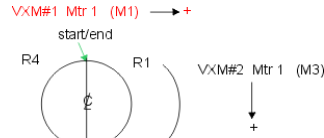


VXM Code Generator for Circles

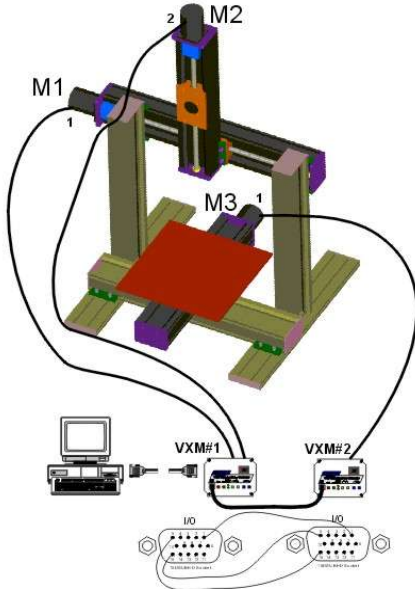
```

Enter> Desired Diameter = 1.000
Enter> Max Speed desired (1 to 6000 steps/sec) = 2000
Enter> Motor Power (blank=70%, A=100%)
Enter> Lead Screw Advance per turn = 0.1
Enter> Acceleration (1 to 127) = 10
Enter> M1 Direction toggle (0 or 1) = 1
Enter> M3 Direction toggle (0 or 1) = 1
Enter> Output 1 ON when moving (0=No, 1=Yes)
Enter> *Start command(s) A2M5,I2M400,P2,
Enter> End command(s) I2M-400
    
```

***NOTE: If start command is a motor Z Index put a 200ms pause (P2) after it**



NOTE: VXM#1 Output 2 must be connected to Input 1 of VXM#2 (Pin 15 to Pin 5) for this program to work



Gantry Router (M1 gantry with motor at left, M3 platen inverted)

```

VXM Text Program
(Copy and Paste all highlighted below into Notepad,
Save Notepad file, and transfer to VXM as text file
From HyperTerminal or COSMOS)
E[PM-1,
A1M 10,
S1M 57,I 3,
U0,U77,
S1M 153,I 8,
S1M 267,I 14,
S1M 363,I 19,
S1M 458,I 24,
S1M 575,I 30,
S1M 667,I 35,
S1M 762,I 40,
S1M 856,I 45,
S1M 955,I 50,
S1M 1051,I 55,
S1M 1131,I 59,
S1M 1221,I 64,
S1M 1295,I 68,
S1M 1375,I 72,
S1M 1452,I 76,
S1M 1524,I 80,
S1M 1584,I 83,
S1M 1649,I 86,
S1M 1701,I 89,
S1M 1757,I 92,
S1M 1807,I 95,
S1M 1849,I 97,
S1M 1886,I 99,
S1M 1916,I 100,
S1M 1947,I 102,
S1M 1967,I 103,
S1M 1982,I 104,
S1M 1994,I 104,
S1M 1999,I 106,
J2,PM-1,
A1M 10,
U15,U77,
S1M 1999,I 106,
U14,
S1M 1994,I 104,
S1M 1982,I 104,
S1M 1967,I 103,
S1M 1947,I 102,
S1M 1916,I 100,
S1M 1886,I 99,
S1M 1849,I 97,
S1M 1807,I 95,
S1M 1757,I 92,
S1M 1701,I 89,
S1M 1649,I 86,
S1M 1584,I 83,
S1M 1524,I 80,
S1M 1452,I 76,
S1M 1375,I 72,
S1M 1295,I 68,
S1M 1221,I 64,
S1M 1131,I 59,
S1M 1051,I 55,
S1M 955,I 50,
S1M 856,I 45,
S1M 762,I 40,
S1M 667,I 35,
S1M 575,I 30,
S1M 458,I 24,
S1M 363,I 19,
S1M 267,I 14,
S1M 153,I 8,
S1M 57,I 3,
J2,PM-2,
S1M 1999,I 106,
S1M 1994,I 104,
S1M 1982,I 104,
S1M 1967,I 103,
S1M 1947,I 102,
S1M 1916,I 100,
S1M 1886,I 99,
S1M 1849,I 97,
S1M 1807,I 95,
S1M 1757,I 92,
S1M 1701,I 89,
S1M 1649,I 86,
S1M 1584,I 83,
S1M 1524,I 80,
S1M 1452,I 76,
S1M 1375,I 72,
S1M 1295,I 68,
S1M 1221,I 64,
S1M 1131,I 59,
S1M 1051,I 55,
    
```

M3 R1

M1 R1

M3 R2

S1M	955,I	50,
S1M	856,I	45,
S1M	762,I	40,
S1M	667,I	35,
S1M	575,I	30,
S1M	458,I	24,
S1M	363,I	19,
S1M	267,I	14,
S1M	153,I	8,
S1M	57,I	3,
J3,PM-2,		
S1M	57,I	-3,
S1M	153,I	-8,
S1M	267,I	-14,
S1M	363,I	-19,
S1M	458,I	-24,
S1M	575,I	-30,
S1M	667,I	-35,
S1M	762,I	-40,
S1M	856,I	-45,
S1M	955,I	-50,
S1M	1051,I	-55,
S1M	1131,I	-59,
S1M	1221,I	-64,
S1M	1295,I	-68,
S1M	1375,I	-72,
S1M	1452,I	-76,
S1M	1524,I	-80,
S1M	1584,I	-83,
S1M	1649,I	-86,
S1M	1701,I	-89,
S1M	1757,I	-92,
S1M	1807,I	-95,
S1M	1849,I	-97,
S1M	1886,I	-99,
S1M	1916,I	-100,
S1M	1947,I	-102,
S1M	1967,I	-103,
S1M	1982,I	-104,
S1M	1994,I	-104,
S1M	1999,I	-106,
J3,PM-3,		
S1M	57,I	-3,
S1M	153,I	-8,
S1M	267,I	-14,
S1M	363,I	-19,
S1M	458,I	-24,
S1M	575,I	-30,
S1M	667,I	-35,
S1M	762,I	-40,
S1M	856,I	-45,
S1M	955,I	-50,
S1M	1051,I	-55,
S1M	1131,I	-59,
S1M	1221,I	-64,
S1M	1295,I	-68,
S1M	1375,I	-72,
S1M	1452,I	-76,
S1M	1524,I	-80,
S1M	1584,I	-83,
S1M	1649,I	-86,
S1M	1701,I	-89,
S1M	1757,I	-92,
S1M	1807,I	-95,
S1M	1849,I	-97,
S1M	1886,I	-99,
S1M	1916,I	-100,
S1M	1947,I	-102,
S1M	1967,I	-103,
S1M	1982,I	-104,
S1M	1994,I	-104,
S1M	1999,I	-106,
J4,PM-3		
S1M	1999,I	-106,
S1M	1994,I	-104,
S1M	1982,I	-104,
S1M	1967,I	-103,
S1M	1947,I	-102,
S1M	1916,I	-100,
S1M	1886,I	-99,
S1M	1849,I	-97,
S1M	1807,I	-95,
S1M	1757,I	-92,
S1M	1701,I	-89,
S1M	1649,I	-86,
S1M	1584,I	-83,
S1M	1524,I	-80,
S1M	1452,I	-76,
S1M	1375,I	-72,
S1M	1295,I	-68,
S1M	1221,I	-64,
S1M	1131,I	-59,
S1M	1051,I	-55,
S1M	955,I	-50,
S1M	856,I	-45,
S1M	762,I	-40,
S1M	667,I	-35,
S1M	575,I	-30,
S1M	458,I	-24,
S1M	363,I	-19,
S1M	267,I	-14,
S1M	153,I	-8,
S1M	57,I	-3,
J4,PM-4,		
S1M	1999,I	-106,
S1M	1994,I	-104,
S1M	1982,I	-104,
S1M	1967,I	-103,
S1M	1947,I	-102,
S1M	1916,I	-100,
S1M	1886,I	-99,

M1 R2

M3 R3

M1 R3

S1M	1849,I	-97,	
S1M	1807,I	-95,	
S1M	1757,I	-92,	
S1M	1701,I	-89,	
S1M	1649,I	-86,	
S1M	1584,I	-83,	
S1M	1524,I	-80,	
S1M	1452,I	-76,	
S1M	1375,I	-72,	
S1M	1295,I	-68,	
S1M	1221,I	-64,	
S1M	1131,I	-59,	
S1M	1051,I	-55,	
S1M	955,I	-50,	
S1M	856,I	-45,	
S1M	762,I	-40,	
S1M	667,I	-35,	
S1M	575,I	-30,	
S1M	458,I	-24,	
S1M	363,I	-19,	
S1M	267,I	-14,	
S1M	153,I	-8,	
S1M	57,I	-3,	

M3 R4

U99,PM-4,			
S1M	57,I	3,	
S1M	153,I	8,	
S1M	267,I	14,	
S1M	363,I	19,	
S1M	458,I	24,	
S1M	575,I	30,	

M1 R4

S1M	667,I	35,	
S1M	762,I	40,	
S1M	856,I	45,	
S1M	955,I	50,	
S1M	1051,I	55,	
S1M	1131,I	59,	
S1M	1221,I	64,	
S1M	1295,I	68,	
S1M	1375,I	72,	
S1M	1452,I	76,	
S1M	1524,I	80,	
S1M	1584,I	83,	
S1M	1649,I	86,	
S1M	1701,I	89,	
S1M	1757,I	92,	
S1M	1807,I	95,	
S1M	1849,I	97,	
S1M	1886,I	99,	
S1M	1916,I	100,	
S1M	1947,I	102,	
S1M	1967,I	103,	
S1M	1982,I	104,	
S1M	1994,I	104,	
S1M	1999,I	62,	
U92,	I	44,	

PM-0,PMA1,			
A2M5,I2M400,P2,			
U5,			
JM1,			
U4,			
I2M-400			

jump to pgm 1 to do circle
