

Offsets-Work Drill Block Stratos PRO

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.

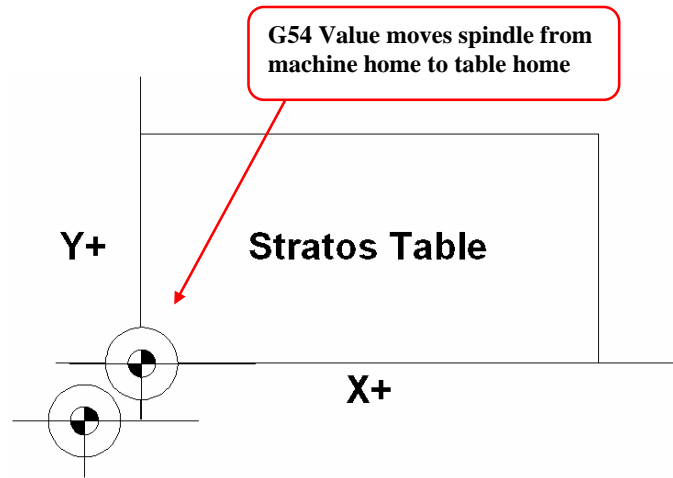


Figure 1 5 x 5 Drill Block – Work Offsets set position for primary spindle and Drill Block.

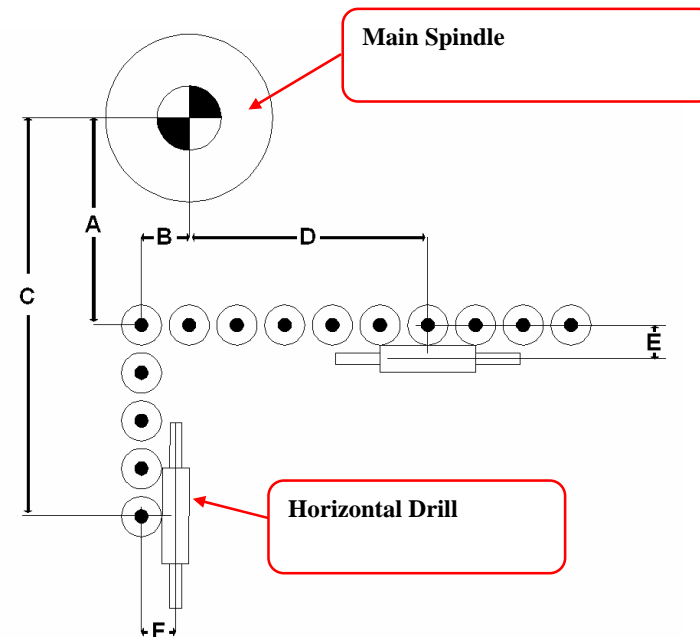


Figure 2 (see Table Below) Work Offsets must be put in Table to swap primary position of the axis. Your Multidrill postprocessor will select the M code and T codes, however you can test drill block by going to MDI mode and dropping selected drill. Example M88T1 drops corner drill.

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 Drill	
D	X offset position to Horizontal Drill	
E	Y offset position to Horizontal Drill	
F	X offset position to Horizontal Drill	

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

G56 & G57 Center point of horizontal drills. You must fill in values for your machine. Starting Values are in Anderson operation manual.

G54		G55		G56		G57	
NO.	DATA	NO.	DATA	NO.	DATA	NO.	DATA
00	X 0.0000	02	X -9.7930	01	X 5.2000	03	X -15.1805
(EXT)	Y 0.0000	(G55)	Y -68.7720	(G54)	Y 5.2000	(G56)	Y -63.4225
	Z 0.0000		Z -13.0230		Z 0.0000		Z -12.0260

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