IsoUs – Ultimate Step
Plugin – Go Block

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PROMAX Motion & Control

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1 Go Block

This PlugIn allows to execute a Gcode file from a specific line number.
For a correct use is necessary to configure the GO BLOCK MACRO
Ex:

Essential functions to insert in the MACRO GO BLOCK (ex: for 3 Axes system)
Generate the relative M GOBLOCK set in the configurator by PlugIn MHM

$POSX=$[C0] //Resume the Axis X counter
$POSY=$[C1] // Resume the Axis Y counter
$POSZ=$[C2] // Resume the Axis Z counter
G96 //Offset suspension
G98 //Work Origins suspension
G0 Z[0] //Move Z in the security position
F1 //Set Feed
G1 X[$POSX] Y[$POSY] //Move X,Y to init position
G62 //Wait Axes
G1 Z[$POSZ] //Move Z in the init position
G62 //Wait Axes
G97 //Resume Offset
G99 //Resume Work Origins
//Others functions
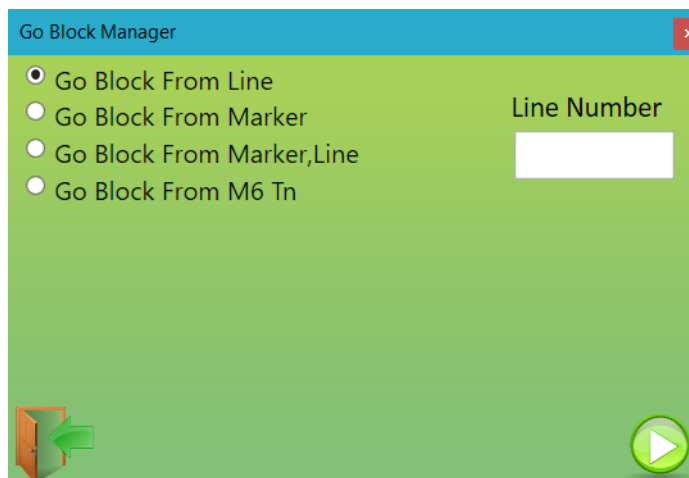
1.1   PlugIn Utilization

For use the PlugIn need select the Type of resume and press the button **START**:

Resume from Line Number

Go Block From Line

Insert the line number in the field **"Line Number"**
If the Gcode file is simulated in preview, you can get the line number directly with mouse from the preview function:

Resume from Marker

Go Block From Marker

This type of resume, is necessary when the Gcode file uses a **LOOP FUNCTION**.
The **MARKER** is a special variable that can be identify a **LOOP ITERATIVE VALUE**
Ex:

MARKER $VAR "TEST MARKER 1"
LOOP 100
  $VAR=$VAR+1
  G1X100Y200Z10
  G1X20Y30Z0
  //.....
  //.....
END_LOOP

Marker Name	Marker Description	Value
VAR	TEST MARKER 1	20

Insert with double click the **MARKER VALUE** in the field **VALUE**.
In the above example, the resume will be performed when the **MARKER $VAR** will have the value 20

Resume from Marker and Line Number

Go Block From Marker,Line

The resume is activated with combined **MARKER** value and **Line Number**

Resume frim M6 function (Tool Change)

Go Block From M6 Tn

The resume is activated from specific **M6** cycle.
Select the **M6** cycle

Set	Gcode	Line
☐	M6T1	49
☑	M6T9	127
☐	M6T5	411

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