

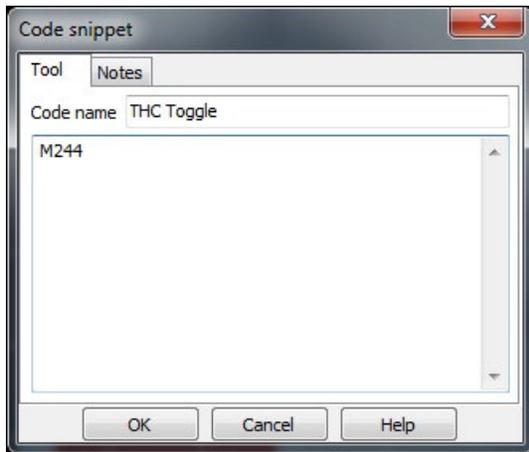
SheetCAM Path Rules

SheetCAM path rules can be setup for things like turning off THC control on small parts and slowing down on corners.

Creating Code Snippets:

Note: The info below is for enabling/disabling the torch height control. You can create custom code in macros to use for other purposes but that is beyond the scope of this document.

1. Attached is M244.m1s file and should be saved to the c:\mach3\macros\plasma\ directory (the path may be a little different depending on your setup and profile name). If M244 already exists in your directory, change the attached file name to an available number and use that new number for the rest of the setup where we have 244. The code in this file simply toggles the state of the THC button on the plasma screen, effectively turning THC control on and off.
2. Under tools menu option, click the G code option.
3. Set the Code Name and enter the filename of the code to run in the box below, without the extension:



4. Click OK button

Creating Path Rules:

Rules to prevent diving (Turn THC Off) and Rounded Corners:

Under the options menu is job options. In there select the path rules tab and you can edit those rules parameters for your liking. The idea is they turn the torch height control off at certain points to prevent it from diving, or slow down the feedrate for corners to prevent rounding.

- **Rule: On lead out**
Feed rate: 100%
Start Code: Code: THC Toggle
Distance Before: .2 in
End Code: Code: THC Toggle

- **Rule: On small shapes**
Smaller than: 2 in
Feed Rate: 75%
Start Code: Code: THC Toggle
End Code: Code: THC Toggle

- **Rule: On all corners**
Tighter than: 45 degrees
Distance Before: 0.2 in
Feed Rate: 100%
Before Code: (nothing)
Distance After: 0.2 in
End Code: (nothing)

Using Path Rules

In order for the path rule to be used, it must be selected in the operation in sheetcam. Double click on the existing operation or when setting a new operation, select the Path rule to be used in the dropdown menu:

