

# SuiteFactory™ DNC Editing Guide

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## ***Editing***

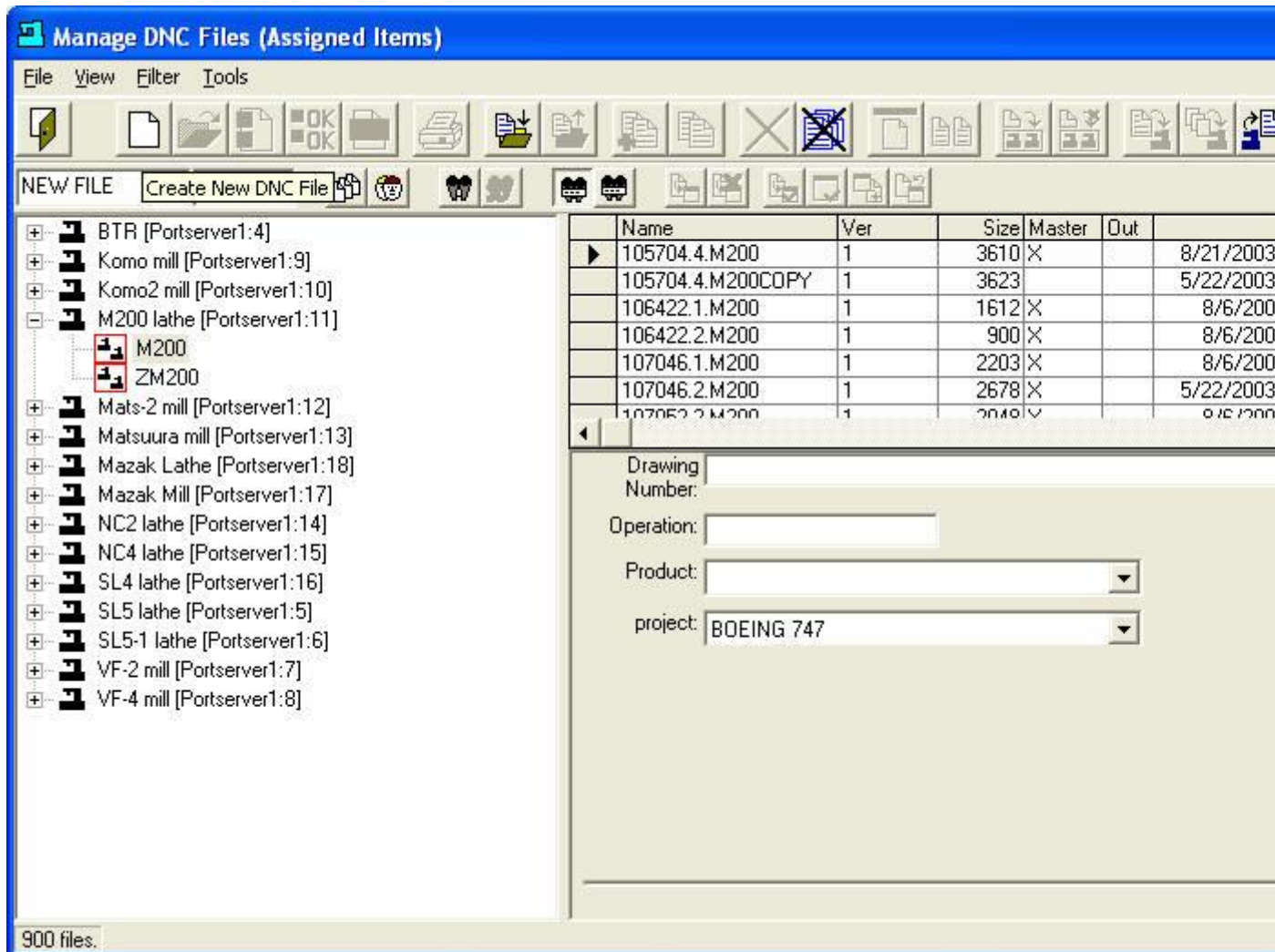
SuiteFactory provides several ways to edit/create a N/C File.

- Create a New File from Scratch
- Edited an Existing File and Save
- Edited an Existing File and Save as a New File

**Note:** You can also create a New File Versions from an Existing File by saving the edited file under a new version. As always your ability is "Rights" dependent.

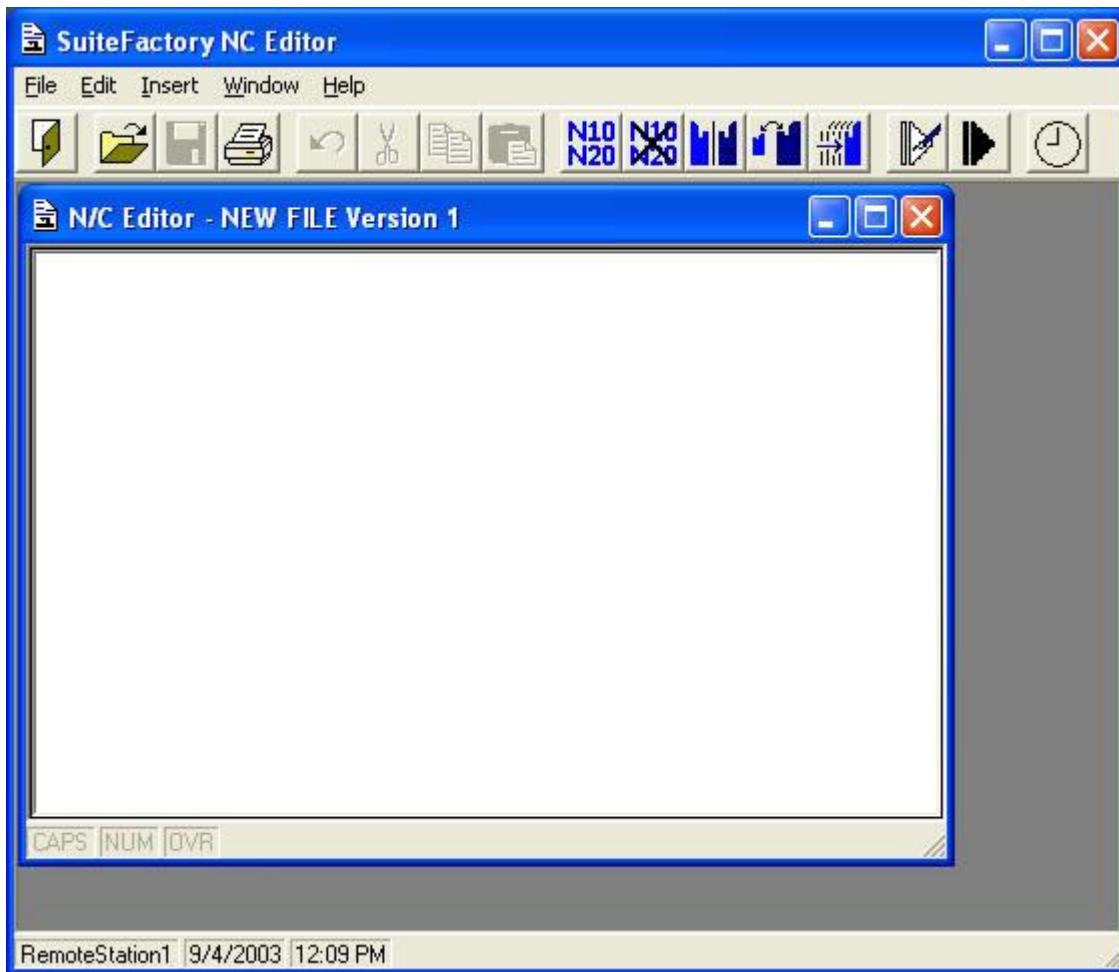
## New File

SuiteFactory allows you to create a New File by using it's "Editor" to open up any number of files allowing you to copy and paste from these files to the new file or just create it from scratch!



To create a New File select the view that best meets your needs and type the name of the New File in the text box above that has the name "New File" in it. You will notice that the Icon "Create New DNC File" becomes un-grayed. After entering the File Name you want and selecting the "Resource Collection" you want to assign it to, click on the "Create New DNC File" Icon to activate the Editor. The following Window will be displayed.

## Editor with Blank File



For Editor Operation see the section "Editor Operation".

When you have finished creating and saving the New File the following Window will be displayed.

**Note:** You will notice that the "New File" has now been added to SuiteFactory's database.

**Manage DNC Files (Assigned Items)**

File View Filter Tools

NEW FILE 1

Name	Ver	Size	Master	Out	
394301.1A.M200	1	2232	X		8/6/200
49296.1.M200	1	1962	X		8/6/200
49296.2.M200	1	1298	X		8/6/200
JACKROD.M200	1	590	X		8/6/200
NEW FILE	1	26			9/4/2003
PARAM.M200	1	1080	X		8/6/200

901 files.

Drawing Number:

Operation:

Product:

project:

At this stage you should enter the information in the data fields for later use in controlling access to this particular N/C File.

## Edit Existing file

SuiteFactory allows you to create a New File by using it's "Editor" to open up any number of files so you can copy and paste or just edit the file contents!

**Note:** This is one of many relationship views that you can configure. If you would like to modify this view click on the "Change View" Icon and select the options that best suite your needs.

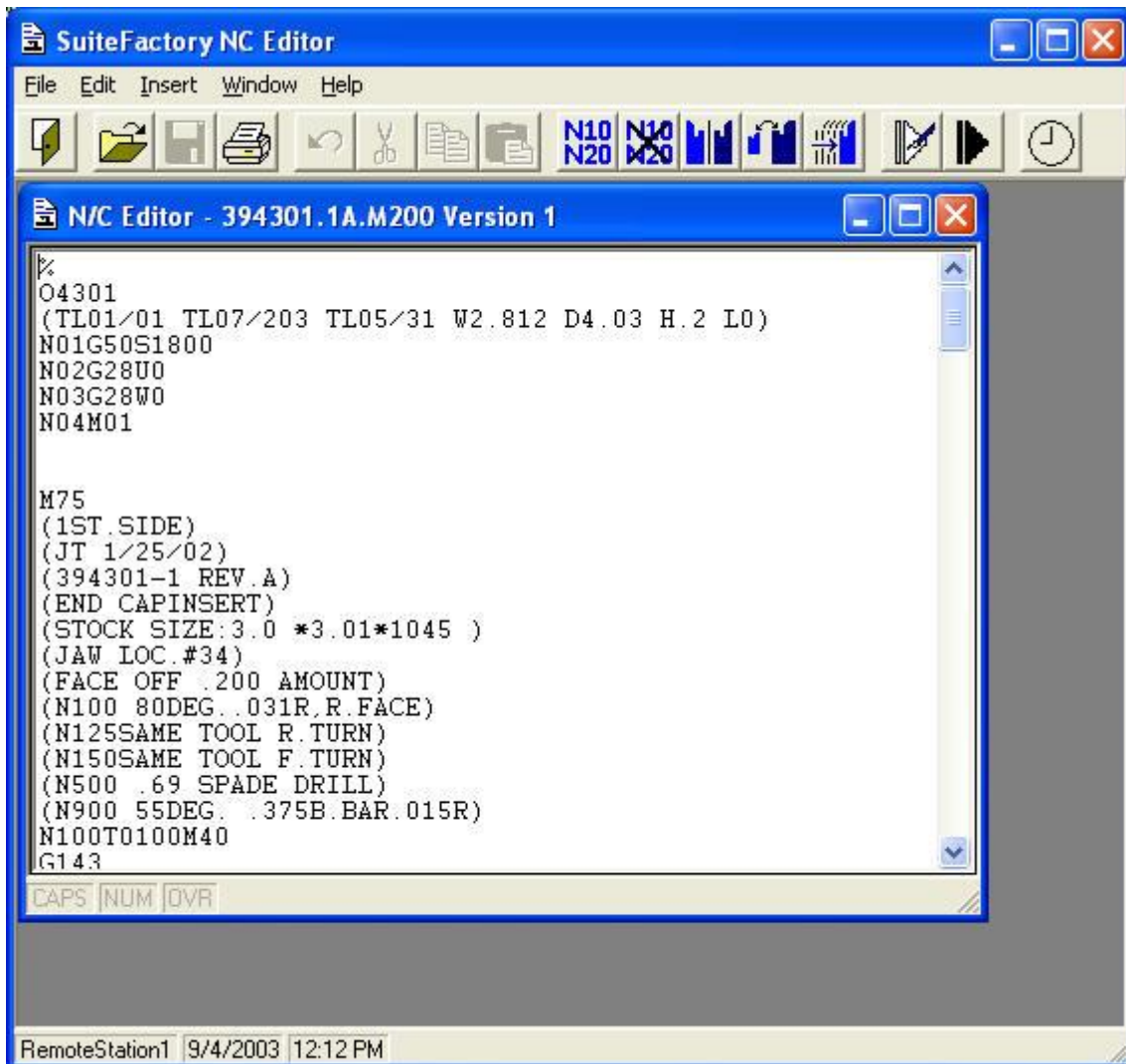
Name	Ver	Size	Master	Out
394301.1A.M200	1	2232	X	8/6/2003
49296.1.M200	1	1962	X	8/6/2003
49296.2.M200	1	1298	X	8/6/2003
JACKROD.M200	1	590	X	8/6/2003
NEW FILE	1	26		9/4/2003
PARAM.M200	1	1080	X	8/6/2003

901 files.

To Edit an existing File select the view that best meets your needs and select the File by highlighting it.

You will notice that the Icon "Edit Existing DNC File" becomes un-grayed. Click on this Icon to activate the Editor. The following Window will be displayed.

## Edit Existing File



For Editor Operation see the section "Editor Operation".

After saving the selected File the following Window will be displayed. You will notice that the "394301.1AmM200\_Modified" has now been added to SuiteFactory's database.



## Updated Manage DNC Files Window

The screenshot shows the 'Manage DNC Files (Assigned Items)' window. The left pane displays a tree view of files, with '394301.1A.M200\_1' selected. The right pane shows a table of file details:

Name	Ver	Size	Master	Out
394301.1A.M200	1	2232	X	
<b>394301.1A.M200_MODIFIED</b>	<b>1</b>	<b>2244</b>		
49296.1.M200	1	1962	X	
49296.2.M200	1	1298	X	
JACKROD.M200	1	590	X	
NEW FILE	1	26		
DADAM.M200	1	1100		

Below the table, there are input fields for:

- Drawing Number:
- Operation:
- Product:
- project:

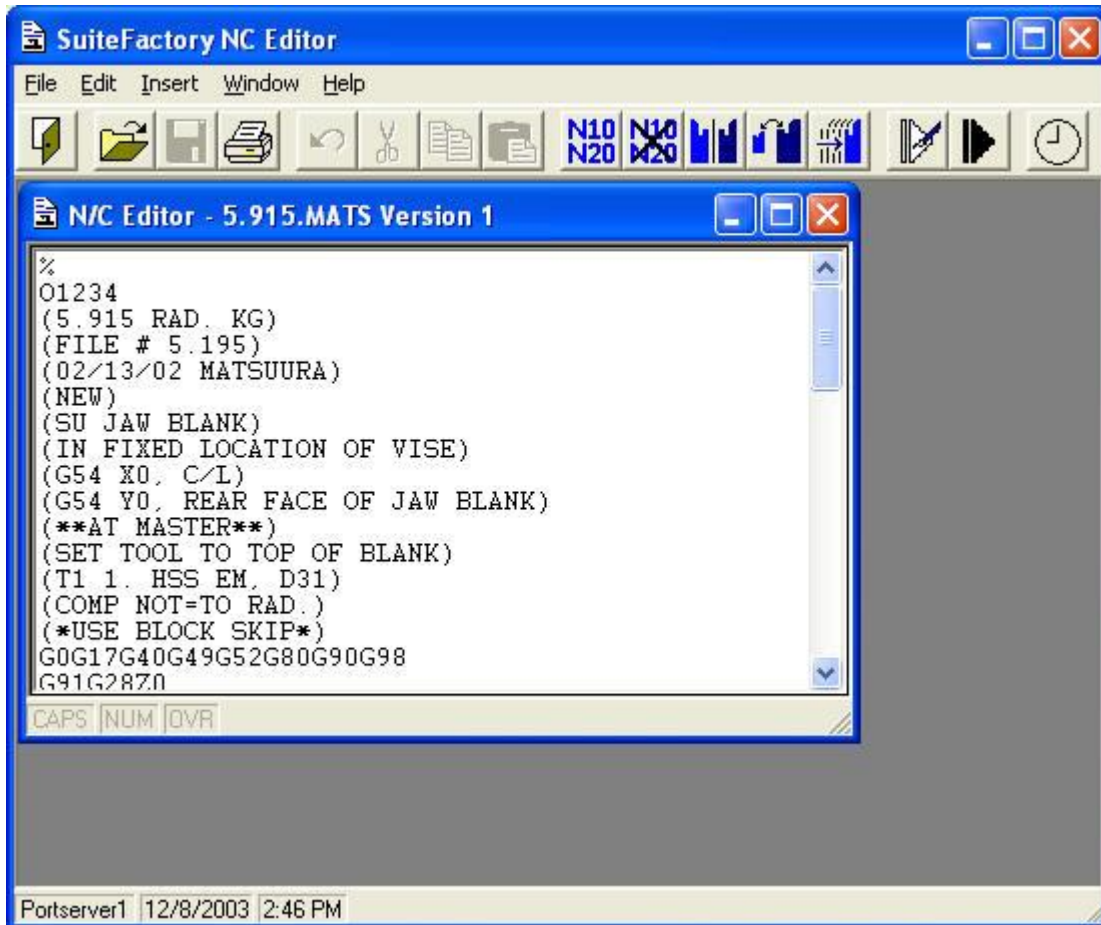
The status bar at the bottom indicates '902 files.'

At this stage you should enter/modify the information in the data fields for later use in controlling access to this particular N/C File.

## Editor Operation

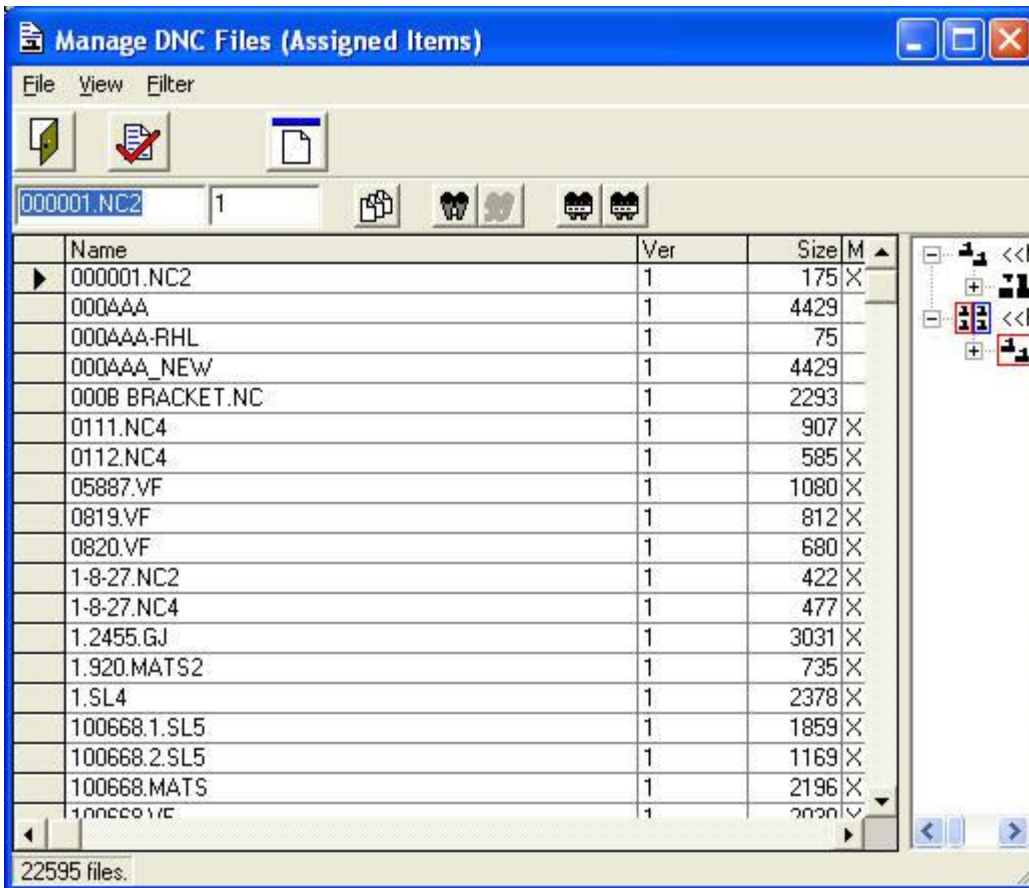
SuiteFactory's N/C Editor is a multi-file editor. You can open up as many files as needed to copy & paste from one file to another.

### Open Primary File



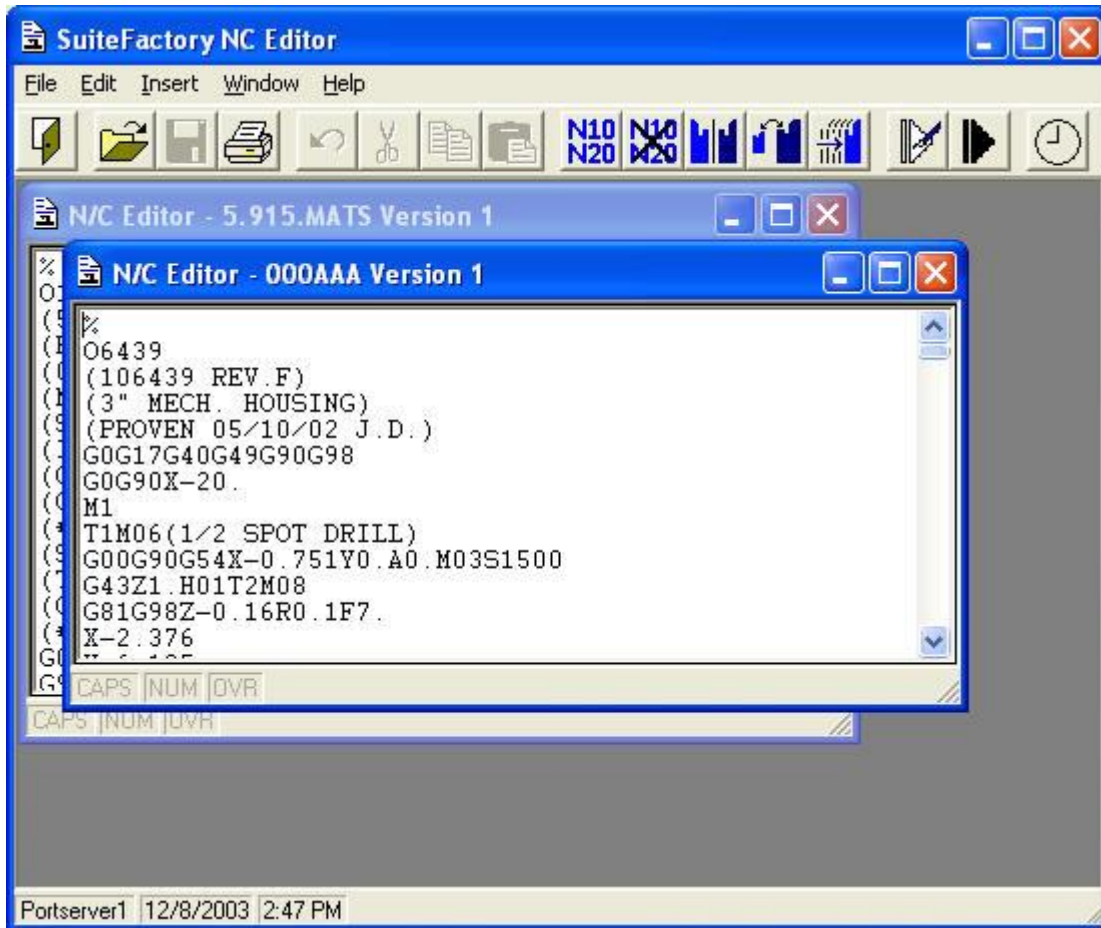
### Open Additional Files

To open an addition file(s) click on the Open Icon and the following Window will be displayed.



Chose the file you want to add to the multi-file Editor and click on the Select Icon and the Editor will be redisplayed with the two files displayed as follows.

## Editor with multiple files opened



### Undo Button

Clicking the "Undo" button undoes the last operation.

### Cut Button

Clicking the "Cut" button cuts the highlighted area and places it into the Clip Board for pasting.

### Copy Button

Clicking the "Copy" button pastes the highlighted area into the Clip Board for pasting but doesn't cut it out of the file.

### Paste Button

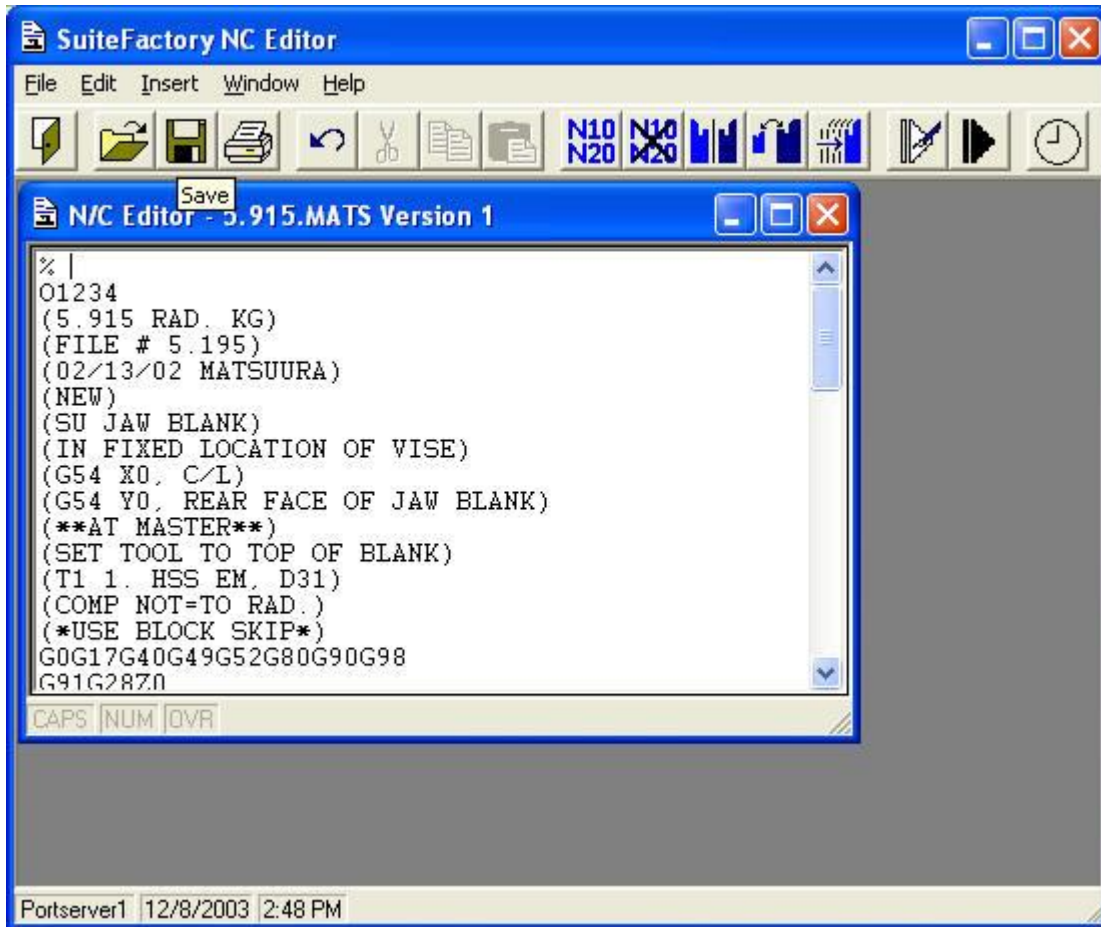
Clicking the "Paste" button will paste whatever is in the Clip Board at the position of the cursor in the N/C File. **Note:** ONLY Paste Text!

### Insert Date and Time

Clicking the "insert Date and Time" button will add the current Date and Time at the position of the cursor. Normally you would place this at the very beginning of the file.

The format can be changed by going to the Insert Menu on the Tool Bar and selecting the format of your choice.

## Save



To save all the changes, click the "Save" Icon.

## Sequencing

### Resequence

Clicking the "Resequence" button will bring up the following Window.

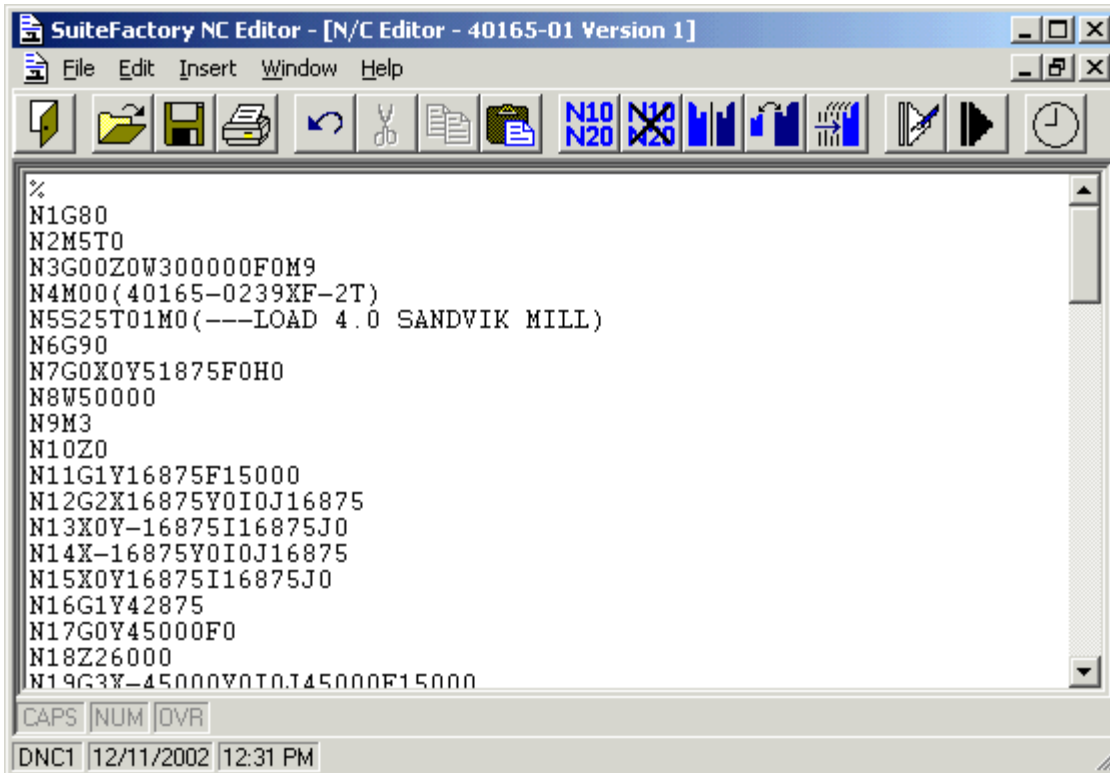
The screenshot shows a dialog box titled "Resequence" with the following fields and options:

- Resequence Data:**
  - Increment: 1
  - Lowest: 1
  - Highest: 9999
- Sequencing Mode:**
  - Sequence All Lines
  - Resequence Only
  - Sequence Comments
- Start from:**
  - Beginning of file
  - Current cursor position
- Continue to:**
  - End of file
  - Matching pattern
  - Pattern to match: [Empty text box]
- Current Resequence Format:** Resequence Always Decimal
- New Resequence Format:** Display value 10 as "10".
- Suppress Leading Zeros
- Total Width: 4
- Buttons: OK, Cancel

You can set the various options for renumbering and or adding program numbers to your N/C File as shown above.

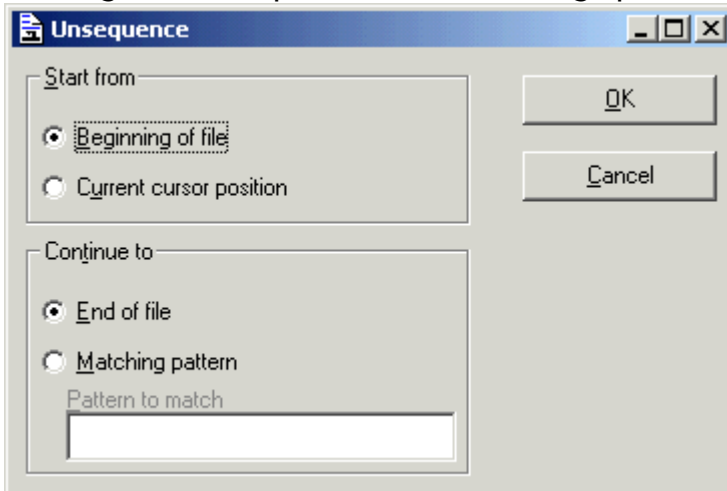
Using the above settings and clicking the "OK" button the selected file will be updated to look as follows:

## Editor with N/C File Resequenced



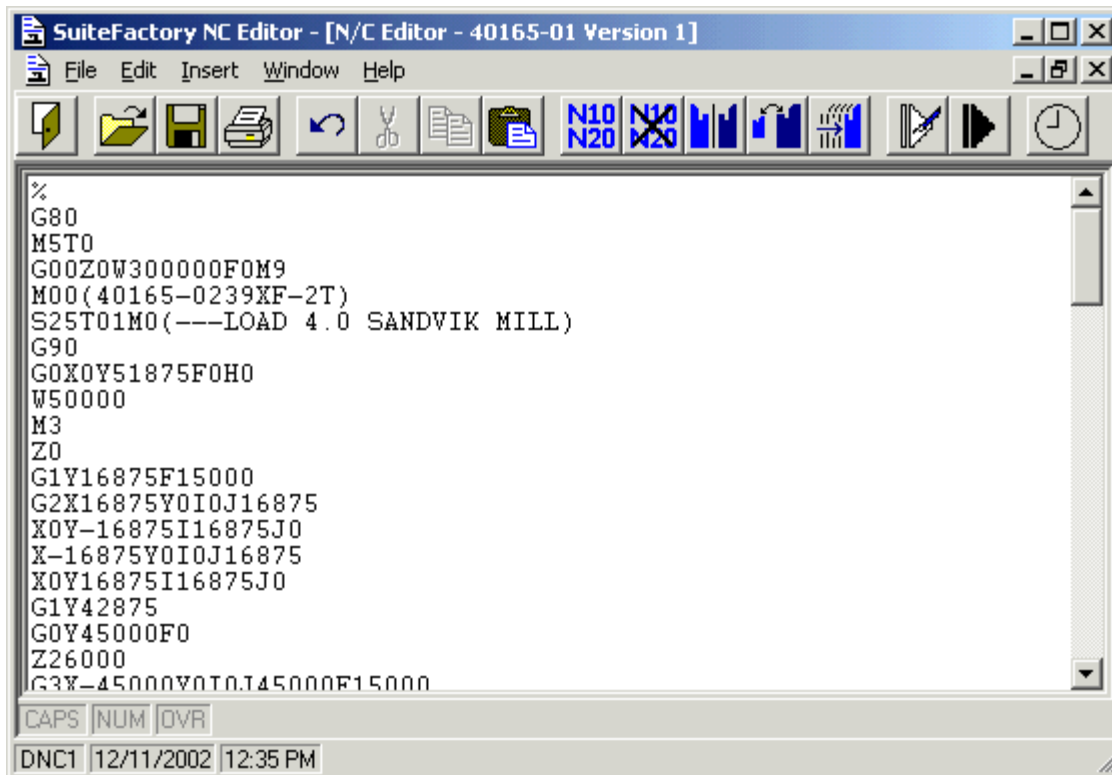
## Unsequence

Clicking the "Unsequence" Icon will bring up the following Window.



Using the above settings and clicking the "OK" button the selected file will be updated to look as follows:

## Editor with Unsequenced N/C File



The screenshot shows the SuiteFactory NC Editor interface. The title bar reads "SuiteFactory NC Editor - [N/C Editor - 40165-01 Version 1]". The menu bar includes "File", "Edit", "Insert", "Window", and "Help". The toolbar contains various icons for file operations (open, save, print), editing (undo, redo, copy, paste), and simulation (N10, N20, bar charts, play, stop, clock). The main text area contains the following G-code:

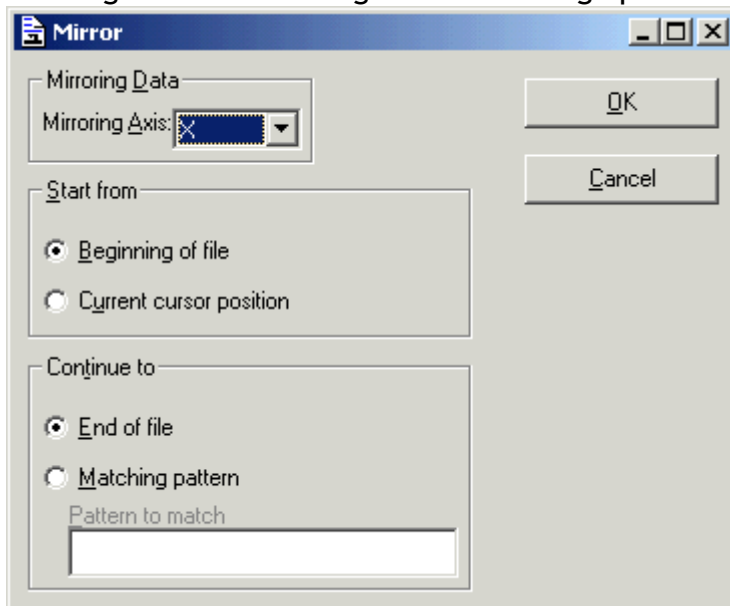
```
%  
G80  
M5T0  
G00Z0W3000000F0M9  
M00(40165-0239XF-2T)  
S25T01M0(---LOAD 4.0 SANDVIK MILL)  
G90  
G0X0Y51875F0H0  
W50000  
M3  
Z0  
G1Y16875F15000  
G2X16875Y0I0J16875  
X0Y-16875I16875J0  
X-16875Y0I0J16875  
X0Y16875I16875J0  
G1Y42875  
G0Y45000F0  
Z26000  
G3X-45000Y0T0I45000F15000
```

At the bottom, there are control buttons for "CAPS", "NUM", and "OVR", and a status bar showing "DNC1 | 12/11/2002 | 12:35 PM".



## ***Mirroring***

Clicking on the "Mirroring" Icon will bring up the following Window.



Mirroring will take the selected Axis and reverse all of the signs.

## Scaling

Clicking on the "Scale" button will display the following Window.

The screenshot shows a dialog box titled "Scale" with the following sections and controls:

- Scaling Data:**
  - Scaling Axis: A dropdown menu with a blue selection.
  - Factor: A text input field containing the value "1".
- Start from:**
  - Beginning of file
  - Current cursor position
- Continue to:**
  - End of file
  - Matching pattern
  - Pattern to match: An empty text input field.
- Current Scaling Format:**
  - Text area: Evaluate "-125" as -125 .
  - Decimal Programming
  - Trailing Zeros are Suppressed
  - Digits to Right of Decimal Point: 4
- New Scaling Format:**
  - Text area: Display value -1.25 as "-1.25".
  - Decimal Programming
  - Suppress Leading Zeros
  - Suppress Trailing Zeros
  - Digits to Left of Decimal Point: 2
  - Digits to Right of Decimal Point: 4

At the bottom of the dialog are two buttons: "OK" and "Cancel".

If you would like to scale the N/C Program you can select the Axis you are interested in scaling and select the various options before processing. Clicking the OK button. Repeat this for all Axis that apply.

## Translate

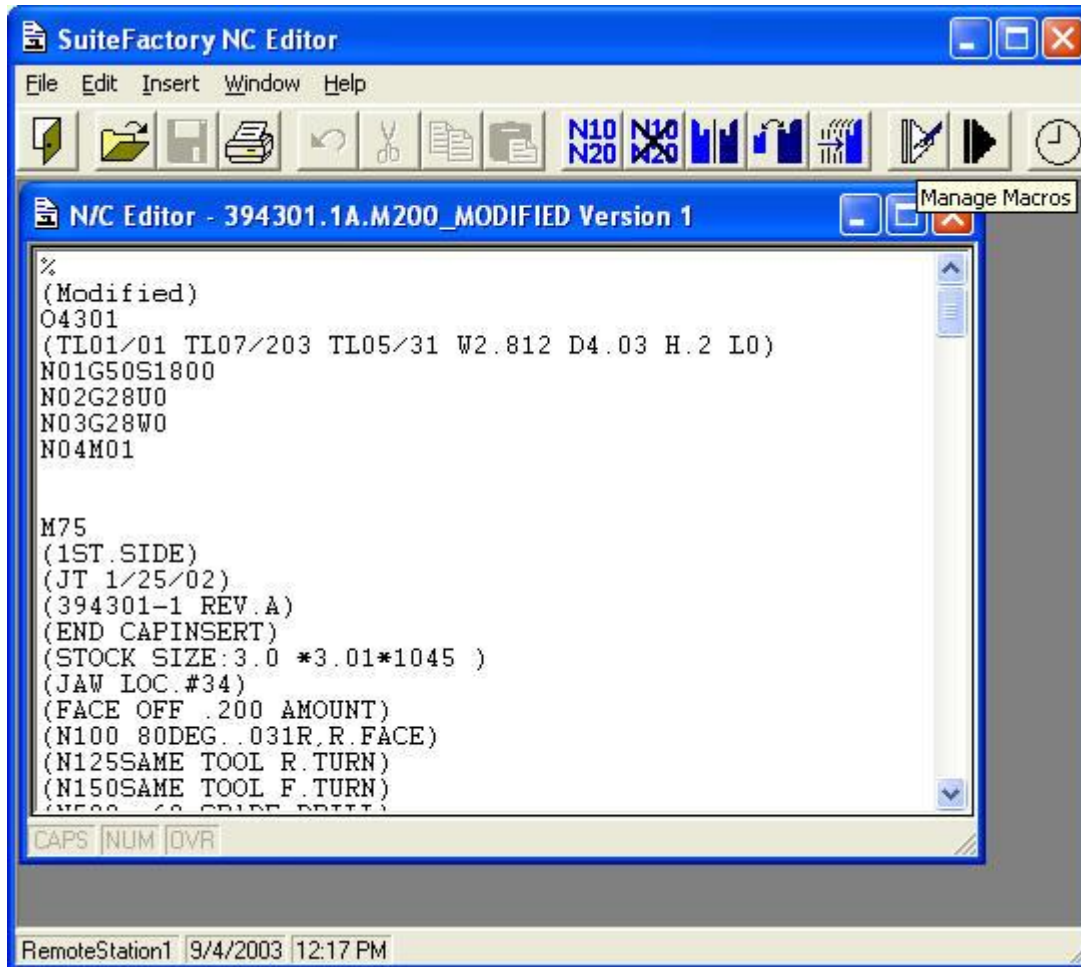
Clicking the "Translate" Icon will display the following Window.

The screenshot shows the 'Translate' dialog box with the following settings:

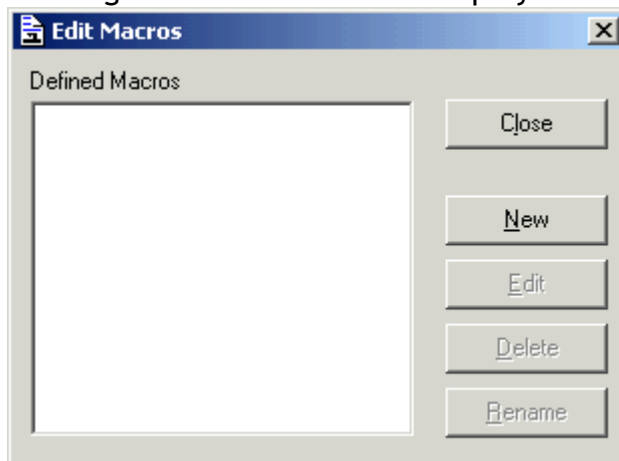
- Translation Data:** Translation Axis: X, Increment: 0
- Start from:** Beginning of file (selected)
- Continue to:** End of file (selected)
- Current Translation Format:** Evaluate "-125" as -125 ., Decimal Programming (checked), Trailing Zeros are Suppressed (unchecked), Digits to Right of Decimal Point: 4
- New Translation Format:** Display value -1.25 as "-1.25"., Decimal Programming (checked), Suppress Leading Zeros (checked), Suppress Trailing Zeros (checked), Digits to Left of Decimal Point: 2, Digits to Right of Decimal Point: 4

If you would like to translate the N/C Program you can select the Axis you are interested in translating and select the various options before processing. Click the OK button. Repeat this for all Axes that apply.

## Manage Macros



Clicking the "Macro" Icon will display the following Window.

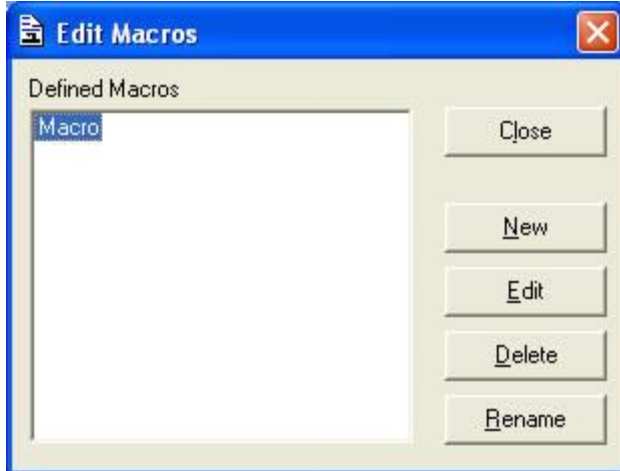


Macros allow you to perform multiple search and replace actions on any selected file. Macros could be used to modify files that were used on one controller and are being used on a new controller where direct substitution of elements of an N/C Program applies.

Since Macros support multiple search and substitute you can usually accomplish whatever structural changes you need.

## New

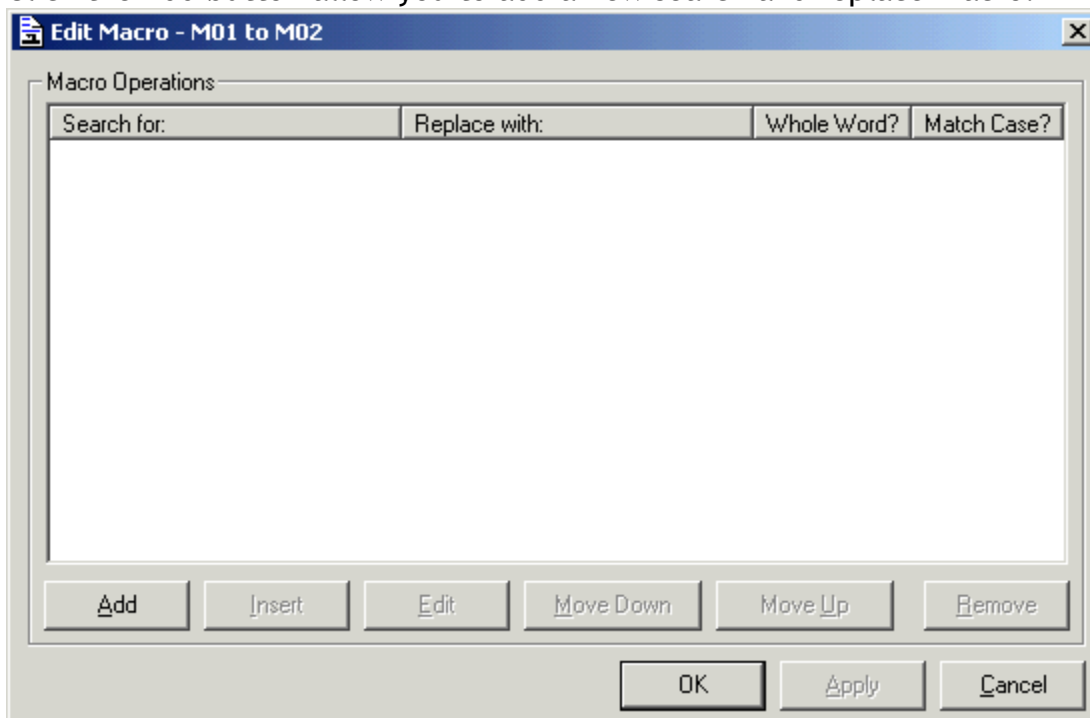
Clicking the "New" Icon will display the following Window.



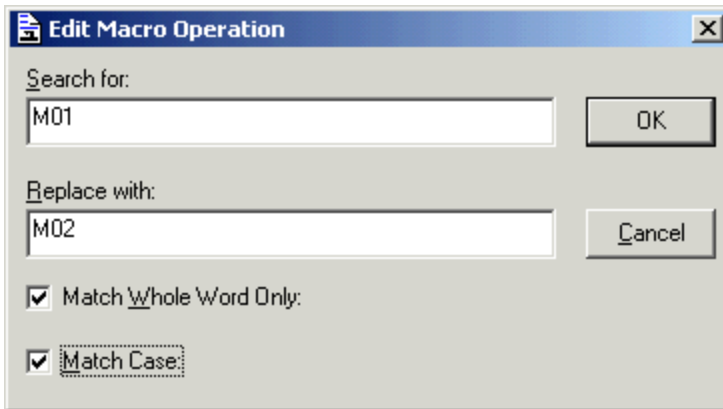
Naming the "Macro" with a meaningful name is important. Clicking the "OK" button displays the following Window.

## Add

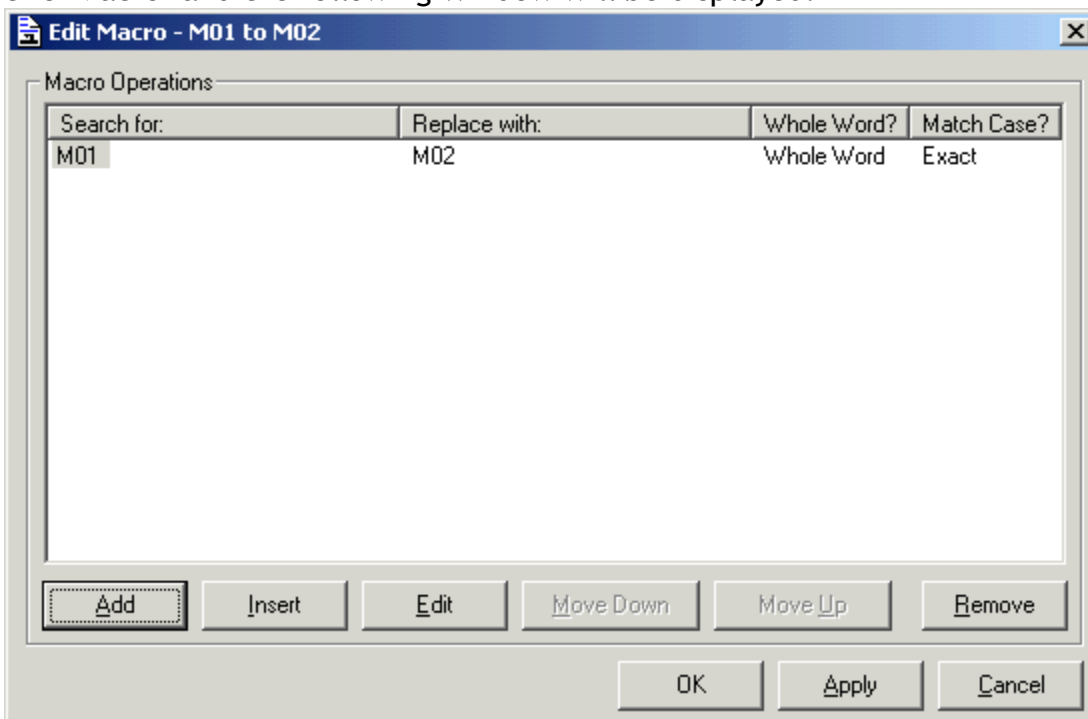
Click the Add button allow you to add a new search and replace macro.



Clicking the "Add" button displays the following Window.



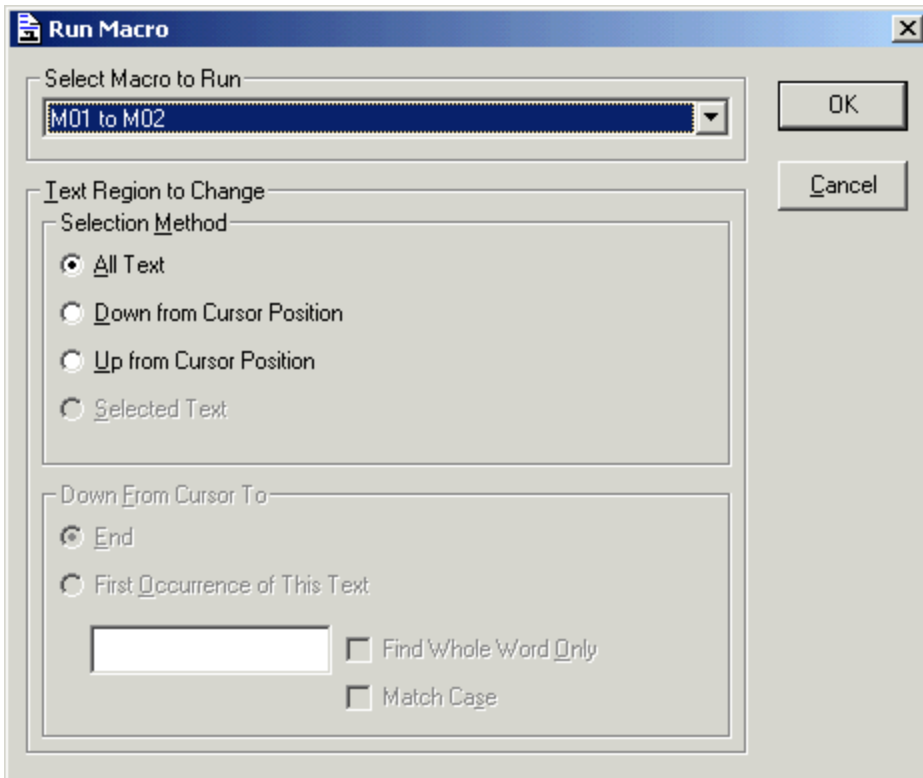
The above "Macro" will replace every occurrence of "M01" with "M02". Click "OK" to save this "Macro" and the following Window will be displayed.



Continue adding as needed and click the "Apply" button to save the sequence of "Macros".

## Run Macros

Clicking the "Run Macros" button displays the following Window.



Select the correct options and click OK or Cancel. If you click "OK" all occurrences of "M01" will be changed to "M02" for this Macro.