

Offsets- Work Drill Block Stratos SUP

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.

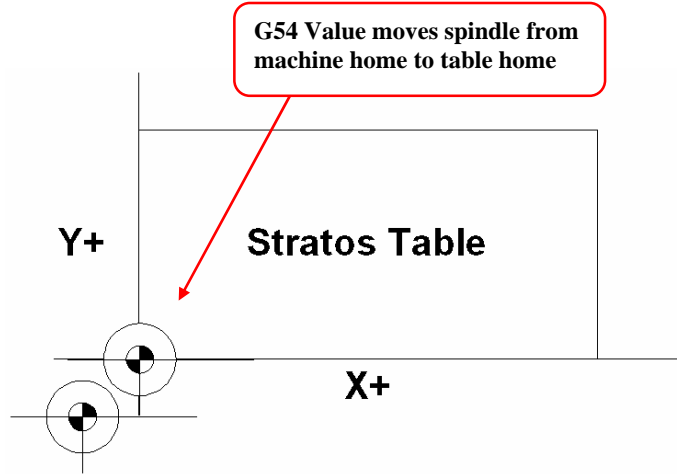


Figure 1 5 x 5 Drill Block – Work Offsets set position for primary spindle and Drill Block.

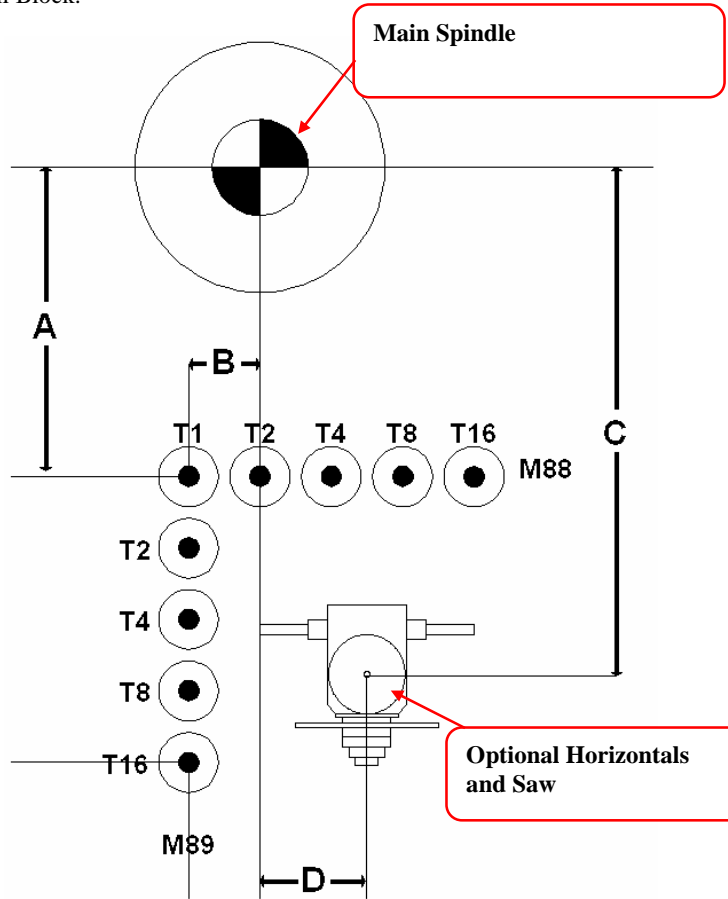


Figure 2 (see Table Below) Work Offsets must be put in Table to swap primary position of the axis. Your Multidrill postprocessor will select the M code and T codes, however you can test drill block by going to MDI mode and dropping selected drill. Example M88T1 drops corner drill.

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	
D	X offset position to Horizontal Drills	

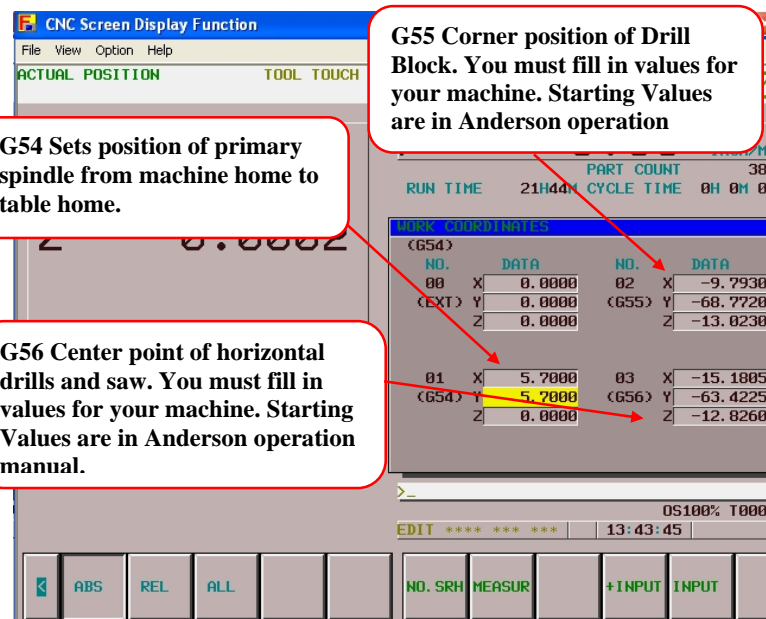


Figure 3 Click on OFST. Click on Work. Cursor to position. You must fill in Values for your machine. Starting