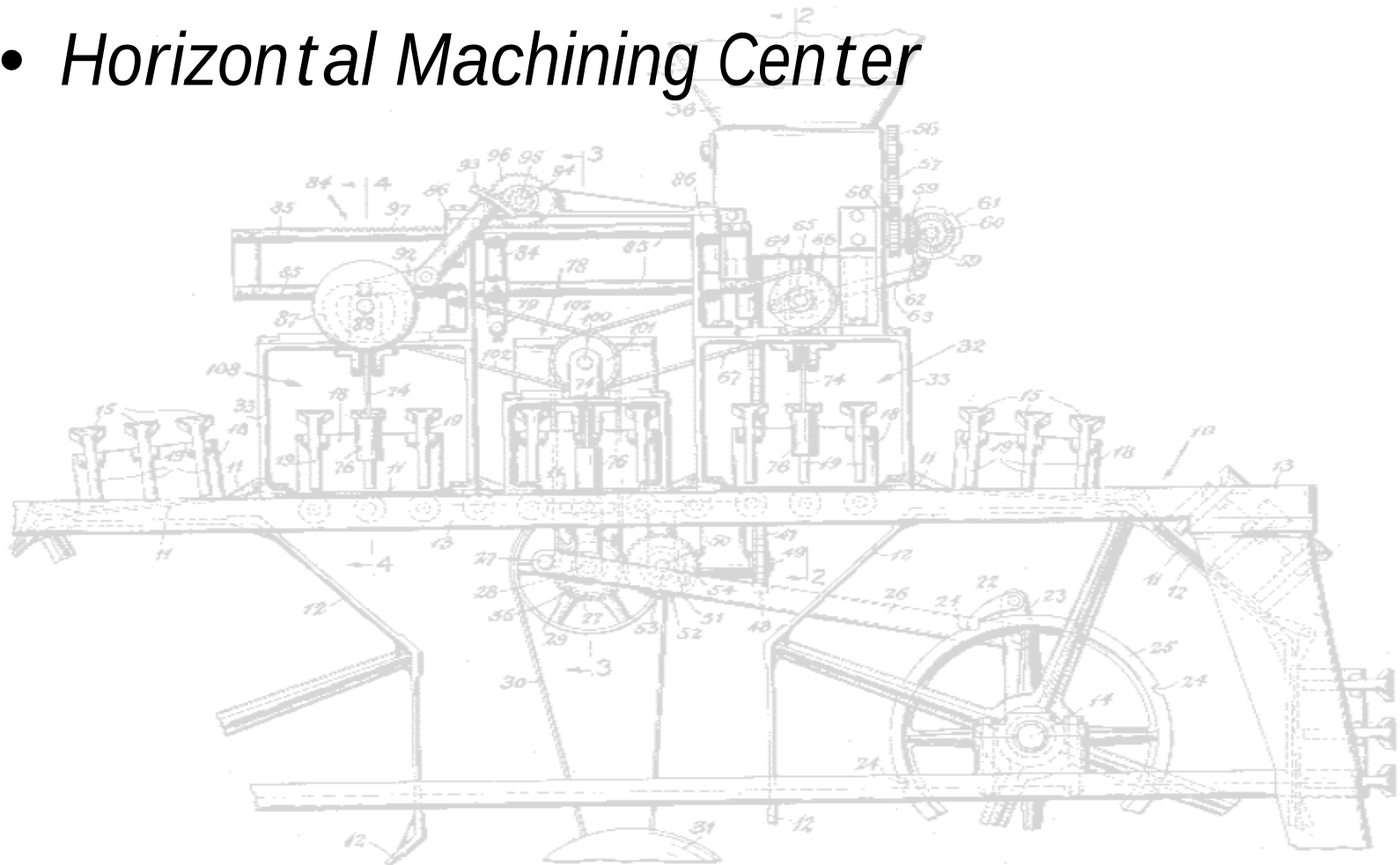


MILLING

- *Vertical Mill*
- *Horizontal Mill*
- *Horizontal Machining Center*



MILLING - HORIZONTAL MACH CENTER



E955

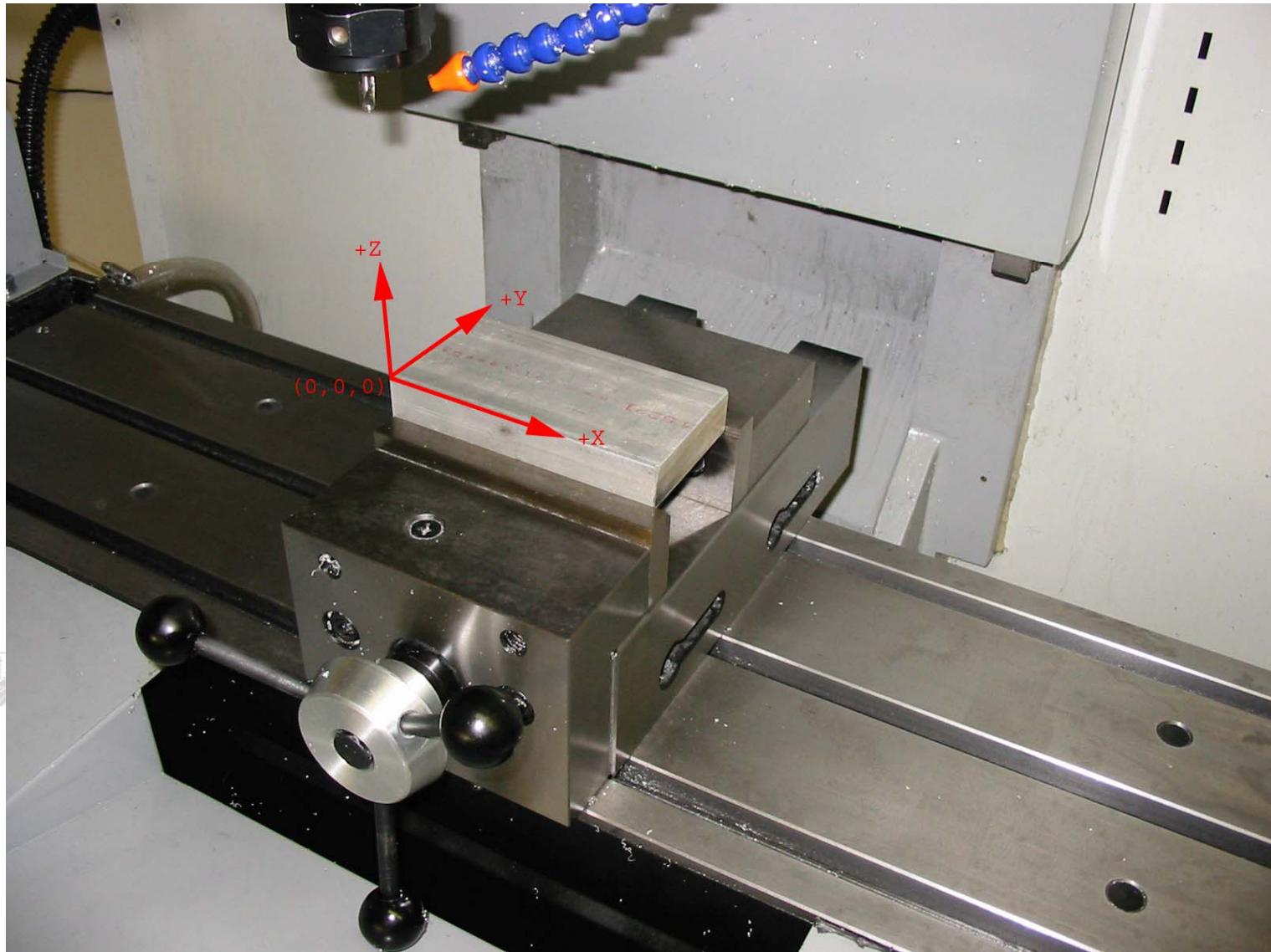
MILLING - 5 AXIS MACHINING CENTER



VERTICAL MILLING

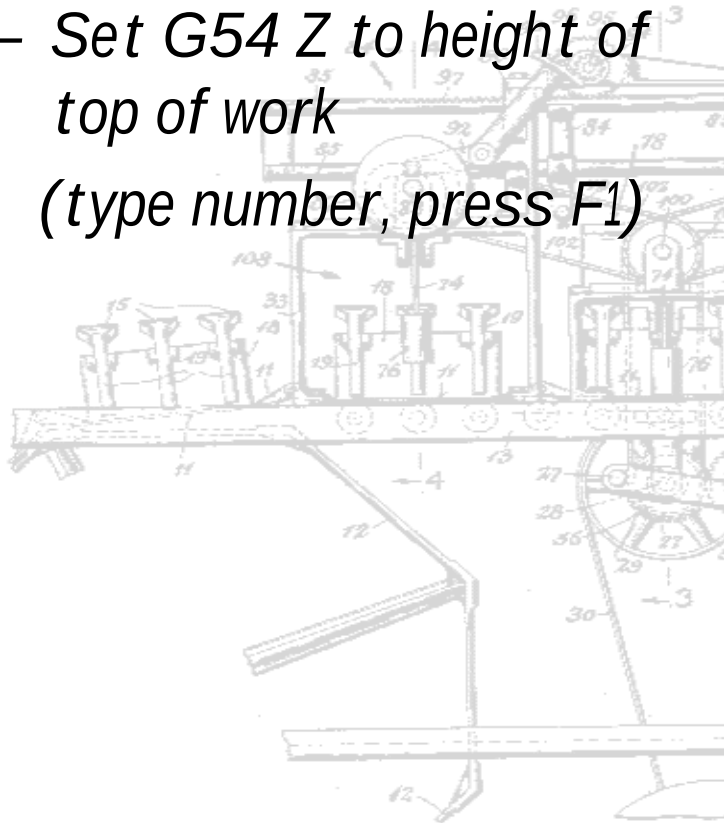


COORDINATE SYSTEM

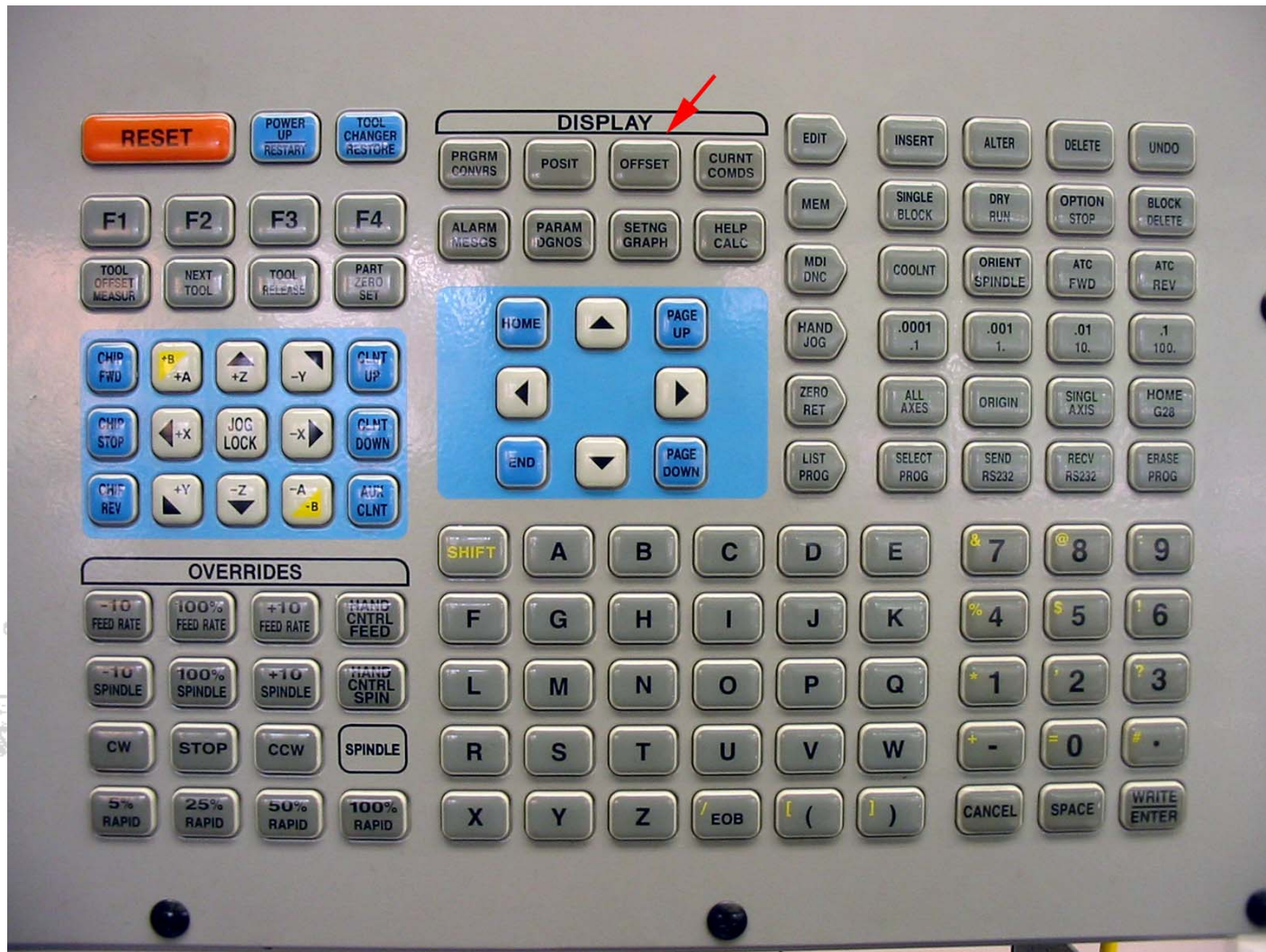


WORK OFFSET

- *Work Offsets*
 - G54 - G59
 - G54 X & Y aligned with vise left front
 - Set G54 Z to height of top of work
(type number, press F1)



OFFSETS



SETTING WORK OFFSET

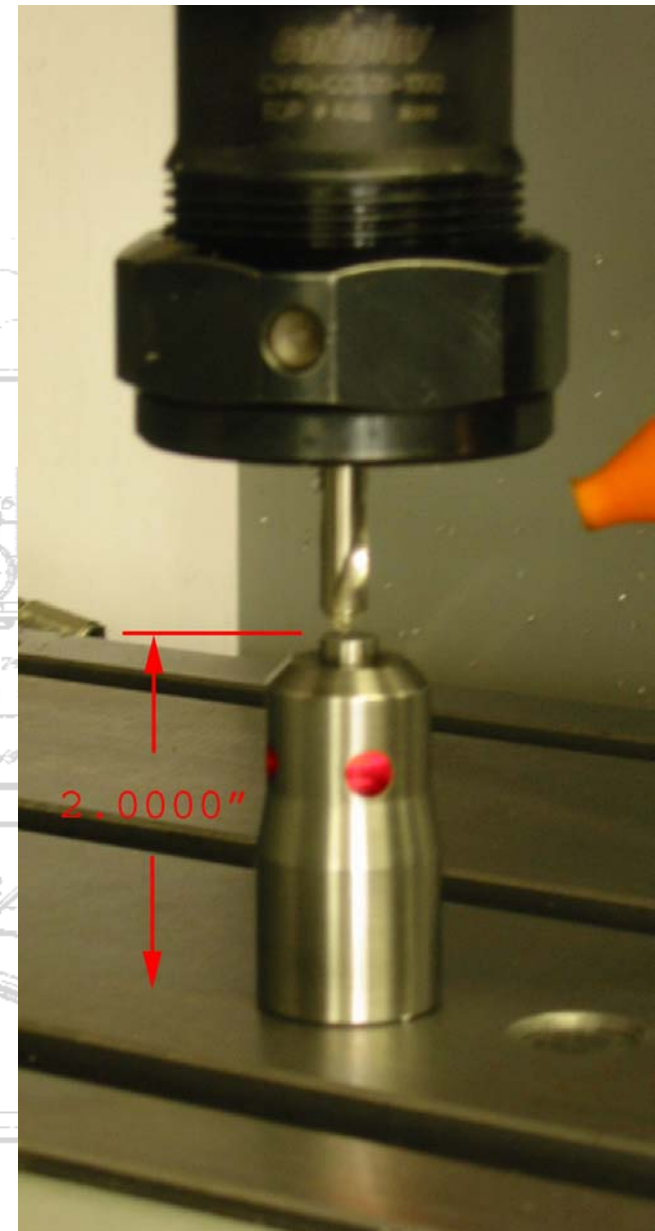
WORK ZERO OFFSET				
G CODE	X	Y	Z	
G 52	0.	0.	0.	
G 54	-18.4871	-8.1975	6.4515	
G 55	-18.8788	-8.5888	0.	
G 56	-22.6688	-6.8888	0.	
G 57	-16.3988	-2.6288	6.8888	
G 58	-12.4185	-8.8782	5.8248	
G 59	-18.4871	-8.8782	5.2285	
G154 P1	0.	0.	0.	(G110)
G154 P2	0.	0.	0.	(G111)
G154 P3	0.	0.	0.	(G112)
G154 P4	0.	0.	0.	(G113)
G154 P5	0.	0.	0.	(G114)
G154 P6	0.	0.	0.	(G115)
G154 P7	0.	0.	0.	(G116)
G154 P8	0.	0.	0.	(G117)
G154 P9	0.	0.	0.	(G118)
G154 P10	0.	0.	0.	(G119)
G154 P11	0.	0.	0.	(G120)
G154 P12	0.	0.	0.	(G121)
G154 P13	0.	0.	0.	(G122)
G154 P14	0.	0.	0.	(G123)
G154 P15	0.	0.	0.	(G124)
G154 P16	0.	0.	0.	(G125)
G154 P17	0.	0.	0.	(G126)
Z POSITION : -5.8343 WRITE ADD/F1 SET/OFFSET TOGGLE				
RAPID 58%				
JOGGING Y AXIS HANDLE .0001				
-0.0675				

TOOL OFFSETS

- *Tool Offset*
 - *Select tool #*
 - *Jog until touchoff*
 - *Press Tool Offset Meas*
 - *Subtract 2" (-2.0 Enter)*

TOOL	POSITION	GEOMETRY	WEAR	GEOMETRY	WEAR	FLUTES
1		-16.1442	0.	0.1250	0.	2
2		-16.7966	0.	0.1250	0.	2
3		-16.7883	0.	0.1250	0.	2
4		-12.2747	0.	0.1000	0.	2
5		-13.9795	0.	0.3750	0.	4
6		-16.2011	0.	0.2500	0.	2
7		-14.4871	0.	0.3125	0.	2
8		-14.4289	0.	0.1250	0.	2
9		-16.9389	0.	0.0625	0.	2
10		-17.0816	0.	0.0625	0.	2
11		0.	0.	0.	0.	2
12		0.	0.	0.	0.	2
13		0.	0.	0.	0.	2
14		0.	0.	0.	0.	2
15		0.	0.	0.	0.	2
16		0.	0.	0.	0.	2
17		0.	0.	0.	0.	2
18		0.	0.	0.	0.	2
19		0.	0.	0.	0.	2
20		0.	0.	0.	0.	2

Z POSITION : -14.1442 WRITE ADD/F1 SET/OFFSET TOGGLE



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