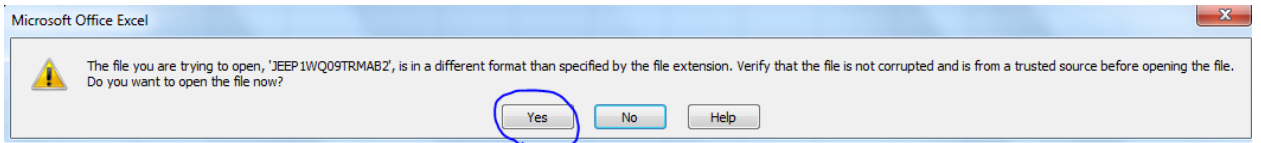


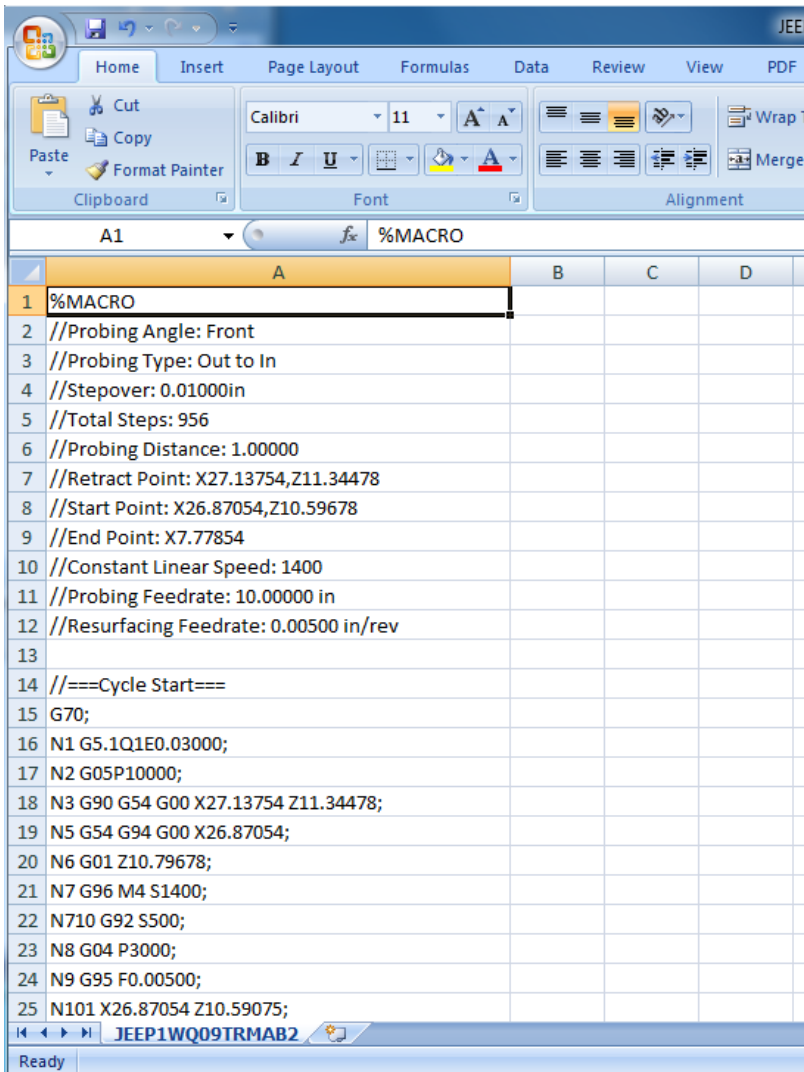
1. Ask customer to export the digitizing file.

Instruction on Syntech control: Program → File Manager → File Transfer → Export File → Send to USB → Email to Atrump

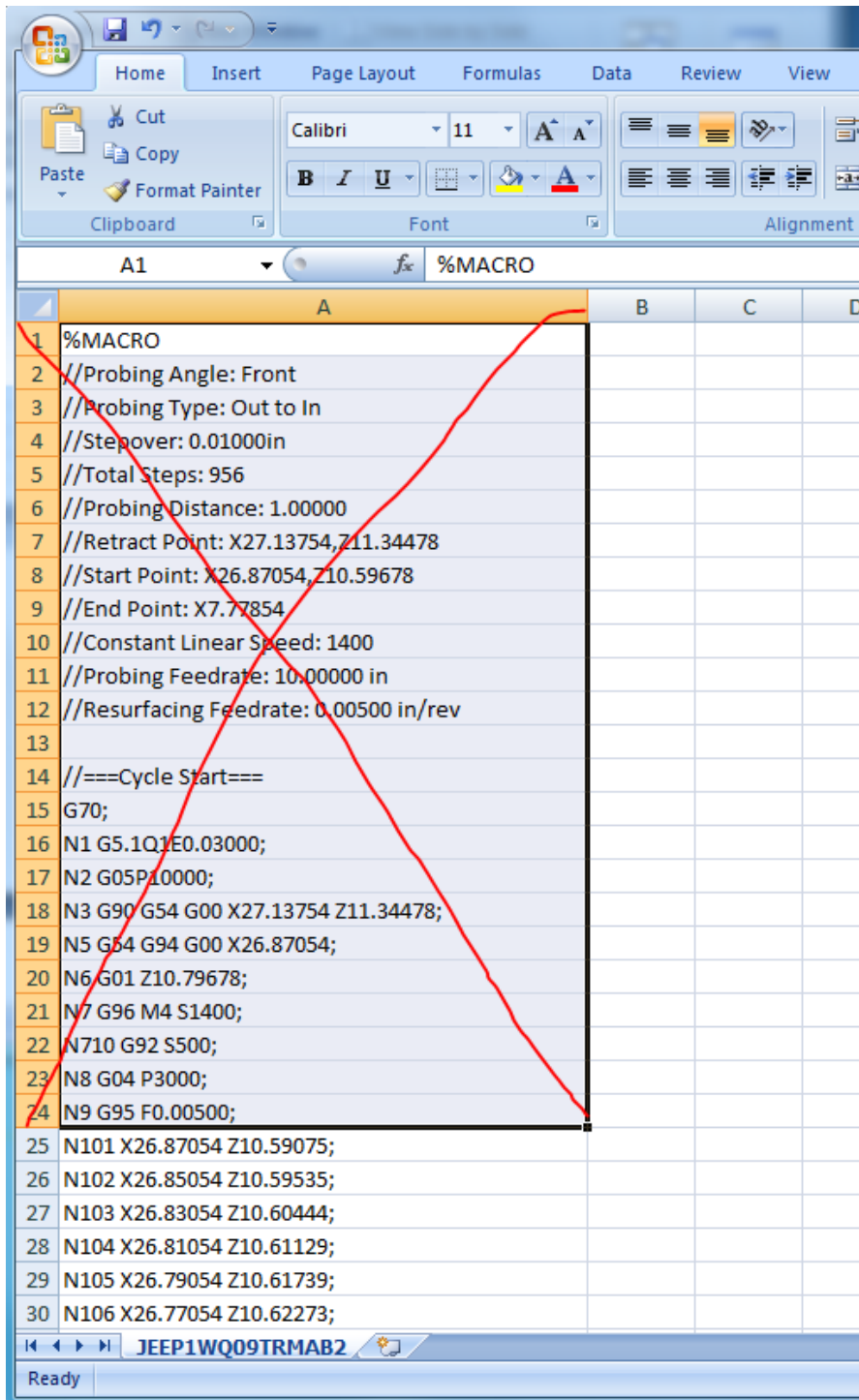
2. Open Excel → Open customer files on excel → A message will pop out → Just click Yes.



3. Customer file opens successfully in Excel.



4. Delete From Row1 to Row24 (typically) because digitizing path starts from Row25, which is N101.



5. N101 now is on Row1.

	A
1	N101 X26.87054 Z10.59075;
2	N102 X26.85054 Z10.59535;
3	N103 X26.83054 Z10.60444;
4	N104 X26.81054 Z10.61129;
5	N105 X26.79054 Z10.61739;
6	N106 X26.77054 Z10.62273;
7	N107 X26.75054 Z10.62733;
8	N108 X26.73054 Z10.63043;
9	N109 X26.71054 Z10.63352;
10	N110 X26.69054 Z10.63587;

JEEP1WQ09TRMAB2

Ready

6. Click "A" and A column will be highlighted. Click "Data" on the ribbon. Then Click "Text to Columns"

The screenshot shows the Microsoft Excel interface with the 'Data' ribbon selected. The 'Text to Columns' option is highlighted with a red circle. A blue arrow points from the 'Text to Columns' button to the 'A' column header in the spreadsheet. The spreadsheet shows column A highlighted in orange, containing data from row 1 to 15. The formula bar shows the formula for cell A1: =N101 X26.87054 Z10.59075;.

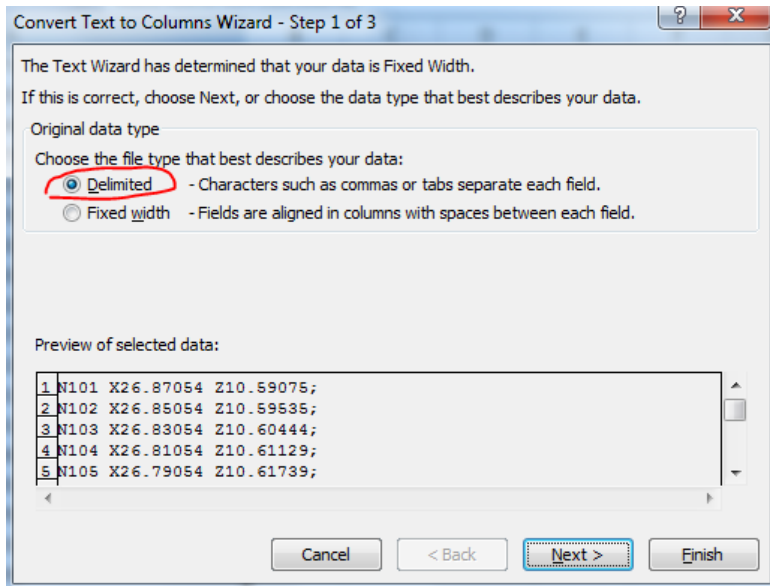
	A	B	C	D	E	F
1	N101 X26.87054 Z10.59075;					
2	N102 X26.85054 Z10.59535;					
3	N103 X26.83054 Z10.60444;					
4	N104 X26.81054 Z10.61129;					
5	N105 X26.79054 Z10.61739;					
6	N106 X26.77054 Z10.62273;					
7	N107 X26.75054 Z10.62733;					
8	N108 X26.73054 Z10.63043;					
9	N109 X26.71054 Z10.63352;					
10	N110 X26.69054 Z10.63587;					
11	N111 X26.67054 Z10.63822;					
12	N112 X26.65054 Z10.63981;					
13	N113 X26.63054 Z10.64141;					
14	N114 X26.61054 Z10.64226;					
15	N115 X26.59054 Z10.64385;					

JEEP1WQ09TRMAB2

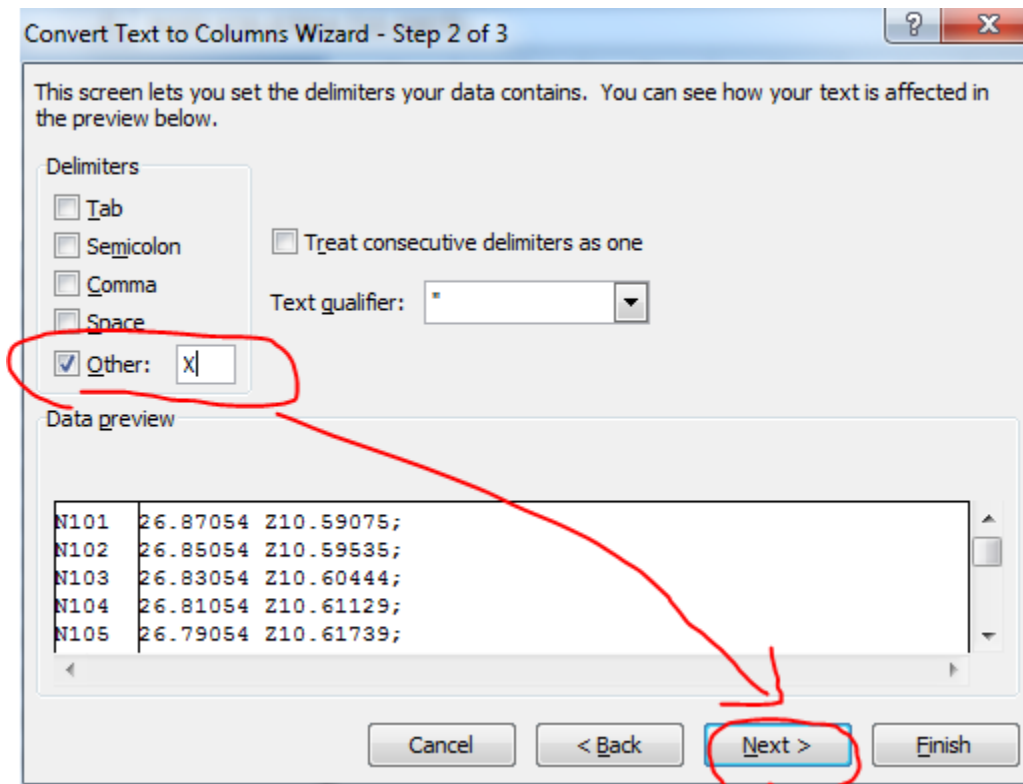
Ready

Count: 962

7. A message will pop out. Click "Delimited"

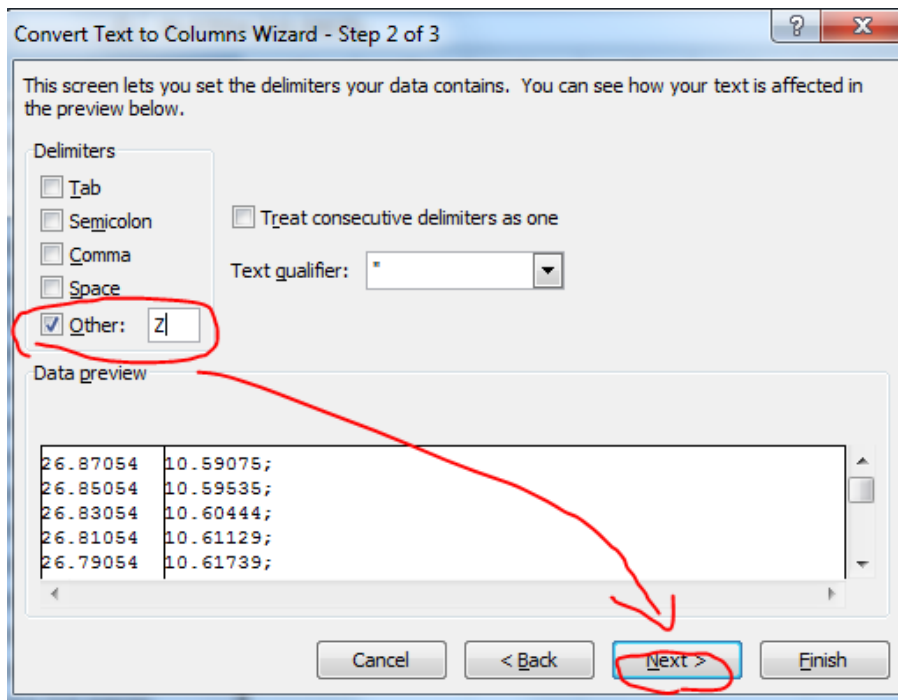


8. Click "Other" and enter "X" → Click Next → Just hit Finish



9. It breaks into two columns.

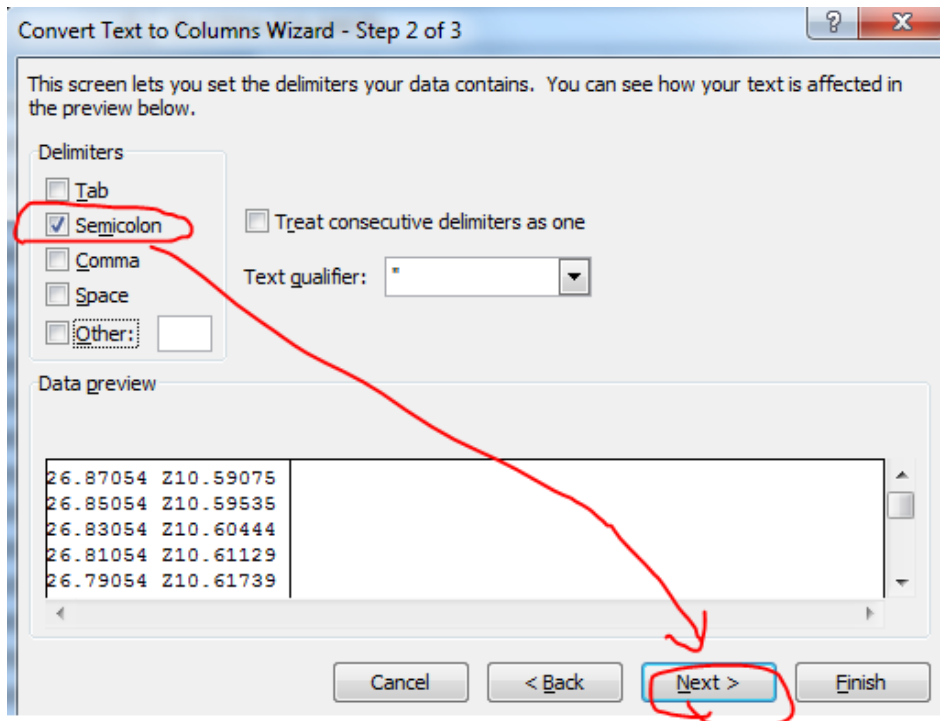
Click "B" → Click "Data" → Text to Columns → Delimited → Select "Other" and Enter 'Z' → Next → Finish



10. It becomes this.

	A	B	C	D	E
1	N101	26.87054	10.59075;		
2	N102	26.85054	10.59535;		
3	N103	26.83054	10.60444;		
4	N104	26.81054	10.61129;		
5	N105	26.79054	10.61739;		
6	N106	26.77054	10.62273;		
7	N107	26.75054	10.62733;		
8	N108	26.73054	10.63043;		
9	N109	26.71054	10.63352;		
10	N110	26.69054	10.63587;		
11	N111	26.67054	10.63822;		
12	N112	26.65054	10.63981;		
13	N113	26.63054	10.64141;		
14	N114	26.61054	10.64226;		
15	N115	26.59054	10.64385;		
16	N116	26.57054	10.64470;		

11. Click "C" → Click "Data" → Text to Columns → Delimited → Select "Semicolon" only → Next → Finish



12. Done with text to columns

	A	B	C	D	E
1	N101	26.87054	10.59075		
2	N102	26.85054	10.59535		
3	N103	26.83054	10.60444		
4	N104	26.81054	10.61129		
5	N105	26.79054	10.61739		
6	N106	26.77054	10.62273		
7	N107	26.75054	10.62733		
8	N108	26.73054	10.63043		
9	N109	26.71054	10.63352		
10	N110	26.69054	10.63587		
11	N111	26.67054	10.63822		
12	N112	26.65054	10.63981		
13	N113	26.63054	10.64141		
14	N114	26.61054	10.64226		
15	N115	26.59054	10.64385		
16	N116	26.57054	10.6447		

13. Calculate the Z differences between each digitizing Z point. In D2, input “=C3-C2.” Then hit Enter.

	A	B	C	D	E
1		X	Z	Z difference	
2	N101	26.87054	10.59075	=C3-C2	
3	N102	26.85054	10.59535		
4	N103	26.83054	10.60444		
5	N104	26.81054	10.61129		
6	N105	26.79054	10.61739		
7	N106	26.77054	10.62273		
8	N107	26.75054	10.62733		

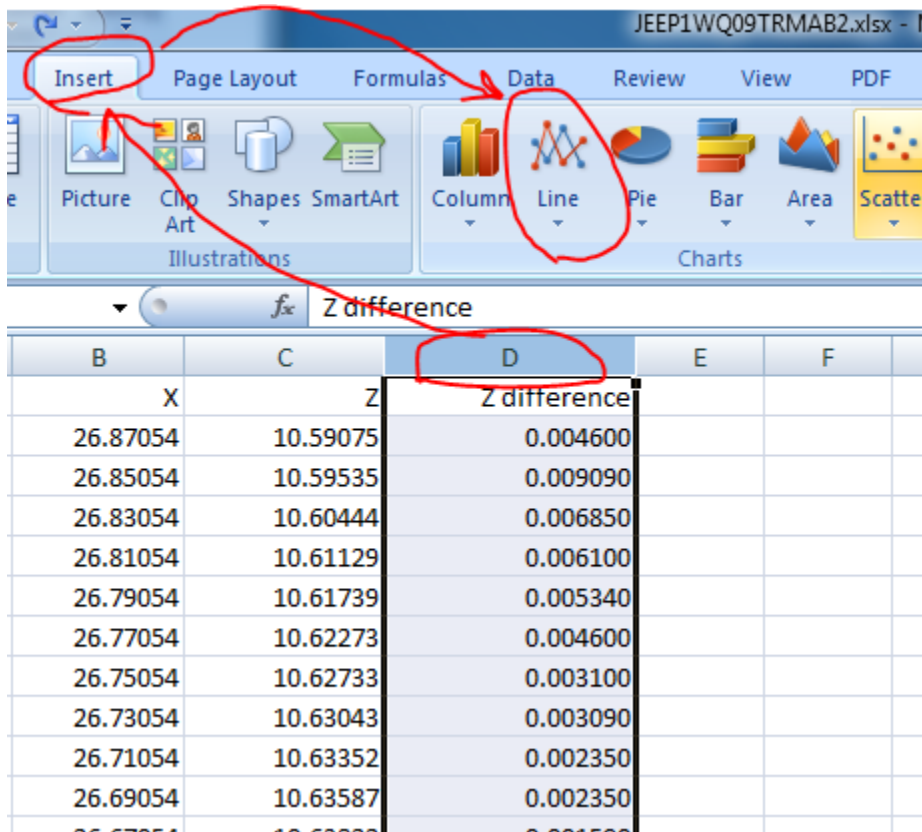
14. D2 will show 0.0046, which is 0.59535 minus 10.59075.

	A	B	C	D	E
1		X	Z	Z difference	
2	N101	26.87054	10.59075	0.0046	
3	N102	26.85054	10.59535		
4	N103	26.83054	10.60444		
5	N104	26.81054	10.61129		

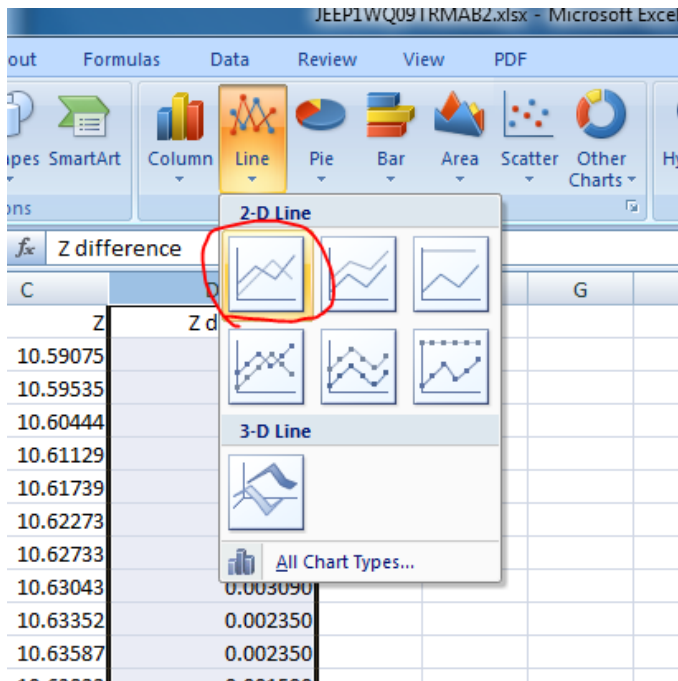
15. Move mouse cursor to right bottom corner on D2. It will show a cross symbol. Left click on your mouse and drag it down to Row957. Release. And all the Z differences will be calculated.

	A	B	C	D	E	F
1		X	Z	Z difference		
2	N101	26.87054	10.59075	0.0046		
3	N102	26.85054	10.59535	0.00909		
4	N103	26.83054	10.60444	0.00685		
5	N104	26.81054	10.61129	0.0061		
6	N105	26.79054	10.61739	0.00534		
7	N106	26.77054	10.62273	0.0046		
8	N107	26.75054	10.62733	0.0031		
9	N108	26.73054	10.63043	0.00309		
10	N109	26.71054	10.63352	0.00235		
11	N110	26.69054	10.63587	0.00235		
12	N111	26.67054	10.63822	0.00159		
13	N112	26.65054	10.63981	0.0016		
14	N113	26.63054	10.64141	0.00085		
15	N114	26.61054	10.64226	0.00159		
16	N115	26.59054	10.64385	0.00085		
17	N116	26.57054	10.6447	0.00085		
18	N117	26.55054	10.64555	0.00084		
19	N118	26.53054	10.64639	0.00085		
20	N119	26.51054	10.64724	0.0016		
21	N120	26.49054	10.64884	0.00084		
22	N121	26.47054	10.64968	0.00085		
23	N122	26.45054	10.65053	0.00085		

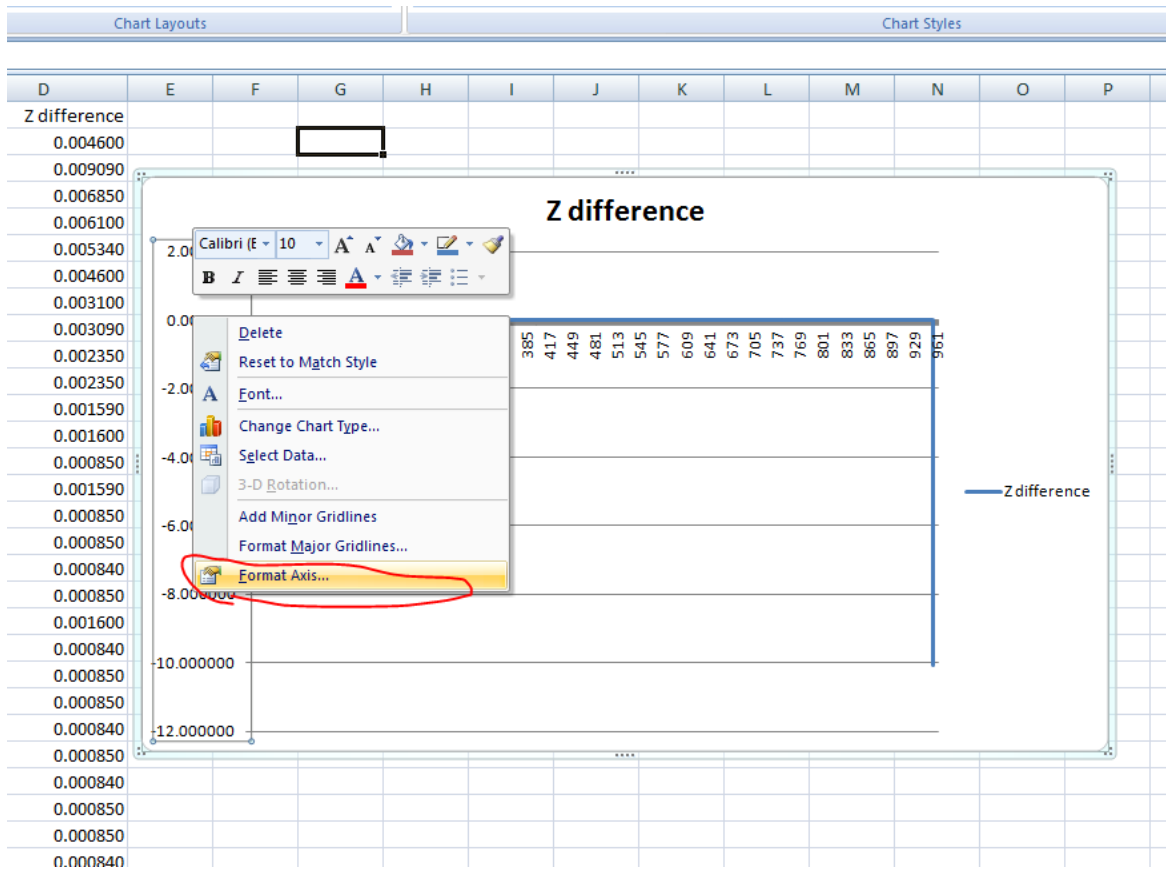
16. Click "D" → Insert → Line



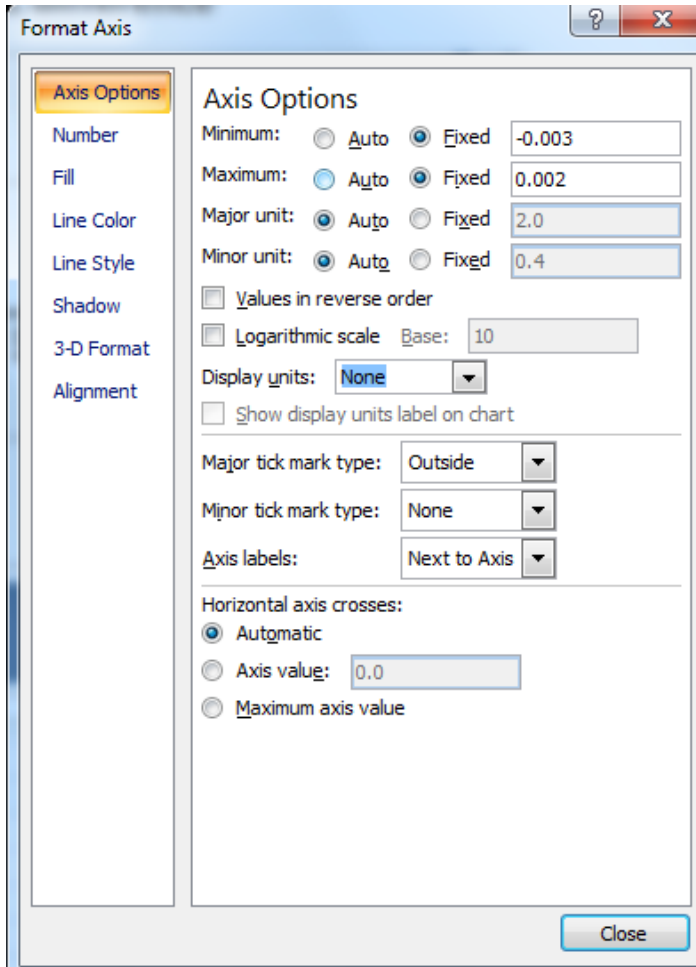
17. Select this one.



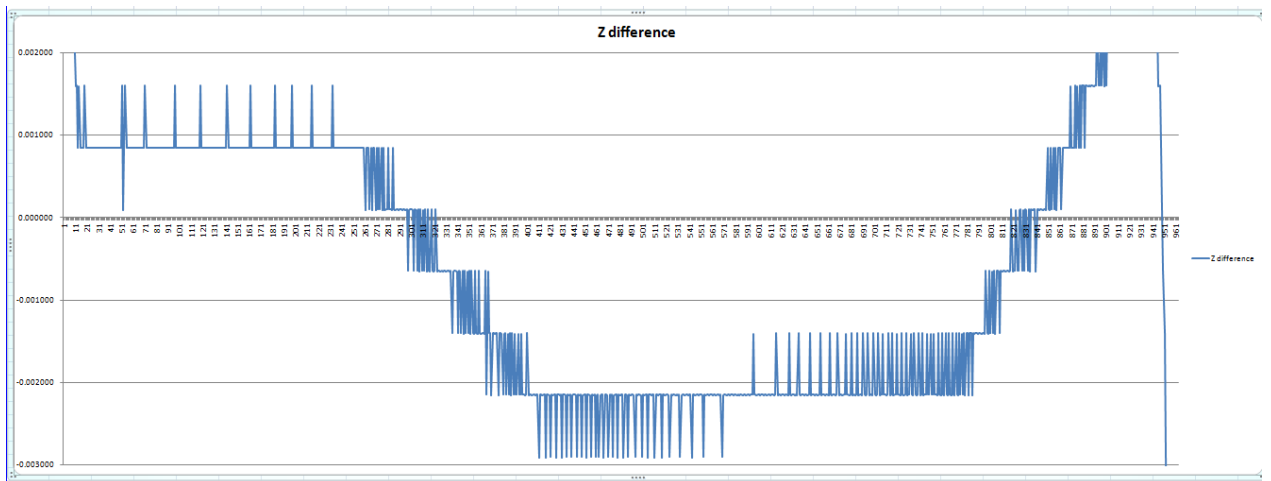
18. The Graph will be generated. Right click Y axis number and select "Format axis."



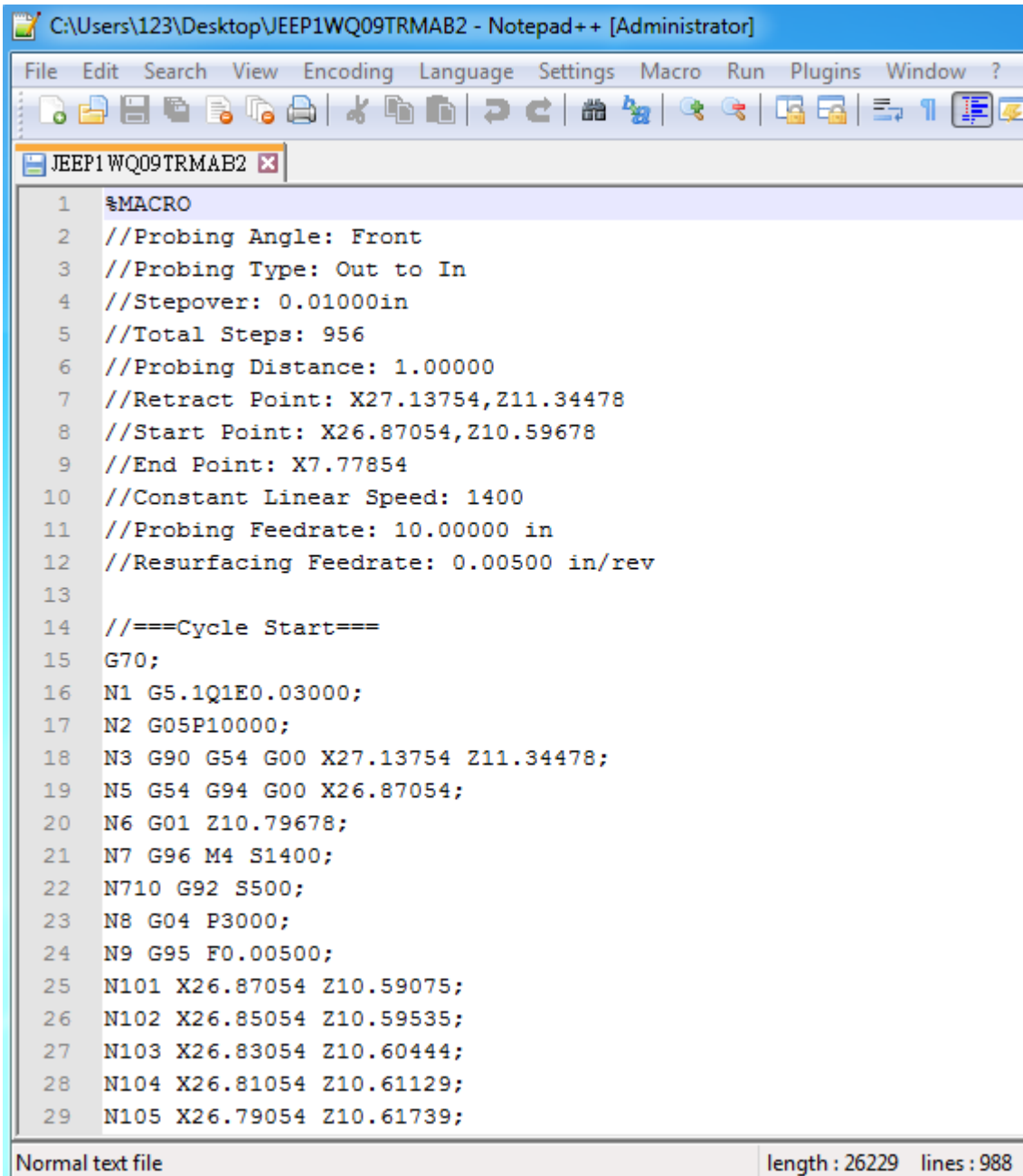
19. Change minimum and maximum from “Auto” to “Fixed.” Then enter the numbers. The numbers are based on the graph.



20. A much better graph.



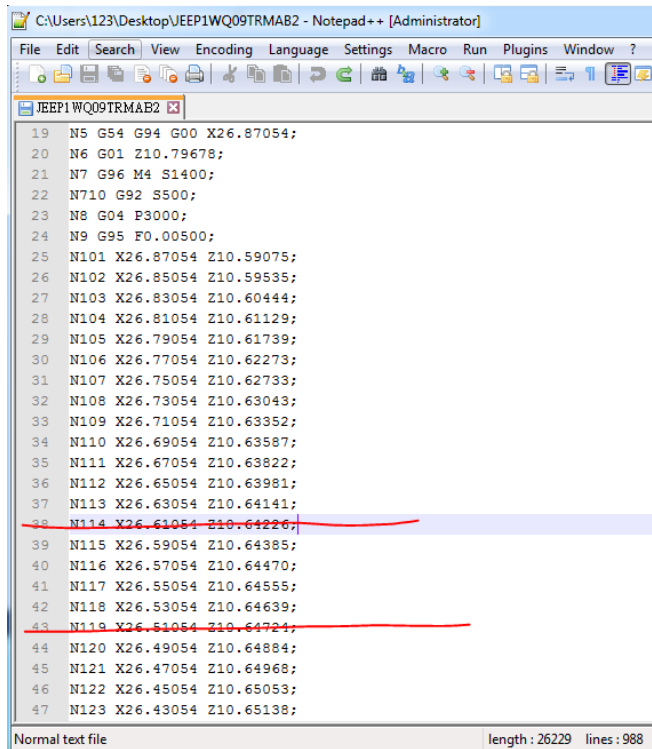
21. In this example, we found there are strange points on N114, N119, N151, N154, N171, N197, N219, N242, N262, N283, N298, N315, and N333. Write down all these N numbers.
22. Download Notepad ++ software at this link: <https://notepad-plus-plus.org/download/>
23. Install and Open Notepad++.



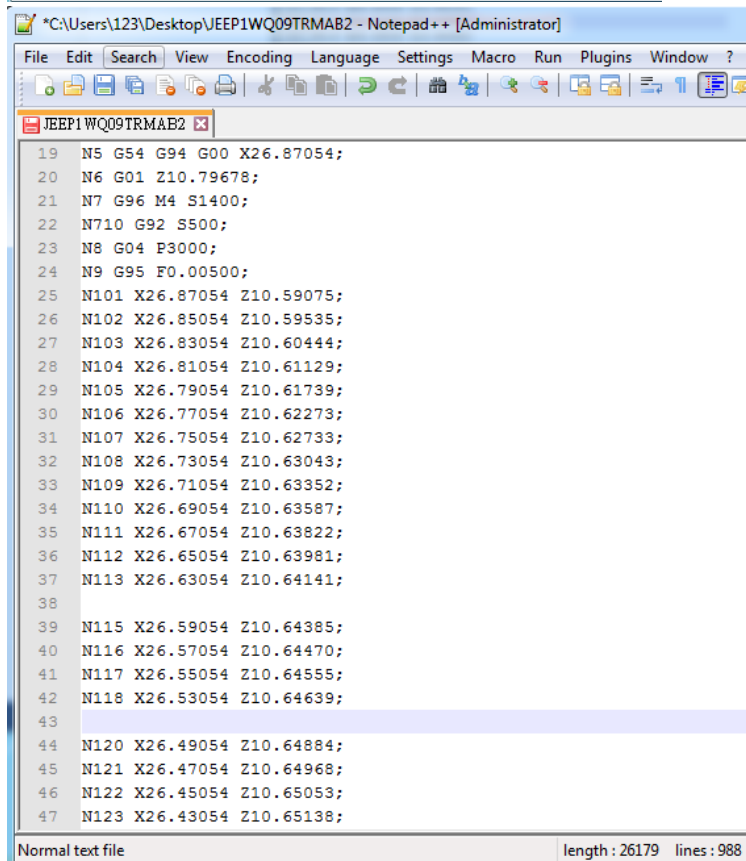
```
1 %MACRO
2 //Probing Angle: Front
3 //Probing Type: Out to In
4 //Stepover: 0.01000in
5 //Total Steps: 956
6 //Probing Distance: 1.00000
7 //Retract Point: X27.13754,Z11.34478
8 //Start Point: X26.87054,Z10.59678
9 //End Point: X7.77854
10 //Constant Linear Speed: 1400
11 //Probing Feedrate: 10.00000 in
12 //Resurfacing Feedrate: 0.00500 in/rev
13
14 //===Cycle Start===
15 G70;
16 N1 G5.1Q1E0.03000;
17 N2 G05P10000;
18 N3 G90 G54 G00 X27.13754 Z11.34478;
19 N5 G54 G94 G00 X26.87054;
20 N6 G01 Z10.79678;
21 N7 G96 M4 S1400;
22 N710 G92 S500;
23 N8 G04 P3000;
24 N9 G95 F0.00500;
25 N101 X26.87054 Z10.59075;
26 N102 X26.85054 Z10.59535;
27 N103 X26.83054 Z10.60444;
28 N104 X26.81054 Z10.61129;
29 N105 X26.79054 Z10.61739;
```

Normal text file length : 26229 lines : 988

24. Delete the strange numbers (lines) you wrote down. (N114, N119, N151, N154, N171, N197, N219, N242, N262, N283, N298, N315, and N333)



```
C:\Users\123\Desktop\JEEP1WQ09TRMAB2 - Notepad++ [Administrator]
File Edit Search View Encoding Language Settings Macro Run Plugins Window ?
JEEP1WQ09TRMAB2
19 N5 G54 G94 G00 X26.87054;
20 N6 G01 Z10.79678;
21 N7 G96 M4 S1400;
22 N710 G92 S500;
23 N8 G04 P3000;
24 N9 G95 F0.00500;
25 N101 X26.87054 Z10.59075;
26 N102 X26.85054 Z10.59535;
27 N103 X26.83054 Z10.60444;
28 N104 X26.81054 Z10.61129;
29 N105 X26.79054 Z10.61739;
30 N106 X26.77054 Z10.62273;
31 N107 X26.75054 Z10.62733;
32 N108 X26.73054 Z10.63043;
33 N109 X26.71054 Z10.63352;
34 N110 X26.69054 Z10.63587;
35 N111 X26.67054 Z10.63822;
36 N112 X26.65054 Z10.63981;
37 N113 X26.63054 Z10.64141;
38 N114 X26.61054 Z10.64226;
39 N115 X26.59054 Z10.64385;
40 N116 X26.57054 Z10.64470;
41 N117 X26.55054 Z10.64555;
42 N118 X26.53054 Z10.64639;
43 N119 X26.51054 Z10.64724;
44 N120 X26.49054 Z10.64884;
45 N121 X26.47054 Z10.64968;
46 N122 X26.45054 Z10.65053;
47 N123 X26.43054 Z10.65138;
Normal text file length : 26229 lines : 988
```



```
*C:\Users\123\Desktop\JEEP1WQ09TRMAB2 - Notepad++ [Administrator]
File Edit Search View Encoding Language Settings Macro Run Plugins Window ?
JEEP1WQ09TRMAB2
19 N5 G54 G94 G00 X26.87054;
20 N6 G01 Z10.79678;
21 N7 G96 M4 S1400;
22 N710 G92 S500;
23 N8 G04 P3000;
24 N9 G95 F0.00500;
25 N101 X26.87054 Z10.59075;
26 N102 X26.85054 Z10.59535;
27 N103 X26.83054 Z10.60444;
28 N104 X26.81054 Z10.61129;
29 N105 X26.79054 Z10.61739;
30 N106 X26.77054 Z10.62273;
31 N107 X26.75054 Z10.62733;
32 N108 X26.73054 Z10.63043;
33 N109 X26.71054 Z10.63352;
34 N110 X26.69054 Z10.63587;
35 N111 X26.67054 Z10.63822;
36 N112 X26.65054 Z10.63981;
37 N113 X26.63054 Z10.64141;
38
39 N115 X26.59054 Z10.64385;
40 N116 X26.57054 Z10.64470;
41 N117 X26.55054 Z10.64555;
42 N118 X26.53054 Z10.64639;
43
44 N120 X26.49054 Z10.64884;
45 N121 X26.47054 Z10.64968;
46 N122 X26.45054 Z10.65053;
47 N123 X26.43054 Z10.65138;
Normal text file length : 26179 lines : 988
```

25. Save file and import to CNC control. Make sure there is no strange points and send file to customer.