

# **HOW TO SET TOOL LENGTH OFFSETS WITH AN AUTOMATIC TOOL PRESETTER**

## **INSTRUCTIONS:**

- 1. PRESS THE INPUT KEY**
- 2. SELECT THE TOOL REVIEW SOFTKEY**
- 3. PRESS THE TOOL SETUP SOFTKEY**
- 4. IF YOUR TOOLS ARE PRE-DEFINED ALREADY, CLICK ON THE GEOMETRY  
OFFSET SOFTKEY**
- 5. SELECT THE TOOL SETTER KEY**
- 6. BEFORE YOU GO ANY FURTHER, MAKE SURE YOU HAVE ENOUGH ROOM  
FOR THE TOOL SETTER TO SWING INTO POSITION.**
- 7. PRESS THE ADVANCE TOOL SETTER SOFTKEY**
- 8. PRESS THE START CYCLE BUTTON**
- 9. YOU WILL THEN NEED TO GRAB YOUR HANDWHEEL AND SELECT AN  
INCREMENT OF FEED TO ACTIVATE IT.**

**10. JOG YOUR TOOL TO THE CENTER OF THE STYLUS AND HAVE IT SET APPROXIMATELY 6MM OR ABOUT A ¼ OF AN INCH AWAY.**

**NOTE: YOU WILL NOW SELECT THE AXIS DIRECTION YOU WANT TO TOUCH OFF, YOU WILL HAVE FOUR OPTIONS TO CHOOSE FROM:**

- X IN THE NEGATIVE DIRECTION**
- X IN THE POSITIVE DIRECTION**
- Z IN THE NEGATIVE DIRECTION**
- Z IN THE POSITIVE DIRECTION**

**IN THIS EXAMPLE, WE ARE GOING TO TOUCH OFF OUR TOOL IN THE Z-AXIS FIRST. IF YOU RECALL, WE JOGGED OUR TOOL DOWN TO THE CENTER OF THE PART ALONG THE RIGHT SIDE OF THE TOOL SETTER. WE WANT TO MOVE LEFT IN THE NEGATIVE DIRECTION TO TOUCH OFF THE TOOL.**

**11. SELECT THE BEGIN TOUCH Z (-) SOFTKEY.**

**12. THEN SELECT THE START CYCLE BUTTON**

**ONCE THE TOOL SETTER HAS COMPLETED THE CYCLE, YOUR NEW Z-AXIS OFFSET WILL BE STORED FOR THAT TOOL.**

**WE HAVE FINISHED SETTING UP THE TOOL IN THE Z-AXIS, LET'S SET UP THE X-AXIS.**

**WE WANT OUR TOOL TO MOVE DOWN IN THE NEGATIVE DIRECTION ALONG THE X-AXIS. GRAB YOUR HANDWHEEL AND SELECT AN INCREMENT OF FEED TO ACTIVATE IT. YOU'LL NEED TO JOG YOUR TOOL TO THE CENTER OF THE STYLUS AND SET IT APPROXIMATELY 6MM OR A ¼ OF AN INCH AWAY FROM THE STYLUS ALONG THE X-AXIS.**

**13. ONCE YOU ARE IN POSITION, PRESS THE BEGIN TOUCH X (-) SOFTKEY**

**14. PRESS THE START CYCLE BUTTON**

**AFTER THE CYCLE IS COMPLETED, THE NEW X-AXIS OFFSET FOR THAT TOOL WILL BE STORED. YOU WILL NEED TO REPEAT THESE STEPS AGAIN FOR EACH NEW TOOL THAT YOU WANT TO TOUCH OFF.**

**15. ONCE YOU HAVE TOUCHED OFF ALL YOUR TOOLS, YOU'LL NEED TO GRAB YOUR HANDWHEEL AND SELECT AN INCREMENT OF FEED TO ACTIVATE IT.**

**16. JOG THE TURRET AWAY FROM THE TOOL SETTER, WE NEED TO DO THIS SO IT HAS ENOUGH ROOM TO MOVE FREELY AS WE STORE IT AWAY.**

**17. PRESS THE RETRACT TOOL SETTER SOFTKEY**

**18. PRESS THE START CYCLE SOFTKEY, THE TOOL PRESETTER WILL MOVE BACK INTO ITS STORED LOCATION.**

**PLEASE NOTE THAT IF YOU ACCIDENTALLY SELECT THE WRONG AXIS SOFTKEY, YOU WILL NEED TO PRESS THE STOP CYCLE BUTTON, REPOSITION YOUR TOOL, AND SELECT THE APPROPRIATE BEGIN TOUCH SOFTKEY.**

**A COMMON MISTAKE WE SEE IS WHEN AN OPERATOR LEAVES TOO MUCH DISTANCE BETWEEN THE TOOL AND THE STYLUS AFTER IT IS JOGGED INTO POSITION. YOU WILL GET A POP UP THAT SAYS “ERROR – PROBE DID NOT TRIGGER”. TO RESOLVE THE ISSUE, JOG YOUR TOOL CLOSER TO THE STYLUS AND THEN SELECT THE APPROPRIATE BEGIN TOUCH SOFTKEY.**