

Offsets- Work Drill Block Exxact DUO Twin Table

When to use: Anderson uses Work Offset to swap primary position of main spindle with Drill Block and/or optional horizontal drills and/or rotating slotting saw.

Note: Exxact Duo Machines have 2 configuration for twin tables. Setting 0, 0 at each table or letting the post processor handle the table selection. Machines have several Drill Block configurations. Listed below are the main configurations.

G54 Value moves spindle from machine home to table home and sets X, Y zero to the corner of table

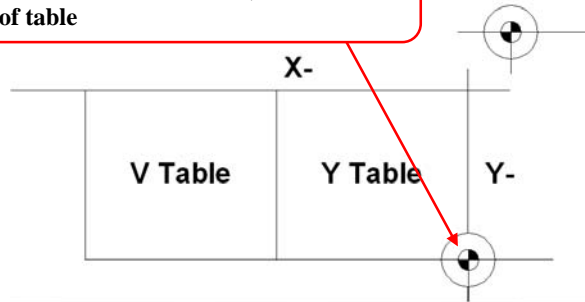


Figure 1 Standard Configuration - Post Processor asks question which table do you want to use. Y Table V Table or Locked.

G54 Value moves X, Y Table
G58 Value moves X, V Table

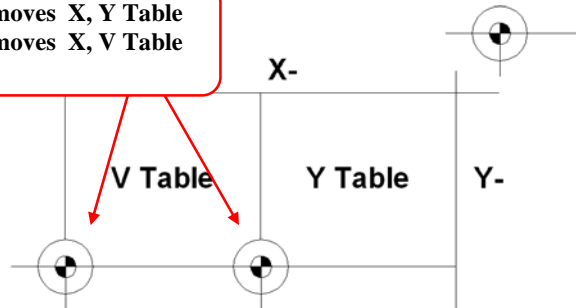


Figure 1 Custom configuration - above uses G54 to set 0, 0 on Y table and G58 to set 0, 0 on V table. This allows a customer to easily swap parts on either table and program parts using the positive positive first quadrant.

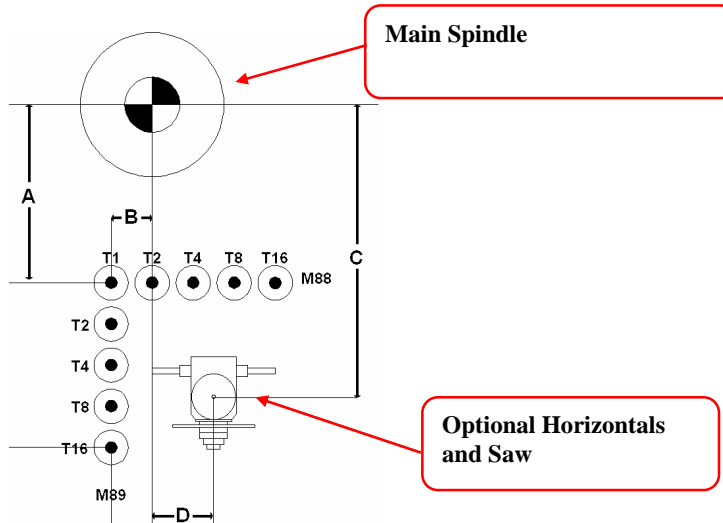


Figure 2 (see Table Below) Work Offsets must be put in Table to swap primary position of the axis. Your Multidrill postprocessor will select the M code and T codes, however you can test drill block by going to MDI mode and dropping selected drill. Example M88T1 drops corner drill.

Note : Value below are only approximate. Must do a test drill pattern for precise alignment.

Pos.	Description	Dist. your Machine
A	Y offset Position to Drill Block corner	
B	X offset Position to Drill Block corner	
C	Y offset position to Horizontal Drills and Saw	
	X offset position to Horizontal Drills	

G54 Sets position of primary spindle from machine home to table home.

G55 Corner position of Drill Block. You must fill in values for your machine. Starting Values are in Anderson operation manual.

G56 Center point of horizontal drills and saw. You must fill in values for your machine. Starting Values are in Anderson operation manual.

NO.		DATA		NO.		DATA	
00	X	0.0000		02	X	-9.7930	
(EXT)	Y	0.0000		(G55)	Y	-68.7720	
	Z	0.0000			Z	-12.9820	
01	X	-31.0430		03	X	-15.1805	
(G54)	Y	-61.9115		(G56)	Y	-63.4225	
	Z	0.0000			Z	-12.8260	

Figure 3 Click on OFST. Click on Work. Cursor to position.