

The Following is a list of supported EX2 drill file commands

M01 -- End of pattern
M02X#Y# -- repeat pattern offset
M08 -- end of step & repeat
M25 -- beginning of pattern
M30 -- End of program
M48 -- Program Header
M70 -- Swap axes*
M80 -- Mirror image x axis
M90 -- mirror image y axis
G90 -- Absolute mode
G91 -- incremental input mode
G92 / G93 -- Zero set
% -- start of drilling

**NOTE: The M70 command can only be used at the end-of-line, as it causes issues otherwise.*

For example:

This will cause errors
M02X-14115Y-18835M70M90
M02X1023Y1267M70M80

This will not
M02X-14115Y-18835M90M70
M02X1023Y1267M90M70

Sample programs

Basic format:

```
M48
T1 ; EX2 statements to the end of program
...
M25
...
M01
...
M08
...
M30
```

Sample programs (cont.)

Sample program 1:

M48
T01C.006
T02C.010
T03C.187
T04C.015
%
T01
M25
X03747Y04416
Y04352
X03883Y0432
[...]
M01
M02X18Y25M80M90
M02X-14115Y-18835M90M70
M02X1023Y1267M80M70
M08
M25
X044000Y086500
X044500
X045000
X045500
X046000
X044000Y086000
Y085500
Y085000
Y084500
X136000Y086000
[...]
M01
M02X18Y25M80M90
M02X-14115Y-18835M90M70
M02X1023Y1267M80M70
M02
M08
M25
T00
M30

Sample Program 2:

M48
T01C.0059
T02C.0157
T03C.1870
T04C.1990
%
T02
Y082259X09796
Y098289
X10503
[...]
Sample Program 3:
M48
T01C.0059
T02C.0157
T03C.1870
T04C.1990
%
T01
X120486Y133306
X119501Y133306
X119009Y132814
X056726Y093550
X054411Y092914
X054570Y092550
X054608Y093550
X054982Y093540
X055192Y092779
X055291Y091653
X055339Y093442
[...]
M01
M02X0Y1404
M08
T00
M30