

7 GCODE EXAMPLES

EXAMPLE 1: TRIANGLE

The following example, triangle.g, is included with the Mx4 GCode Developer installation. This example includes cutter compensation. Fig. 7-1 illustrates the example loaded into the development tool.

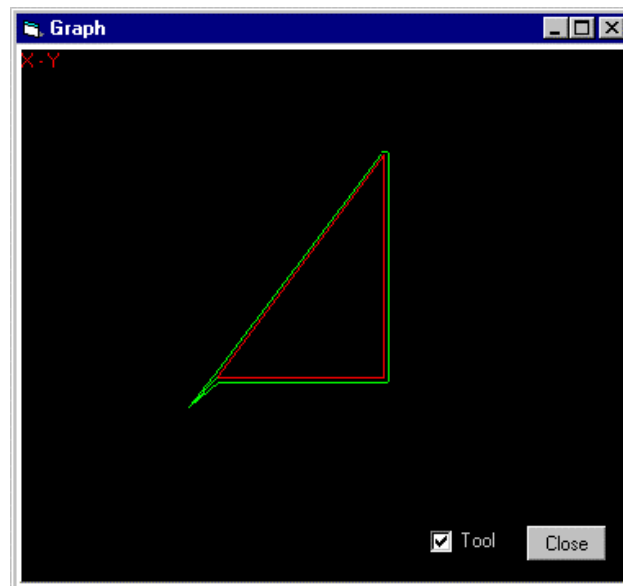


Fig. 7-1: Example 1, Triangle Graph

GCode Examples

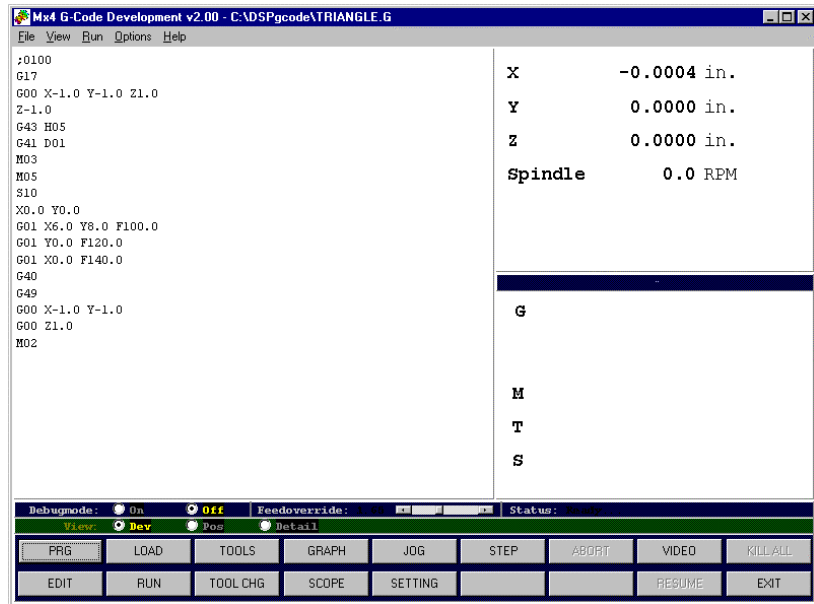


Fig. 7-2: Example 1, Triangle

```
O100
G17
G00 X-1.0 Y-1.0 Z1.0
Z-1.0
G43 H05
G41 D01
M03
M05
S10
X0.0 Y0.0
G01 X6.0 Y8.0 F100.0
G01 Y0.0 F120.0
G01 X0.0 F140.0
G40
G49
G00 X-1.0 Y-1.0
G00 Z1.0
M02
```

EXAMPLE 2: BRACKET

The bracket example, bracket.g, utilizes circular moves (G02, G03). Fig. 7-4 illustrates the example loaded into the development tool.

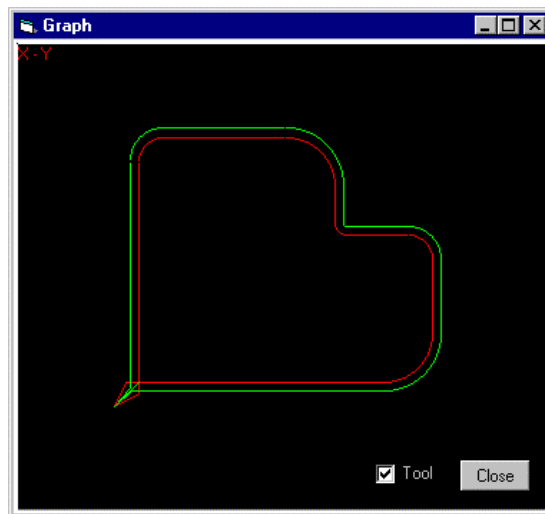


Fig. 7-3: Example 2, Bracket Graph

GCode Examples

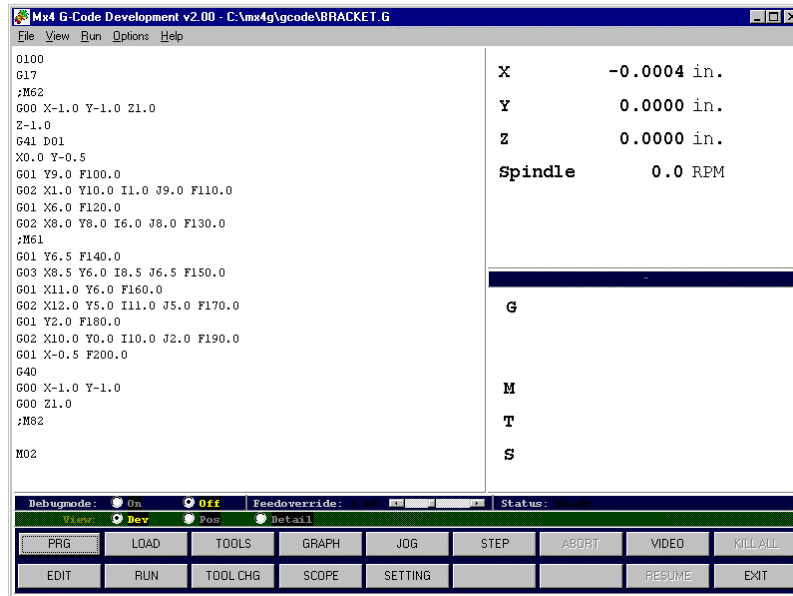


Fig. 7-4: Example 2, Bracket

```
0100
G17
G00 X-1.0 Y-1.0 Z1.0
Z-1.0
G41 D01
X0.0 Y-0.5
G01 Y9.0 F100.0
G02 X1.0 Y10.0 I1.0 J9.0 F110.0
G01 X6.0 F120.0
G02 X8.0 Y8.0 I6.0 J8.0 F130.0
;M61
G01 Y6.5 F140.0
G03 X8.5 Y6.0 I8.5 J6.5 F150.0
G01 X11.0 Y6.0 F160.0
G02 X12.0 Y5.0 I11.0 J5.0 F170.0
G01 Y2.0 F180.0
G02 X10.0 Y0.0 I10.0 J2.0 F190.0
G01 X-0.5 F200.0
G40
G00 X-1.0 Y-1.0
G00 Z1.0
;M62
M02
```

EXAMPLE 3: A-SHAPE

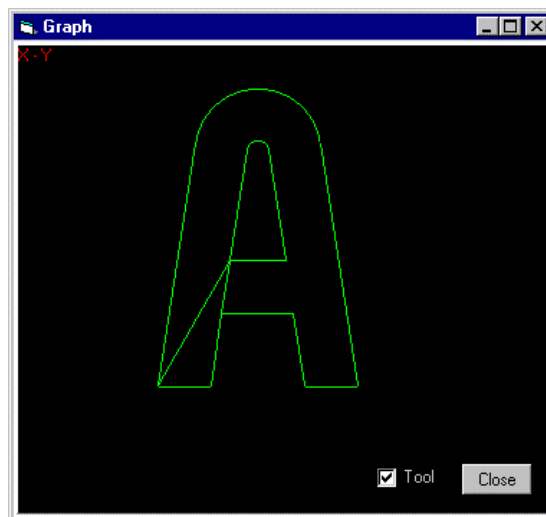


Fig. 7-5: Example 3, A-Shape Graph

GCode Examples

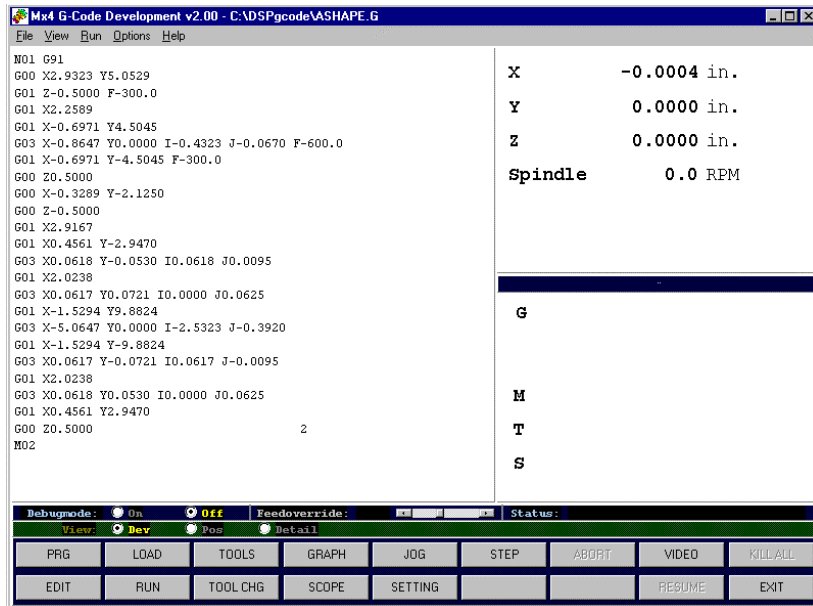


Fig. 7-6: Example 3, A-Shape

```

N01 G91
G00 X2.9323 Y5.0529
G01 Z-0.5000 F-300.0
G01 X2.2589
G01 X-0.6971 Y4.5045
G03 X-0.8647 Y0.0000 I-0.4323 J-0.0670 F-600.0
G01 X-0.6971 Y-4.5045 F-300.0
G00 Z0.5000
G00 X-0.3289 Y-2.1250
G00 Z-0.5000
G01 X2.9167
G01 X0.4561 Y-2.9470
G03 X0.0618 Y-0.0530 I0.0618 J0.0095
G01 X2.0238
G03 X0.0617 Y0.0721 I0.0000 J0.0625
G01 X-1.5294 Y9.8824
G03 X-5.0647 Y0.0000 I-2.5323 J-0.3920
G01 X-1.5294 Y-9.8824
G03 X0.0617 Y-0.0721 I0.0617 J-0.0095
G01 X2.0238
G03 X0.0618 Y0.0530 I0.0000 J0.0625
G01 X0.4561 Y2.9470
G00 Z0.5000
M02
    
```

M02