

TB113 (Rev1) - Skip Original Part When Rotating in Intercon

Overview

This document describes the way to cut a rotated entity (pocket, bolt hole circle, frame, etc.) without performing the original.

Skip Copy #0

To skip the original part in Intercon do the following:

1. Insert a blank line in front of the entity you wish to skip.
2. Press "Other" Button
3. Press "Code" Button
4. Type the letter O, a space, then a number between 9100-9999. *
5. Insert a blank line after the entity that you're skipping.
6. Press "Other" Button
7. Press "Code" Button
8. Type M99 **

This has created a subprogram out of the code between the two added lines.

The lines to use in the rotate are the lines between the two added G-code lines. Do not include the G-code lines in the rotate.

This program WILL generate the G-code for the original entity but, because the subprogram is never called, it will not cut or graph it in G-code back plot. ***If you graph this program in Intercon it will display the entity to be skipped.***

Example:

Operation End Position

Type X Y Z

0010 Header 0.0000 0.0000 Home

0020 M&G Code 0.0000 0.0000 Home (example of G-code: O 9101) *

0030 Frame -0.9000 1.0000 0.1000

0040 M&G Code -0.9000 1.0000 0.1000 (example of G-code: M99) **

0050 Rotate -0.9000 1.0000 0.1000

0060 End Prog -0.9000 1.0000 Home

The line to rotate would be line 0030. **Do not** rotate 0020 to 0040.

Document History

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