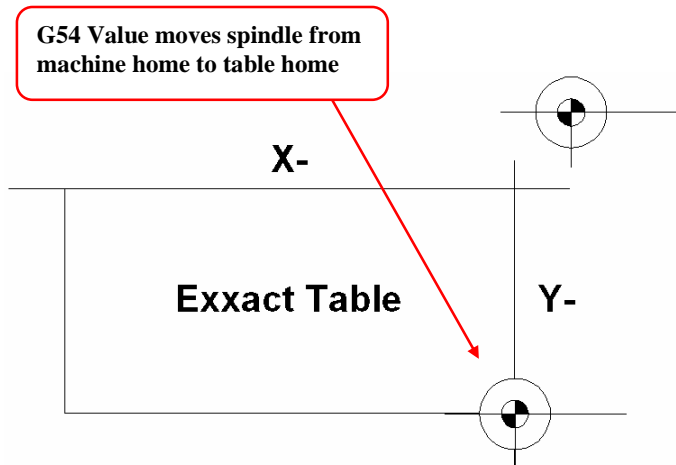


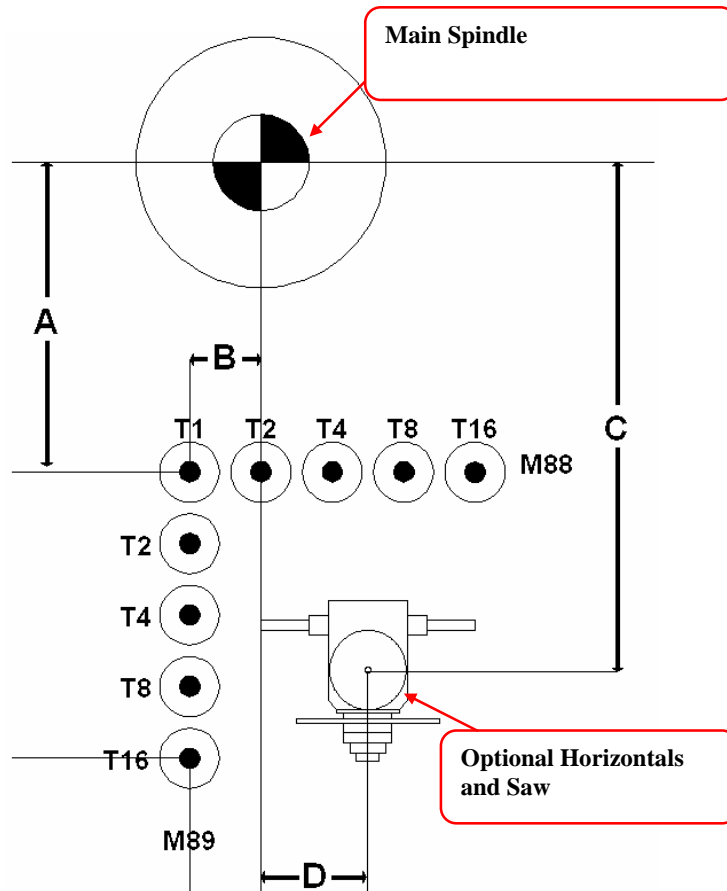
# Offsets- Work Drill Block Exxact-CabMaxx

**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:** Machines have several Drill Block configurations. Listed below are the main configurations.



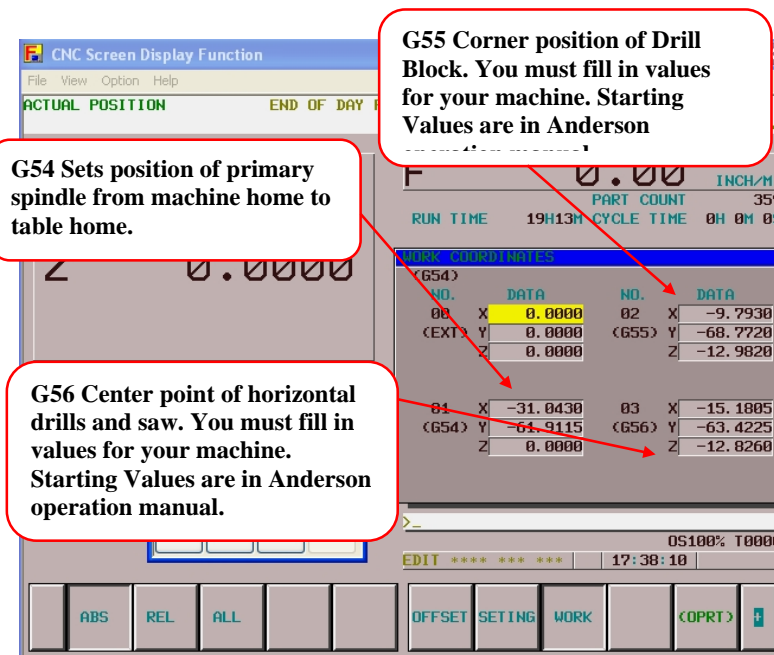
**Figure 1** 5 x 5 Drill Block – Work Offsets set position for primary spindle and Drill Block.



**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	



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