

How to use the resequencing edit option.

Make sure the users have permissions to edit files if this is going to be done.

Adding lines to programs.

- First, select your machine and then select the file by double clicking it

The screenshot shows the Progressive DNC software interface. On the left, a 'Machines' list includes CNC20 through CNC26, with CNC24 selected. Below this, a 'Signal Strength' gauge shows 100%. The main area displays a file editor for a CNC program. The file path is \\btsdc2012\tapes\download\cnc24\7-262110045-11-N--25.TXT. The program content is as follows:

```
%
O01125 (7-262110045-11-N--25.TXT)
(7-262110045-11)
(7/3/08 AT 9:11 AM)

1234.
7-262110045-11-N--25.TXT
(PROVEN 06-08-20 QUACK)
(MACHINE 0)
(CYCLE TIME 00:09:01)
(LAST RUN 19077 20020)
(SAVED RT 6/15/20)

N01 G54
N02 G00 G17 G40 G49 G80 G90
N03 G91 G28 Z0. M05

N04 T1 M06
(TOOL 1 .375 SPOT DRILL)
(OPERATION 1 HOLES)
N05 S800 M03
N06 G00 G90 X-1.0522 Y1.8226
N07 G43 H01 Z2. M08
N08 Z0.5
N09 G83 G98 X-1.0522 Y1.8226 Z-0.07 R0.1 Q0.03 F2.
N10 X1.0523
N11 X2.0888 Y-0.2565
N12 X1.0522 Y-1.8226
N13 X-1.0522
N14 X-2.1045 Y0.
N15 G00 G80 Z1. M09
N16 M05
N17 M01

N18 T2 M06 (LETTER "I" DRILL)
(TOOL 2 .272 DRILL)
(OPERATION 2 HOLES)
N19 S350 M03
N20 G00 G90 X-1.0522 Y1.8226
```

- Once this opens you will be able to make line changes you want. However, when you add a line into the program you must start it with **N - - or N-** If you do not put this in it will not resequencing the program. (see between line N1 and N2 in image below)

The screenshot displays the Progressive DNC software interface. On the left, a sidebar lists machines, with CNC24 selected. Below the machine list is a 'Signal Strength' gauge showing 98. The main interface is divided into several sections:

- Download Path:** Shows the path \\btsdc2012\tapes\download\cnc24.
- Upload Path:** Shows the path \\btsdc2012\tapes\upload.
- File Editor:** Displays a G-code file named \\btsdc2012\tapes\download\cnc24\7-262110045-11-N---25.TXT. The code includes line numbers (e.g., 1234, 7-262) and various G-code commands like G00, G01, G02, G03, G17, G43, M03, M05, M06, M08, M09, M10, M11, M12, M13, M14, M15, M16, M17, M18.
- Machine Details:** Shows 'CNC24' with a status of '0'.

- To finish the resequencing, simply hit save after you make the changes and then it should update and show the new lines renumbered all the way down.

The screenshot displays the Progressive DNC web interface. The browser address bar shows the URL: `192.168.110.12/Thingworx/Runtime/index.html#master=ProgressiveDNC2020Master&mashup=Operator%2520`. The interface includes a navigation menu with options: DNC, MDC, Configuration, System, Support, and Logout. On the left, a 'Machines' sidebar lists various CNC units, with 'CNC24' selected. Below the sidebar, a 'Signal Strength' gauge shows a value of 94. The main content area features a 'Download Path' field containing `\\btsdc2012\tapes\download\cnc24` and an 'Upload Path' field containing `\\btsdc2012\tapes\upload`. A large text area displays the following file content:

```

%
001125 (7-262110045-11-N--25.TXT)
(7-262110045-11 )
(7/3/08 AT 9:11 AM )

1234.
7-262110045-11-N--25.TXT
(PROVEN 06-08-20 QUACK)
(MACHINE 0)
(CYCLE TIME 00:09:01 )
(LAST RUN 19077 20020)
(SAVED RT 6/15/20 )

N01 G54
N02 S800 M03
N03 G00 G90 X-1.0522 Y1.8226
N04 G43 H01 Z2. M08
N05 G00 G17 G40 G49 G80 G90
N06 G91 G28 Z0. M05

N07 T1 M05
( TOOL 1 .375 SPOT DRILL )
( OPERATION 1 HOLES )
N08 S800 M03
N09 G00 G90 X-1.0522 Y1.8226
N10 G43 H01 Z2. M08
N11 Z0.5
N12 G83 G98 X-1.0522 Y1.8226 Z-0.07 R0.1 Q0.03 F2.
N13 X1.0523
N14 X2.0888 Y-0.2565
N15 X1.0522 Y-1.8226
N16 X-1.0522
N17 X-2.1045 Y0.
N18 G00 G80 Z1. M09
N19 M05
N20 M01

N21 T2 M06 ( LETTER " 1 " DRILL )
( TOOL 2 .272 DRILL )

```

A 'Save is successful.' message is displayed at the bottom of the text area, with a 'Save' button next to it.

- To verify open the program back up and ensure your changes have taken effect.

If taking lines out of the program.

- First you will select your machine and then select the file by double clicking it.

The screenshot shows the Progressive DNC software interface. The top navigation bar includes 'DNC', 'MDC', 'Configuration', 'System', 'Support', and 'Logout'. The left sidebar lists machines from CNC20 to CNC26, with CNC24 selected. The main area displays a file editor for the file path '\\btsdc2012\tapes\download\cnc24\7-262110045-11-N---25.TXT'. The file content is a CNC program with various G-code commands and comments. A 'Download Path' field shows '\\btsdc2012\tapes\download\cnc24\'. Below the file editor, there is an 'Upload Path' field and a list of files. The bottom left corner shows a 'Signal Strength' gauge at 100 and 'Device Details' for CNC24.

- Once the program is open take out the lines you want. Then press save and the changes will take effect.
- Image above displays taking these lines out.

BTS-LAB-SVR01 - ConnectWise Control

ProgressiveDNC2020Master - M... x + Your computer is being controlled by Tyler Arthur

Not secure | 192.168.110.12/Thingworx/Runtime/index.html#master=ProgressiveDNC2020Master&mashup=Operator%2520Dashb

Apps Thingworx Composer BTS Form Log in Moxa MTConnect Vembu BDR Data

Progressive DNC **Powered by Thingworx** DNC MDC Configuration System Support Logout

Machines

- 28-IAWS150A-6
- 4 port hub port #1
- 4 port hub port #2
- CNC20
- CNC21
- CNC22
- CNC23
- CNC24
- CNC25
- CNC26-Wired
- CNC64.2

CNC24

Download Status

0

Signal Strength

94

Device Details

CNC24

Download Path

\\btsdc2012\tapes\download\cnc24

1234

7-262

Upload Path

\\btsdc2012\tapes\upload

bridgeport

brothtc229

cincav200t

cnc11

cnc20

cnc21

cnc22

cnc24

cnc25

cnc26

\\btsdc2012\tapes\download\cnc24\7-262110045-11-N---25.TXT

%

O01125 (7-262110045-11-N--25.TXT)

(7-262110045-11)

(7/3/08 AT 9:11 AM)

(PROVEN 06-08-20 QUACK)

(MACHINE 0)

(CYCLE TIME 00:09:01)

(LAST RUN 19077 20020)

(SAVED RT 6/15/20)

N01 G54

N02 S800 M03

N03 G00 G90 X-1.0522 Y1.8226

N04 G43 H01 Z2. M08

N05 G00 G17 G40 G49 G80 G90

N06 G91 G28 Z0. M05

N07 T1 M06

(TOOL 1 .375 SPOT DRILL)

(OPERATION 1 HOLES)

N08 S800 M03

N09 G00 G90 X-1.0522 Y1.8226

N10 G43 H01 Z2. M08

N11 Z0.5

N12 G83 G98 X-1.0522 Y1.8226 Z-0.07 R0.1 Q0.03 F2.

N13 X1.0523

N14 X2.0888 Y-0.2565

N15 X1.0522 Y-1.8226

N16 X-1.0522

N17 X-2.1045 Y0.

N18 G00 G80 Z1. M09

N19 M05

N20 M01

N21 T2 M06 (LETTER " I " DRILL)

(TOOL 2 .272 DRILL)

Save is successful.

Save

- Image above after changes have been saved.

ProgressiveDNC2020Master - M: x + Your computer is being controlled by Tyler Arthur

Not secure | 192.168.110.12/Thingworx/Runtime/index.html#master=ProgressiveDNC2020Master& mashup=Operator

Apps Thingworx Composer BTS Form Log in Moxa MTConnect V Vembu BDR Data

Progressive DNC Powered By Thingworx

DNC MDC Configuration System Support Logout

Machines

- 28-IAWS150A-6
- 4 port hub port #1
- 4 port hub port #2
- CNC20
- CNC21
- CNC22
- CNC23
- CNC24
- CNC25
- CNC26-Wired
- CNC64_2

CNC24

Download Status

0

Signal Strength

98

Device Details

Download Path

\\btsdc2012\tapes\download\cnc24

Upload Path

\\btsdc2012\tapes\upload

bridgeport
brothtc229
cincav200t
cnc11
cnc20
cnc21
cnc22
cnc24

\\btsdc2012\tapes\download\cnc24\7-262110045-11-N---25.TXT

```

%
O01125 (7-262110045-11-N--25.TXT)
(7-262110045-11)
(7/31/20 AT 9:11 AM)

1234.
7-262110045-11-N---25.TXT
(PROVEN 06-08-20 QUACK) |
(MACHINE 0)
(CYCLE TIME 00:09:01 )
(LAST RUN 19077 20020)
(SAVED RT 6/15/20)

N01 G54
N02 G00 G17 G40 G49 G80 G90
N03 G91 G28 Z0. M05

N04 T1 M06
(TOOL 1 .375 SPOT DRILL )
(O OPERATION 1 HOLES )
N05 S800 M03
N06 G00 G90 X-1.0522 Y1.8226
N07 G43 H01 Z2. M08
N08 Z0.5
N09 G83 G98 X-1.0522 Y1.8226 Z-0.07 R0.1 Q0.03 F2.
N10 X1.0523
N11 X2.0888 Y-0.2565
N12 X1.0522 Y-1.8226
N13 X-1.0522
N14 X-2.1045 Y0.
N15 G00 G80 Z1. M09
N16 M05
N17 M01

N18 T2 M06 ( LETTER " I " DRILL )
(TOOL 2 .272 DRILL )
(O OPERATION 2 HOLES )
N19 S850 M03
N20 G00 G90 X-1.0522 Y1.8226

```

Save is successful..

Save

- To verify open the program back up and ensure your changes have taken effect (shown above).