

Offsets- Height

When to use: Height Offset sets distance from the bottom of the Tool Tip to the zero point. This point can be the top of material, top of pods, top of grid table or the most common selection the top of the Spoil Board.

Note: Customers just need to pay careful attention to their touch off zero, since this point plus the Z move in the program determines the final Z plunge.

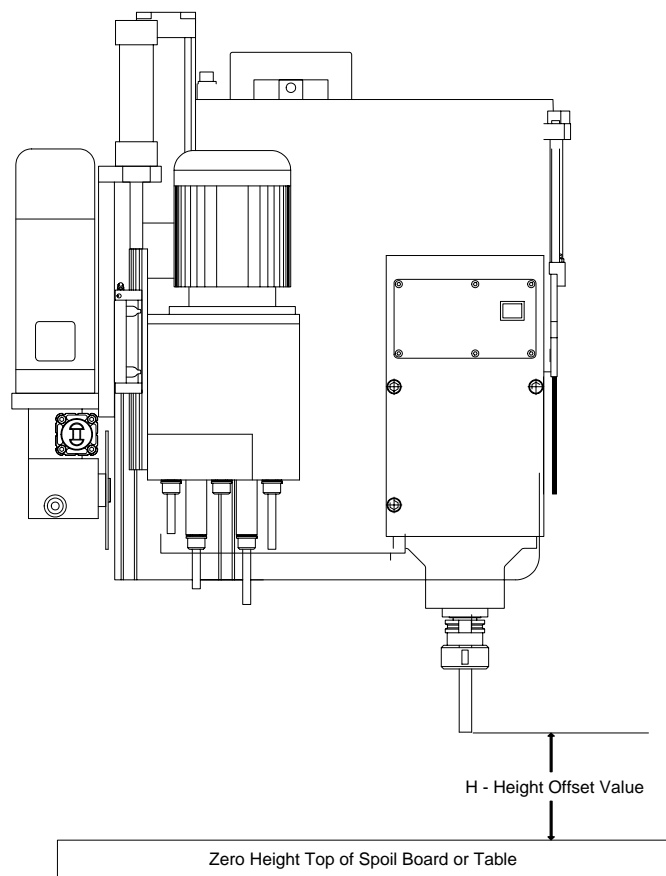


Figure 1 To program value into offset table use Jog Mode and Jog Button. Lower spindle to top of spoil board. Record Z value and enter into offset table. This table saves values for tool height and for tool diameter. Also see Automatic Tool Touch Macro.

Note : Make sure the spindle has been lowered into position.

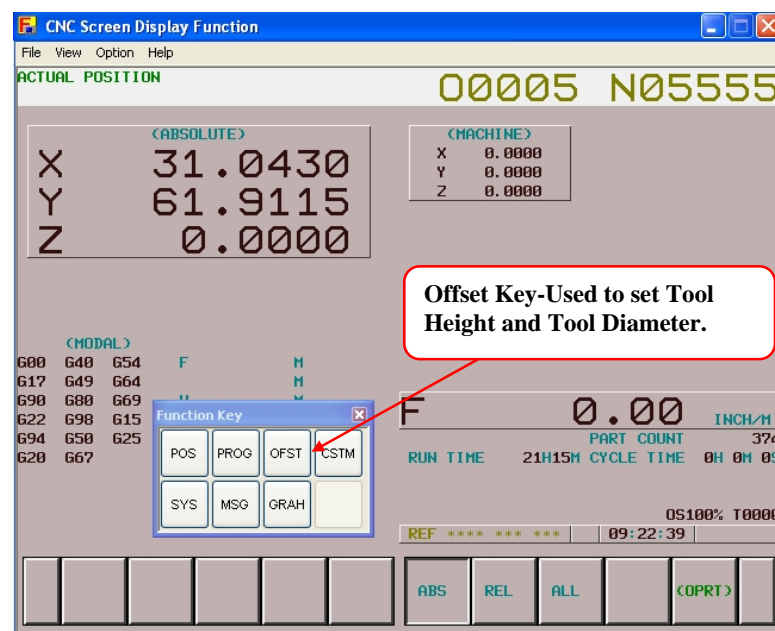


Figure 2 Select OFST button for height and diameter offsets.

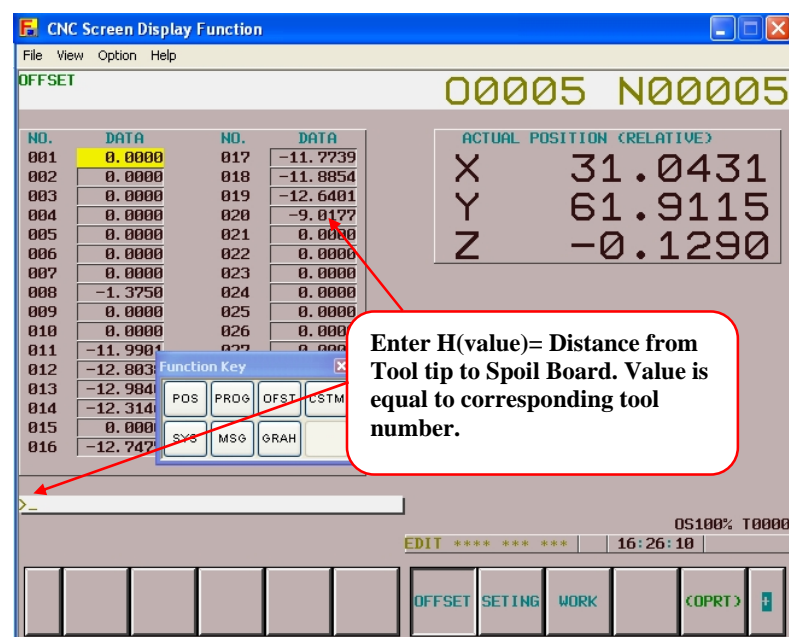


Figure 2 To enter go to EDIT of MDI mode. Table where height and diameter offsets are stored. Typically 1-10 on a 10 Tool ATC are used for tool diameter offsets and 11-20 are used for Tool Height offsets, however customers can select other configurations.