



Tool offset:

Press MODE and the currently selected tool offset is displayed on the keyboard display.

To program tool offsets select tool 0. Mark the workpiece with the first tool and reset the X and the Y axis to zero. All offsets are then calculated from this tool.



Tool offset programming:

Press MODE then P on the keyboard. The light above the P key will light up. Enter the tool offset number to be programmed on the keyboard (1-9). Press E to enter. The axis indicator lights come on. Move the X axis until the tool marks the workpiece and press the X key. The axis indicator will go off and the tool offset value for X is stored. Repeat the step for the Y axis. The axis indicator for the Y axis goes off as well as the light above the P key. The tool offset programming for the selected tool is complete.



Tool offset recall:

To recall previously programmed tool offsets press MODE then R. The light above the R key lights up. Enter the required tool offset number (1-9) on the keyboard and press E to enter. The tool offset is loaded into the axis counters. The light above the R key goes off. If a tool offset is selected that has not been programmed Error 01 is displayed. To cancel press C.

Tool offset editing:



To edit the programmed tool offset value press P then enter the number 800. Press E to enter. The keyboard display will show tool 01. Press E until the tool to be edited is displayed. Press the axis key of the value to be edited. Enter the new value on the keyboard and press E to enter. Repeat for any other value to be edited. Then press the E key until the light above the P key goes off.