6\Cam-anzr\CPP-IGES.igs written.

OK

CDD-IGES igs - Notenad	
File Edit Format View Help	
	~
OU 1H.,1H:,9HPTI VER 1,22HLobe Data Convertd IGS,13HPTI CONVERTER,1H1,16,8,G	
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¹¹ TI,8,0; G 3	
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LO 116 2 0 1 1 0 00000000 3	
116 0 3 1 0 0D 4	
L. 116 3 0 1 1 0 00000000 5	
116 0 3 1 0 0D 6	
116 4 0 1 1 0 00000000 7	
116 0 3 1 0 0D 8	
116 5 0 1 1 0 00000000 9	
116 0 3 1 0 0D 10	
116 6 0 1 1 0 00000000 11	
25 עשטשטשטש ש ר ר ש 13 סרר	-
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Ln 1. Col 1	