

Setup Events and Engraving

DynaPath WinDelta CNC Mill · Conversational Programming Quick Guide

Setup events control the program between machining events: offsets, stops, units, coolant, spindle, safe height and raw G-code. Engraving is also in this group. [15.11]

Event	Settings	What it does
Work offset / P-offset	G = G54–G59 · P = P1–P48	Later events use this work origin
Program stop	M00 / M01 / M30 / M99	Stop · optional stop (M01 button on) · end · restart and loop
Dwell	X seconds	Pause
Inch / metric	G20 / G21	Units for what follows
Coolant control	M7 mist · M8 flood · M9 off	Coolant on / off
Safe height override	O height above part zero	New travel height between events from here on, e.g. to clear clamps
Spindle control	M3 CW · M4 CCW · M5 stop · S RPM	Start or stop the spindle
Repeat work	WO table of work offsets	Runs the whole program again at each offset
G-code	SNC text, blocks separated by ';'.	Inserts raw G-code. Must not end with an empty line
Comment	Text	A note in the event list

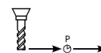
Coordinate Origin



Work offset origin

Dwell

→ Feed (F)
 Ⓢ Dwell (P)



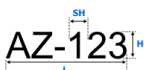
Dwell

Engraving Manual 15.11.11

Engraves stick-letter text, in a straight line or around a circle.

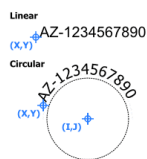
Code	Meaning	Code	Meaning
S1	Text to engrave	TYP	Linear or circular
X, Y	Text start point (absolute)	I, J	Circle centre (circular text)
RP	Plunge height (absolute)	Z	Engraving depth (absolute)
H	Letter height	L	Length of the whole text
SH	Spacing between letters	V	Italic angle
Q	Angle of a linear text line		

Text Dimensions



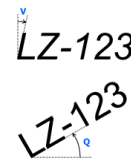
Text size H, L, SH

Text Position



Linear and circular position

Text Angles



Italic V and line angle Q