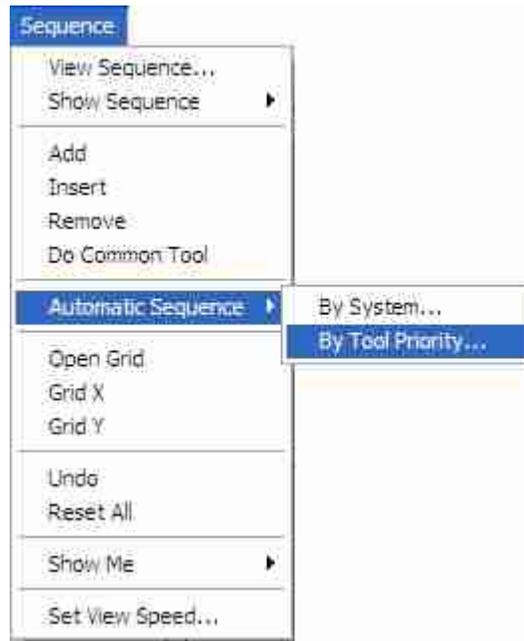


THE PUNCHING SEQUENCE ORDER

There are two ways of adding the sequence, you can either let the system choose the best sequence automatically or you can do it yourself manually.



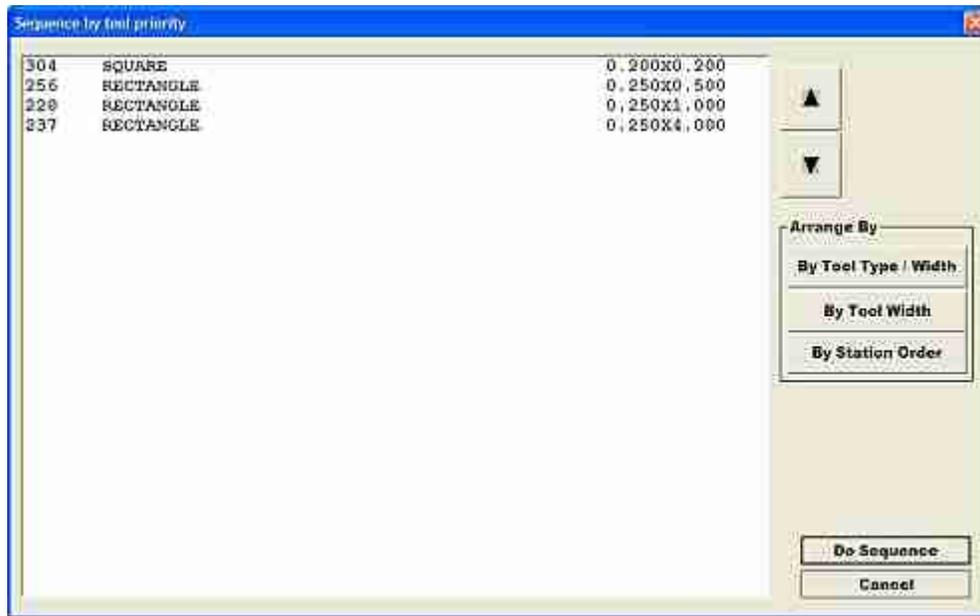
1. Automatic sequencing

- **By System**

The system decides which tool are first to be punched by choosing the smallest tool first regardless of the shape and by the distance to centers, it does a good job and will save you tons of time. To start use pull down Sequence- Automatic-Do sequence menu as shown below.

- **By Tool Priority**

You are given the chance to arrange the tool order in which the system will generate the sequence. A dialog box pop up with the list of tools and arrows to alter the order as shown below:



2. **Manual sequencing** you can go three ways to generate the sequence manually; All single hits, all grid groups (U-V-W for amada machines) or a mix of both single hits and groups.
 - **All Single Hits**
To sequence this way all you have to do is click the Sequence-Add pull down menu as shown above. Once you get in to the work area click on any entity that you want to sequence first, just once, then use the Do common Tool command to automatically locate the rest of the same tools in the sheet, do the same thing for all the tools and patterns in you sheet.
When you are done with all your tools and patterns then you are ready to generate g-code by using the File-Make Nc Code pull down menu.
 - **Using Grids Groups**
Start by opening a group, use the Sequence- Open Grid command and next pick a tool or entity once then use the Do Common Tool option to find the rest of the tool or entities in the part, once done that you have to close the group by using pull down menu Sequence-Grid X or Sequence-Grid Y.
 - Sequence-Grid X will close the group and punch the group in X direction.
 - Sequence-Grid Y will close the group and punch the group in Y direction.
 When you are done with all your tools and patterns then you are ready to generate g-code by using the File-Make Nc Code pull down menu.
 - **Mix of single hits and groups** do both at the same time as described above. To generate single hits a group must be closed or otherwise you are just generating groups.

Other useful commands that would help you do the sequence are :
Sequence-Undo, which will reset your sequence one step back at a time.

Reset All will reset your sequence all the way back to start again from the beginning.

Sequence-Show Me-Last Hit will show you the last tool hit in the sequence by redrawing your screen and showing just this tool hit so you know your position when sequencing.

Sequence-Show Me-Hits Not Sequenced will redraw your screen and show you all the tool hits that haven't been added to the sequence.

Sequence-View Sequence redraws the screen displaying the order in which the tool will be punched.

Sequence-Set View Speed present you a dialog box to set the redrawing speed of your hits in the blank, you can change it in a range of 1-9, 1 being the slowest and 9 the fastest. You can also when viewing the sequence just press a number in your keyboard but you need to do it fast.

Sequence-Insert use this command to add a tool hit first in front of other hit in the blank. Click on the tool that you want your hit in front of then click the tool to be inserted in the sequence.

Sequence Remove just click the pattern to be remove from the sequence.

Do Common Tool find all the same tools hits in the blank. Click the tool you want to add to sequence just once and then click the Do Common Tool command to find the rest of the same tools.