



User manual

CNC-EDIT

Version 3

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Installation

Requirements

CNC-Edit does not need special equipment and should work with any PC that runs Windows about 2MB of free hard disk space for installation. Running CNC-Edit on slow computers detract the Monitor function.

Software protection

To use all functions of CNC-Edit, you have first to unlock the software. From version 3.0 "Register". The base functions are always available. You will get the username and the password you have purchased CNC-Edit or already own a hardlock for CNC-Edit 2, please contact us for the username and a code.

This list show you which functions are free or only accessible via registration.

<i>Function</i>	<i>Free</i>	<i>Hard lock</i>
Edit program in the editor	✘	✘
Data transmission	✘	✘
Compress		✘
ReNUMBER		✘
Change values		✘
Mirror		✘
Reverse		✘
Decimal points		✘
Convert axes		✘
Separate		✘
Monitor		✘

Step by Step

To install CNC-Edit, please start the installation program „SETUP.EXE“ in the „CNC-Edit“ folder. Follow the instructions of the dialogs. After you have closed the last dialog with [OK], CNC-Edit will be installed. The program links will be created at „Start – Program files – SM-STAHl“ in the Start-Menu.

Start

Click on the link „CNC-Edit“ in the Start-Menu to start CNC-Edit.

Common

The software CNC-Edit should simplify the work with CNC-programs which were written for other software. Therefore several functions are built in to edit existing CNC-programs. The data transmission function enables you to transfer data between the PC and the CNC.

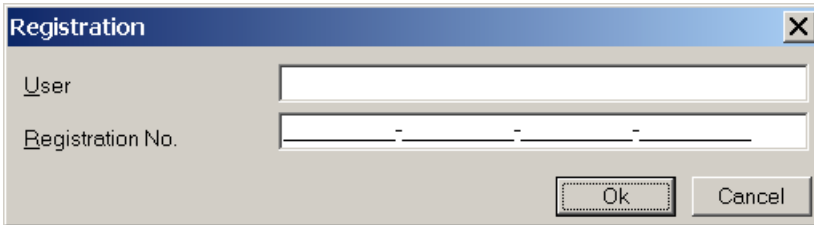
After you have modified a CNC-program with the functions of CNC-Edit, you should always set a low override before you use it in the daily production process.



Nevertheless, despite detailed tests, we cannot guarantee that there are no bugs in the software. In case that there will appear any errors or you have any suggestions to improve CNC-Edit, please feel free to contact us. SM-STAHl is not responsible for any damage that results from the use of CNC-Edit.

Registration

By the registration dialog you can unlock the enhanced functions of CNC-Edit. The username and a registration number. Please preserve these informations to unlock CNC-Edit. Enter the name and the number at the dialog “Help – Registration”. Take care of upper and lower case. After clicking at [Ok], you can use all functions of CNC-Edit. If you have received the data per email, you can copy and paste the values to the appropriate fields.



The image shows a standard Windows-style dialog box titled "Registration". It features a blue title bar with a close button (X) on the right. The main area is light gray and contains two text input fields. The first field is labeled "User" and the second is labeled "Registration No.". The "Registration No." field has three dashes (- - -) indicating a three-part number. At the bottom right of the dialog are two buttons: "Ok" and "Cancel".

Picture 1: Dialog Registration

Menus

Files

New



Creates a new edit window.

Open...



Reads a file from a data device to a new edit window.

Restore

Replaces the contents of the active editor with the last saved version of the file.

Last opened

Show a list of recently opened files.

Save



Saves the contents of the active editor window to a storage medium. If the file does not exist, the „Save as“ function will be executed.

This menu entry is only available if the contents of the editor has changed since the last save.

Save as...

Saves the contents of the active edit window to a storage medium. Thereby a dialog box is opened to enter the file name.

Close

Closes the active editor window. If there are unsaved modifications, you will be prompted to save before closing.

Close all

Closes all editor windows. If there are unsaved modifications in one of the editor windows, you will be prompted to save the file before closing.

Setup page

Shows the page setup dialog. Here you can configure the format of the printout.

Preview

Opens a preview window to show how the printout looks.

Print



Show the print dialog and print the contents of the active editor window.

Cut



Moves the selected text to the clipboard.

Paste



Insert the text from the clipboard at the cursor position into the editor.
Evtl. selected text will be deleted.

Select all


Selects the whole text in the editor.

Delete



Deletes the selected text in the editor.

Preferences

Opens the configuration dialog 37. Here you can modify the base settings of CNC-E

Find

Find

Shows the find dialog.

Replace

Shows the find/replace dialog.

Find again

Repeats the last find operation.

Replace again

Repeats the last replace operation.

Go to line

Opens a dialog to enter a line number. Pressing [OK] will move the cursor to the begin

Go to program no.

Opens a dialog to enter a program no. Pressing [OK] will move the cursor to the be
the entered program no.

View

Show sidebar

Shows / hides the sidebar.

Toolbars

CNC-Program


Compress



Shows the compress dialog 16.


Renumber



Shows the renumber dialog 17.


Decimal points



Shows the dialog for modifying the decimal points of axes 18.


Change values



Shows the dialog for changing the values of axes, feed rate and R-parameters 19.

Mirror



Shows the dialog of the mirror function 21.


Reverse



Executes the reverse function 23.


Convert axes



Shows the dialog for converting axes 24.

Separate




Shows the program separation dialog 25.

Data transmission

Receive / send data



Shows the data transmission dialog 32. Use this function to transmit data between


Connection manager



Shows the dialog for predefining data transmission connections for different machi

Monitor



Shows the Monitor dialog 35. You can use the Monitor to control a SM-STAHL m

Windows

Help

Hints

Switches hints for control elements on and off.

Registration

If you have the username and the code, use this dialog to unlock all functions of CNC

About

Shows the about dialog of CNC-Edit. Here you can find the program version and cont

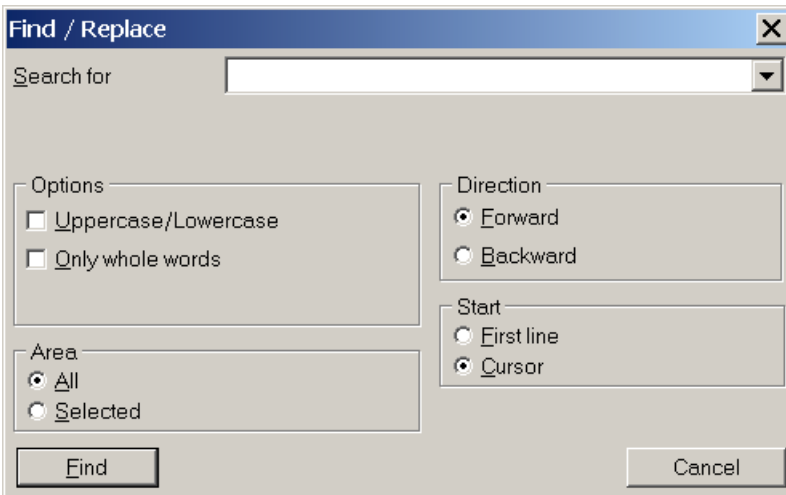
The Editor

CNC-programs are modified in an editor. The editor is the main part of CNC-Edit. You can have multiple editor windows at the same time.

In the appendix: Keyboard (📄 45) you find the keyboard shortcuts of the editor.

Find

Use the find dialog to search for text inside an editor. The command “Edit – Find” starts the find operation again.



Picture 2: Dialog find

Input fields

Search for

Enter here the text to search for.

Options – Uppercase / Lowercase

The search function will distinguish between uppercase and lowercase chars.

Options - Only whole words

The find operation only searches for whole words. If only parts of the text appear, the find operation fails.

Area - All

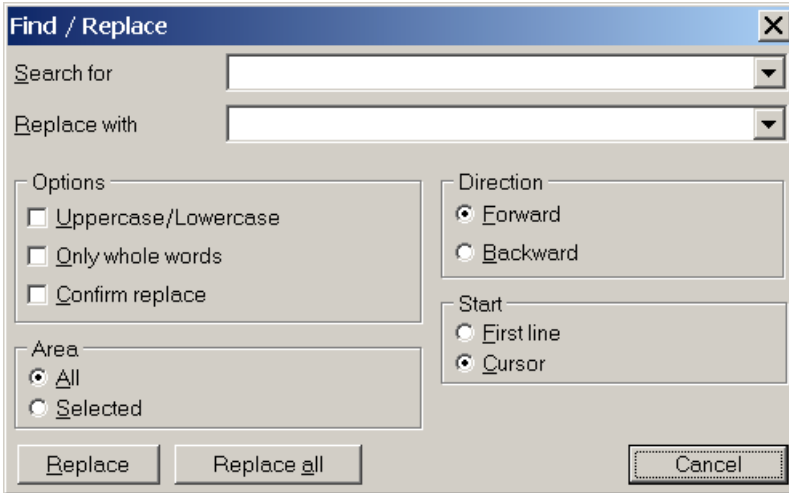
The complete contents of the editor will be searched.

Area: Selected

Only the selected area in the editor will be searched.

Replace

Use the replace dialog to find text and replace it with other text. The command “Edit → Replace” starts the last replace operation again.



Picture 3: Dialog Replace

Most of the input fields appropriate the one in the find dialog. So only the different fields a

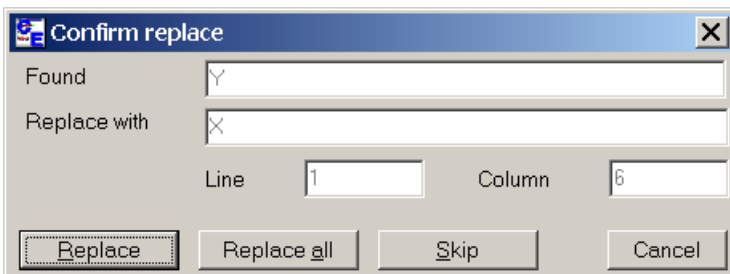
Input fields

Replace with

Text which replaces the found text position.

Options – Confirm replace

Before a text will be replaced, a dialog is show, to confirm the replace operation. The dialog shows the following choices:



Picture 4: Dialog Confirm replace

Bookmarks

Bookmarks are positions in the text, which can be set via the keyboard shortcuts [C] define up to ten bookmarks. To move the cursor to a bookmark use the shortcuts [C] the bookmarks are shown as small rectangles with the captions 0..9.

To switch on and off the following functions or to modify their parameters, use the pre

Syntaxhighlighting

The different items of a CNC-record like record no., axis identifier, comments, ... are better readability.

Border line

The border line can be shown at an arbitrary column. It serves a survey over the program set the position to 120, because that's the limit of char per line for a CNC-pr

Line numbers

The line numbers are shown in the gutter of the editor. They serve the better orientati

Background color of the actual line

The line with the cursor can be shown in a deviating background color. Thereby th relieved.

Automatic record number generation

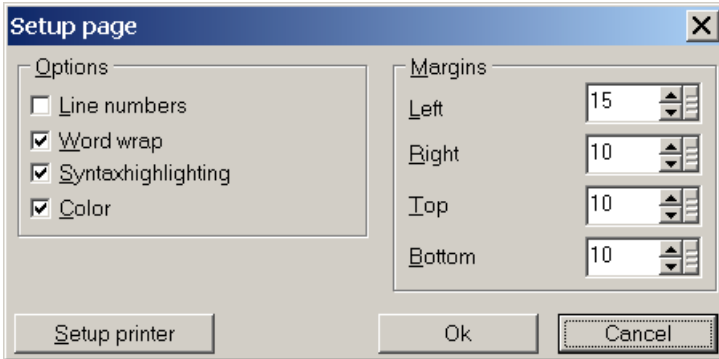
The keyboard shortcut [Strg]+[Enter] inserts a new line with a record number into record number, the value of "Interval record-no. generation" from "Preferences – Edit Three different cases can appear when using this function:

- ▶ The cursor is located in an empty line:
The new record number receive the value of "Interval record-no. generation".
- ▶ The cursor is located in a line with record number, followed by an empty line:
The new record number is build out of the record number of the actual line plus generation".
- ▶ The cursor is located in a line with record number, followed by another line with re
The new record number is average between the record number of the actual ar

Printing

You output print the contents of the editor on a printer.

Setup page



Picture 5: Dialog Setup page

Input fields

Options – Line numbers

The line numbers will be printed.

Options – Word wrap

Lines, that are wider than the available page width, will be wrapped.

Options – Syntaxhighlighting

Activates the syntaxhighlighting for the printout. Certain program elements will format.

Options – Color

If the printer supports color printouts, the text will be printed in color.

Margins –Left, Right, Top, Bottom

Enter here the distance of the text to the edges of the page. The values are in centimeters. The values are given by the printer.

Control elements

[Setup printer] Shows the dialog to setup the printer.

[OK] Take over settings and close the dialog.

[Cancel] Close the dialog.

Scaling (right area of the control panel)

Here you can adjust the scaling of the preview.

Control elements



Shows the first page of the preview.



Shows the previous page of the preview.



Shows the next page of the preview.



Shows the last page of the preview.



Modifies the scaling to show the whole page width in the preview dialog.



Modifies the scaling to show the whole page in the preview dialog.



Shows the page setup dialog.



Starts the printout.



Closes the preview dialog.

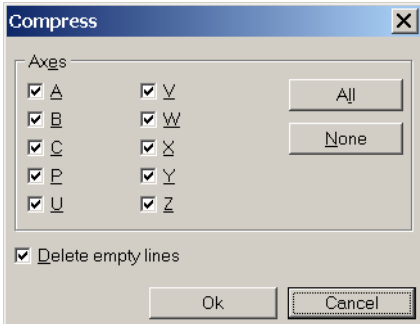
Start printing

If you select the menu item “File – Print” or click on the print button in the preview, the printer, the print area and the number of copies. Click on the button [OK] to start the printout.

Compress

The teach process always takes over all axes into the cnc program. Positions of axes that are recorded are without meaning for the later program execution and will be deleted by the control unit. Less memory is needed for that program by the control unit.

Thereby it is possible, that a record has no contents after compression. Such records are



Picture 7: Dialog Compress

Input fields

Axes A..Z

Only selected axes are considered by the compress function.

Delete empty lines

If this option is enabled, records which are empty after compression, will be deleted.

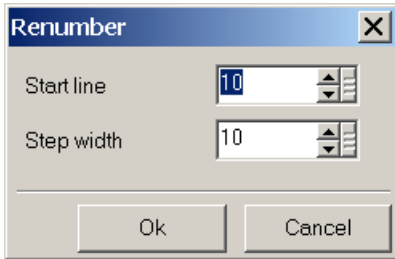
Control elements

- | | |
|----------|---------------------------------------|
| [All] | Select all axes. |
| [None] | Deselect all axes. |
| [Ok] | Execute compression and close dialog. |
| [Cancel] | Close dialog. |

Renumber

At renumbering new record numbers are generated for the selected program lines. You enter the start line and a value that increases the record number of the next program line at a time.

Branches inside a CNC-program will be adapted to the new record numbers. The actual record numbers are generated for the selected program lines. It is possible to renumber more than one CNC-program at a time. The record number of the first program number always receives the record number of **Start line**.



Picture 8: Dialog Renumber

Input fields

Start line

Record number of the first line to renumber.

Step width

Value that increases the record number of the following line at a time.

Control elements

[Ok]

Start renumbering with the entered parameters and close the dialog.

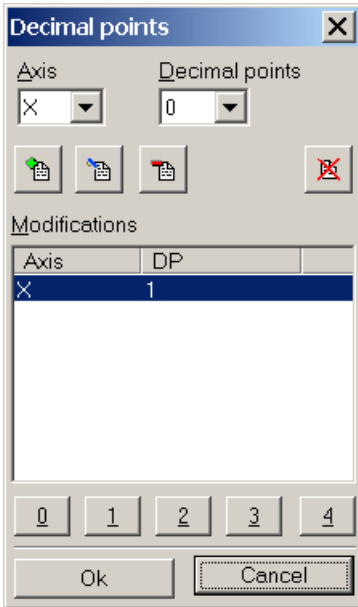
[Cancel]

Close the dialog.

Decimal points

This function modifies the number of decimal points of axes values.

Normally at teaching axes value are generated with the precision of two or three decimal level of precision, with this function you can adjust the number of decimal points in the range to enter the count for each axis separately. Only one entry per axis is allowed in the modifications table.



Picture 9: Dialog Decimal points

Input fields

Axis

Select the axis whose decimal points should be modified.

Decimal points

Enter the number of decimal points here.

Modifications

This list show the modifications that will be made.

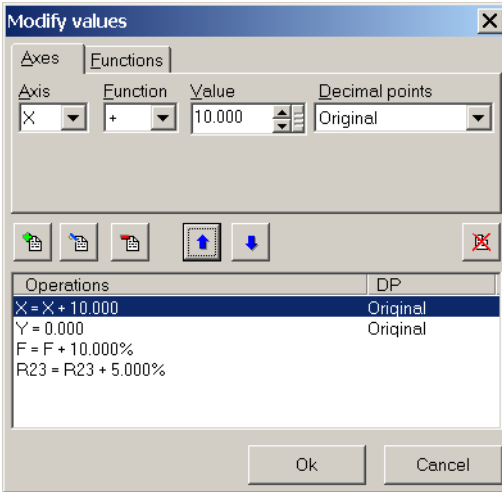
Axis - Axis which should be modified.

DP - Number of decimal points.

Modify values

Modifying axes values, feed rate values and R-Parameters from an arithmetic operation.

The operations were executed in the order of the operations list. If you process a new operation identifier, the order in the operations list effect the end result.



Picture 10: Dialog Modify values

Input fields - Axes

Axis

Axis identifier for the operation.

Function

Arithmetic operation or assignment to adapt to the identifier value.

The following functions are available:

- ▶ "+" Add the field Value to the axis value.
- ▶ "-" Subtract the field Value from the axis value.
- ▶ "*" Multiplies the axis value by the field Value.
- ▶ "/" Divide the axis value by the field Value.
- ▶ "=" Assign the field Value to the axis.

Value

Value to use for the function.

DP

Count of decimal points of the result. With the setting "original" the result has the same number of decimal points as the former axis value.

Mode

Type of value.

- Value - Operations value is a number.
- per cent - Operations value is in per cent.

In “per cent” mode only the functions “+“ and “-“ are available.

Function

Arithmetic operation or assignment to adapt to the identifier value.

The following functions are available:

- ▶ “+“ Add the field Value to the identifier value.
- ▶ “-“ Subtract the field Value from the identifier value.
- ▶ “*“ Multiplies the identifier value by the field Value.
- ▶ “/“ Divide the identifier value by the field Value.
- ▶ “=“ Assign the field Value to the identifier.

Value

Value to use for the function.

Input fields – Functions

Operations list

List containing the impending operations.

Control elements



Insert a new operation into the operations list.



Replace the selected operation with the current values.



Delete the selected operation from the operations list.



Move the selected entries on line up.



Move the selected entries one line down.



Delete all entries from the operations list.

[OK]

Execute the function “modify values” and close the dialog.

[Cancel]

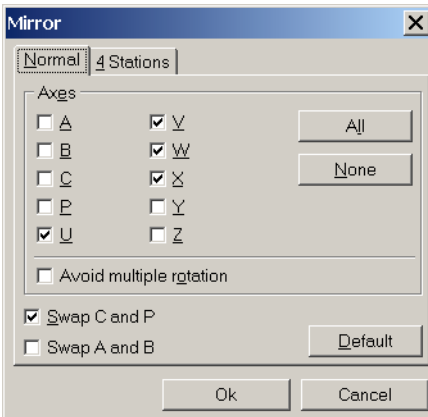
Close the dialog.

Mirror

The function “Mirror” reliefs the adjustment of CNC-programs for symmetrical work pieces.

The “Mirror” dialog offers two basic function modes.

- The *normal* mirror is used to generate a program for a symmetrical counterpart out of a



Picture 12: Dialog Mirror - normal

Input fields

Axes: A,B,C,P,U,V,W,X,Y,Z

The values of the selected axes are to be negated.

Avoid multiple rotation

On calculation of rotation axes, multiple rotations are suppressed when moving



If you use this function, you should check the result exactly, because CNC-E some axes.

Swap C and P

The values of the axis identifiers C and P are to be swapped when mirroring.

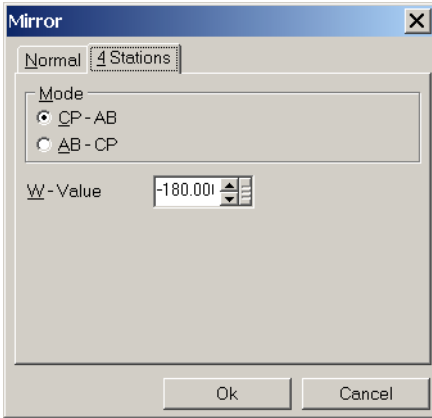
Swap A and B

The values of the axis identifiers A and B are to be swapped when mirroring.

Control elements

[All]

Select all axes



Picture 13: Dialog Mirror - 4 stations

Input fields

Mode - CP – AB

Mirror station pair CP to AB.

Mode - AB – CP

Mirror station pair AB to CP.

W-Value

Value to modify the W-axis.

Control elements

[Ok] Execute function mirror and close dialog.

[Cancel] Close dialog.

Mode: Normal

After mirroring you get in opposite to the original a program with swapped stations. That swap the configuration of the stations inside the machine too. For instance, on a CNC grinder you have to install the contact wheels and the grinding belts of station C to station P and

Example:

Supposed you have two symmetric work pieces. For work piece one you already get a program, create the same program for work piece two. In this case you can create a completely new program from the already existing program.

Mode: 4 stations

This mode is only suitable for 4 station machines. The program flow is mirrored crosswise

Example:

Reverse

The flow of the selected program part is to be reversed. Means, the appropriate direction.

The reverse function reliefs the adaption of program parts to other stations of the machine.

Conditions:

- ▶ If the working area contain a program line with G64-word, there have to be at least 3 axes values in front of that line.



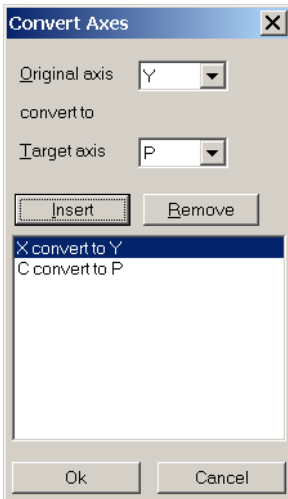
This function is very complex and therefor should only be used from experienced users.

Convert axes

This function replaces axes identifiers with other axes identifiers.



It will not be checked if there are already axes with the same identifiers in the line



Picture 14: Dialog Convert axes

Input fields

Original axis

Axis to be modified.

Target axis

Axis identifier to whom the original axis will be converted.

Modifications list

Contains all operations to be executed.

Control elements

[Insert]

Inserts an operation into the modifications list.

[Remove]

Removes an operation from the modifications list.

[Ok]

Executes the operations and closes the dialog.

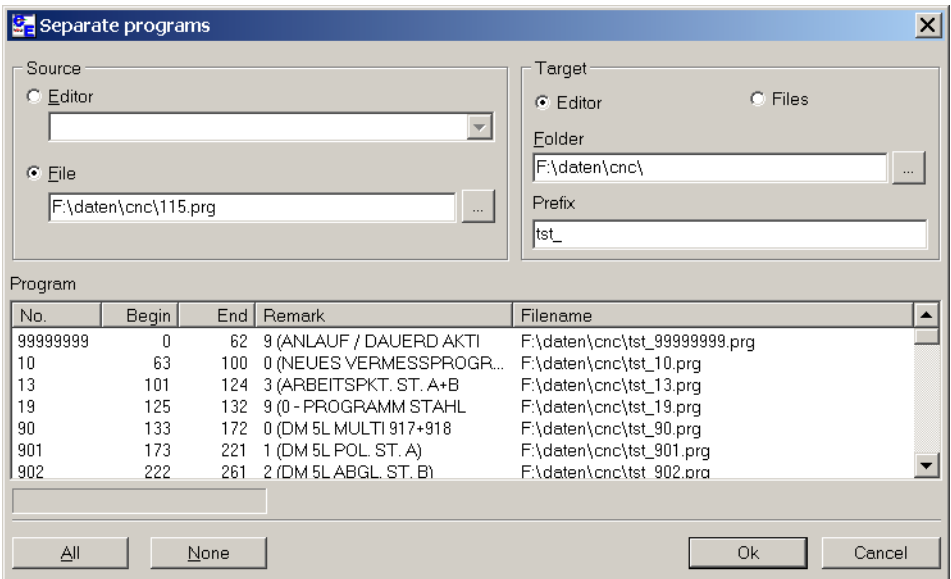
Separate

The function “Separate” splits a file containing multiple CNC-programs into single programs.

All programs located in the control unit can be transmitted to the PC as a single program out of this file and send it back to the control unit, you first have to save the file. “Separate” takes care of the searching and copying of single programs from you. They are placed in new editor windows or direct in files on a data carrier.

Filenames are generated out of Folder, Prefix and the program number of the appropriate program list and are updated on every modification of the input fields.

Only those programs which are selected will be extracted from the source file. This current state of the separate process is shown by a progress bar below the programs list.



Picture 15: Dialog Separate programs

Input fields

Source - Editor

Activate this option to separate a file located in a editor window. Use the appropriate editor window

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Prefix

The Prefix is located at the beginning of the filename of the separated program names of all new files at a moment.

Programs

The programs list shows all CNC-programs located in the "Source".

No.	- Program number of the CNC-program.
Begin	- Start line of the CNC-program.
End	- End line of the CNC-program.
Remark	- Program name.
Filename	- New generated filename.

Control elements

[All]	Select all programs in the programs list.
[None]	Deselect all programs in the programs list.
[Ok]	Execute separation and close the dialog.
[Cancel]	Close the dialog.

Sidebar

The sidebar can be displayed in the left area of the main window. To modify its width, click on the border of the sidebar, until the shape of the mouse cursor turns into the resize symbol. Then, click and drag the button and hold it down while moving the mouse horizontally.

If the sidebar is displayed the first time after program start, it could take some seconds to be displayed because of scanning the file system.

Areas



Show file system



Show file favorites



Show folder favorites



Show history



Inspector



Error list

File system

Through the file system window you have access to the file system of the PC. By clicking on a file with the right mouse button, you get the same functionality as in the Windows Explorer. A double click on a file will open it in an editor window.

Control elements



Changes to the prior folder.



Changes to the CNC-Edit default folder.

Favorites: Files

Files that are often used, can be stored in the favorite files list. A double click on an element in the list will open it in an editor window.

Control elements



Inserts the name of the file, that is current edited, into the favorites list.



Favorites: Folders

Folders that are often used, can be stored in the favorite folders list. A double click on system showing the appropriate folder.

Control elements



Inserts the folder name of the file you are current working on into the



Inserts the folder name, located in the input field into the favorites list.



Modifies the selected entry to the contents of the input field



Removes the selected entry from the favorites list.



Opens a explorer window with the folder located in the input field.



Opens a folder selection dialog. The selected folder name is put to the

History

The history shows which file was opened or saved at what date and time. Use a double click in an editor window.

Control elements



If this button is down, files which were opened are shown.



If this button is down, files which were saved are shown.

Line inspector

The line inspector shows the elements and commands of a cnc-record in a clear way.

Error list

The error list shows errors CNC-Edit recognizes in CNC-programs. A double click on a line in the editor where the error occurs.

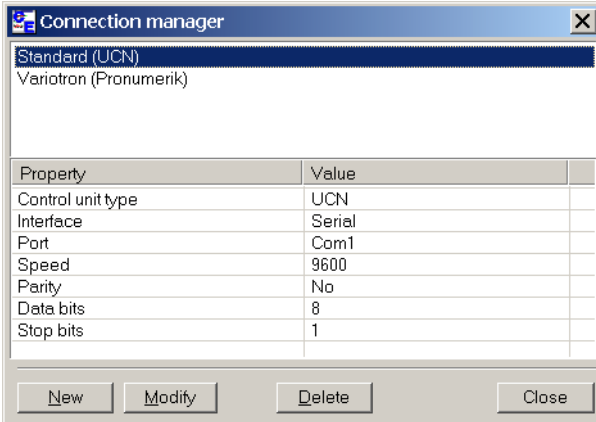
Control elements



Checks the CNC-program in the current editor.

Connection manager

In the connection manager you create connection parameter defaults for different predefinitions in the data transmission dialog. So you don't have to set all data transmission parameters for every connection.



Picture 16: Dialog Connection manager

Control elements



Inserts new connection definition into the list.



Copy marked connection.



Modifies the selected entry.



Deletes the selected entry.



Move marked connection upwards.



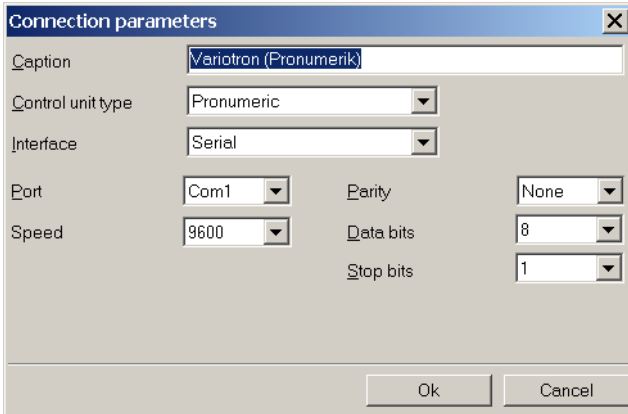
Move marked connection downwards.

[Close]

Closes the connection manager.

The connection definitions are shown in the upper area of the dialog. The connection parameters are shown below.

Connection parameters: Serial



Picture 17: Dialog Connection parameters Serial

Input fields

Caption

Caption of the connection preference.

Control unit type

Type of the control unit to be used for data transmission.

Interface

Type of interface for data transmission.

Port

Serial port.

Speed

Speed for data transmission given in Baud.

Default: 9600

Parity

Parity for serial transmission.

Default: None

Data bits

Number of data bits.

Default: 8

Stop bits

Number of stop bits.

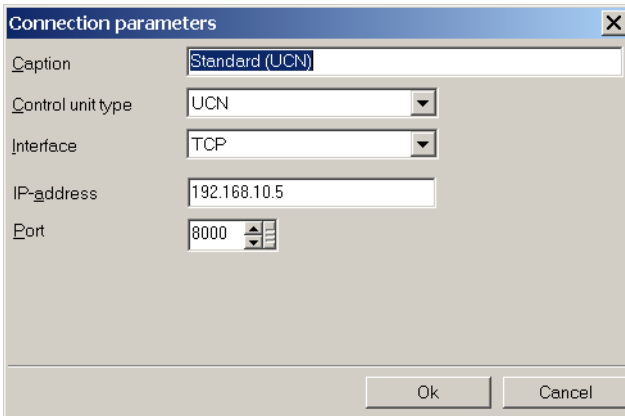
Default: 1

Control elements

[OK]

Takes over settings and closes dialog.

Connection parameters: TCP/IP



Picture 18: Dialog Connection parameters TCP/IP

Input fields

Caption

Caption of the connection preference.

Control unit type

Type of the control unit to be used for data transmission.

Interface

Type of interface for data transmission.

IP-Address

IP-Address of counterpart.

Default: 192.168.xxx.xxx

Port

Port address of counterpart.

Default: 8000

Control elements


[Ok]

Takes over settings and closes dialog.

[Cancel]

Closes dialog.

Data transmission

With the data transmission, data is sent to a control unit or received from a control unit. It parameters,... to a PC or to write them into the memory of the control unit. The pin out of find in appendix: Pin outs 50.

Depending on the control unit type there are different transmission modes available:

Normal:

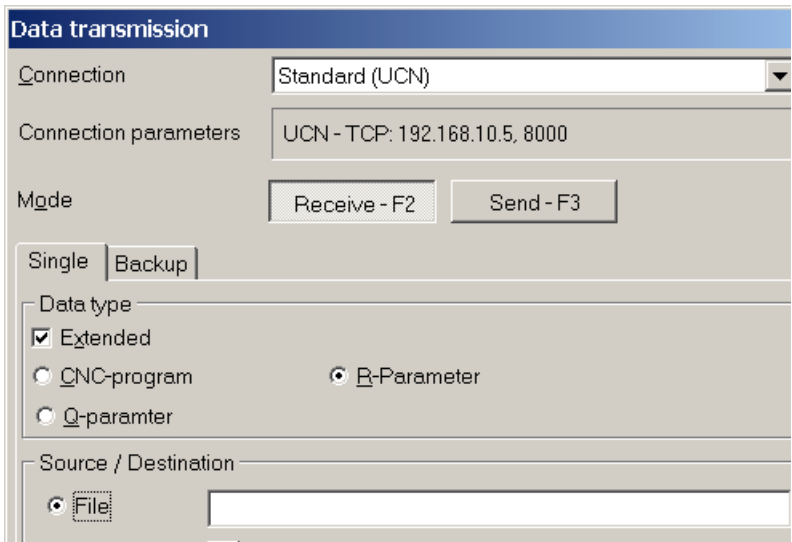
In this mode you have to make settings at the control unit and the PC, to transmit data.

Extended:

In the extended mode data can be transmitted automatically. Means, the complete data the PC. It's not necessary to setup the control unit.

Possible combinations for control unit types and data types:

	<i>Pronumeric</i>	<i>Promodul-U</i>
Normal	X	X
Extended		X
CNC-programs	X	X
Q-parameters	X	X
R-parameters	X	X
PLC	X	



[Receive - F2]	Data transmission from control unit to PC.
[Send - F3]	Data transmission from PC to control unit.
File ...	Shows a selection dialog for the file name of the send
[+]	Create new editor window.
[Start]	Start the data transmission.
[Cancel]	Interrupts a active data transmission.
[Close]	Closes the data transmission dialog.

Input fields

Connection

If you have created predefinitions in the connection manager, you can choose

Connection parameters

This fields displays the current connection parameters. They can be modified w

Mode: Single

Data type – Extended

Switches on and off the extended data transmission. The input of transmission data type is only possible in the extended mode.

Data type – CNC-program

Select this option if you want to transmit CNC-programs.

Parameters

Program No. 1

You have to enter the program number of the program you want to send or re (in quotation marks), all programs are to be transmitted.

Data type – Q-parameters

Select this option if you want to transmit Q-parameters.

Data type – R-parameters

Select this option if you want to transmit R-parameters.

Parameters


0 to 9679

Enter the range of parameters you want to transmit. Possible values are from 0

Data type – SPS

Error recovery

- ▶ Check if the transmission cable is linked to the correct interface and that it is fixed.
- ▶ Have you selected the correct control unit type?
- ▶ Are the interface parameters ok?
- ▶ CNC-Programs can only be sent to the control unit, if no program with the same number is already sent to the control unit.

If the control unit switches to receiving mode at extended data transmission, but the transmission is not finished, the value Delay time in “Preferences – Data transmission” 43.

Procedure:

Pronumeric - Normal

- ▶ Select in the data transmission dialog the type of data you want to transmit.

Sending:

- ▶ Execute the steps, to receive the appropriate data, at the control unit.
- ▶ Start the transmission at the control unit.
- ▶ Start the transmission at the PC by clicking on [Start].

Receive:

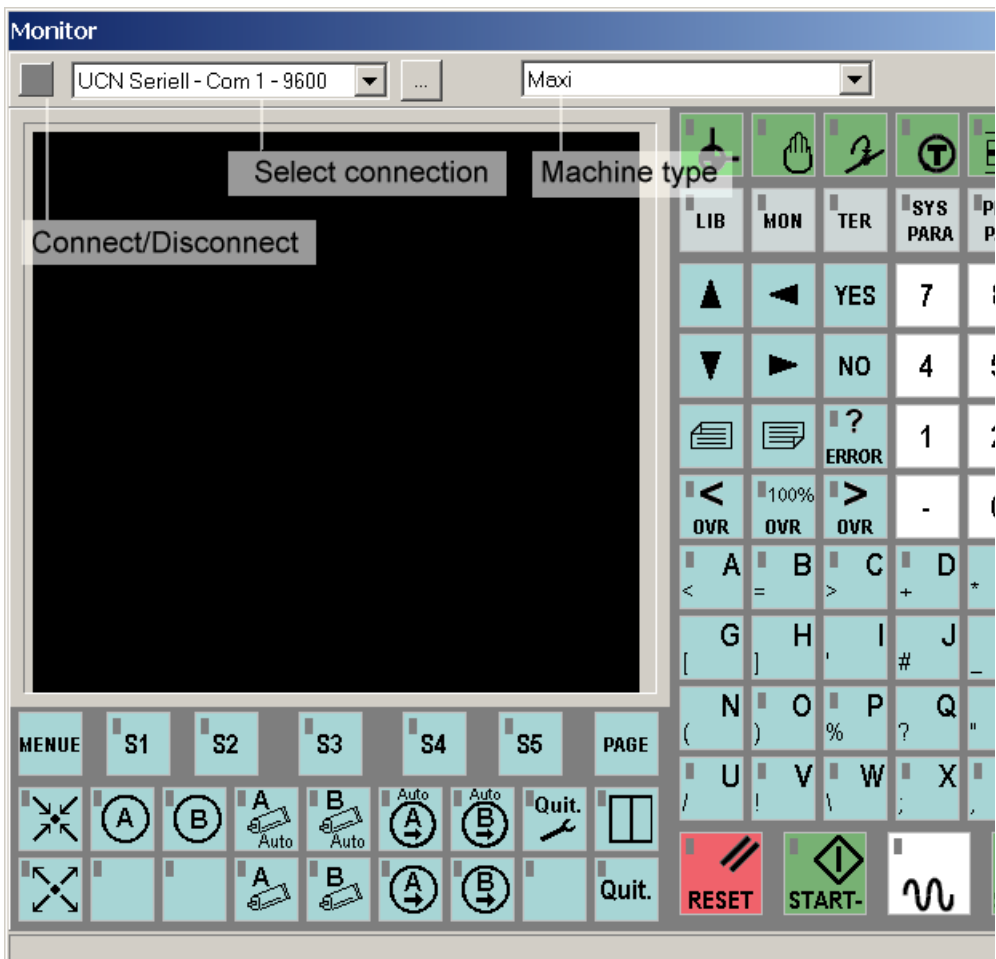
- ▶ Execute the steps, to send the appropriate data, at the control unit.
- ▶ Start the transmission at the PC by clicking [Start].
- ▶ Start then transmission at the control unit.

Promodul-U – Extended

- ▶ Select in the data transmission dialog the type of data and the transmission mode. See [here](#).
- ▶ Start the transmission at the PC by clicking [Start].

Monitor

The Monitor copies the control panel UTE completely. It can also be used for machines by an UBG. In that case, all functions of the UBG are transferred to the surface of the the Pronumeric control unit are supported.



Picture 20: Monitor – Machine type Maxi

Input fields

Connect/Disconnect

By clicking this button, a connection to the control unit is established, or a connection is terminated.
During connecting to the control unit, the button flashed yellow. If the connection is established, the button is green.

Select connection

At this field, you can select the serial connection to the control unit. All

You can control the Monitor either by keyboard or by mouse. The appropriate function is assigned to the respective button at the control panel. The moving in mode rapid traverse is a special function and requires the [Ctrl]-button in addition to the “Start-”- or “Start+”-button.

Each function can be additionally executed by the keyboard. The shortcuts are listed in the appendix on page 47.

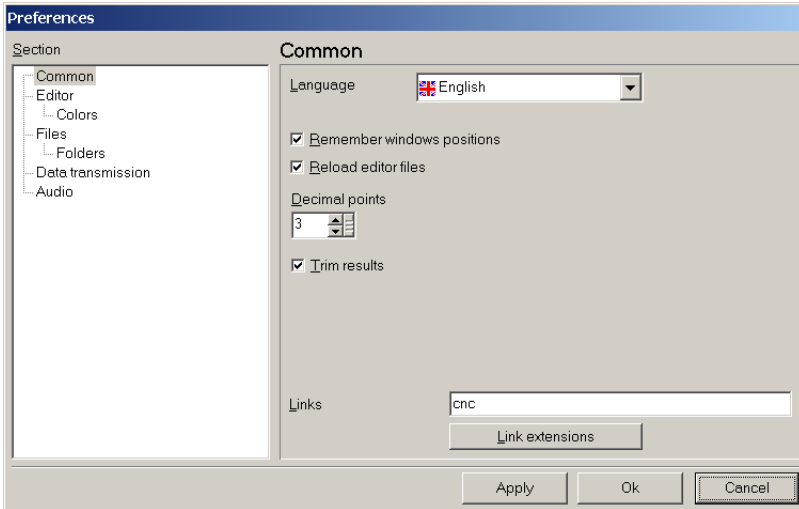
Before connecting, check if you choose the correct machine type. With a wrong monitor and the functions of the machine can differ.



Because you can use the Monitor in some distance from the machine, you're prone to accidents in emergency situations by pressing the Emergency-Stop-button of the machine. Be careful to ensure that the machine and persons beside the machine are not endangered by the function.

Preferences

The preferences define the base look and behavior of CNC-Edit.



Picture 21: Dialog Preferences

Control elements

- [Apply] Takes over the current settings.
- [Ok] Takes over the current settings and closes the dialog.
- [Cancel] Closes the dialog.

You can choose the section of the preferences from the list in the left area of the dialog.

Common



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Decimal points

Sets the number of decimal points of values in a CNC program.

Values which have to be calculated when calling a function, are normally restored to the original number of decimal points as the original value. If a calculation results more decimal points than the number of decimal points entered here is used.

Trim results

The decimal points setting is only considered if this option is active.

Suffixes

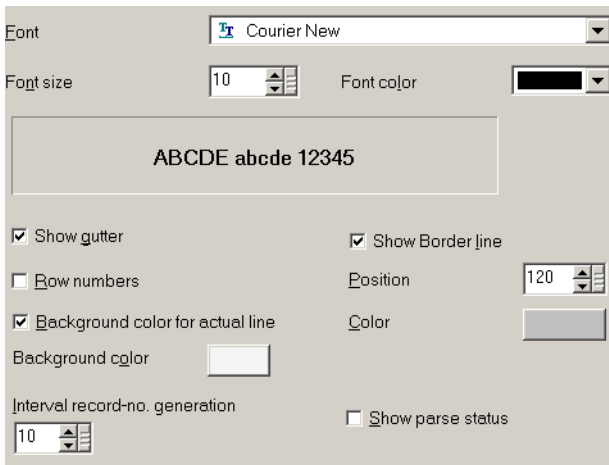
CNC-Edit can be set as default program for certain file types. A double click in Windows Explorer opens the files in CNC-Edit.

Enter the suffixes of the appropriate files separated by semicolons.

[Associate]

The suffixes are only associated to CNC-Edit, when pressing this button. The [C] button affect this setting.

Editor



Picture 23: Dialog Preferences Editor

Font

Select the font for the display inside the editor.

Font size

Sets the size of the chars inside the editor.

Font color

This is the color of the chars inside the editor.

The example text „ABC...“ shows the combination of font, font size and font color.


Show gutter

Shows a gutter for line numbers, bookmarks, ... at the left side in the editor.

Row numbers

Shows row numbers of the editor contents in the gutter.


Background color for actual line

Activates the background color  13 of the actual line, that holds the Cursor.

Background color

Here you can select the background color for the active line.

Show border line

The border line  13 serves as orientation for the line length.

Position

Rows in which the border line is shown.

Color

Color of the border line.

Editor – Colors

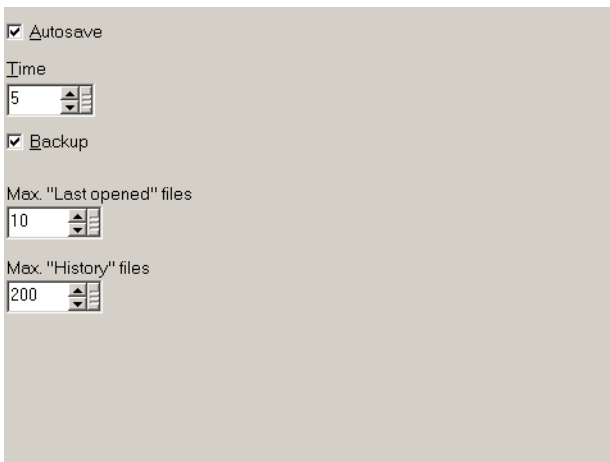


Picture 24: Dialog Preferences Editor - Colors

Syntaxhighlighting

Enables the Syntaxhighlighting  13 of the editor.

Files



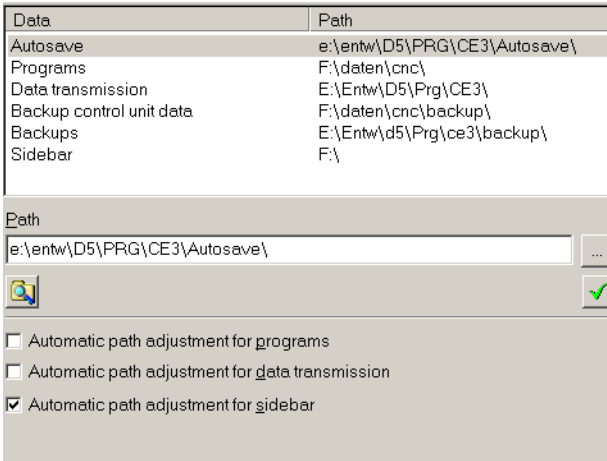
Picture 25: Dialog Preferences Files

Autosave

Enables autosave  13 for editor files.

Time

Files – Folders



Picture 26: Dialog Preferences Files - Folders

Control elements



Opens a dialog for choosing a folder.



Opens the Windows Explorer with the folder shown in Path.



Takes over the folder shown in Path to the folder list.

Input fields

Path

Use this input field to enter and edit folder names in combination with the control elements.

Automatic path adjustment for programs

When quitting the program, the last used folder for opening and saving of files is saved.

Automatic path adjustment for data transmission

When quitting the program, the last used folder for data transmission is saved for data transmission.

Automatic path adjustment for sidebar

When quitting the program, the actual used folder of the sidebar – file system is saved for the sidebar.

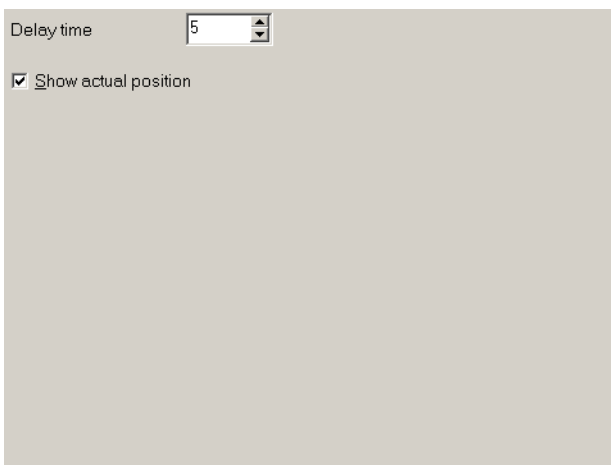
Folders

Autosave

Folder for autosave.

Programs

Data transmission



Picture 27: Dialog Preferences Data transmission

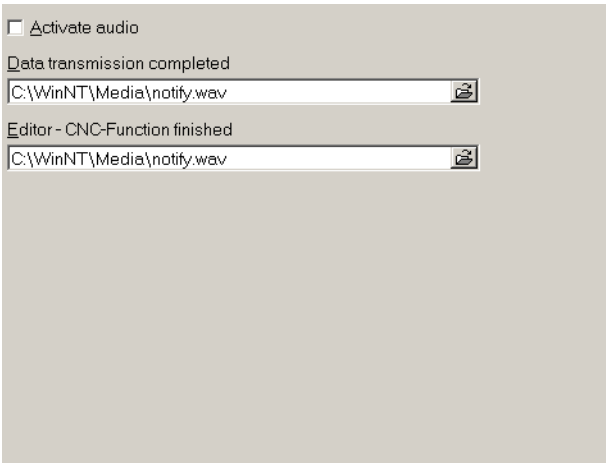
Delay time

When using the extended data transmission between PC and Promodul-U, the number of seconds the PC should wait until it begins to transmit data.

Show actual position

If the received data is written to the editor, always the current transmitted line is

Audio



Picture 28: Dialog Preferences Audio

Activate audio

Plays sounds for certain events.

The files for the appropriate event can be chosen with the symbol at the end of the input

Data transmission finished

This sound files is played, if the data transmission is finished.

Editor – CNC-operation finished

This sound files is played, if a CNC-operation is finished.

Appendix: Shortcuts

Shortcuts are described as followed.

[S]	Shift – key
[C]	Ctrl – key
[A]	Alt – key

That implies eg the shortcut

[SC] F1	Press and hold the Shift- and then Ctrl-key and press the F1
---------	--

Common

F2	Show/hide the sidebar.
F5	Opens the data transmission dialog.
[A] F4	Quits CNC-Edit.

Editor

Cursor up	Positions the cursor one row upwards.
Cursor down	Positions the cursor one row downwards.
Cursor left	Positions the cursor one char leftwards.
Cursor right	Positions the cursor on char rightwards.
Page up	Moves the contents of the editor one page downwards.
Page down	Moves the contents of the editor one page upwards.
Home	Moves the cursor to the beginning of the row.
End	Moves the cursor to the end of the row.
[C] Home	Moves the cursor to the beginning of the editor contents.
[C] End	Moves the cursor to the end of the editor contents.
[C] cursor right	Moves the cursor to the beginning of the next word.
[C] cursor left	Moves the cursor to the beginning of the previous word.
[C] cursor up	Moves the editor contents one row upwards.
[C] cursor down	Moves the editor contents one row downwards.
[C] page up	Moves the cursor to the upper edge of the editor window.
[C] page down	Moves the cursor to the lower edge of the editor window..

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[C] F	Opens the find dialog.
[C] R	Opens the find / replace dialog.
F3	Repeats the last find operation.
[S] F3	Repeats the last replace operation.
[C] G	Moves the cursor to a row with a certain number.
[C] U	Moves the cursor to a certain program.

Monitor

F1	LIB
F2	MON
F3	TER
F4	SYS PARA
F5	PROG PARA
F6	CYCL
F7	PROG
F8	Override -
F9	Override 100%
F10	Override +
F11	YES
F12	NO
[S] F1	Reference point
[S] F2	Manual control
[S] F3	Repositioning
[S] F4	Test
[S] F5	Single step
[S] F6	BLOK
[S] F7	Automatic
[C] F1	S1
[C] F2	S2
[C] F3	S3
[C] F4	S4
[C] F5	S5
[C] F11	Menue
[C] F12	Page
Insert	Insert / Teach
[S] Insert	Modify
[C] Insert	JOG/EDIT
Delete	Delete
Enter	Enter
Cursor up	Cursor up
Cursor down	Cursor down

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[C] W	F2
[C] E	F3
[C] R	F4
[C] T	F5
[C] Z	F6
[C] U	F7
[C] I	F8
[C] O	F9
[C] A	F10
[C] S	F11
[C] D	F12
[C] F	F13
[C] G	F14
[C] H	F15
[C] J	F16
[C] K	F17
[C] L	F18

Appendix: Glossary

Working area

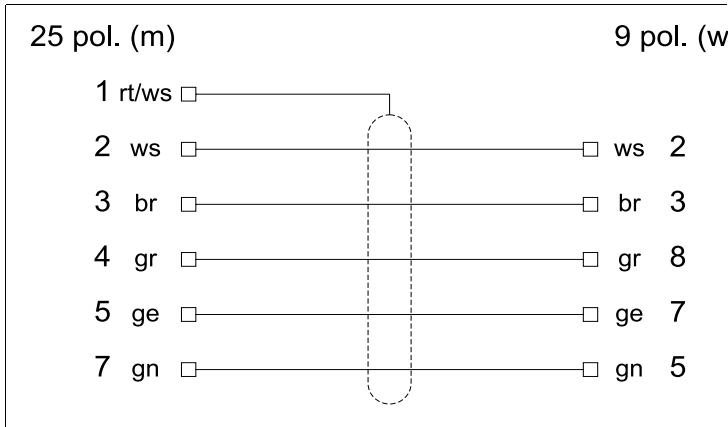
The working area is the whole contents of the editor or the selected lines, on which

Hints

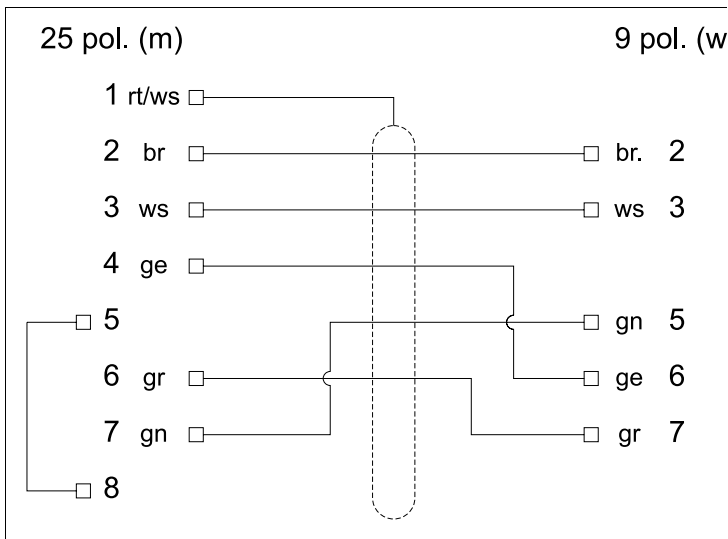
Hints are help texts for control elements, which are shown if the mouse cursor rests on an element.

Appendix: Pin out

Data transmission cable



Pin out Monitor - PC



Pin out Pronumerik - PC

15 pol. (m)

9 pol. (w)

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