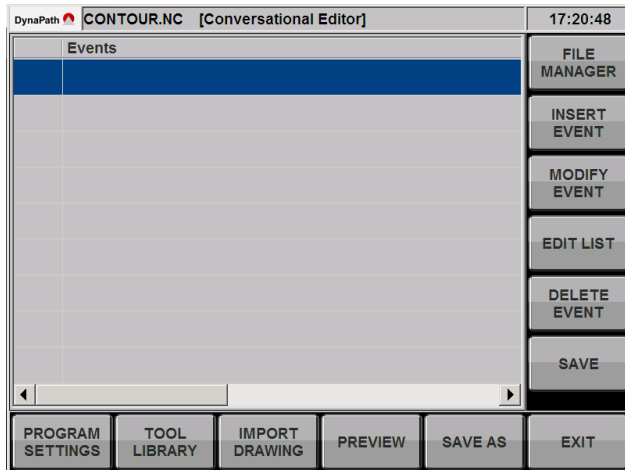


Conversational Workflow and Settings

DynaPath WinDelta CNC Lathe · Conversational Programming Quick Guide

Lathe conversational programs (.HNC) are a list of events: profiles, stock removal, holes, threads, grooves, cut-off. SAVE generates a normal G-code program for AUTO. Set the program settings first: the stock size drives every roughing cycle. [15]



Conversational editor: event list, event buttons right, program buttons along the bottom [Fig. 15.3-1]

Build a program Manual 15.2, 15.3

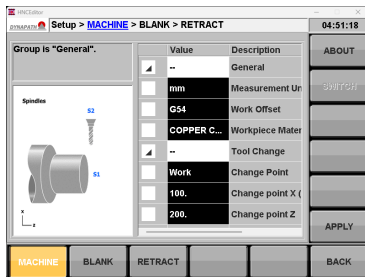
- 1 **FILE MANAGER** → **NEW** conversational program (.HNC), or open an existing one.
- 2 **PROGRAM SETTINGS**: machine, blank and retract settings (below).
- 3 **TOOL LIBRARY**: set up the tools the job uses.
- 4 Add the part shape as a **Profile** event (draw it, or **IMPORT DRAWING** from a DXF).
- 5 **INSERT EVENT** for each operation: inserted above the highlighted event. Use **MODIFY EVENT** to change one and **EDIT LIST** to shift, cut, copy or paste.
- 6 **PART** switches between the front end and back end of the part.
- 7 **PREVIEW** the toolpaths, then **SAVE / SAVE AS**.
- 8 **EXIT** and run in AUTO with tool and work offsets set; **SINGLE BLOCK** for the first run.

Conversational Workflow and Settings

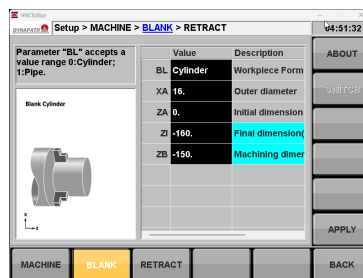
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Program settings Manual 15.4

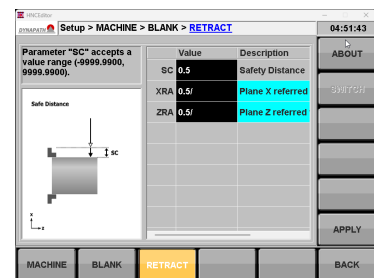
Tab	Setting	Meaning
Machine	Units	G20 inch or G21 mm
	Work offset	G54-G59 written in the program header
	Material	Used with tool data to suggest feeds and speeds
	Tool change position	Where tool changes happen, relative to part zero or machine zero
Blank	BL	Stock type: bar (cylinder) or pipe
	XA / XI	Stock outer / inner diameter
	ZA / ZI / ZB	Z start of stock / end of part in the chuck / where the chuck starts
Retract	SC	Stock allowance; also the clearance used to travel between events
	XRA / ZRA	Default retract amounts in X and Z



Machine [Fig. 15.4-1]



Blank [Fig. 15.4-2]



Retract [Fig. 15.4-3]

Event quick guides Manual 15.5-15.12

Guide	Event	Guide	Event
LC2	Profile (part shape)	LC8	Thread and tapered thread
LC3	Stock removal – turning G71	LC9	Face groove
LC4	Stock removal – facing G72	LC10	Turn groove
LC5	Stock removal – pattern repeat G73	LC11	Irregular groove
LC6	Turning G90 and facing G94	LC12	Cut-off
LC7	Hole events (face and side)	LC13	Line-arc, position and auxiliary
		LC14	Drawing import (DXF)