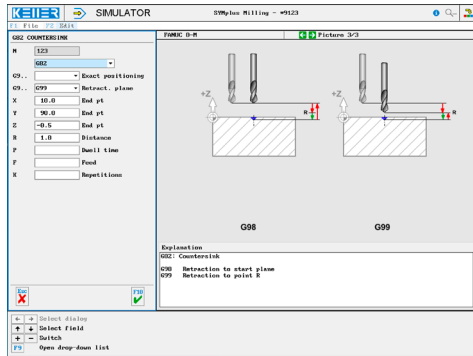
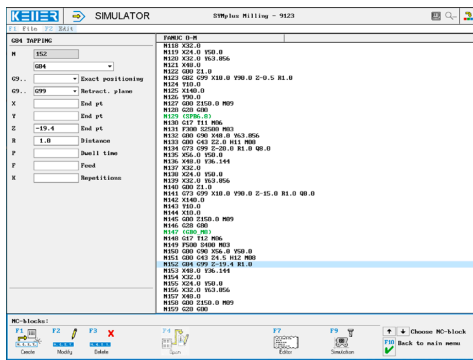


The control related simulator is an additional module for SYMplus. This simulator is used to learn the control system programming. A program generated by a postprocessor can also be edited and simulated.

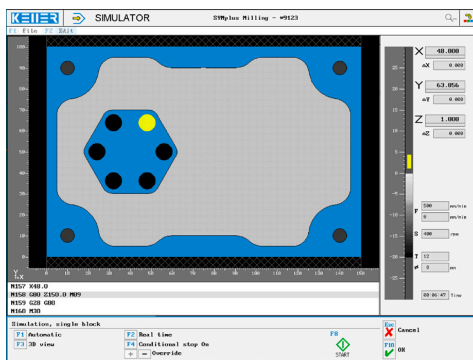
### Help pictures and texts (for all input dialogues)



### NC editor incl. input dialogue and syntax control



### Optimal control through simulation with position display (real time, fast run, single block with path preview etc.)



### Keyboard information system: Getting familiar with the meaning of all keys of the control system by moving the mouse cursor over the keys



## COMMANDS/ FUNCTIONS/CYCLES

- G00 Rapid traverse
- G01 Line
- G02 Arc, clockwise
- G03 Arc, counter-clockwise
- G04 Dwell time
- G15 Polar coordinates end
- G16 Polar coordinates
- G28 Approach reference point
- G29 Retract. Of reference point
- G40/G41/G42 Radius compensation
- G43/G44/G49 Length compensation
- G52 Local coordinate system
- G54-G59 Machine coordinates
- G73 Deep-hole drilling
- G74 Tapping left
- G76 Fine boring
- G80 Terminate canned cycle
- G81 Spot drilling
- G82 Countersink
- G83 Deep-hole drilling
- G84 Tapping
- G85 Drilling
- G86 Drilling
- G87 Back drilling
- G88 Special drilling
- G89 Drilling
- G90/G91 Exact positioning
- G92 Zero offset
- G94 Feed
- T Tool call
- Comment Explanations
- X/Y/Z End point (modal)
- M98 Sub-program call

