

**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:

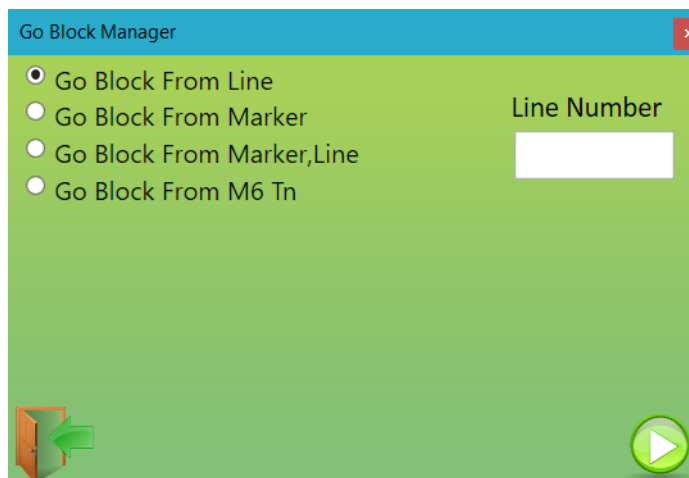
Essential functions to insert in the MACRO GO BLOCK (ex: for 3 Axes system)

Generate the relative M GOBLOCK set in the configurator by Plugin MHM

```

$PO SX=$[C0] //Resume the Axis X counter
$PO SY=$[C1] // Resume the Axis Y counter
$PO SZ=$[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[$PO SX] Y[$PO SY] //Move X,Y to init position
G62 //Wait Axes
G1 Z[$PO SZ] //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 from M6 function (Tool Change)

Go Block From M6 Tn

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

Select the **M6** cycle

Set	Gcode	Line
<input type="checkbox"/>	M6T1	49
<input checked="" type="checkbox"/>	M6T9	127
<input type="checkbox"/>	M6T5	411

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