Spyder Wrap Pattern Generator

Load Pattern

Save Pattern

Save As New

Pattern Name	3inSpy1.tap

Gcode Output

%Startup_GCODE%
F30
M7
M2500
% XY coordinates F1100 M3
% XY coordinates
% XY coordinates M5
% XY coordinates
% XY coordinates
% XY coordinates
%End_of_main_WrapGCODE%
M2500
\\Burnish Section
%XY coordinates %BurnishStartSpeed 1 (F500)
%XY coordinates %BurnishRampSpeed2 (F900)
%XY coordinates %BurnishRampSpeed 3 (F1300)
%XY coordinates %BurnishFinalSpeed (F1500)
%XY Burnishcoordinates
%XY Burnishcoordinates
%XY Burnishcoordinates
%XY Burnishcoordinates
%End_of_Complete_Wrap%
M2500
open file 3inSpy1.tap

Shell Size Variables

Shell Size	Measured size	Diameter %	Circ +
3"	2.5"	98	0.01

Kick Variables

Total Kick	Kick ratio %
18	25

Shell Description	

Wrap Speed Variables

Wrap Feedrate	Burnish Feedrate	Overwrap %	Total Layers	Wraps per laye	Burnish Layers
1100	1500	100	6	12	4

Burnish Start Speed	500
Burnish Ramp Steps	4
Burnish Final Speed	1500

Machine G-Ccode Variables

Startup Gcode	End of Main Wrap	End of Complete Wrap
F30 **M7** **M2500**	M2500	M2500 **Open File %Pattern_Name%**

Total Estimated Feet

Water Pump Variables

Pump on/off code		Enable Pump	Cycles per shell		Duration
M3	M5	Yes/No?	1		3

Water Pump is used on some of the machines. If the cycle is 1, M3 would be inserted behind the first XY coordinate
Duration says how many lines to leave the pump on for before inserting M5 to turn it off.
Cycles would indicate how many times to insert M3 and M5 into the main wrap pattern.
Cycles per shell of 2 and a duration of 3 would imply that it inserts M3 at the beginning of the wrap
Then 3 lines later it would insert M5. Being cycles 2, would indicate that it looks at the number of lines
in the main wrap pattern, divides it by 2 and inserts M3 again followed by M5 3 lines later