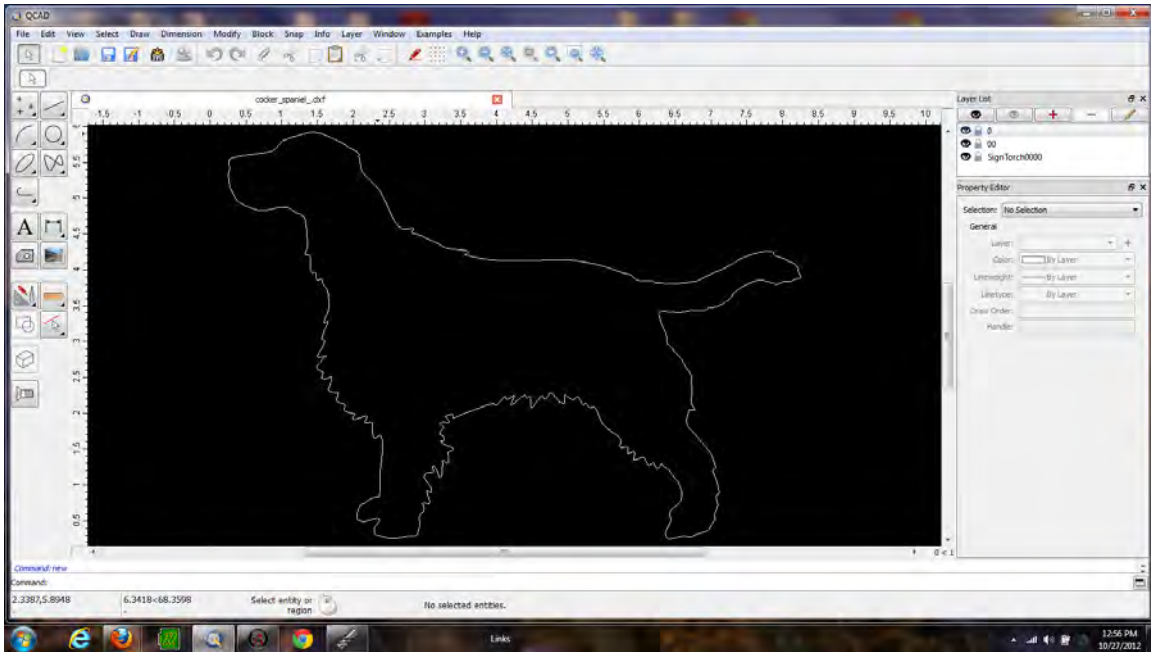
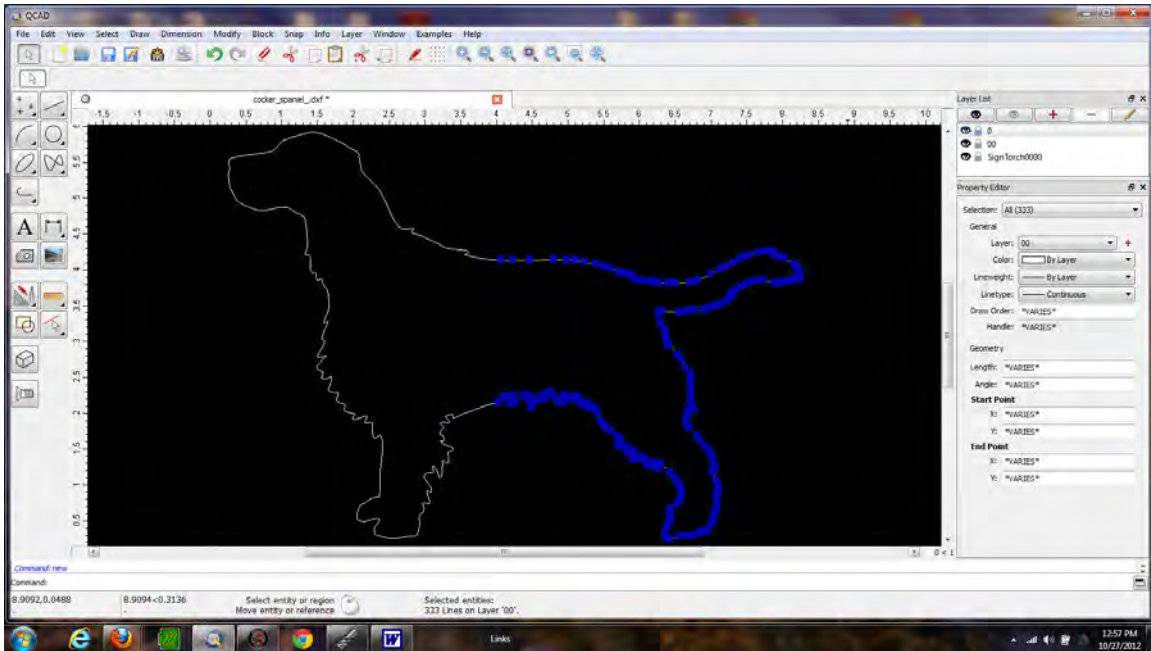


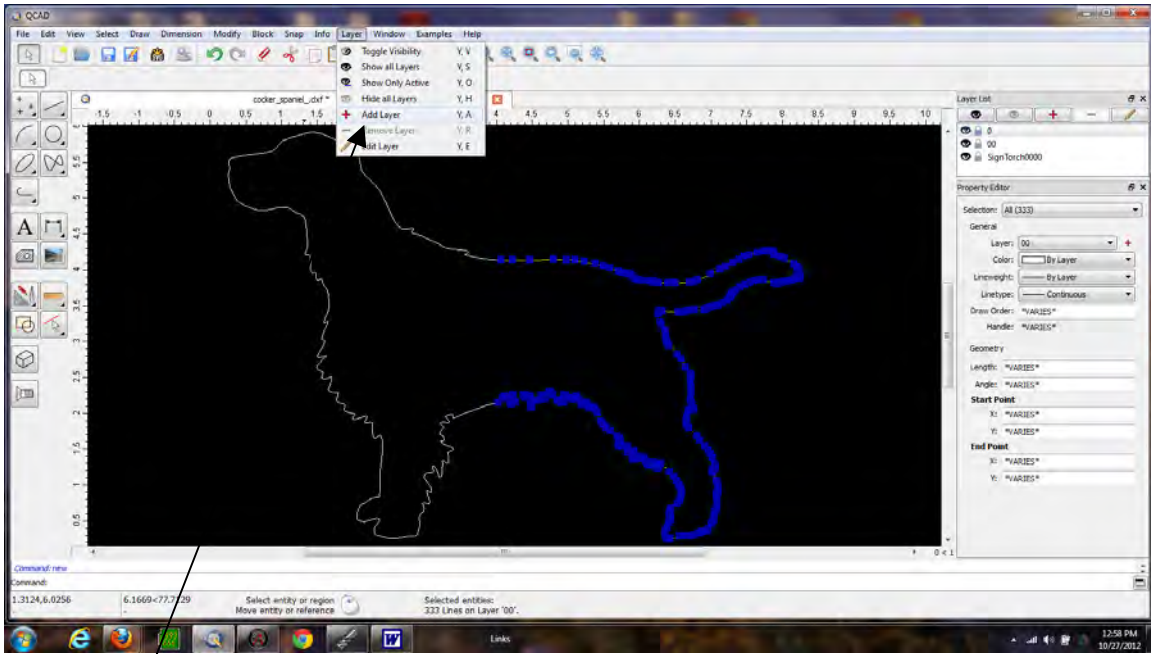
Step 1: Load a DXF file.



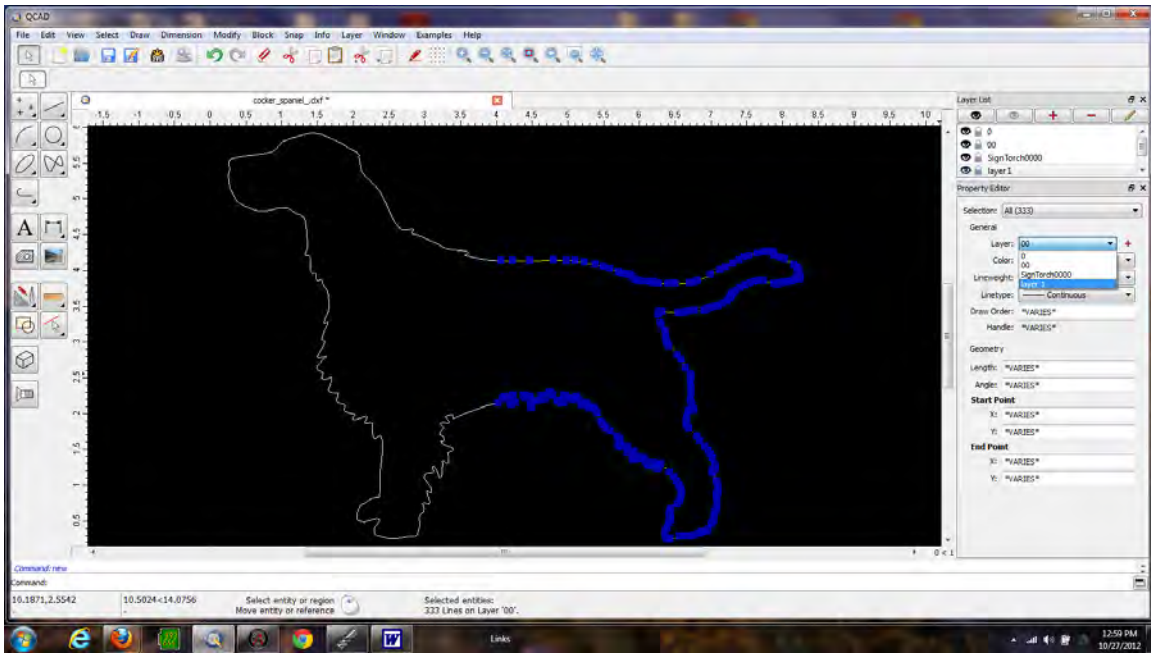
Step 2: With the mouse select half of the image.



Step 3



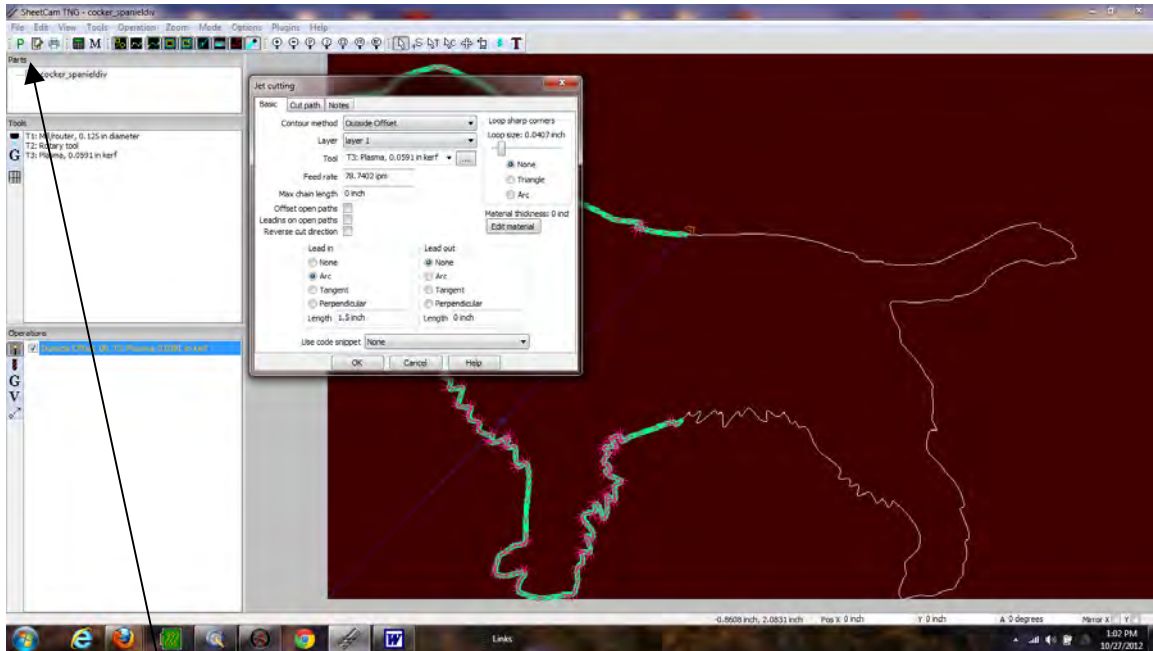
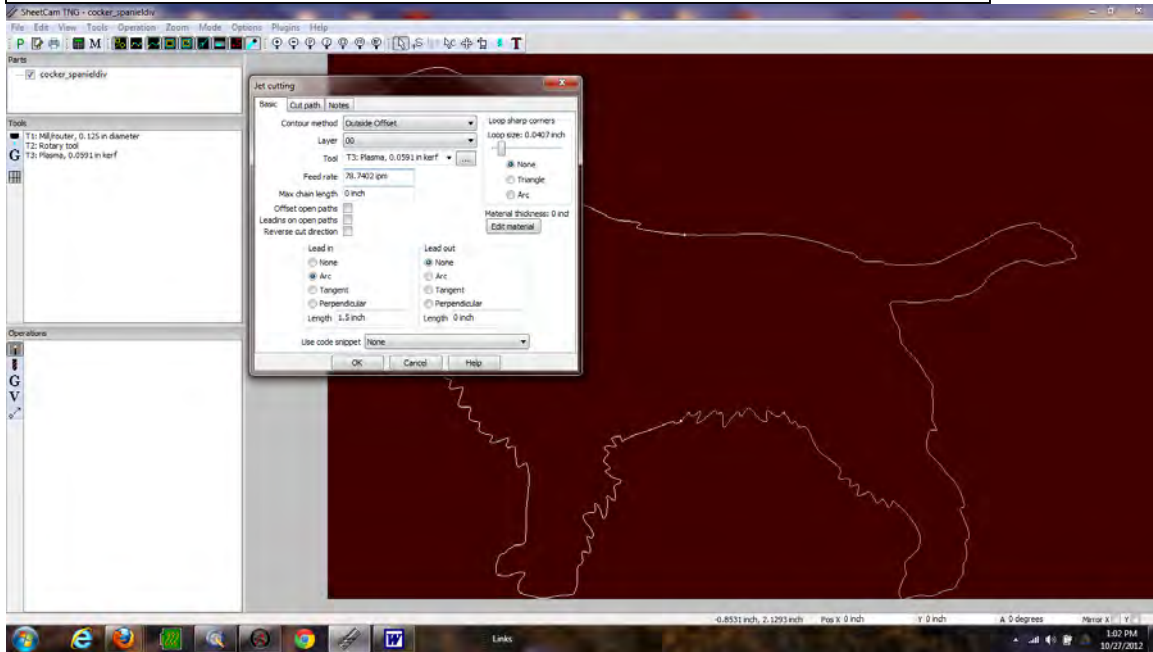
Add a layer.



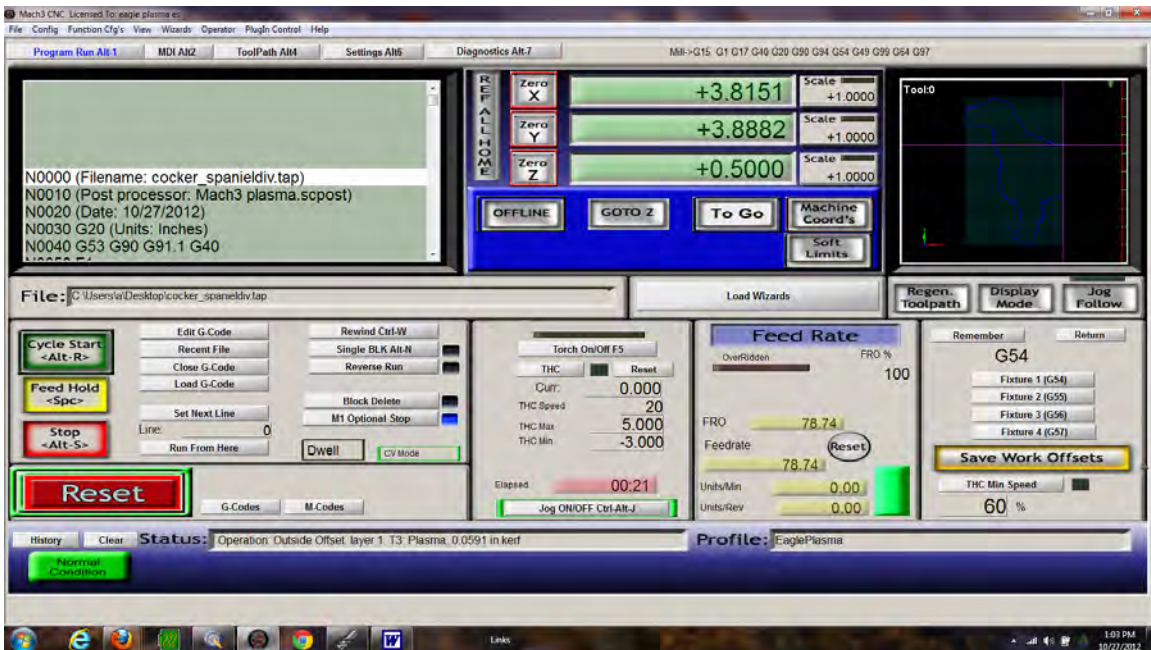
Step 4: In the property window select the new layer.

Step 5: Save the file and load into SheetCam.

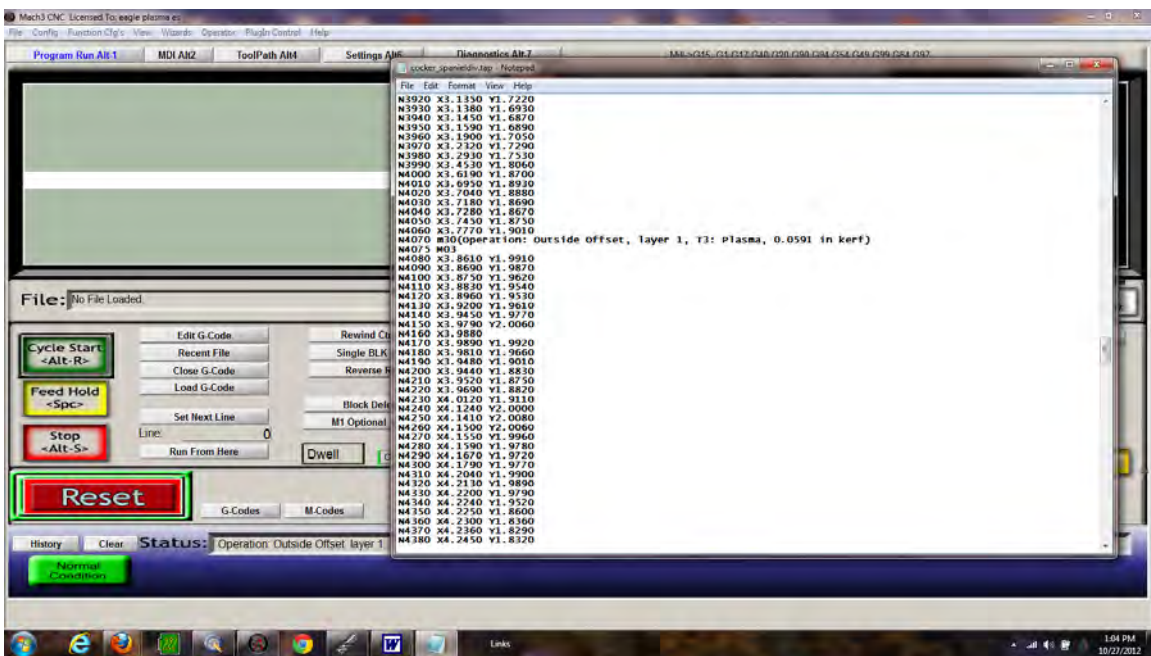
Step 6: Create the first operation for the 0 layer.



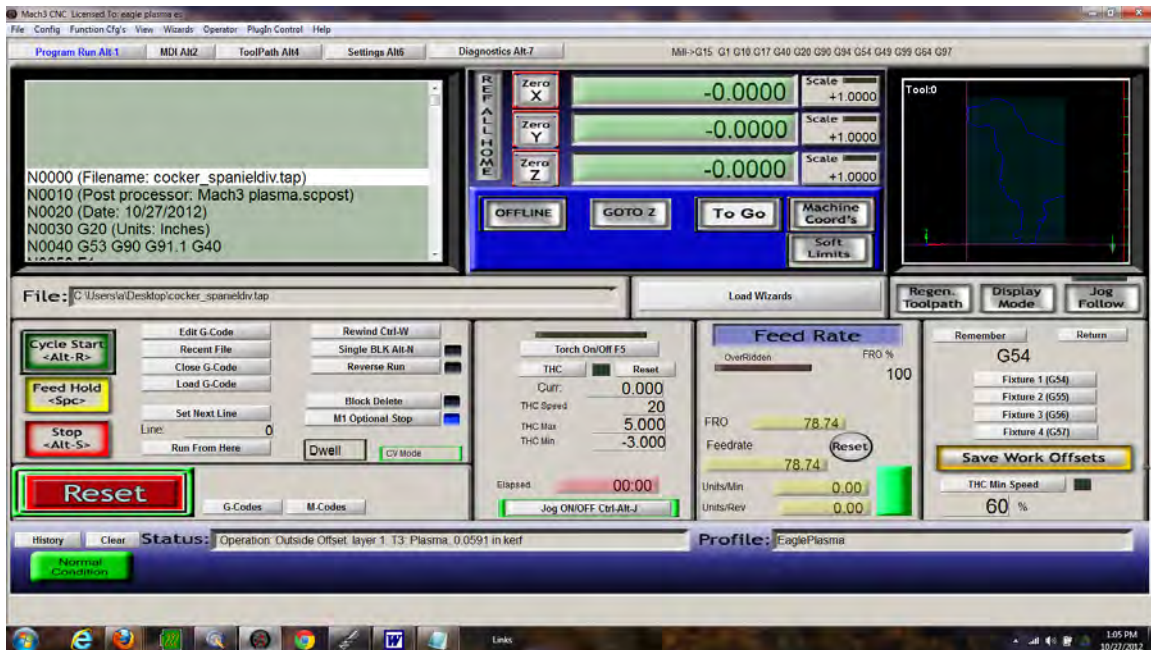
Step 7: Create the next operation for the new layer.
Step 8: Post the file.



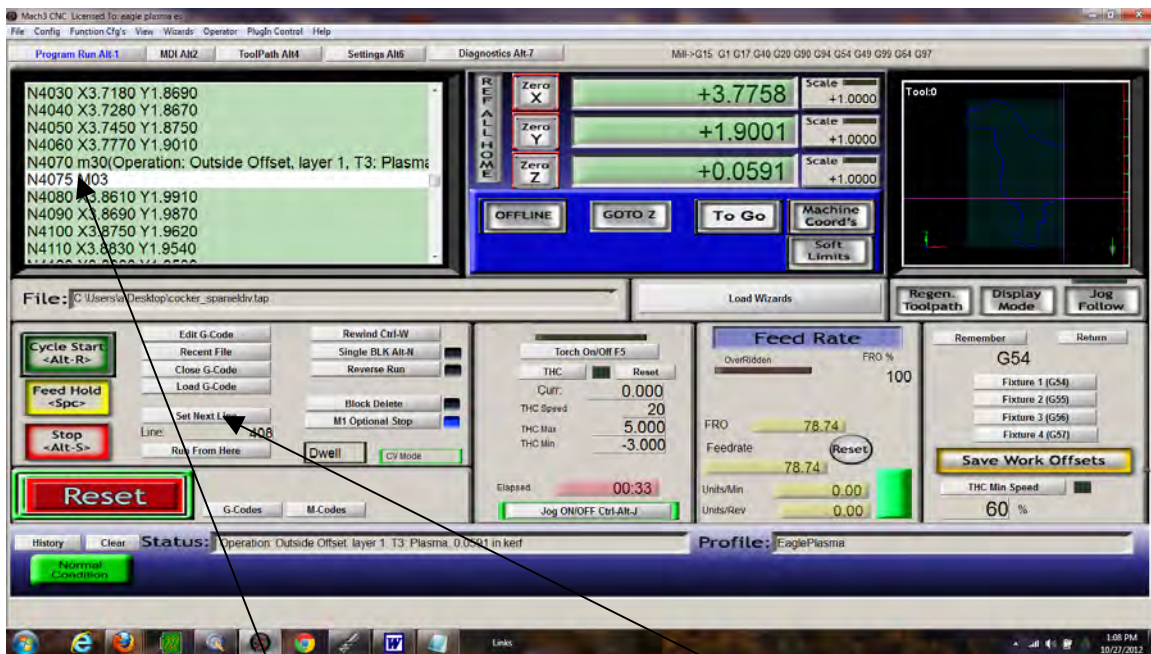
Step 9: Load the file into Mach3.



Step 10: Select edit G code, add M30 to the line that starts the new layer cut. Insert a new line with a number 5 units greater than the new layer line number. Save the changes.



Step 11: Set the zero point for the cut. Run the file and it will cut the first half of the file.



Step 12: Select the M03 line we added and then press Set Next Line. Note the value in the X and Y-axis, move the cut sheet then move the torch to the last end of the cut. Set the X and Y values to the same as noted. You are now ready to press Cycle Start.