

## WinCNC GCode Map

WinCNC GCode Map

GCode File  
Path: C:\TEST\WINCNC.TAP

X Min: 0.3083 X Max: 7.1581  
Y Min: 0.9951 Y Max: 2.5370


Probe Mapping  
X Start: 0.3083 X End: 7.1581 X Points: 28 Total: 224  
Y Start: 0.9951 Y End: 2.5370 Y Points: 8 X Size: 0.2446 Y Size: 0.1927

Probe Settings  
X Probe Offset: 3.9390 Probe Clearance: 0.1000  
Y Probe Offset: 1.0720 Probe Calibration: 1.2430

☐ Use Auto Run Sub Directory Map Run Exit

View

PU PL : PR PD RU RL : RR RD ZI : ZO Original Map Data Modified



Viewer Controls

Probe Mapping Configuration

View Original G-Code

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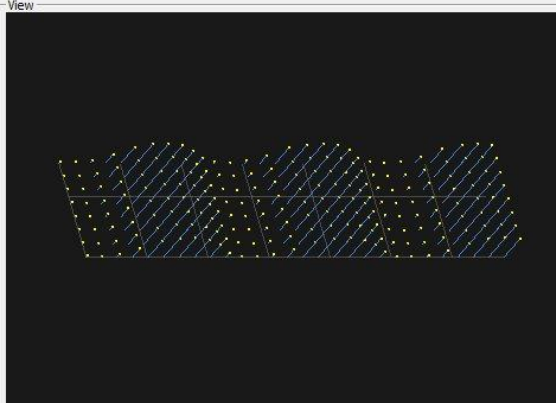
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Main Controls

View Modified G-Code

\*Before running the WinCNC GCode Map utility, XY zeros should be set at the lower-left corner of the material and the Z zero should be set at the top or bottom of the material as required by the GCode file to be mapped.

### **Probe Mapping Configuration**

X/Y Start and X/Y End – Minimum and maximum XY positions for the selected GCode file.

X/Y Points – Desired number of probe points along the X and Y axes.

Total – Displays the total amount of probe points.

X/Y Size – Displays the distance between points.

### **Probe Settings Configuration**

X/Y Probe Offset – The offset between the main spindle/router and the probe.

Probe Clearance – Additional Z clearance used when moving between probe points.

Probe Calibration – The Z distance between tool tip and the probe tip.

### **Main Controls**

Use Auto Run Sub Directory – Check if WinCNC is configured to use an “AutoRun” subdirectory.

Map – Creates a GCode file with \_MAP appended to the file name to probe the material surface at the specified points and create a SCAN.CSV file containing the data.

Run – Uses the data in SCAN.CSV to create a new GCode file with \_RUN appended to the file name.

Exit – Close the WinCNC GCode Map utility.

### **Viewer Controls**

PU - Pan Up

RU – Rotate Up

PL - Pan Left

RL – Rotate Left

ZI – Zoom In

: - Center

: - Center

: - Center

PR - Pan Right

RR – Rotate Right

ZO – Zoom Out

PD - Pan Down

RD – Rotate Down

### **View Original G-Code**

Original – View the original GCode file.

### **View Map Data**

Map Data – View data taken by the probe.

### **View Modified G-Code**

Modified – View the modified GCode file.