# TOOL SETTING PROCEDURE

The following procedure should be adhered to :-

- Datum the machine

- Any offsets already in the file can be overwritten.

- Select tool in MDI,(JOG mode).

- Press T, then tool number required, then EOB. The correct tool will now be selected.

- Start the Spindle - Press S, then a spindle speed, then press EOB.

- Press SPINDLE CW.

- Using AXIS JOG keys, touch on the end of the bar.

- Press the MENU\OFFSET Key.

- Press MZ 0 EOB Z now reads zero.

- Press RESET or CANCEL Key.

- Turn an outside diameter and move away in the Z Axis only.

- Stop the Spindle and measure the outside diameter just turned.

- Press MENU OFFSET Key.

- Press MX and input the measured diameter.

- Press RESET or CANCEL Key.

- Return machine to " home " position.

- Repeat the above procedure for the remaining tools.

- To save the OFFSETS press F9,which brings up the offset menu,then select SAVE OFFSETS.