

IsoUs – Ultimate Step
Plugin – Retrace

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Motion
&
Control

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1 Retrace

Retrace allows to work a Gcode file, drawing the tool path, **FORWARD** and **BACKWARD**, with **JOG BUTTONS** and allows to make a **RESTART** from **ANY POINT**.

Retrace is like to PlugIn **GO BLOCK**, but the difference with it, is that the work **RESTART** can be performed for any **POINT** to **G1,G2,G3** and not only from beginning how allows **GO BLOCK**.

RETRACE IS OPTIMIZED FOR 3 AXES MACHINES

For a correct use is necessary to configure the **GO RETRACE MACRO**

Ex:

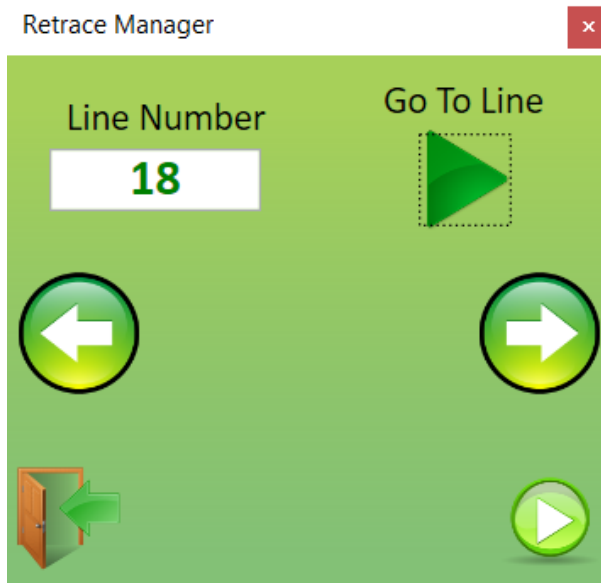
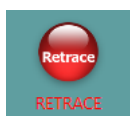
Essential functions to insert in the MACRO GO RETRACE (ex: for 3 Axes system)

Generate the relative M GORETRACE set in the configurator by PlugIn MHM

```

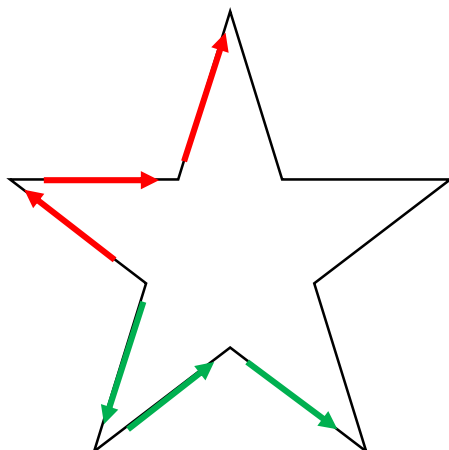
$POSX=${C0} //Resume the Axis X counter
$POSY=${C1} // Resume the Axis Y counter
$POSZ=${C2} // Resume the Axis Z counter
G96 //Offset suspension
G98 //Work Origins suspension
G0 Z[0] //Move Z in the security position
F1 //Set Feed
G1 X[$POSX] Y[$POSY] //Move X,Y to init position
G62 //Wait Axes
G1 Z[$POSZ]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

```



1.1 Plugin Using

With Retrace is possible to move **X,Y AXES** on tool path



1.1.1 Go To Line

For jump directly to Gcode line number:

- 1) Insert in the **FIELD LINE NUMBER** the Gcode line Number desired

Line Number
18

- 2) Press button **Go To Line**



The **X,Y AXES** will go directly to number of line inserted.

The movement can be interrupted by **BUTTON STOP OF ISOUS**:



WARNING

**THE BUTTON STOP DOES NOT GUARANTEE AN EMERGENCY CONDITION.
THEREFORE IT MUST BE GUARANTEED BY EXTERNAL CERTIFICATED COMPONENTS**

1.1.2 JOG Forward and Backward

For **JOG** of the Tool Path in **FORWARD** and **BACKWARD** direction press the **BUTTONS**:



The axis movement is performed in **NEGATIVE** or **POSITIVE** direction. The movement is interrupted by **BUTTON RELEASE**.

The axis speed is got from **CURRENT FEED OF GCODE LINE**.

1.1.3 Restart from current Point

For **RESTART** for current point press the **BUTTON**:



The PlugIn makes the **WORK RESTART** how is indicated in the **MACRO GO RETRACE**

Index

1	Retrace	3
1.1	PlugIn Using	4
1.1.1	Go To Line	4
1.1.2	JOG Forward and Backward.....	5
1.1.3	Restart from current Point.....	5