

Questo semplice tutorial mostra come scrivere testo, direttamente nelle operazioni di percorso utensile.

gcEditor v 0.9.9.2

File Edit Text Tools Help

C:\ProgramData\SimplyCam 3\gcode\test.nc

```
%
N1 (POST PROCESSOR: MACH2-3)
N2 (TEST.NC)
N3 G21 (UNITS: MM)
N4 G00 G17 G40 G49 G80 G90
N5 G64 (Constant Velocity Mo
N6 T1 M6 (TLDIA=2)
N7 G91.1 (IJ Incremental mod
N8 G00 X26.19 Y25.706 M03
N9 G43 H1 Z2.
N10 G01 Z-1. F50.0
N11 G01 X26.13 Y29.706 Z-1.
N12 X25.835
N13 X22.999 Y25.706
```

In 0 col 0

estimate machining time = 0h, 01m, 12s

10.371 mm

SNAP OFF

90°

Grid

Label

STOP

Green checkmark

Current layer: 0

Label1

New Open Vectorize Save Machining Settings Help Close Create point Line Endpoints Rectangle Circle Ct + Pt

Carica

Geometry Toolpath

Geometry

Open

Look in: samples

Name

LatheSampleRouFin.DXF
LatheSampleRouFin.SNC
LatheSampleRough.SNC
PIZZALED.JPG
SAMPLE_CONTOUR.DXF
Sample_ipad-base.DXF
SAMPLE_LABEL.JPG
SAMPLE_MULTI_OP.DXF
SAMPLE_POCKET.DXF
SAM
SAM
SAM
SAM

Scegliere "SAMPLE_LABEL.JPG"

File name: SAMPLE_LABEL.JPG

Files of type: Bitmap/Vector files (*.snc;*.bmp;*.jpg;*.dxf;*.stl)

Open

Cancel

X: -16.098 Y: -9.659

Open file (*.snc;*.dxf;*.stl;*.svg;*.bmp;*.jpg)

SNAP OFF

90°

[Grid Icon]

[Grid Icon]

[Grid Icon]

[Grid Icon]

[Grid Icon]

[Grid Icon]

[Grid Icon]

[Grid Icon]

[Grid Icon]

[Grid Icon]

[Grid Icon]

[Grid Icon]

[Grid Icon]

[Grid Icon]

[Grid Icon]

[Grid Icon]

[Grid Icon]

[Grid Icon]

Current layer: 0

Label1

3.157 mm

Open Jpg

Jpg info

- Image
 - Name: SAMPLE_LABEL.JPG
 - Width(px): 253
 - Height(px): 113
 - Bit/Plane: 24 bit
 - Dpi: 72
 - Layer: 0

Scale to:

Width(X): 100 mm

Height(Y): 44.54 mm

Thickness:

Keep ratio

Reference system:

Select Pt.

Reference point X: 0

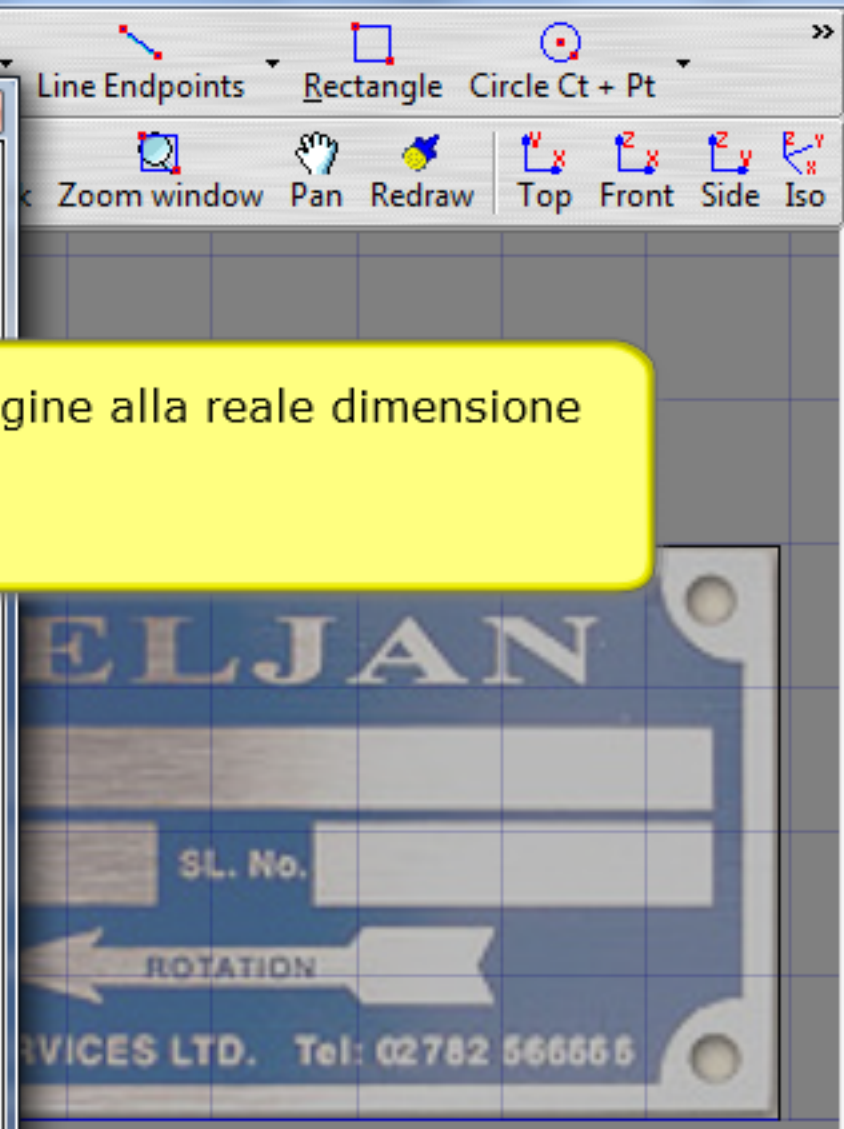
Reference point Y: 0

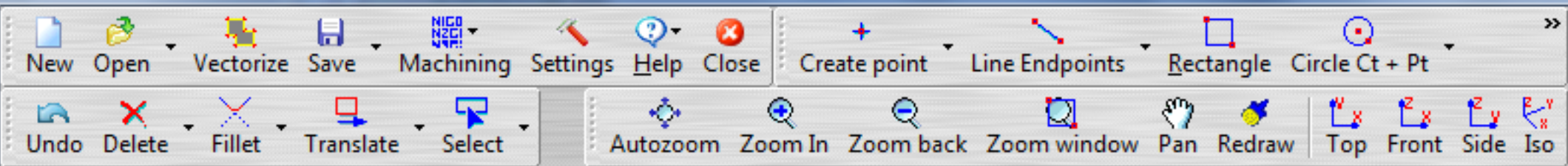
Reference point Z: 0

Autozoom

Apply Done

Scalare l'immagine alla reale dimensione
Inserire 100





Geometry Toolpath

- Geometry
 - Layer:Layer_0
 - Bitmap

Click sulla entità Bitmap



Bitmap:

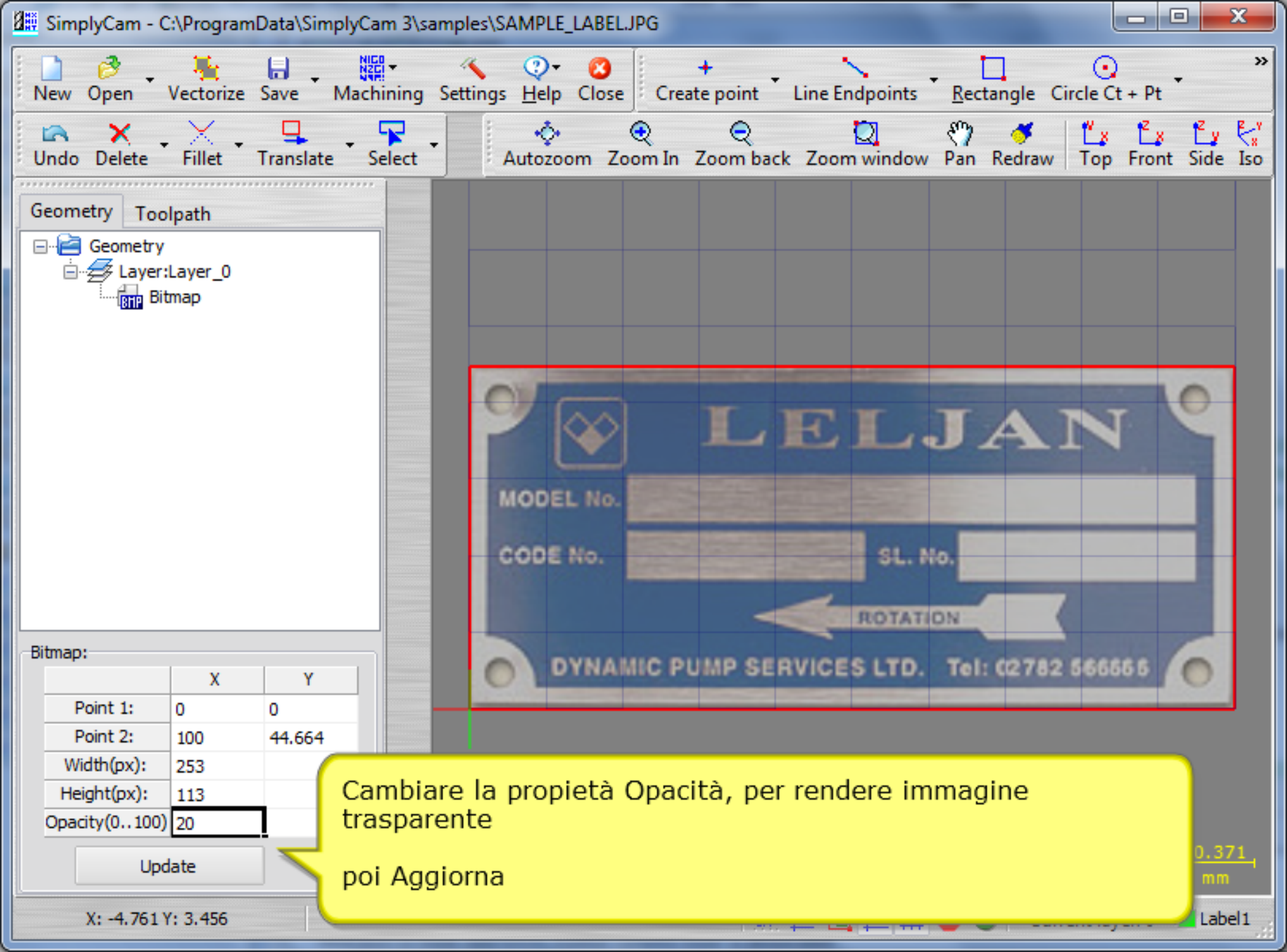
	X	Y
Point 1:	0	0
Point 2:	100	44.664
Width(px):	253	
Height(px):	113	
Opacity(0..100)	50	

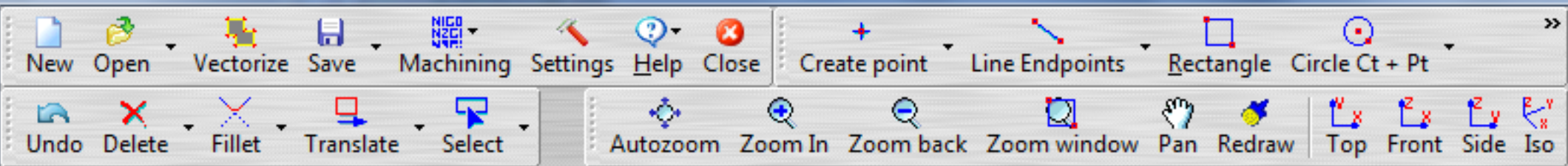
Update



10.371 mm

X: -4.761 Y: 3.456





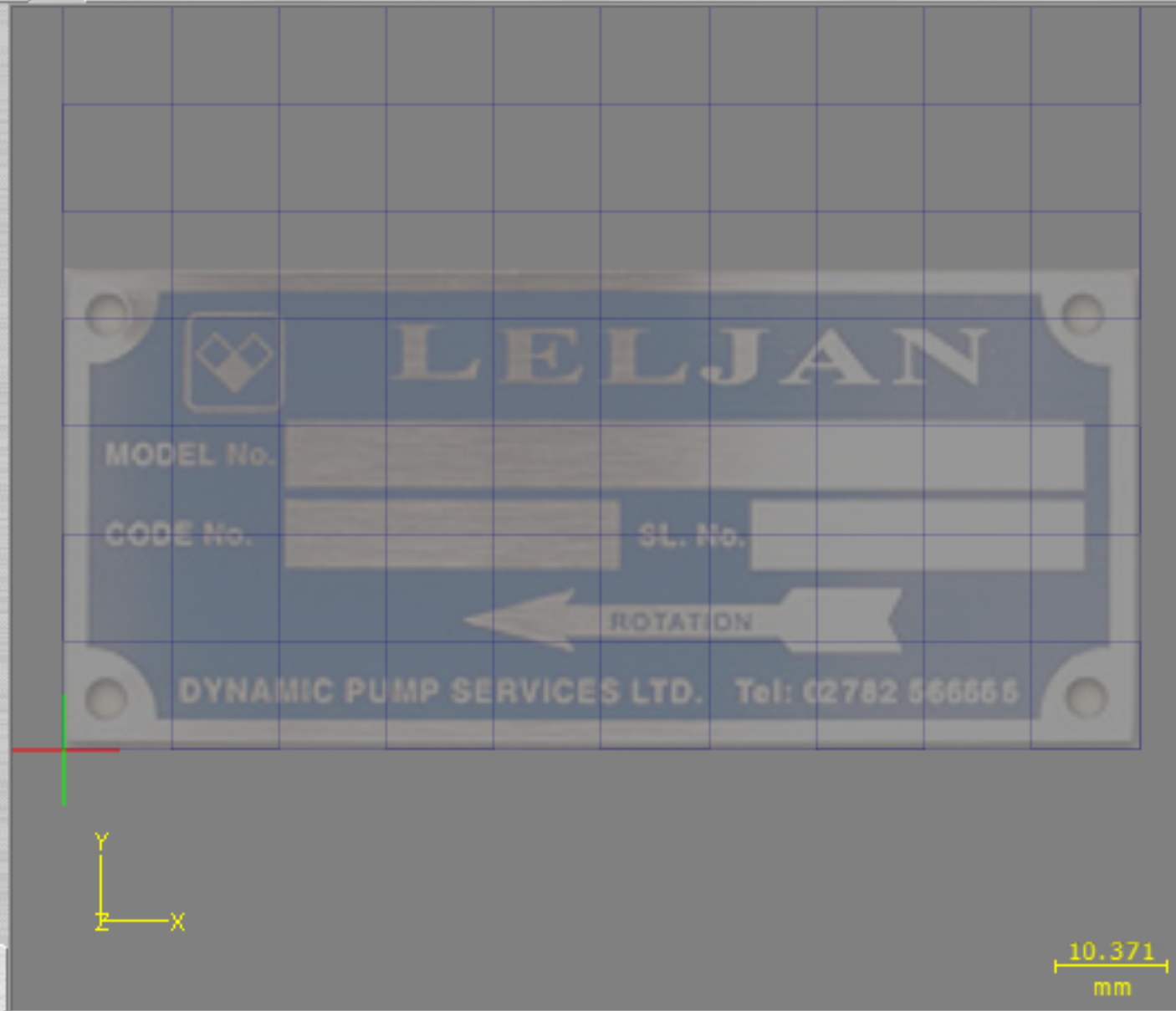
Geometry Toolpath

- Geometry
 - Layer:Layer_0
 - Bitmap

Bitmap:

	X	Y
Point 1:	0	0
Point 2:	100	44.664
Width(px):	253	
Height(px):	113	
Opacity(0..100)	20	

Update



10.371 mm

X: 54.771 Y: -10.026

New Open Vectorize Save Machining Settings Help Close Create point Line Endpoints Rectangle Circle Ct + Pt

Undo Delete Fillet Translat tozoom Zoom In Zoom back Zoom window Pan Redraw Top Front Side Iso

Geometry Toolpath

- Geometry
 - Layer:Layer_0
 - Bitmap

- New
- Contour
- Pocket
- Drill
- Write
- Parallel
- Edit G-Code
- Grbl Panel

Creazione nuova operazione.
Selez. "Scritte" dal menu Lavorazioni.

Bitmap:

	X	Y
Point 1:	0	0
Point 2:	100	44.664
Width(px):	253	
Height(px):	113	
Opacity(0..100)	20	

Update



Contour

Tools

Tools List:
C:\ProgramData\SimplyC... \Tools_mm.tbl

- Flat(Diam. 2)
- Flat(Diam. 3)
- Flat(Diam. 4)
- Flat(Diam. 5)
- Flat(Diam. 6)
- Flat(Diam. 8)
- Flat(Diam. 10)
- Drill(Diam. 3)
- Drill(Diam. 4)
- Drill(Diam. 6)
- Conical(Diam. 0.3)
- Conical(Diam. 0.5)
- Spherical(Diam. 4)
- Flat(Diam. 5)

Tool number: 1

Speed rate: 2000

Plunge rate: 50

Coolant

Name: Flat

Type: Flat

Diameter (d): 2

Length: 1.875

Depth pass: 0

Buttons: Open library, Save library, Add to lib., Modify in lib.

Sezione "Utensile"

Selez. l'utensile

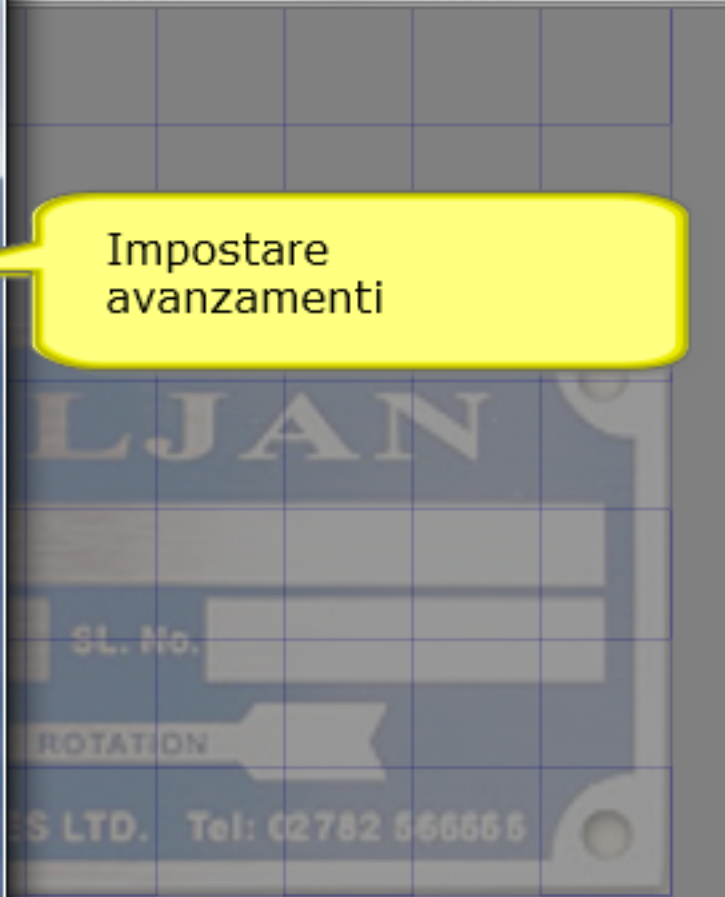
Impostare avanzamenti

Endpoints

Rectangle Circle Ct + Pt

Window Pan Redraw

Top Front Side Iso



Show/Hide toolpaths

10.371 mm

X: -4.346 Y: 68.588

Define tool, speed and feeds

SHARP OFF

90°

Grid icons

STOP

Green checkmark

Current layer: 0 Label1

Contour

Tools Write

Write definition:

(1) Text to insert:
Abc123

X: 19.923 Y: 28.762 Place

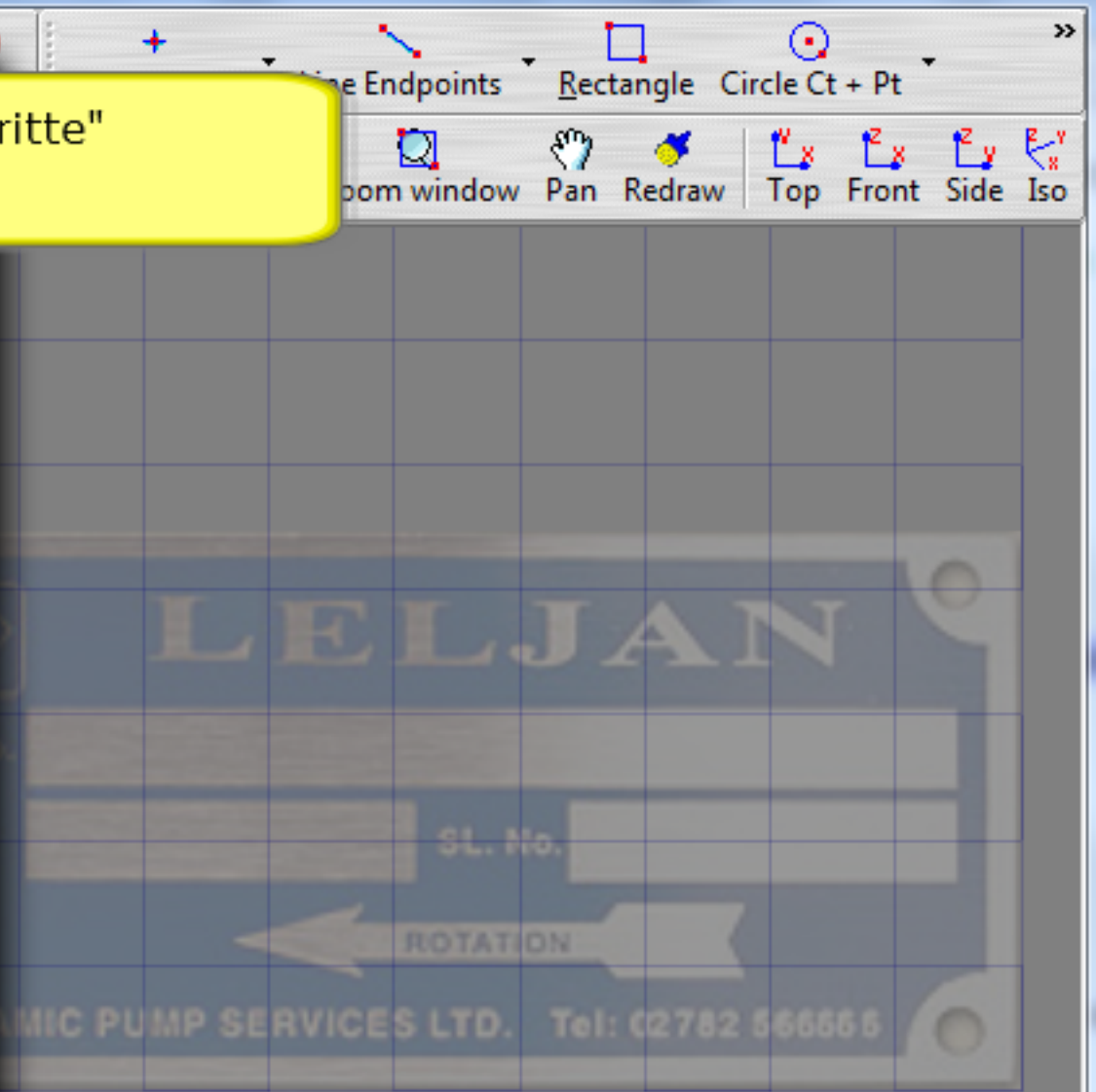
Character height: 4 Spacing: 1

+ - Eng_EuroExtLine Apply

Sezione "Scritte"

Line Endpoints Rectangle Circle Ct + Pt

Zoom window Pan Redraw Top Front Side Iso



Show/Hide toolpaths

10.371 mm

X: 19.508 Y: 40.171

Contour

Parameters

Testo da inserire

(1) Text to insert:
Abc123

X: 19.923 Y: 28.762 **Place**

Character height: 4 Spacing: 1

+ - Eng_EuroExtLine Apply

Create point Line Endpoints Rectangle Circle Ct + Pt

Zoom In Zoom back Zoom window Pan Redraw Top Front Side Iso

LELJAN

SL. No.

← ROTATION →

MIC PUMP SERVICES LTD. Tel: (02782 566555

Click sul bottone Posiz.

Show/Hide toolpaths

10.371 mm

X: 19.508 Y: 40.171

Contour

Tools Write Parameters

Write definition:

(1) Text to insert:
Abc123

X: 22.412 Y: 25.443 Place

Character height: 4 Spacing: 1

+ - Eng_EuroExtLine Apply

Create point Line Endpoints Rectangle Circle Ct + Pt

Zoom In Zoom back Zoom window Pan Redraw Top Front Side Iso

Abc123

SL. No.

← ROTATION →

MIC PUMP SERVICES LTD. Tel: (02782 566555

Posizionare il testo

Show/Hide toolpaths

10.371 mm

X: 18.679 Y: 12.583

Contour

Tools Write Parameters

Write definition:

(1) Text to insert:
Abc123
X: 22.412 Y: 25.443 Place
Character height: 4 Spacing: 1


(2) Text to insert:
1234
X: 0 Y: 0
Character height: 3.5 Spacing: 1

+ - Eng_EuroExtLine Apply

Testo da inserire

Create point Line Endpoints Rectangle Circle Ct + Pt

Zoom In Zoom back Zoom window Pan Redraw Top Front Side Iso



Show/Hide toolpaths

10.371 mm

X: 18.679 Y: 12.583

Contour

Tools Write Parameters

Write definition:

(1) Text to insert:
Abc123
X: 22.412 Y: 25.443 Place
Character height: 4 Spacing: 1


(2) Text to insert:
1234
X: 0 Y: 0 Place
Character height: 3.5 Spacing: 1

Altezza carattere

+ - Eng_EuroExtLine Apply

Create point Line Endpoints Rectangle Circle Ct + Pt

Zoom In Zoom back Zoom window Pan Redraw Top Front Side Iso



Contour

Tools Write Parameters

Write definition:

(1) Text to insert:
Abc123
X: 22.412 Y: 25.443 Place
Character height: 4 Spacing: 1

(2) Text to insert:
1234
X: 22.412 Y: 18.183 Place
Character height: 3.5 Spacing: 1

+ - Eng_EuroExtLine Apply

Create point Line Endpoints Rectangle Circle Ct + Pt

Zoom In Zoom back Zoom window Pan Redraw Top Front Side Iso



Posizionare il testo

Show/Hide toolpaths

X: 18.264 Y: 10.924

10.371 mm

Contour

Tools | Write | Parameters

Write definition:

(1) Text to insert:
Abc123
X: 22.412 Y: 25.443 Place
Character height: 4 Spacing: 1

(2) Text to insert:
1234
X: 22.412 Y: 18.183 Place
Character height: 3.5 Spacing: 1

(3) Text to insert:

X: 0 Y: 0 Place
Character height: 10 Spacing: 1

+ - Eng_EuroExtLine Apply

Create point | Line Endpoints | Rectangle | Circle Ct + Pt

Zoom In | Zoom back | Zoom window | Pan | Redraw | Top | Front | Side | Iso



Show/Hide toolpaths

10.371 mm

X: 18.264 Y: 10.924

Contour

Tools Write Parameters

Write definition:

(1) Text to insert:
Abc123
X: 22.412 Y: 25.443 Place
Character height: 4 Spacing: 1

(2) Text to insert:
1234
X: 22.412 Y: 18.183 Place
Character height: 3.5 Spacing: 1

(3) Text to insert:
xx-22
X: 0 Y: 0 Place
Character height: 3.5 Spacing: 1

+ - Eng_EuroExtLine Apply

Create point Line Endpoints Rectangle Circle Ct + Pt

Zoom In Zoom back Zoom window Pan Redraw Top Front Side Iso



Show/Hide toolpaths

10.371 mm

X: 0.633 Y: -11.478

Contour

Tools Write Parameters

Write definition:

(1) Text to insert:
Abc123
X: 22.412 Y: 25.443 Place
Character height: 4 Spacing: 1

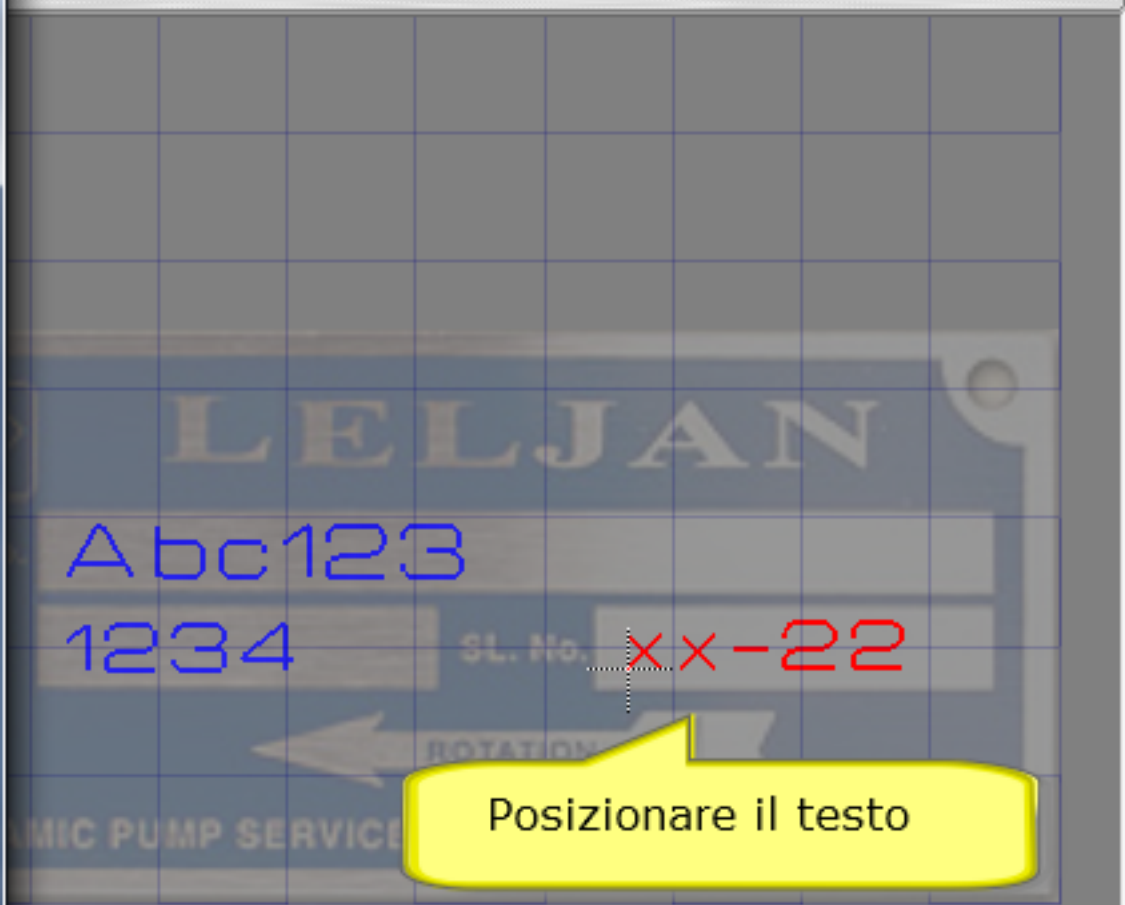
(2) Text to insert:
1234
X: 22.412 Y: 18.183 Place
Character height: 3.5 Spacing: 1

(3) Text to insert:
xx-22
X: 66.594 Y: 18.391 Place
Character height: 3.5 Spacing: 1

+ - Eng_EuroExtLine Apply

Create point Line Endpoints Rectangle Circle Ct + Pt

Zoom In Zoom back Zoom window Pan Redraw Top Front Side Iso



Show/Hide toolpaths

10.371 mm

X: 66.387 Y: 18.391

Press the mouse on the desired insertion point.

SHARP OFF 90° [Grid] [Snap] [Stop] [Check]

Current layer: 0 Label1

Contour

Tools Write Parameters

Write definition:

(1) Text to insert:
Abc123
X: 22.412 Y: 25.443 Place
Character height: 4 Spacing: 1

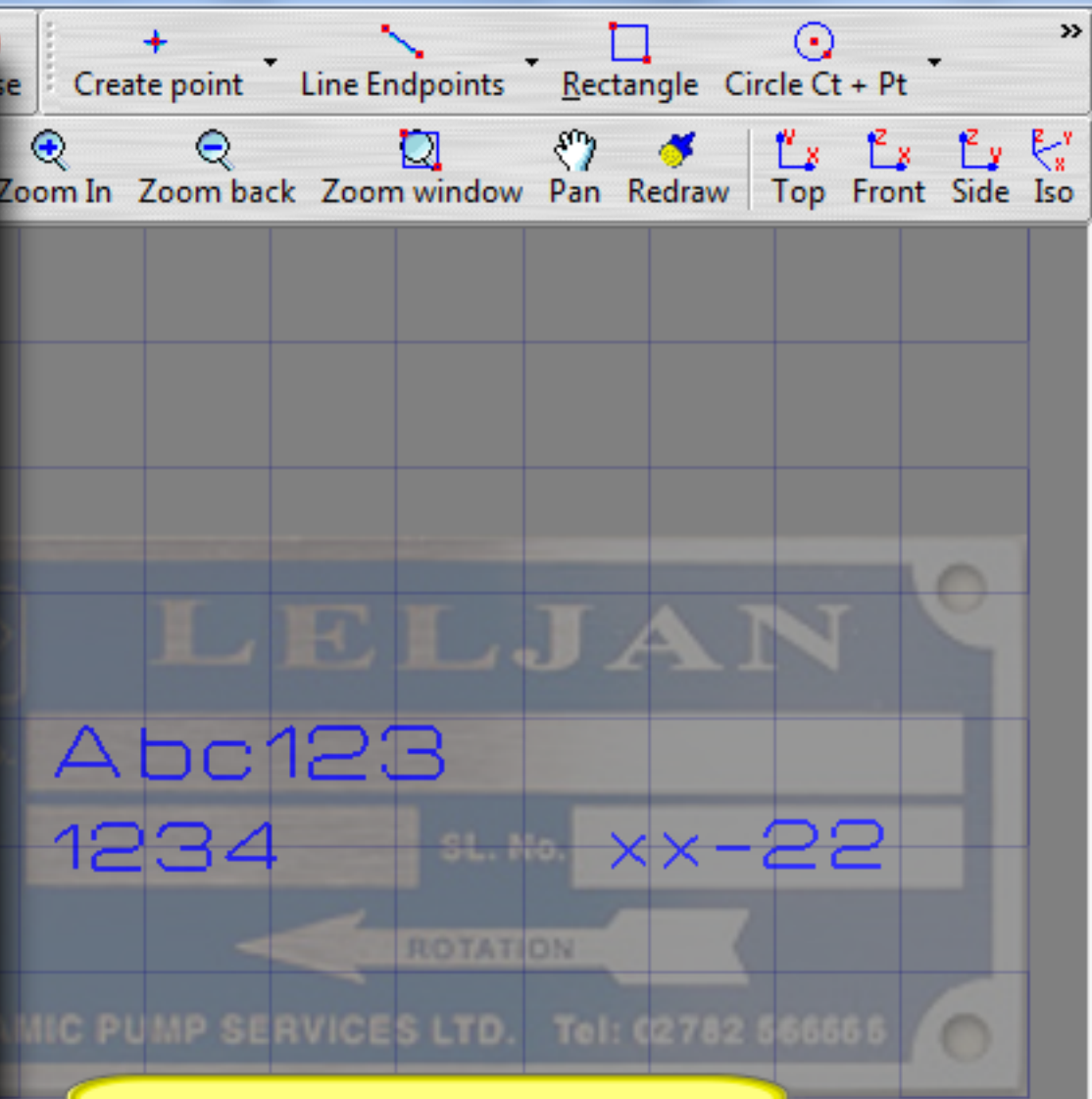
(2) Text to insert:
1234
X: 22.412 Y: 18.183 Place
Character height: 3.5 Spacing: 1

(3) Text to insert:
xx-22
X: 66.594 Y: 18.391 Place
Character height: 3.5 Spacing: 1

+ - HE-engrave-oblique Apply

Create point Line Endpoints Rectangle Circle Ct + Pt

Zoom In Zoom back Zoom window Pan Redraw Top Front Side Iso



Click sul bottone Applica

Contour

Tools | Write | **Parameters**

Contour parameters:

Feed Plane: 2

Top of part: 0

Depth: -1

Depth increment: 1

Stock to leave: 0

N. 1

Rough cuts of size: 0.0

N. 0

Finish cut of size: 0.0

sbtConEntExi

Holding Tabs

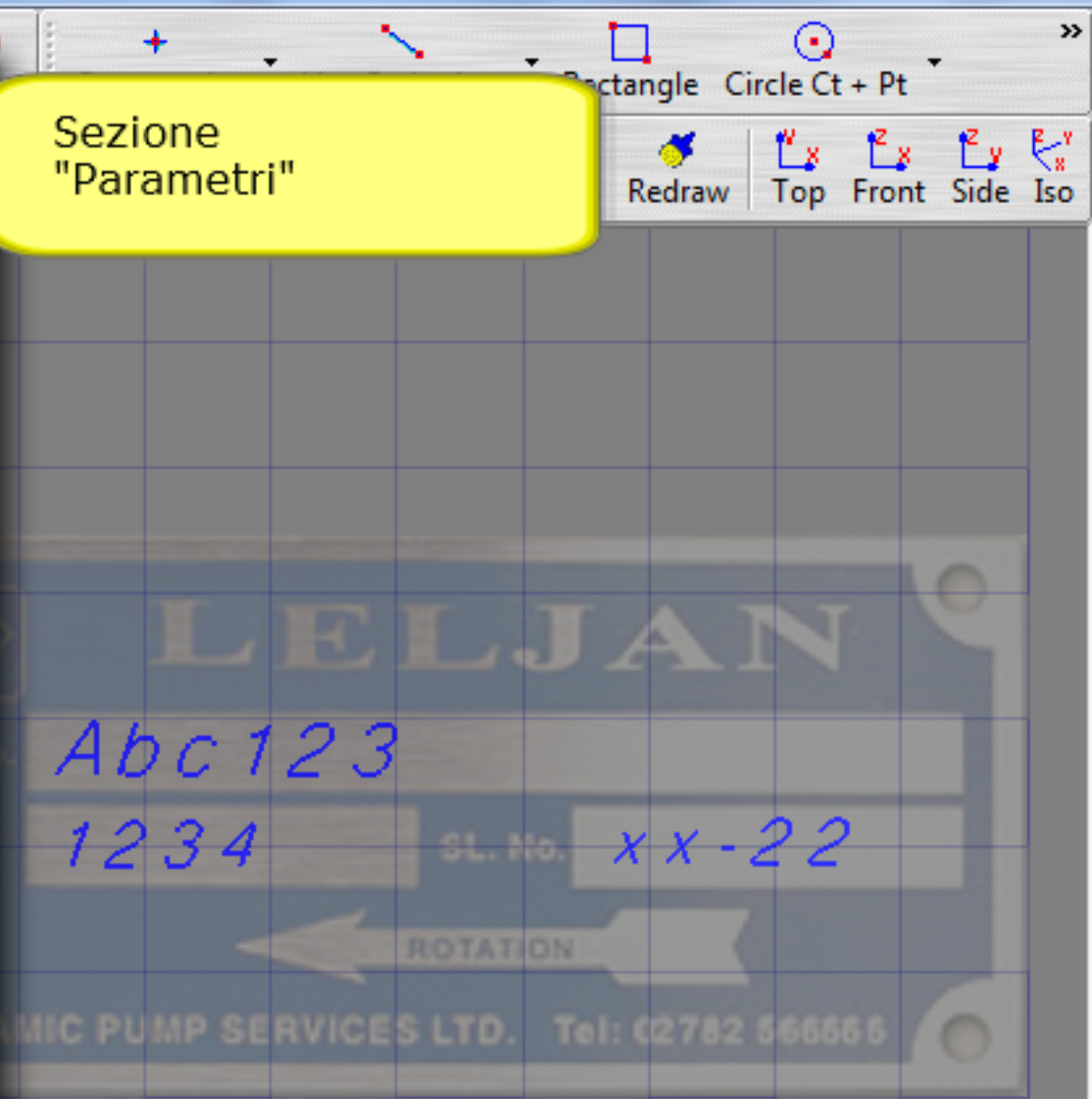
Calculation Method: Standard

Cutting rules: None

Depth cuts order by: contour

Transform | Calculate | Cancel

Sezione "Parametri"



Show/Hide toolpaths

10.371 mm

X: 24.072 Y: 59.461

Set the cutting parameters and press the 'Calculate' button

Contour

Tools Write Parameters

Contour parameters:

Feed Plane: 2

Top of part: 0

Depth: -1

Depth increment: 1

Stock to leave: 0

N. 1

N. 0

Rough cuts of size: 0.0

Finish cut of size: 0.0

sbtConEntExi

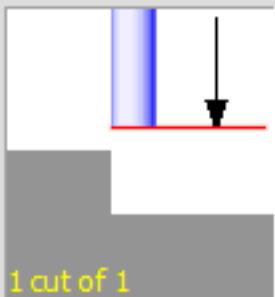
Holding Tabs

Calculation Method: Standard

Cutting rules: None

Depth cuts order by: contour


Transform Calculate



Premere "Calcola"

Create point Line Endpoints Rectangle Circle Ct + Pt

Zoom In Zoom back Zoom window Pan Redraw Top Front Side Iso

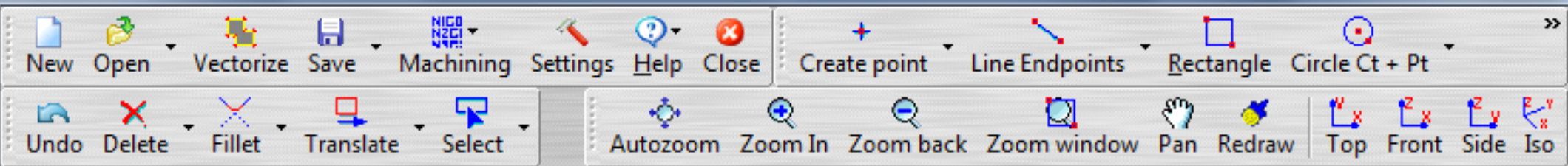


Show/Hide toolpaths

X: 24.072 Y: 59.461

Set the cutting parameters and press the 'Calculate' button

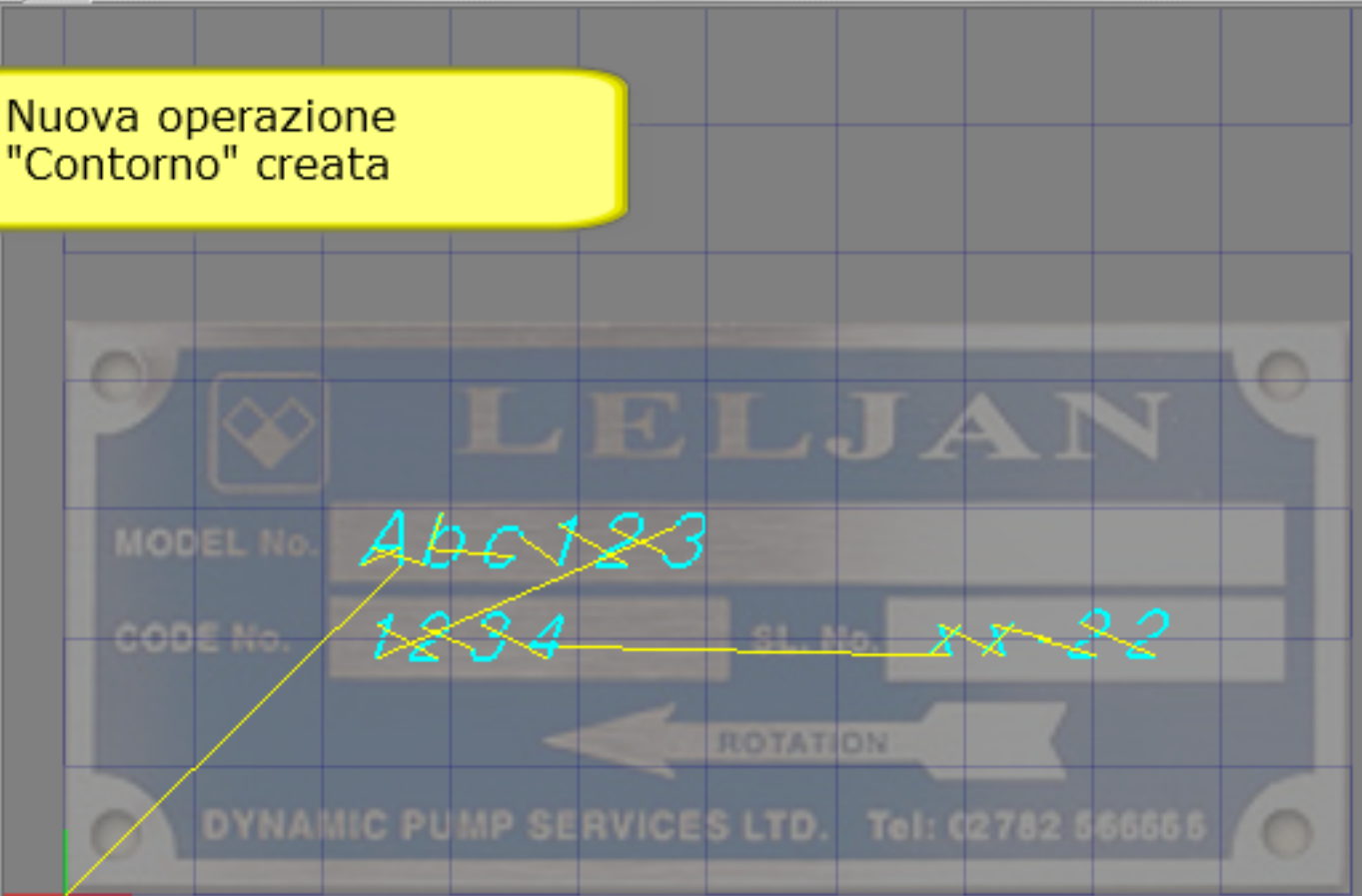
10.371 mm



Geometry Toolpath

- Machine: Mach2-3
 - Contour - T1 D.2 (Flat)**
 - Parameters
 - Toolpath (444)

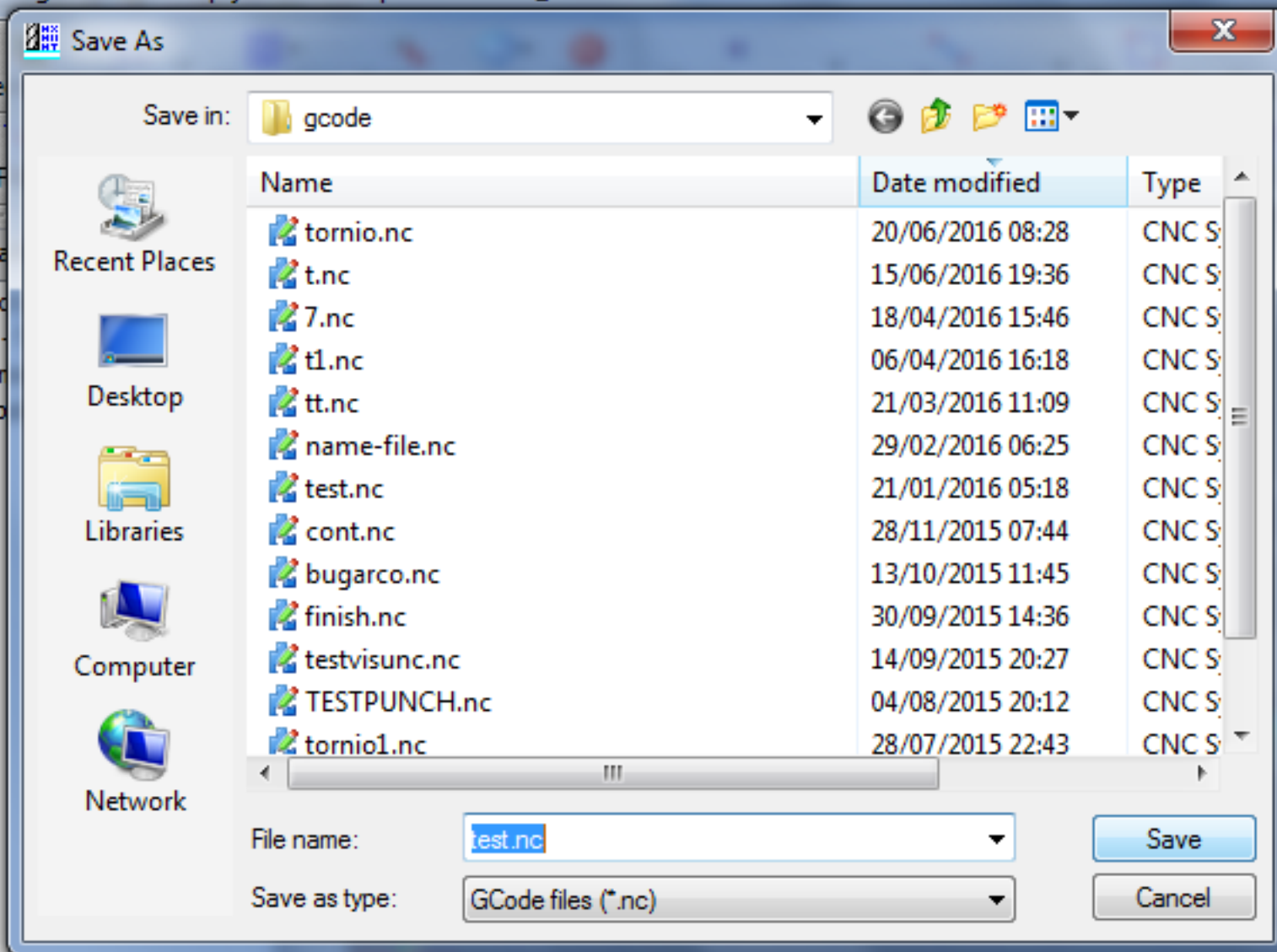
Nuova operazione "Contorno" creata



Change Post Run Post
 Show/Hide toolpaths

10.371 mm

X: -4.553 Y: 11.961



Change Post

Run Post

Show/Hide toolpaths

Eeguire il Postprocessor

Estimate machining time = 0h, 01m, 12s

10.371
mm

X: 39.629 Y: -23.717

SNAP
OFF

Current layer: 0

Label1

File Edit Text Tools Help

C:\ProgramData\SimplyCam 3\gcode\test.nc

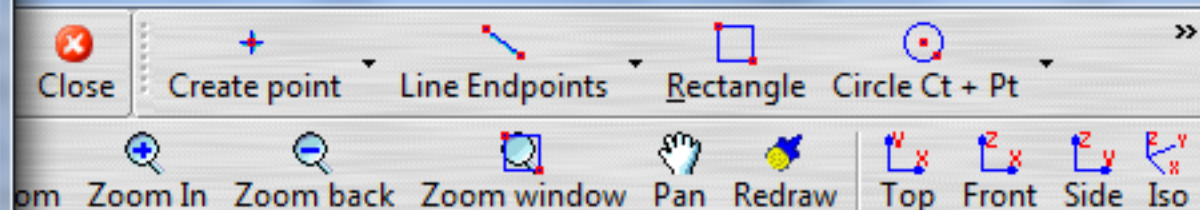
```
%  
N1 (POST PROCESSOR: MACH2-3)  
N2 (TEST.NC)  
N3 G21 (UNITS: MM)  
N4 G00 G17 G40 G49 G80 G90  
N5 G64 (Constant Velocity Mode)  
N6 T1 M6 (TLDIA=2)  
N7 G91.1 (IJ Incremental mode for arcs)  
N8 G00 X26.19 Y25.706 M03  
N9 G43 H1 Z2.  
N10 G01 Z-1. F50.0  
N11 G01 X26.13 Y29.706 Z-1. F100.0  
N12 X25.835  
N13 X22.999 Y25.706  
N14 G00 Z2.  
N15 X26.172 Y27.037  
N16 G01 Z-1. F50.0  
N17 G01 X23.945 Y27.037 Z-1. F100.0  
N18 G00 Z2.  
N19 X27.929 Y25.711  
N20 G01 Z-1. F50.0  
N21 G01 X29.287 Y29.706 Z-1. F100.0  
N22 G00 Z2.  
N23 X28.354 Y26.94  
N24 G01 Z-1. F50.0
```



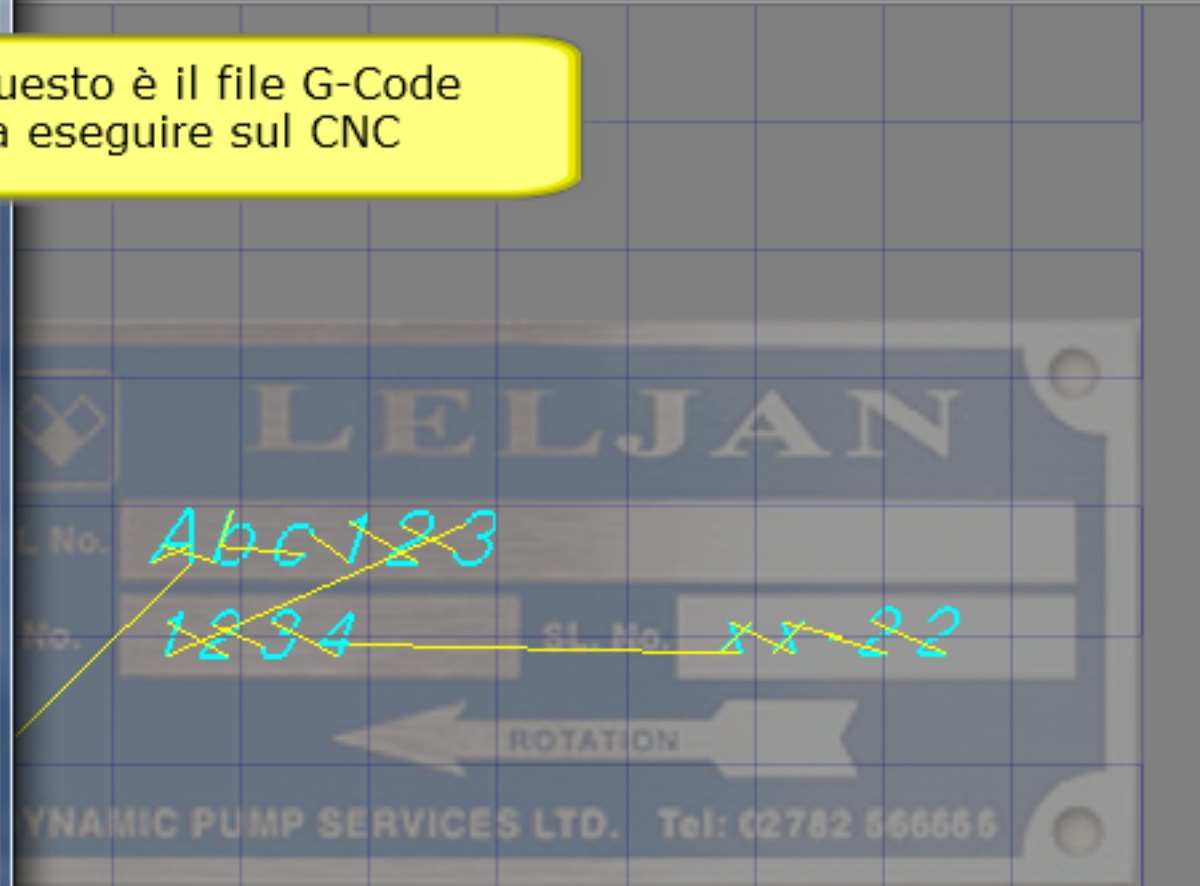
Current Z: 0

In 0 col 0

X: 22.412 Y: 49.505



Questo è il file G-Code
da eseguire sul CNC




Machining time = 0h, 01m, 12s

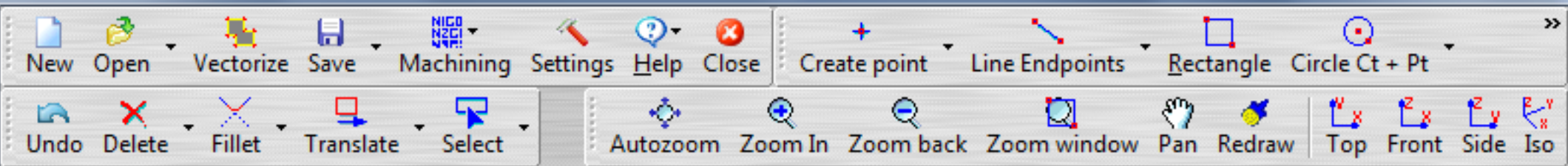
10.371
mmSNAP
OFF

90°

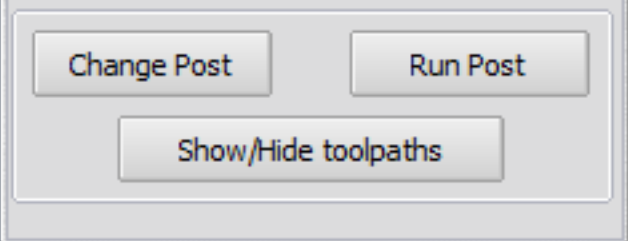
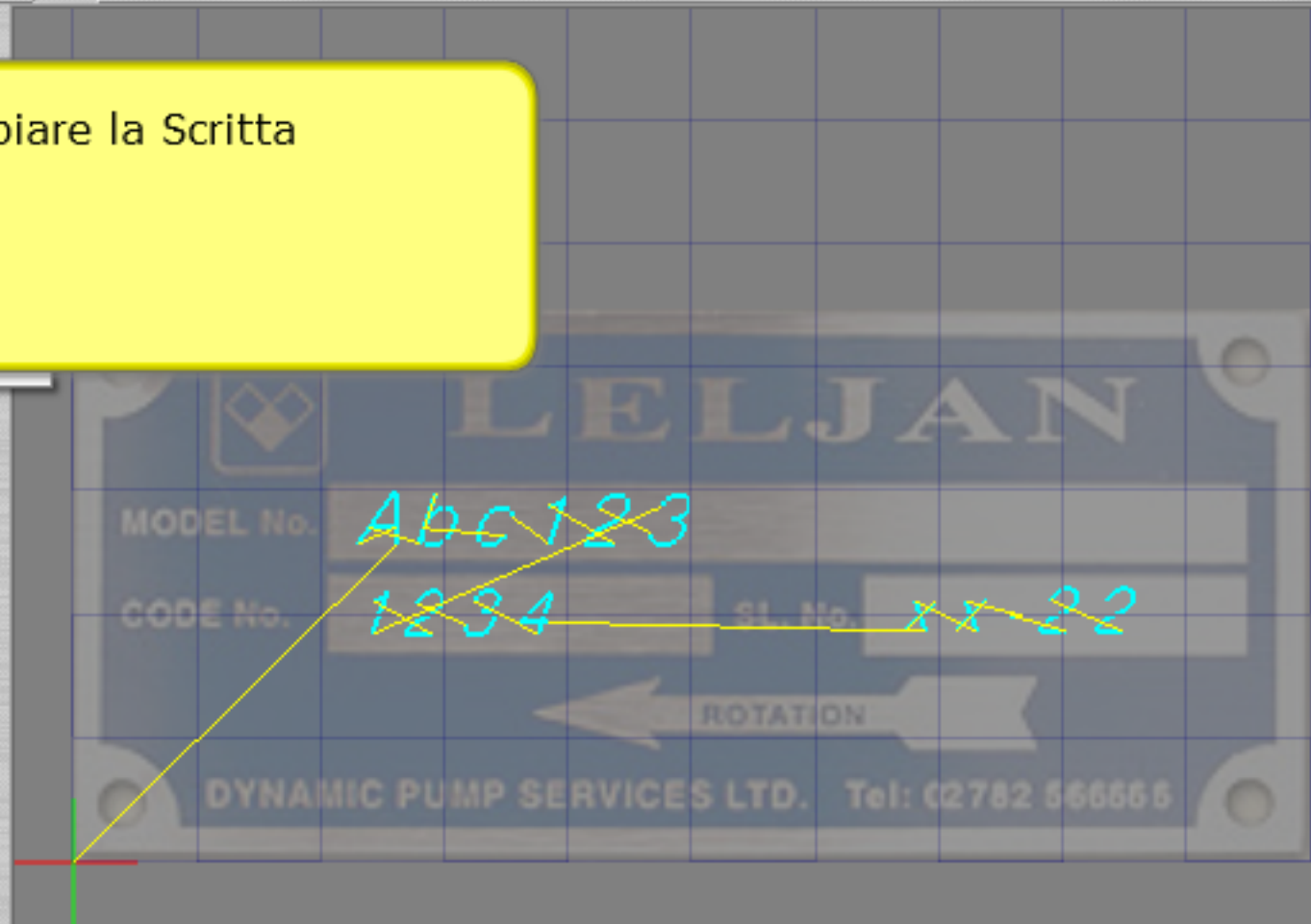
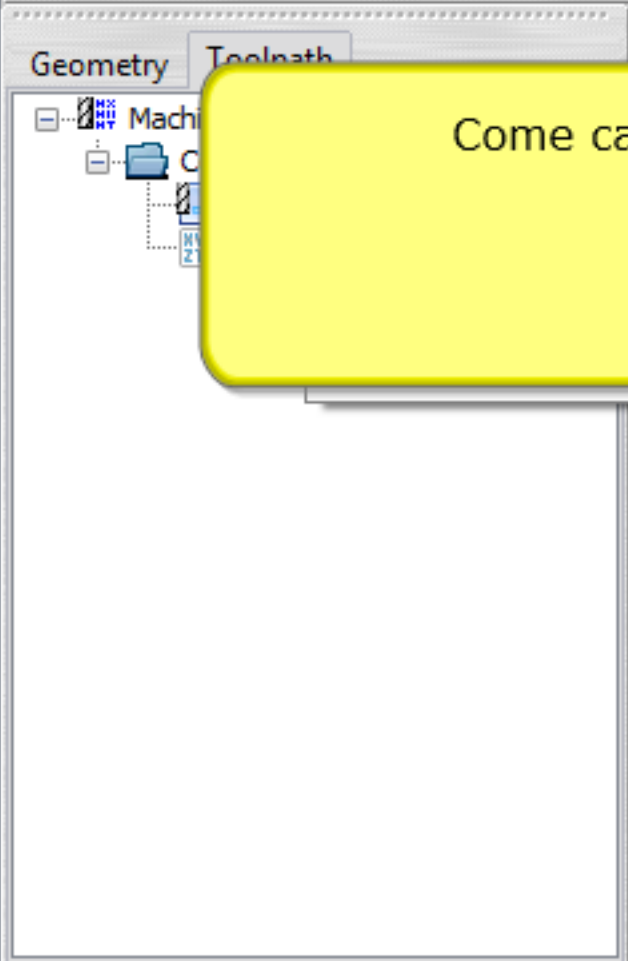


Current layer: 0

 Label1

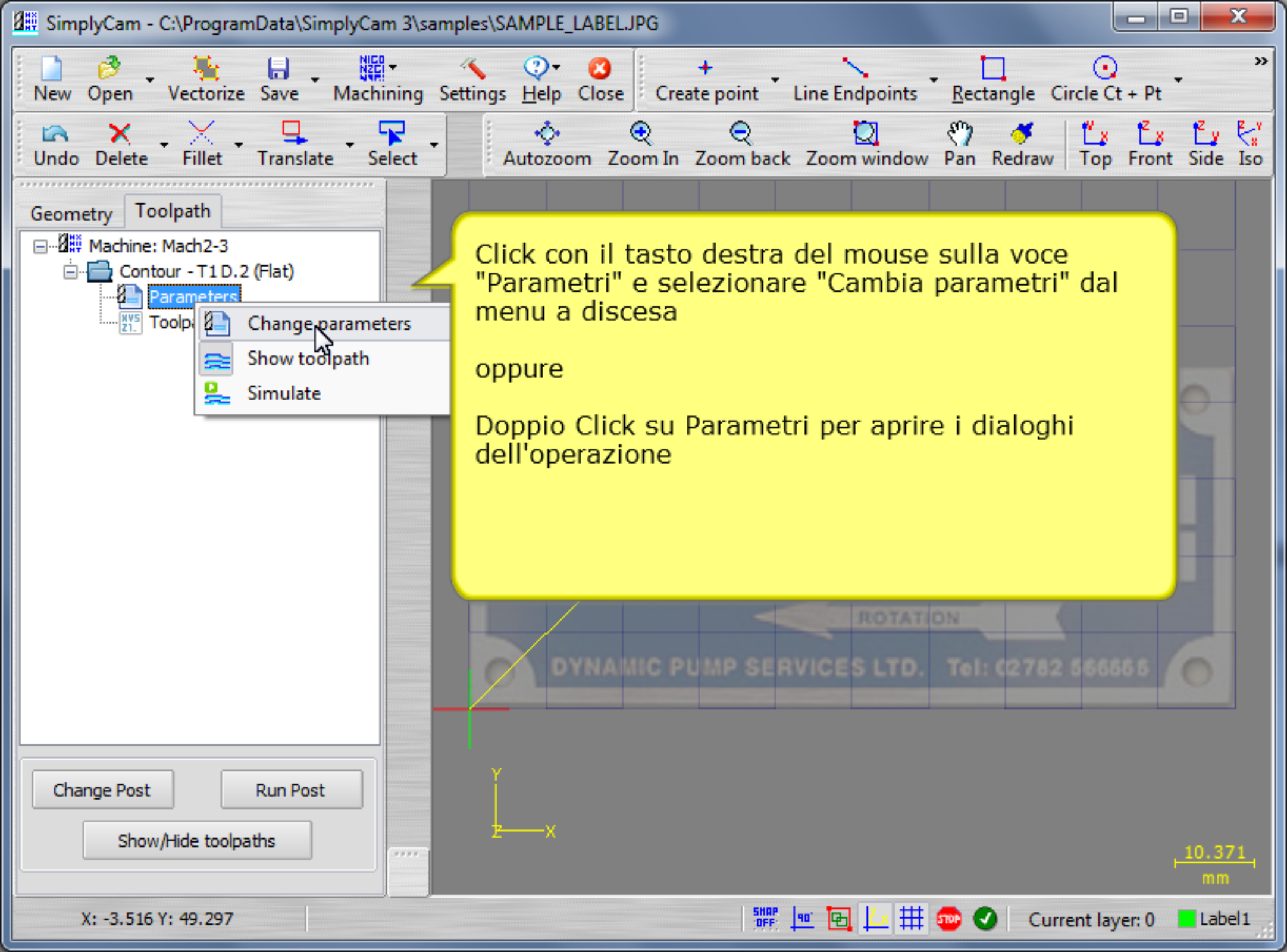


Come cambiare la Scritta



10.371 mm

X: -3.516 Y: 49.297



Click con il tasto destro del mouse sulla voce "Parametri" e selezionare "Cambia parametri" dal menu a discesa

oppure

Doppio Click su Parametri per aprire i dialoghi dell'operazione

Change Post

Run Post

Show/Hide toolpaths

X: -3.516 Y: 49.297

SNAP OFF

90°

Grid

Ortho

Grid

STOP

Checkmark

Current layer: 0

Label1

Contour

Tools Write Parameters

Write definition:

(1) Text to insert:
Abc123
X: 22.412 Y: 25.443 Place
Character height: 4 Spacing: 1

(2) Text to insert:
1234
X: 22.412 Y: 18.183 Place
Character height: 3.5 Spacing: 1

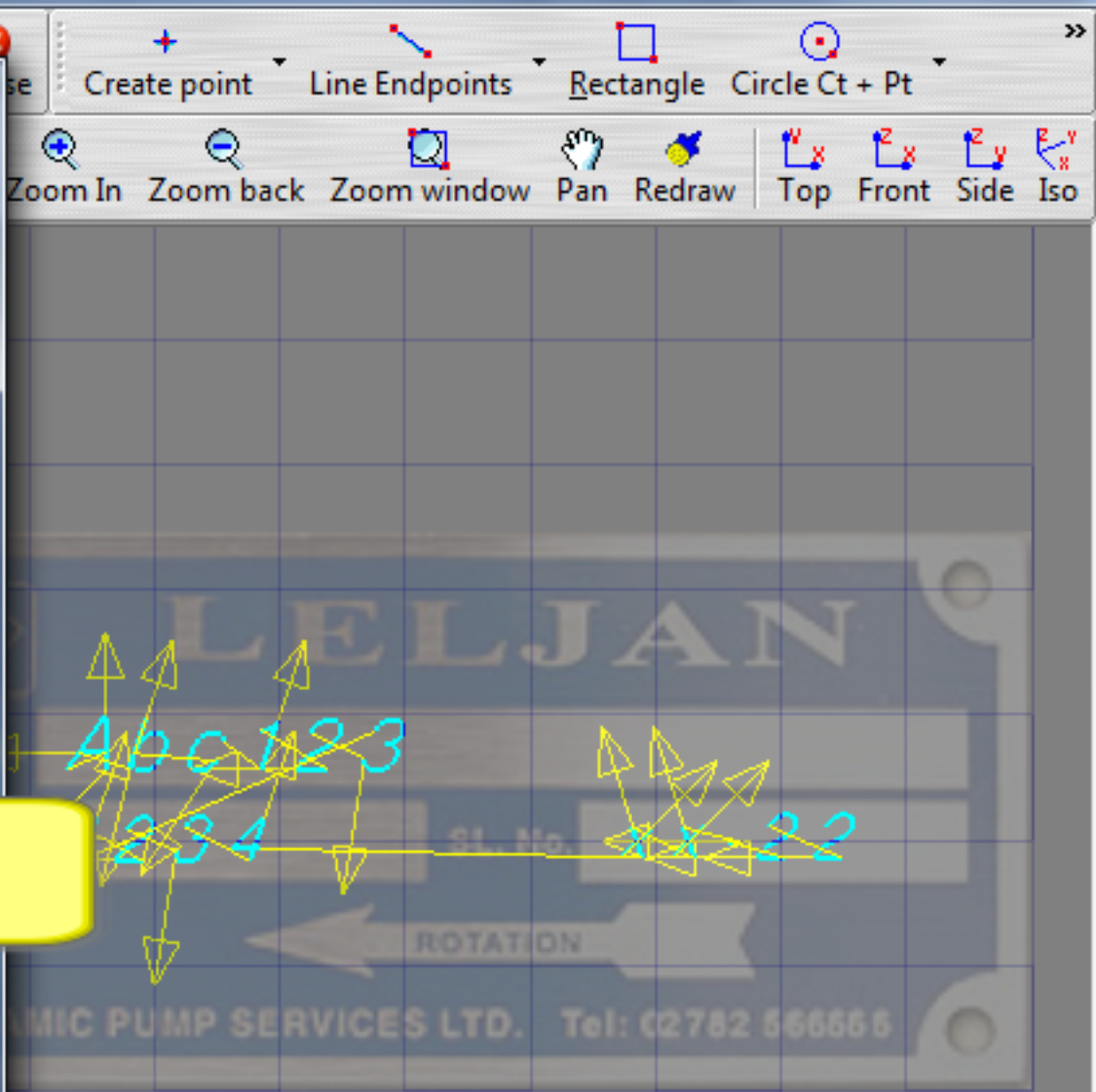
(3) Text to insert:
xx-22
X: 66.594 Y: 18.183 Place
Character height: 3.5 Spacing: 1

+ - HE-engrave-oblique Apply

Modificare il testo

Create point Line Endpoints Rectangle Circle Ct + Pt

Zoom In Zoom back Zoom window Pan Redraw Top Front Side Iso



Contour

Tools Write Parameters

Write definition:

(1) Text to insert:

 X: Y: Place
 Character height: Spacing:

(2) Text to insert:

 X: Y: Place
 Character height: Spacing:

(3) Text to insert:

 X: Y: Place
 Character height: Spacing:

+ - HE-engrave-oblique Apply

Create point Line Endpoints Rectangle Circle Ct + Pt

Zoom In Zoom back Zoom window Pan Redraw Top Front Side Iso



X: -3.516 Y: 49.297

Define tool, speed and feeds

SHARP OFF 90° [Grid] [Snap] [Zoom] [Stop] [Check]

Current layer: 0 Label1

Contour

Tools Write Parameters

Write definition:

(1) Text to insert:
Abc123
X: 22.412 Y: 25.443 Place
Character height: 4 Spacing: 1

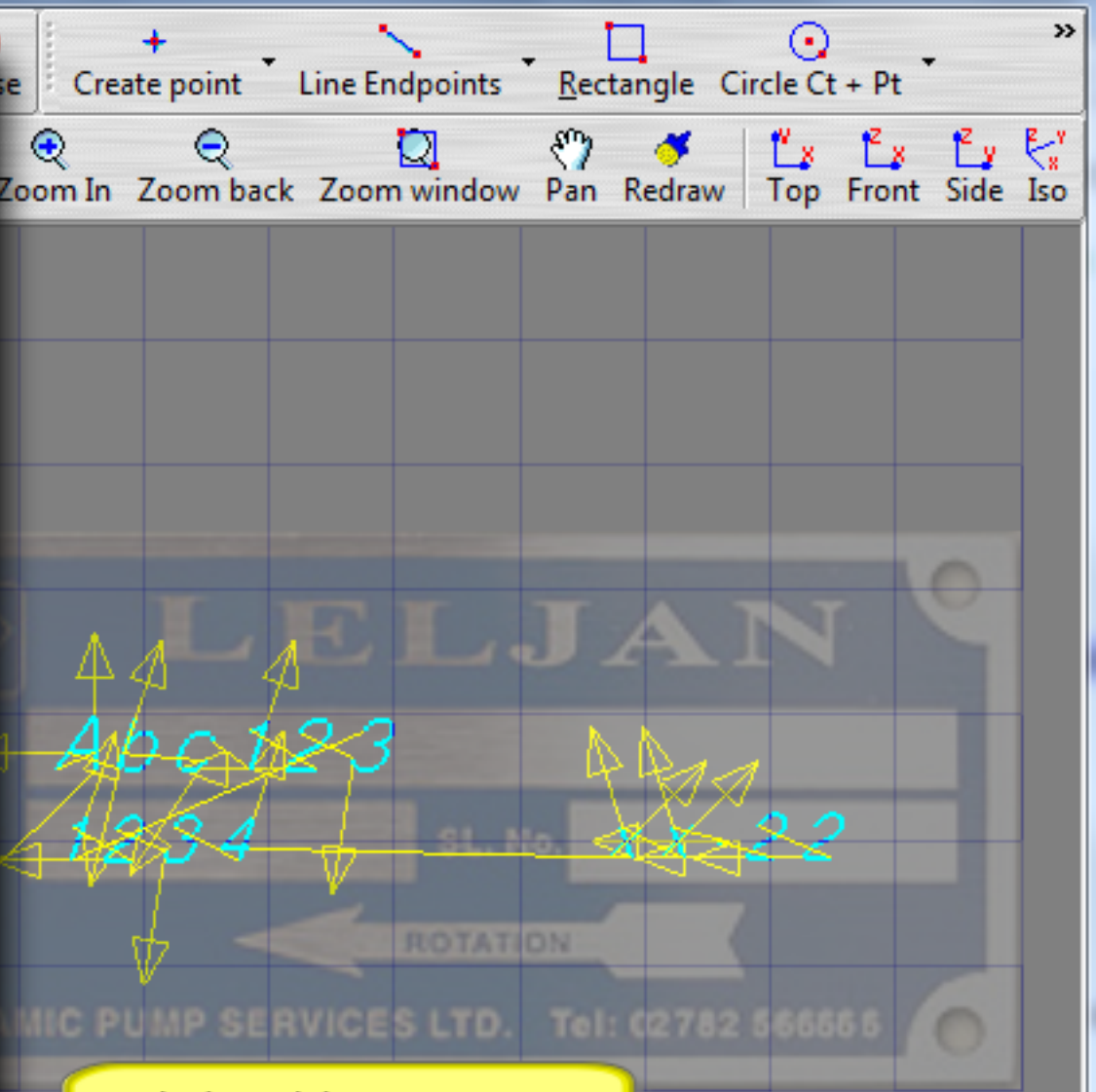
(2) Text to insert:
1234
X: 22.412 Y: 18.183 Place
Character height: 3.5 Spacing: 1

(3) Text to insert:
xx-23
X: 66.594 Y: 18.391 Place
Character height: 3.5 Spacing: 1

+ - HE-engrave-oblique Apply

Create point Line Endpoints Rectangle Circle Ct + Pt

Zoom In Zoom back Zoom window Pan Redraw Top Front Side Iso



Click sul bottone Applica

Contour

Tools Write Parameters

Write definition:

(1) Text to insert:

 X: Y:
 Character height: Spacing:

(2) Text to insert:

 X: Y:
 Character height: Spacing:

(3) Text to insert:

 X: Y:
 Character height: Spacing:

+ - HE-engrave-oblique

Create point Line Endpoints Rectangle Circle Ct + Pt

Zoom In Zoom back Zoom window Pan Redraw Top Front Side Iso

Show/Hide toolpaths

10.371 mm

X: -3.516 Y: 49.297

Define tool, speed and feeds

SHARP OFF 90° [Grid] [Snap] [Zoom] [Stop] [Check]

Current layer: 0 Label1

Contour

Tools Write Parameters

Contour parameters:

Feed Plane: 2

Top of part: 0

Depth: -1

Depth increment: 1

Stock to leave: 0

N. 1

Rough cuts of size: 0

N. 0

Finish cut of size: 0

sbtConEntExi

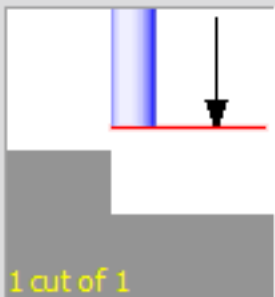
Holding Tabs

Calculation Method: Standard

Cutting rules: None


Depth cuts order by: contour

Transform Calculate



Create point Line Endpoints Rectangle Circle Ct + Pt

Zoom In Zoom back Zoom window Pan Redraw Top Front Side Iso



Premere "Calcola"

Show/Hide toolpaths

X: -3.516 Y: 49.297

Set the cutting parameters and press the 'Calculate' button

SHARP OFF 90° [Grid] [Snap] [Stop] [Check] Current layer: 0 Label1

10.371 mm

File Edit Text Tools Help

C:\ProgramData\SimplyCam 3\gcode\test.nc

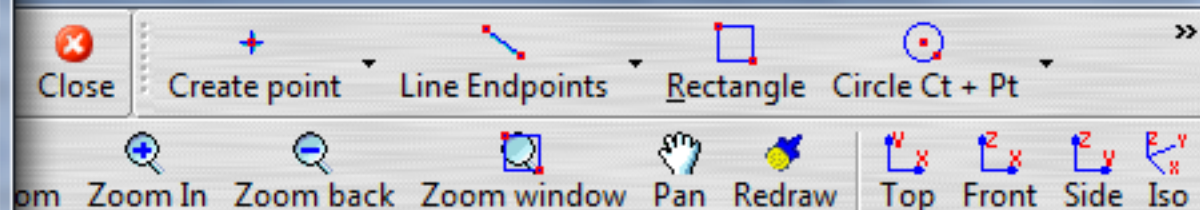
```
N486 A03.033 I21.01
N487 X85.568 Y21.879
N488 X85.491 Y21.939
N489 X85.406 Y21.984
N490 X85.305 Y22.02
N491 X85.196 Y22.045
N492 X85.087 Y22.061
N493 X84.97 Y22.065
N494 X84.816 Y22.057
N495 X84.675 Y22.041
N496 X84.537 Y22.008
N497 X84.416 Y21.964
N498 X84.299 Y21.907
N499 X84.19 Y21.843
N500 X84.093 Y21.766
N501 X84. Y21.681
N502 X83.915 Y21.584
N503 X83.838 Y21.483
N504 X83.774 Y21.37
N505 X83.713 Y21.252
N506 G00 Z2.
N507 M05
N508 M30
```

%

Current Z: 0

In 0 col 0

X: 12.456 Y: 59.046

~~ABC123~~

...e eseguire il postprocessor,
per creare il nuovo file G-Code

DYNAMIC PUMP SERVICES LTD. Tel: (02782 566555

Machining time = 0h, 01m, 12s

10.371
mmSNAP
OFF

90°

Current layer: 0 Label1