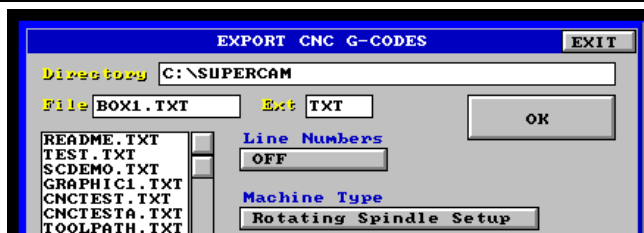
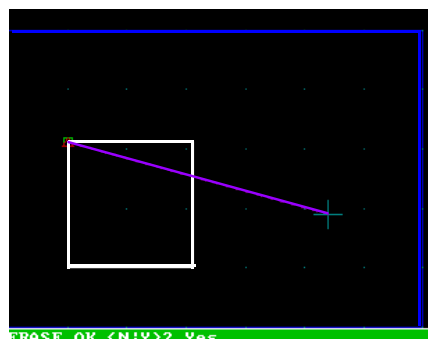


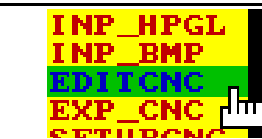
Creating CNC file/Example

Use “zoomc” to look at the big picture outside the limits. Find the origin of the travel line and use the “erase” command to get rid of it. This will assure that the header information in the file is for points within the mechanical limits.



Select the “exp_cnc” command. Type in the name you want the file called in the file window. Select the machine type. Click on the “ok” button. The cnc file you have just created will appear in the “imp_cnc” file menu.

To view the code list that has been generated, select the “editcnc” command. Select the file in the scroll menu and click the “ok” button.



```
9 G01 F100.1
10 X1.0000 Y1.0000
11 X3.1250 Y1.0000
12 X3.1250 Y3.1250
13 X1.0000 Y3.1250
14 G00 Z0.1000 F30.0
15 G00 F100.1
```

```
EXIT SAVE EDIT CNC
0 (SuperCam Ver 3.1Q 10/20/99 SPINDLE
1 G17
2 T1 M06
3
4 M03
5 G00 F100.1
6 X1.0000 Y3.1250
7 G00 Z0.1000 F30.0
8 G01 Z0.1250 F30.0
9 G01 F100.1
10 X1.0000 Y1.0000
11 X3.1250 Y1.0000
12 X3.1250 Y3.1250
13 X1.0000 Y3.1250
14 G00 Z0.1000 F30.0
15 G00 F100.1
16 M04
17 M30
18 (End of CNC Program)
19
```

The “editcnc” command enables direct line revision of the cnc file. Use the mouse to activate the cursor. Backspace to erase and then type the new value. Click the “save” button to record the revision. You can create cnc files from scratch using the cnc editor screen if you want. Simply start with a blank screen in SuperCam, bring up the “exp_cnc” screen and give the file a name. Then you can write the list of machine moves the old fashioned way.

```
0 G0.1
1 Y1.
2 Y1.0000
3 Y3.1250
4 Y3.1250
5 .1000 F30.0
```