Artsoft Helpdesk

I have extra circular movements in my tool path that are not in my Gcode Mach4.

Imported User 6 - 2019-04-29 - in Mach4

If you load a G Code file and see a bunch of circles that are not programmed into the gcode in your toolpath, you need to change the Arc Center Mode setting (called IJ Mode in Mach3). Open Mach4 and go to Configure>Control>General. Under Arc Center Mode, make sure that Absolute is selected and then reload your file. Those cicles should be gone. Alternatively, you can use a G91.1 command in the startup block at the beginning of your G Code file to change that setting for that file, but leave your default setting in Mach4 as is.