G-Code Compiler

The Techno G-Code Compiler accepts industry standard G-Code programs and translates them into a form compatible with the Techno series of electronics. The software features:

- 2-axis circular interpolation
- Up to 8-axis linear interpolation
- Incremental and absolute positioning
- Canned cycles
- Peck drilling
- M-Codes to turn outputs on and off
- Input sensing and decision making with branching
- Looping
- The servo version also features continuous motion capability

The software package includes:

- A **built-in text editor** to assist in writing programs
- **Compiler** with built-in debugger
- **Jogging**
- **DNC capabilities** for running unlimited length code, such as from CAM programs

SUMMARY OF COMMANDS

G-Code	Function
G0	Rapid traverse
G1	Linear interpolation (feed function)
G2	Circular interpolation, clockwise
G3	Circular interpolation, counterclockwise
G4	Dwell
G10	Home Axis
G46	Backlash compensation
G90	Absolute programming
G91	Incremental programming
G92	Preset zero point
G99	Set acceleration / deceleration
Miscellaneous	**Function**
M02/M2	Program End
=N_/_	Loop Command, Repetitive Programming
M91/M90	Output ON / Output OFF
IFBIT N=S,L	Conditional Branching

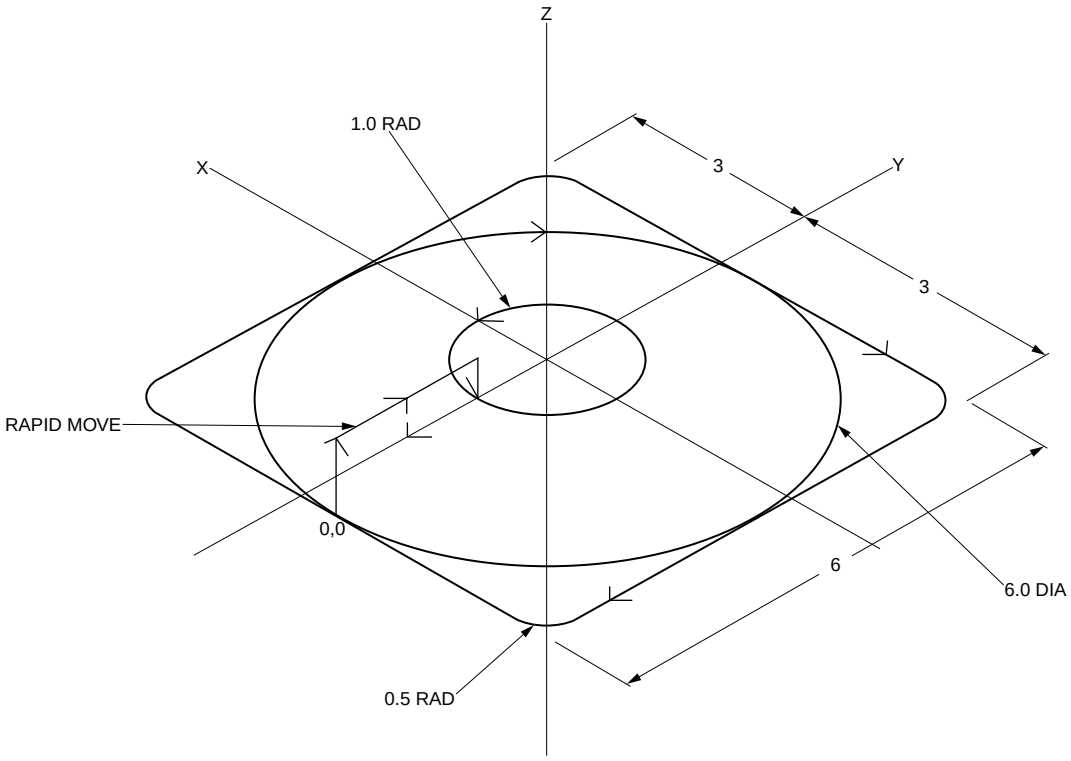
G - CODE COMPILER SOFTWARE

Catalog Number	Description
H22T59-GCODE-M	MAC Controller Version
H22T59-GCODE-C	"C" Controller Version
H22T59-GCODE-S	Servo Version

A complete G-CODE machining center consists of:

- G-Code Compiler software package
- An IBM/AT or compatible computer
- Any Series III, 3-axes Gantry or equivalent X, XY or XYZ system
- Techno Controller

SAMPLE OF G-CODE COMPILER



;EXAMPLE1.GCD FOR TECHNO G-CODE COMPILER
;UNITS BASED ON SCALE FACTOR SETTING
;HOME X,Y,Z AXES AT THE TABLE SPEED OF 4 IN/SEC
L01G10Z1F4
G10X4
G10Y2
G92X0Y0Z0 ;SET REFERENCE POINT 0,0
G90 ;SET ABSOLUTE INPUT MODE
G01Z0.5F1 ;ROUTE A BOX WITH FILLET RADIUS 0.5" AT THE FEED RATE OF 1"/SEC
G01X2.5
G03X3Y0.5R0.5
G01X3Y5.5
G03X2.5Y6R0.5
G01X-2.5Y6
G03X-3Y5.5R0.5
G01X-3Y0.5
G03X-2.5Y0R0.5
G01X0Y0
G04/4 ;DELAY 4 SEC
G02X0Y0I0J3F2 ;ROUTE A CLOCKWISE CIRCLE, R = 3"
G00X0Y2Z-1 ;FAST POSITIONING TO (0,2,-1)
G01Z0.5F0.5
G03X0Y2I0J3F2 ;ROUTE A COUNTERCLOCKWISE CIRCLE, R = 1"
M02 ;END OF PROGRAM