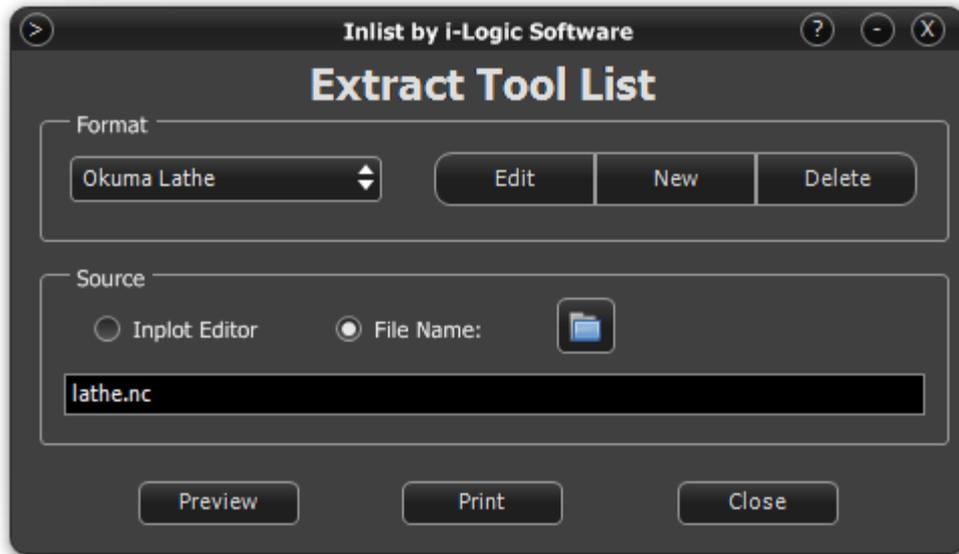


# **Inlist**

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# Inlist



The Inlist program is for producing a tool list printout from an NC program file.

If you have a consistent format of how you make your NC programs you should be able to extract data from the program and print it out on a report.

**Format** - You can have multiple user defined extraction formats. You can have to different extraction formats for different types of CNC machines. Choose a user defined format from the Dropdown box.

**Edit** - Edit the definition settings for the chosen format. This opens the Settings window.

**New** - Create a new Format.

**Delete** - Delete the selected format.

**Source** - Filename - Enter the NC filename to process.

**Source** - Inplot Editor - This will use the the file that is in the Inplot Editor to produce the report.

**Preview** - Produces the report and displays it on the screen.

**Print** - Prints the report.

## Settings

**Format: Okuma Lathe**

Tools | Items | Lists | **Config**

Report File:

Test NC File:

**Start of Tool Sequence**

Start of Tool:

Line Contains:

Not Contain:

**End of Tool Sequence**

End of Tool:

Line Contains:

Not Contain:

Skip Lines Containing:

Skip everything after M30

Default Picture Path:

User Data Path:  
M:\temp\inlist\

```
N365X40.0Z40.0
N370M01 P360
N375T1200
(--
N380G14
(TL 7T-12463)
(--
(-TOOL SET OD & FACE)
(--
(-TOOL HOLDER CTCPR-204D)
(-INSERT TPG 433 KC730 R.047)
(-KENNAMETAL)
(--
N385G00X6.984Z20.0 T020202 G110
N390Z5.355 P301
N395G01Z4.555F.010 M08 P302
N400G01Z5.205F.10 P303
N405G00Z20.0 M09 P304
N410M01P305
(--
N415G00X8.827M03 S150 P306
N420Z5.821 P307
N425G01X8.485Z5.651F.016M08 P308
N430Z4.57P309
```

Edit Report | Preview Report | Close

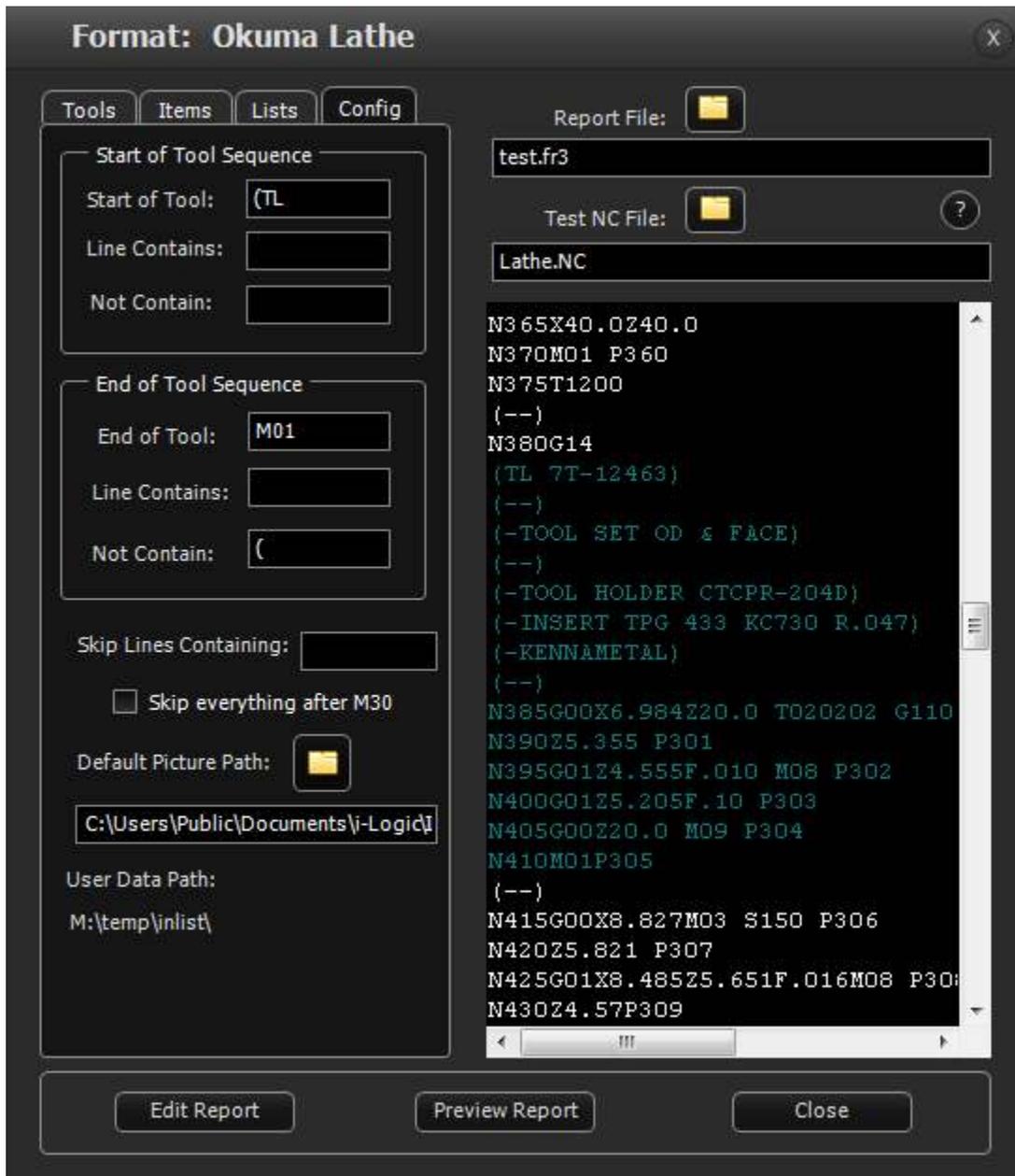
**Settings Window** - The settings window shows all the settings for a particular format.

**Edit Window** - The settings window has an edit window that holds an NC program file in order to test how your settings will extract items.

**Test NC File** - enter the file you want to use as a test file.

**Report File** - Each format can have it's own report template that to use for printing.

## Settings - Configuration Tab



These settings are for defining the tool segment. An NC program has many tools and we want to extract items from each different tool - for instance the tool number and offset number for each tool. In order to do this, we must define where the start of the tool segment and the end of the tool segment. This means you must have a consistent method of starting lines and ending lines for each tool.

**Start of Tool Sequence** - In this example, we notice that every start of a tool segment starts with a tool name in a comment so we enter into Start of Tool "(TL" because we know those characters will be at the start of every tool.

**Line Contains** - This makes sure there are certain characters in the start line we are looking for. In this example we don't need to look for anything except what is in the start of tool.

**Not Contain** - This will make sure the start of tool line does not contain these characters.

**End of Tool Sequence** - In this example we notice that the end of every tool contains M01 on the line.

**Line Contains** - If we wanted to make sure the end line also had certain other

characters in it we would put them here.

**Not Contain** - In this case we want to make sure it doesn't find any M01 that happens to be in any comment, so we will put "(" in here so it will skip any lines that are comments.

**Skip Lines Containing** - This is a universal skip line define. Any of the searches will skip lines that contain these items. Multiple strings of characters can be entered with a semicolon between them.

**Skip everything after M30** - This is helpful if you have other subprograms in the file after the main program and need to skip them.

**Default Picture Path** - With the default picture path defined, you can just put the filename in the program and Inlist will add this path to the filename to find the on the hard drive.

If no extension is used on the filename ".png" is used by default.

See Also: [Setting-Items](#), [Settings-Tools](#).

**User Data Path** - this displays the directory the Inlist program is using to put its settings and configuration files in.

# Settings - Tools

**Format: NMCC-Mill**

Tools | Items | Lists | Config

Report File:

Test NC File:

Extract Tool Item

Report Field:

Name:

Address or Start Text:

Include Start Text

Line Contains:

Not Contain:

End Text:

Include End Text

First Only

Unique  DataLink

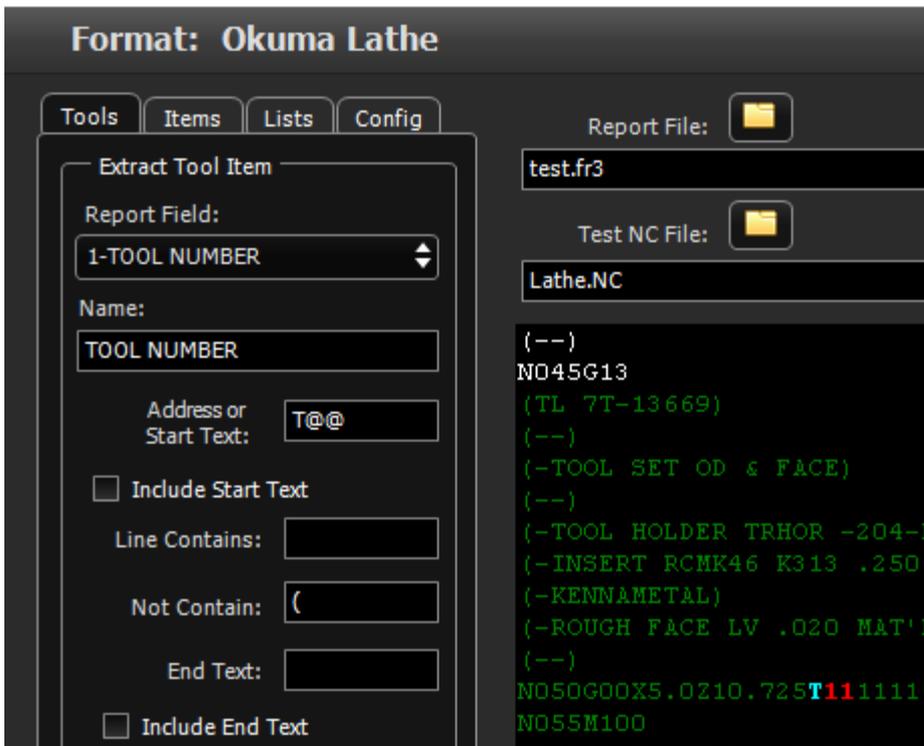
For each tool sequence, finds matching Items and puts them in the data field. Start and End of tool sequence is defined in config tab.

```
G00 G49 Z0. M09
M01

N2 (* ROUGH OUTSIDE CONTOUR - 2
T02 M06 (-- REM 0.500 3FL)
(PIC MTOOL7)
G00 G90 G55 X0 Y1.5 S2400 M03
G43 Z1. H02 M08
G01 Z-0.75 F36.
G41 X-0.5 Y1.5 D02
M97 P100 (* 1ST PASS)
G00 G40 X0 Y1.5
G01 Z-1.41
G41 X-0.5 Y1.5 D02
M97 P100 (* 2ND PASS)
G00 G40 X0 Y1.5
G00 G49 Z0. M09
M01

N3 (* FINISH OUTSIDE CONTOUR -
T03 M06 (-- FEM 0.500 4FL)
(PIC MTOOL5)
G00 G90 G55 X0 Y1.5 S900 M03
G43 Z1. H03 M08
```

Edit Report | Preview Report | Close



**Extract Tool Item** - Tool Items are items that re-occur in every tool sequence - like tool numbers and tool descriptions. These items are put in data fields that will print in the report for every tool.

The user defines each data field he wants to use.

**Report Field** - A dropdown list of user defined fields.

**Name** - This is where you assign the field name for this item. To create a new field, choose one of the empty items in the dropdown and type in a name in the Name box

**Address or Start Text** - This is what to use to identify what we are looking for. Above we are going to extract the value of the T address. In a lathe program the T address value has multiple parts. The first two digits are the tool number so we have a technique to extract certain digits. After the "T" add the "@" character in the place of the digits you want. The values it will extract are highlighted in red as you type your definition.

**Include Start Text** - Check this if you want to include the Begin Text in the extracted value.

**Line Contains** - Use this if there are any characters you want to make sure are in the line we are looking for - to distinguish it from other similar lines. For instance, you may want to extract the tool number but you only want to extract it on the lines that also have an "M6" on them.

**Not Contains** - Use this to make sure the search skips lines with these characters. Example: you may want to extract the "H" number but not if it has a "G15" on the same line.

**End Text** - Use this to extract something in the line and stop the extraction at this character. Example: for ( PN 4321987 REV.1 OP 30) you could set Part Number Start Text to "PN" and End Text to "OP".

**Include End Text** - Include the End Text into the field value.

**First Only** - If there are multiples of the same items, like multiple D addresses in the tool sequence but you only need one of them then you can check the First Only box.

**Unique Only** - If there are multiple items in this tool that are different, you can extract just one of each. For instance, if the tool uses multiple tool comp D values, but don't want redundant extractions of the same value, check this.

First Only - If you had multiple lines repeating the same address or text you may want to only get the first one. If this is not check, all of them will be extracted to lines in a memo field.

**DataLink** - See [DataLink](#) instructions.

**Tool Pictures** - Tool pictures can be added to the report for each tool section by putting the filename in comment starting with "(PIC ". One picture per tool section is allowed.

EX:

(PIC TOOLM.PNG)

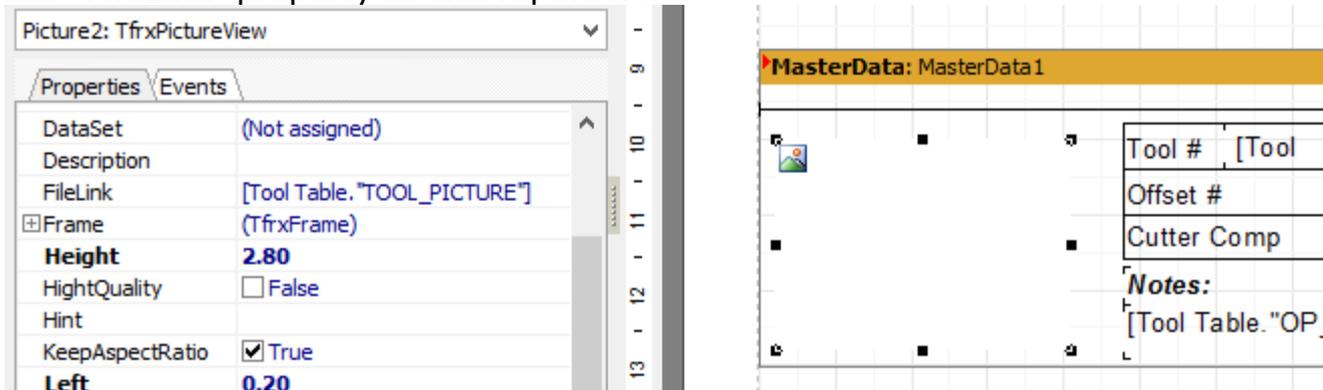
(PIC C:/TOOLPICS/TOOLM.PNG)

Note: You can use forward slashes or back slashes since your CNC machine might not accept backslashes in the program.

With the default picture path defined, you can just put the filename in the program and Inlist will add this path to the filename to find the on the hard drive.

If no extension is used on the filename ".png" is used by default.

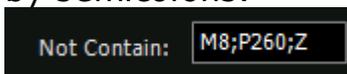
Then you can put a picture item on the report template in the tool section and set the "FileLink" property to the report field.



See Also: [Setting-Items](#)

### Tips:

Multiple items to look for - In the definitions you can have multiple items separated by semicolons.



To include spaces on the end or beginning of search text, put a semicolon after the text.

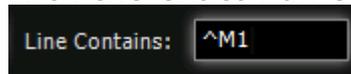


Address or Start Text does not allow multiple items but can include spaces.

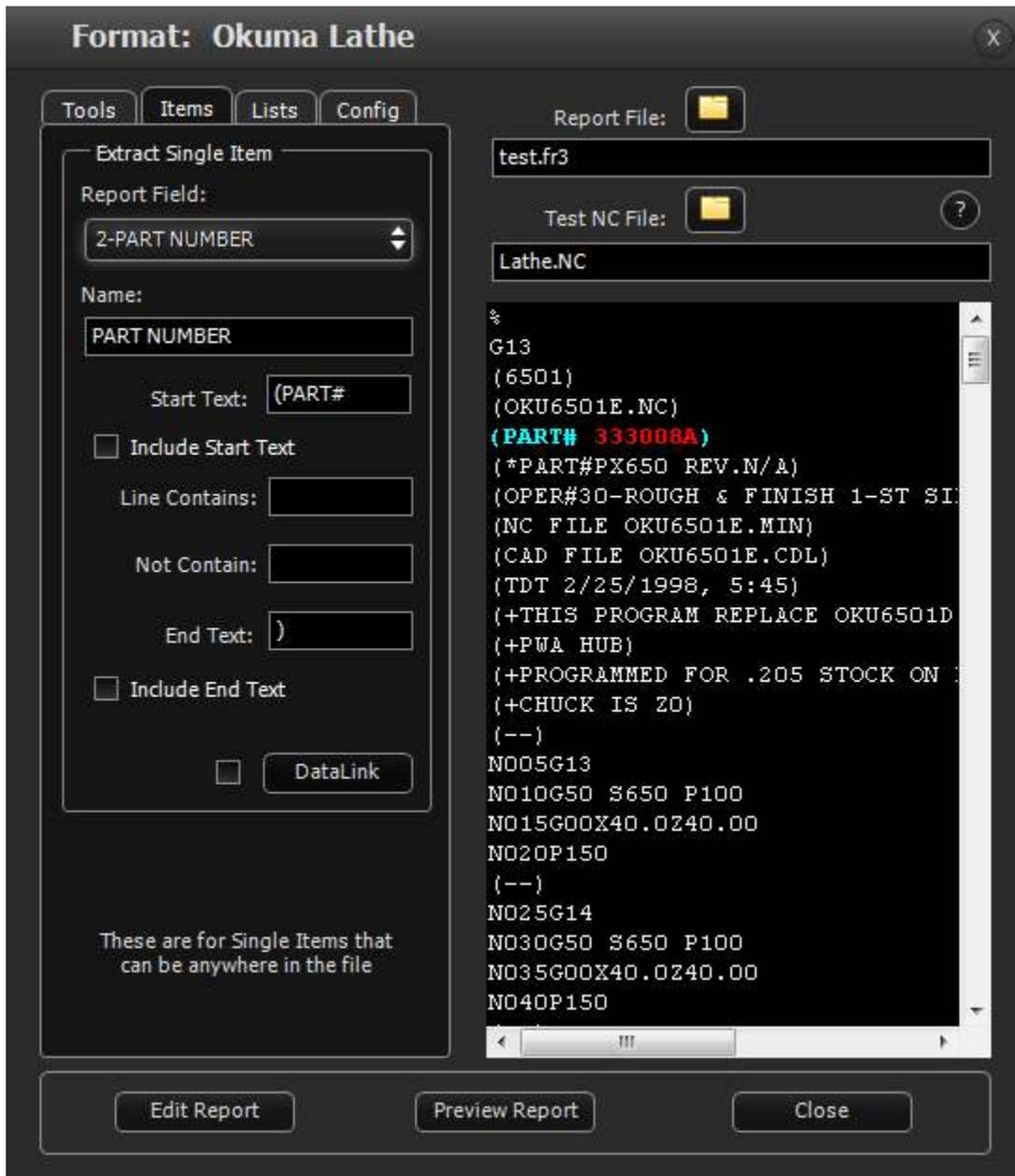
To skip digits in an address insert the "&" character into the definition.



Normally InList is only looking for strings of characters but this may be a problem in some cases. If I want to end each tool with "M1" then if I search for that string it might find it in "M18" or "M100" and won't find it in "M01". To find number value instead of string put a "^" in front. For instance, "^M1" will look for the address "M" with the exact numeric value of 1 after it.



## Settings - Items



Extract Single Item - Single Items are on one line anywhere in the file. It can be used to extract items like part number etc.

The user defines each data field he wants to use.

**Report Field** - A dropdown list of user defined fields.

**Name** - This is where you assign the field name for this item. To create a new field, choose one of the empty items in the dropdown and type in a name in the Name box

**Start Text** - This is what to use to identify the beginning of what we are looking for. You define the end of what you are looking for with End Text.

**Include Start Text** - Check this if you want to include the Begin Text in the extracted value.

**Line Contains** - Use this if there are any characters you want to make sure are in the line we are looking for - to distinguish it from other similar lines. For instance, you

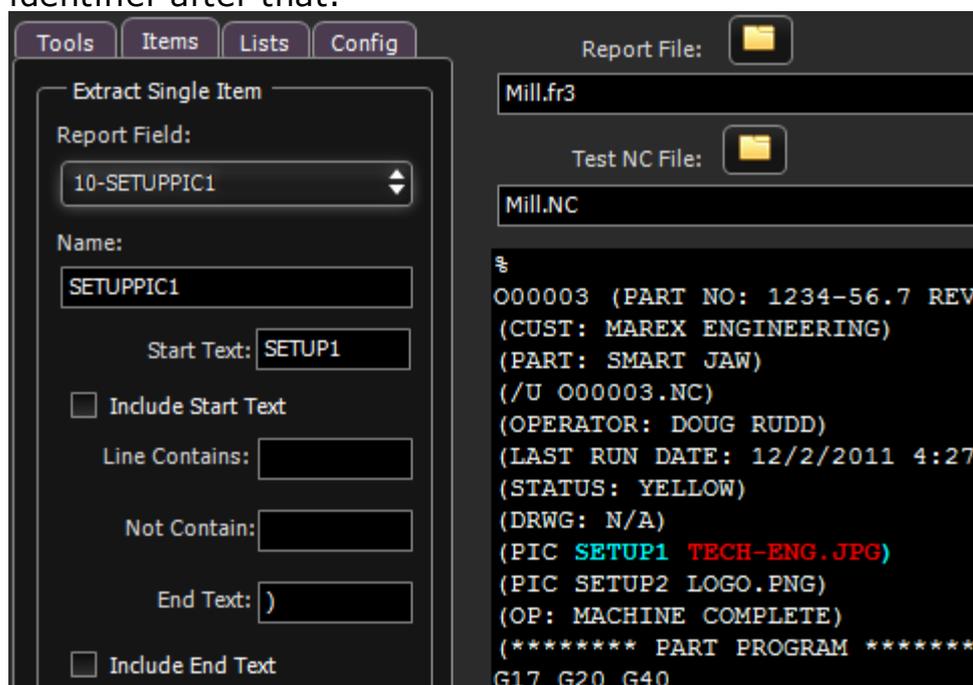
may want to extract the tool number but you only want to extract it on the lines that also have an "M6" on them.

**Not Contains** - Use this to make sure the search skips lines with these characters. Example: you may want to extract the "H" number but not if it has a "G15" on the same line. Put "(" in here to skip looking in comments.

**End Text** - Use this to extract something in the line and stop the extraction at this character. Example: for ( PN 4321987 REV.1 OP 30) you could set Part Number Start Text to "PN" and End Text to "OP". If there is no End Text defined then will extract to the end of the line.

**Include End Text** - Include the End Text into the field value.

**Using Pictures** - Other separate pictures can be added to the report as separate items by putting the filename in comment starting with "(PIC ". Then add another identifier after that.

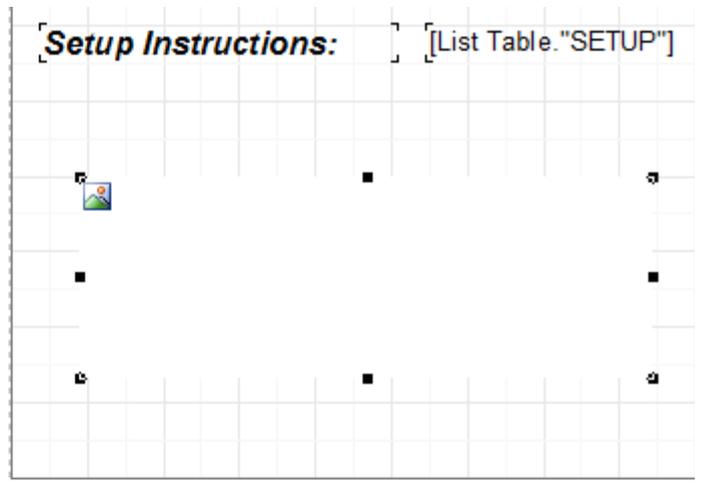
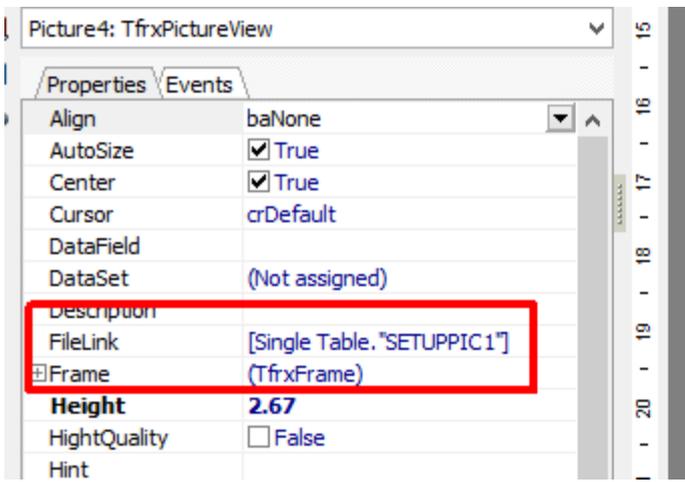


EX:  
(PIC SETUP1 1234.PNG)  
(PIC SETUP2 2345.PNG)

With the default picture path defined, you can just put the filename in the program and Inlist will add this path to the filename to find the on the hard drive.

Put it outside of all the tool sequences - like in the heading, or it will think it is a tool picture.

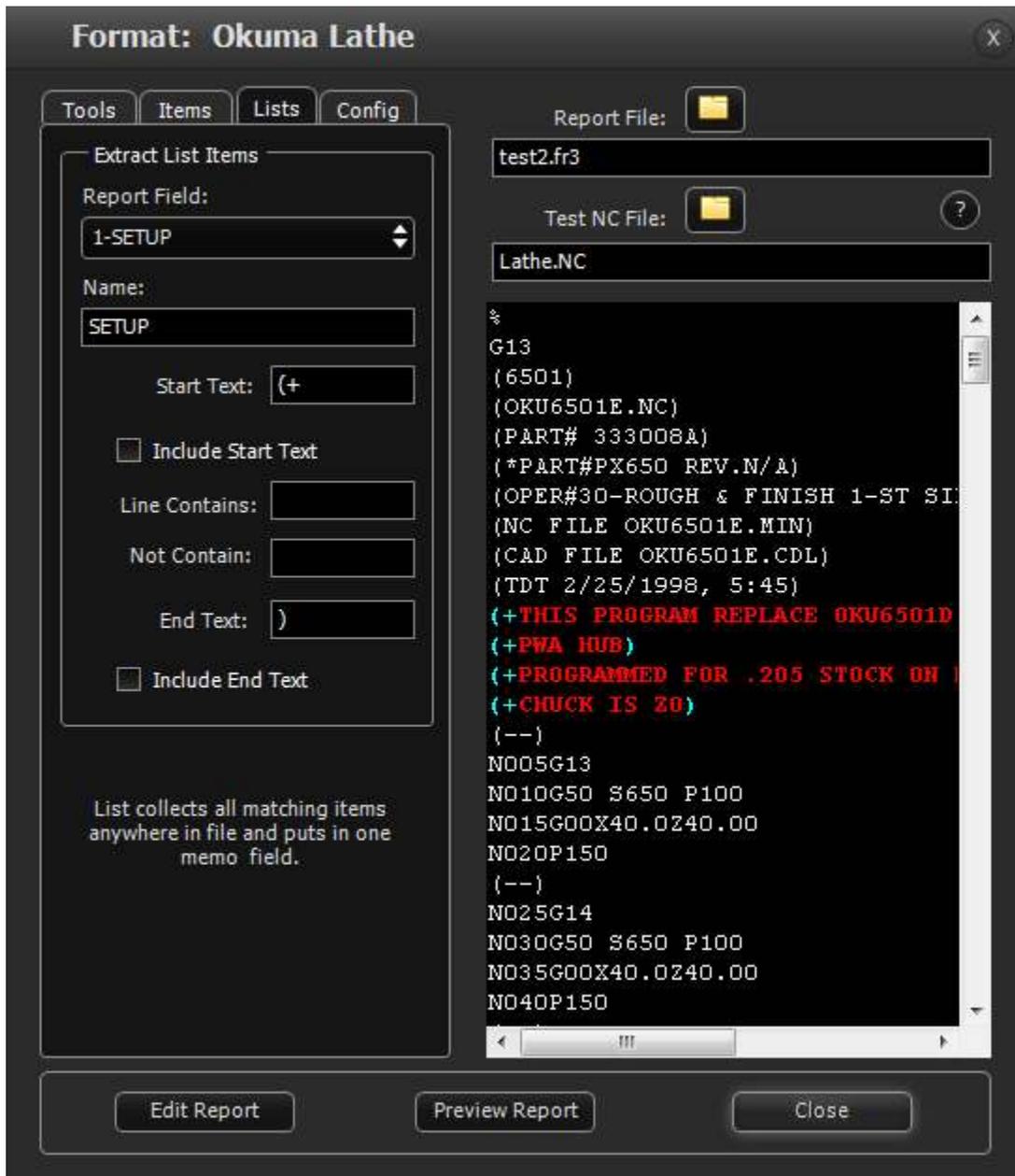
Then you can put a picture item on the report template outside of the tool section and set the "FileLink" property to the report field.



If no extension is used on the filename ".png" is used by default.

See Also [Settings-Config](#)

## Settings - Items



**Extract List Items** - List Items are similar tagged lines anywhere in the file that are gathered up into one piece. For instance, you have setup information in the file. You can take these lines and put them in one field called "Setup" to make it easy to print where you want on the printed report.

The user defines each data field he wants to use.

**Report Field** - A dropdown list of user defined fields.

**Name** - This is where you assign the field name for this item. To create a new field, choose one of the empty items in the dropdown and type in a name in the Name box

**Start Text** - This is what to use to identify what we are looking for. This marks each line it finds.

**Include Start Text** - Check this if you want to include the Begin Text in the extracted value.

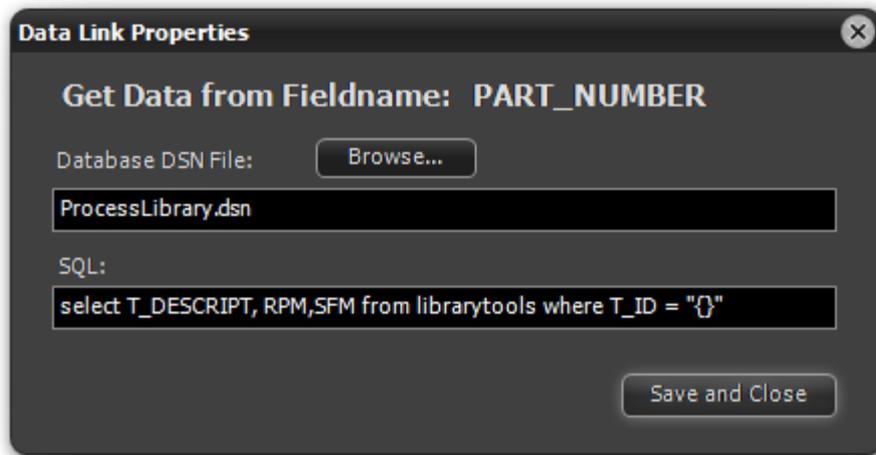
**Line Contains** - Use this if there are any characters you want to make sure are in the line we are looking for - to distinguish it from other similar lines. For instance, you may want to extract the tool number but you only want to extract it on the lines that also have an "M6" on them.

**Not Contains** - Use this to make sure the search skips lines with these characters. Example: you may want to extract the "H" number but not if it has a "G15" on the same line. Put "(" in here to skip looking in comments.

**End Text** - Use this to extract something in the line and stop the extraction at this character. For something you have in comments you would usually stop at the end comment character ")".

**Include End Text** - Include the End Text into the field value.

## DataLink to External Database



Only databases with ODBC drivers are supported.

**Database DSN File** - The connection to the database is made through a DSN file. A DSN file is a text file that contains the connection string to the database driver. It's format is:

```
[ODBC]
DRIVER=MySQL ODBC 5.1 Driver
Server=gateway
Pwd=george
Persist Security Info=True
Uid=root
Database=ProcessLibrary
OPTION=2
Provider=MSDASQL.1
```

You can find more information about DSN files for your database on the Internet.

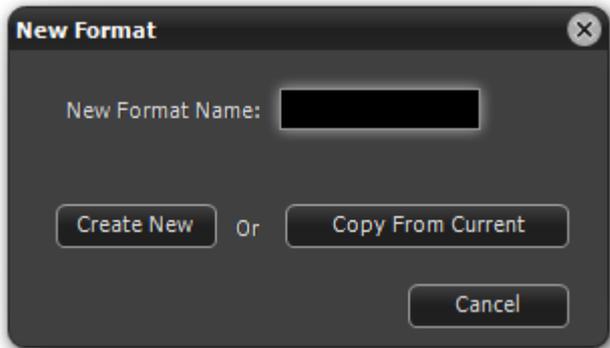
**SQL** - This is the SQL statement that will retrieve fields from your database. The fields listed in the SQL select statement will be added to the fields available to your report. The two curly brackets {} will be substituted with the extracted value for this extraction item. In our example, you can extract a tool ID from the NC program and then look up that ID in a database and put those fields in the extracted items record.

1. Extract SNMG433FACE from (TL SNMG433FACE) to Report Field SFM
2. Open Datalink window for this item.
3. Fill in Database DSN File.
4. Enter SQL "select SFM from librarytool where T\_ID="{}"
5. On report page design, put a text label for field SFM. It will display value from SFM field from database.

## New Format

---

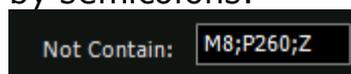
**New Format** - Enter the new format name. You can either press the Create New button and the format will be created with blank settings, or the Copy From Current button to copy the settings from the currently selected format.



The image shows a dark-themed dialog box titled "New Format" with a close button (X) in the top right corner. Inside the dialog, there is a label "New Format Name:" followed by a text input field. Below the input field, there are three buttons: "Create New", "Or", and "Copy From Current". At the bottom right of the dialog is a "Cancel" button.

## Tips:

Multiple items to look for - In the definitions you can have multiple items separated by semicolons.



---

To include spaces on the end or beginning of search text, put a semicolon after the text.



Address or Start Text does not allow multiple items but can include spaces.

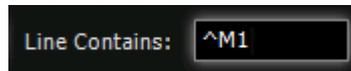
---

To skip digits in an address insert the "&" character into the definition.



---

Normally InList is only looking for strings of characters but this may be a problem in some cases. If I want to end each tool with "M1" then if I search for that string it might find it in "M18" or "M100" and won't find it in "M01". To find number value instead of string put a "^" in front. For instance, "^M1" will look for the address "M" with the exact numeric value of 1 after it.



---

[Use from command line](#) - Inlist can be started from a command line with several parameters.

/F = filename

/P = print report without preview. Without this the report will be displayed in the preview window where it can be printed.

/I = get filename from Inplot.

/N = Format Name. Inlist will be set to this format name. The same names as are in the Format Dropdown box on the main page of Inlist.

You need to put quotation marks around any parameters that have spaces in them.

With filename and format name the code is put directly in front of the name without a space.

Example:

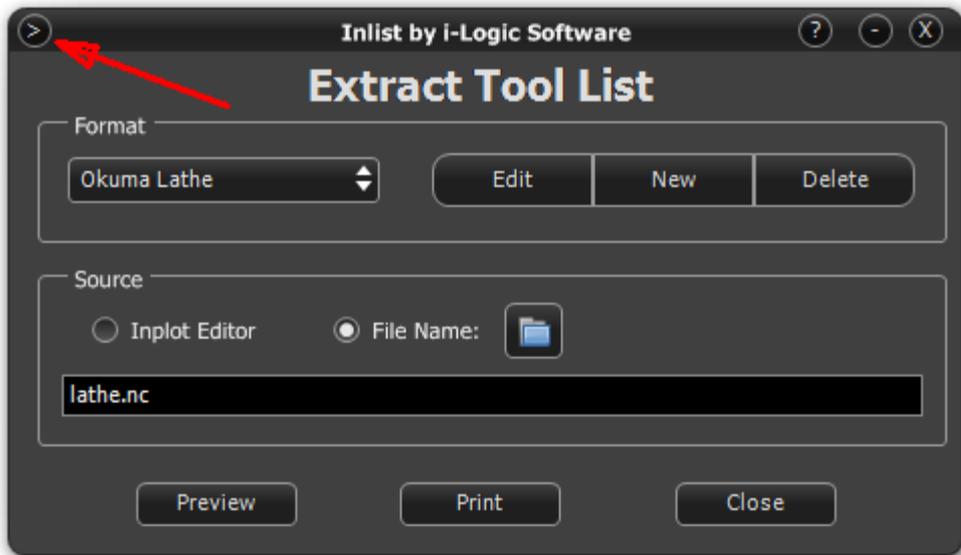
```
inlist.exe /Fc:\nc\myprogram.nc "/NOkuma Lathe"
```

```
inlist.exe /i /p
```

It is also possible to cause the program to always use the preview window when run from the command line. Add "UsePreview=1" to the inlist.ini file.

```
[InList]
```

```
UsePreview=1
```



Enter Registration Code that you received when purchased.

# Installation

---

## Running on a Remote Server

In order to have the program on a remote server where multiple users can use it at the same time, you will have to make some adjustments. The main thing is that when Inlist starts up, it first looks in the user data folder (which is created on installation) for the configuration and license files, and if that directory does not exist, then it looks in the current directory that the executable is in. So, if you want everyone to use the same configuration files then remove the user data folder and put all the files where the executable is. If you want everyone to have their own configuration, then make sure the configuration files are in the user files directory on the local computer.

The current user data path is shown in [Settings-Config](#).