

# Offsets- Diameter

**When to use:** 2 Methods of Tool Diameter offsets.

**Design the Tool the right size-** to the correct size and use CAD/CAM tool path centerline. For Example a .500 diameter bit measured as .480 would be added to the tool library as .480.

Program Tool actual size.



**Machine Compensation-** Pick G41/G42 Machine compensation in your Cad/Cam program. Enter the radius difference of the tool diameter in the Tool Table. Enter Radius value in tool offset table.

Tool Radius  $.480/2 = .240$

Make sure the D value is for the tool that you are using.

Put .240 value in Offset Table to compensate for tool wear.

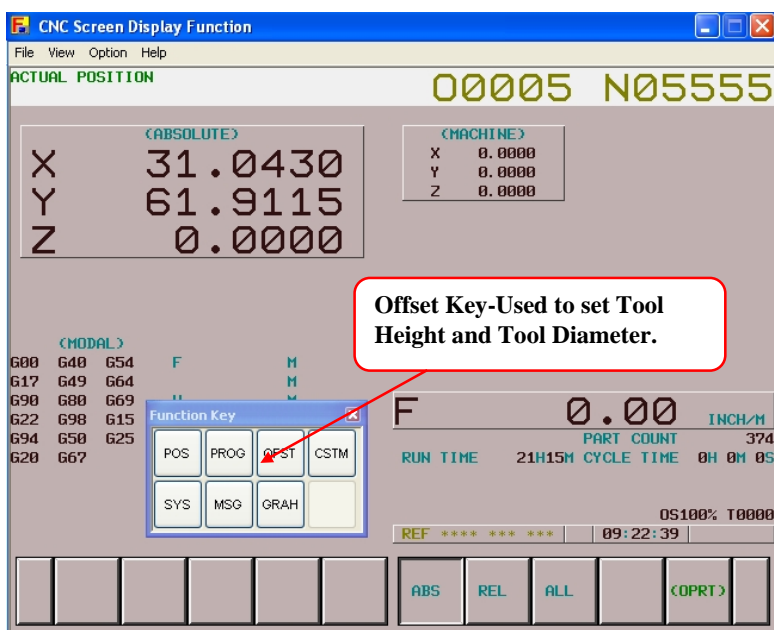


Figure 2 Select OFST button for height and diameter offsets.

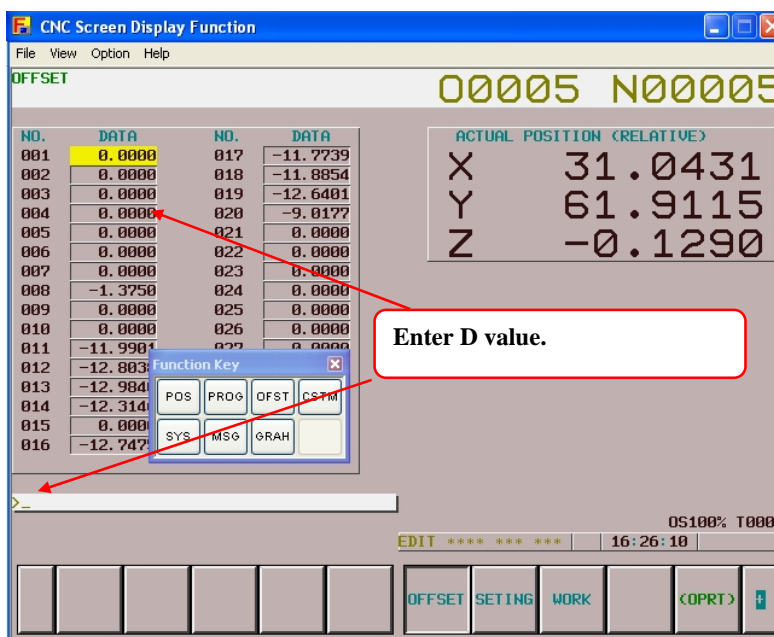


Figure 1 To enter go to EDIT of MDI mode. Table where height and diameter offsets are stored. Typically 1-10 on a 10 Tool ATC are used for tool diameter offsets and 11-20 are used for Tool Height offsets, however customers can select other configurations.