



Micron Laser Technology

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Appendix B: Supported EX2 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:

```
M02X-14115Y-18835M70M90  
M02X1023Y1267M70M80
```

will cause errors, but

```
M02X-14115Y-18835M90M70  
M02X1023Y1267M90M70
```

will not.

Appendix C: EX2 formatting and sample programs

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Basic format:

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

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
```