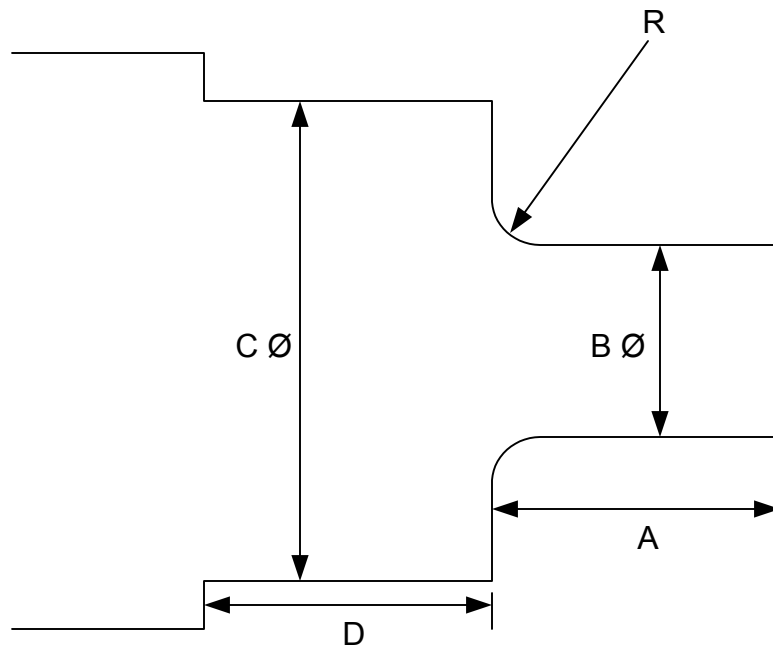


Programming the OmniTurn with variables using Excel[®]

- 1. Create an Excel[®] file with 2 sheets, one for the program code and the other for the variable values (print dimensions).**
- 2. Enter values from print into variables sheet.**
- 3. Write lines of G-code in first column of sheet for program. When a line that needs to contain a value from the variables sheet is required, write it as an Excel[®] formula. See cells A5, A7, A8 and A9 of example. Initially, write formulas to take values from “B” column. To create new programs, use “Replace” function to find and replace all !B to another column. If it is column H that you want to pull the values from, replace all !B with !H.**
- 4. After G-code program is finalized (with program sheet active), save as Text (MS-DOS)(* .txt) file. You will be notified that “The selected file type does not support workbooks that contain multiple sheets.” It will allow you to save only the active sheet, which is correct.**
- 5. After file is saved, find file, remove “.txt” extension and transfer to OmniTurn.**



| Part # | A | B | C | D | R |
|--------|-----|-----|----|-----|------|
| 100 | .2 | .4 | .5 | .2 | .03 |
| 200 | .25 | .45 | .6 | .1 | .05 |
| 300 | .31 | .6 | .7 | .25 | .025 |