

# TB159 (Rev1) - Skip First Copy in Intercon

## Overview

This document describes how to skip the first copy of a Repeat or Rotate operation in Intercon.

## Background

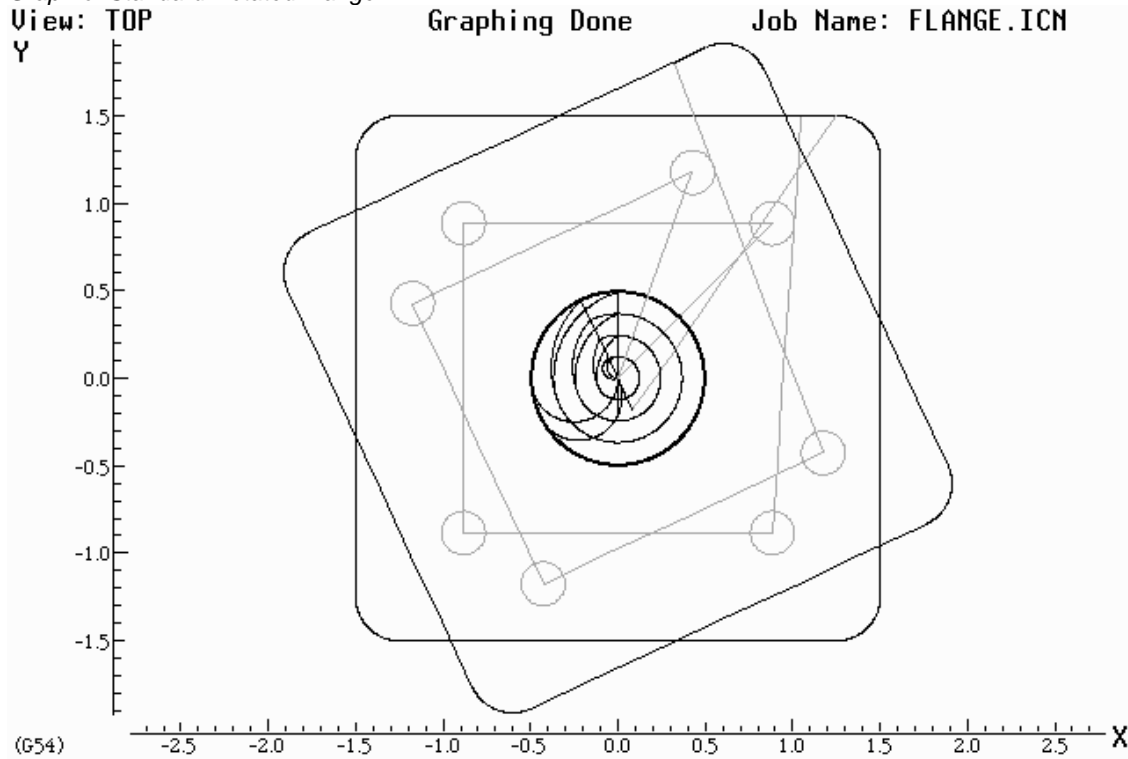
The standard Rotate, Repeat, and Mirror operations in Intercon do not have a "Skip First Copy" option in the operation itself. An example is the flange program shown below.

*Standard Rotated Flange Program*

Operation #	Type	X	End Y	Z
0010	:Rotated Flange			
0020	Tool #1	0.0000	0.0000	Home
0030	Circ Poc	0.0000	0.0000	0.1000
0040	Drill BHC	0.8839	-0.8839	0.1000
0050	Frame	1.2500	1.5000	0.1000
0060	Rotate	0.4990	1.8877	0.1000
0070	End Prog	0.4990	1.8877	Home

This program produces a part that looks like this:

*Graph of Standard Rotated Flange:*



## Procedure

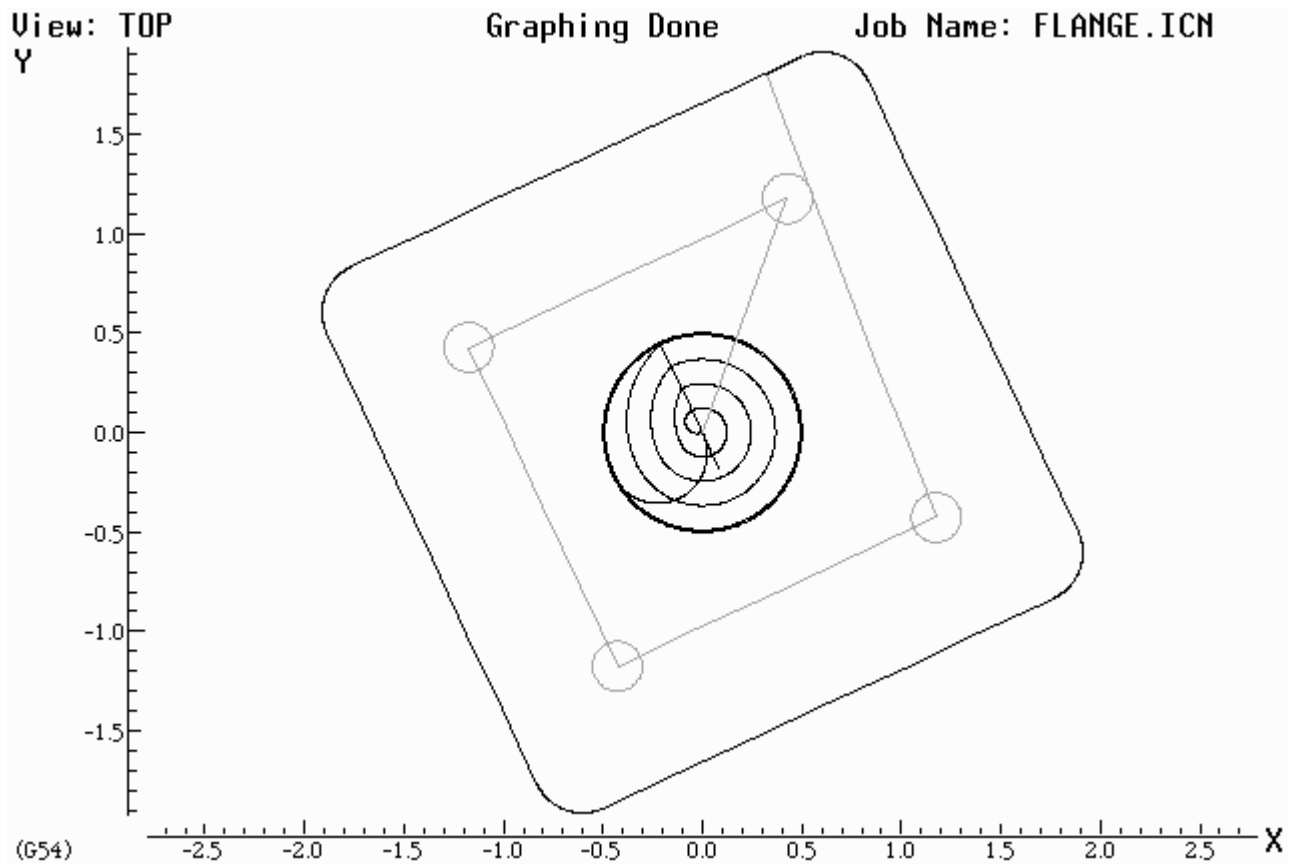
To skip the first copy of a part in a Repeat, Mirror or Rotate, insert a "GOTO" before the first copy. The destination of the GOTO must be the Repeat, Rotate or Mirror operation itself. In this example, we insert the GOTO at line 50, as shown below. The rapid at line 40 makes sure that the height offset is posted before the code for the first copy. The GOTO forces a branch around the first copy so that it never executes.

Standard Rotated Flange Program:

Operation #	Type	X	End Y	Z	N0050 M & G Codes
0010	;Rotated Flange - Skip 1st				GOTO 90; Skip first copy
0020	Tool #1	0.0000	0.0000	Home	Warning: Any M & G codes entered here will be unrecognized by Intercon.
0030	;Make sure offset is posted				Careful consideration must be taken before using this function.
0040	Rapid	0.0000	0.0000	0.1000	
0050	GOTO 90; Skip first copy				
0060	Circ Poc	0.0000	0.0000	0.1000	
0070	Drill BHC	0.8839	-0.8839	0.1000	
0080	Frame	1.2500	1.5000	0.1000	
0090	Rotate	0.4990	1.8877	0.1000	
0100	End Prog	0.4990	1.8877	Home	

This program produces a part that looks like this:

Graph of Rotated Flange with First Copy Skipped:



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**Document History**

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