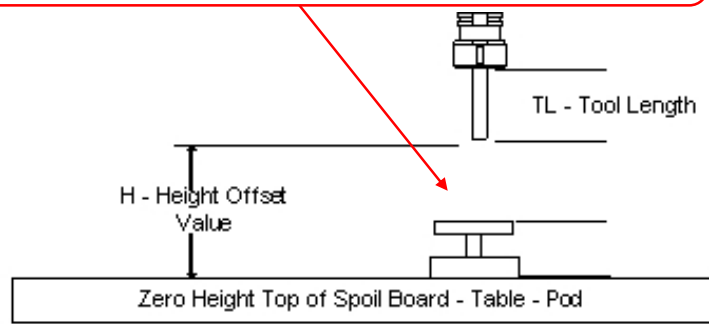


# Tool Touch Off Macro

**When to use :** There are 2 programs to automatically touch off tool tip to the Z zero point.

Tool Touch off Button enters Height Offset value in table. Set ZO Point by measuring Tool Length and Spoil board thickness.



## 501 Macro Program

Enter 501 click Number Search to find Macro

X & Y Button Position

Material Thickness

Adjust Button Height

Tool Number 101 Offset Number 11

Bit Length

Next Tool - Tool Number 102 Offset Number 12

NO.	NAME	DATA
500	X POINT	-0033.0305
501	Y POINT	-0060.6525
502	M-THICK.	0000.7610
503	SENSOR ADJ	0000.0029
504	01TOOL. OFF	0101.0110
505	01T-LENGTH	0001.5000
506	02TOOL. OFF	0102.0120
507	02T-LENGTH	0001.0000

**Figure 1** 501 Macro requires that you find the 500 Touch off Macro Program. Fill in the location for the touch off button, any minor height adjustments for the button, Tool and offset number that you want the value and where this value should be placed, and finally all the tools that you want to touch off.

00005 N00005

NO.	DATA	NO.	DATA
001	0.0000	017	-11.7739
002	0.0000	018	-11.8854
003	0.0000	019	-12.6401
004	0.0000	020	-9.0177
005	0.0000	021	0.0000
006	0.0000	022	0.0000
007	0.0000	023	0.0000
008	-1.3750	024	0.0000
009	0.0000	025	0.0000
010	0.0000	026	0.0000
011	-11.9907	027	0.0000
012	-12.803		
013	-12.984		
014	-12.314		
015	0.000		
016	-12.747		

ACTUAL POSITION (RELATIVE)

X 31.0431

Y 61.9115

Z -0.1290

Automatically Enter in Offset Table.

H(value)= Distance from Tool tip to Spoil Board. Value matches corresponding tool number.