

TOOL SETUP

Should a user want to use the generic lathe tool screen / page, it is provided with the addition of tip direction / position per the Mach3 Turn Manual. Tool input and information is similar / same as the generic lathe screen, but, numerous buttons have been added to manipulate the tool table information.

Tool probing is provided to automatically find X lathe center and Z end based on a four surface tool setter. The user defines the setter basic dimensions and probes the appropriate surface. Tool offset adjustment is provided for tools such as a drill, reamer, or tool with a user defined tip radius.

Thus one can populate a tool table, alter a tool, find X=0, touch off to a part, reset the DRO's and create a home position or tool change position using keyboard, mouse or MPG.

File Config Function Cfg's View Wizards Operator Plugin Control Help

DIA MODE ☒ IMP ☒ MM

X ZERO

Z ZERO

Program Machine Part

Zero World X Zero World Z S Limits On/Off

Home X Home Z Home ALL

Set Home X Set Home Z DE-REF ALL AXES

JOG ON

Jog Mode Cont. Step MPG

MPG Axis X Z Jogging Mode

1 ☒ Vel Only ☒ Single

2 ☒ Step / Vel ☒ Multi

Cycle Step

FRO 100%FRO

Feed Rate +

Slow Jog % +

TOOL DESC Empty Lathe -> G15 G80 G18 G40 G20 G90 G94 G54 G49 G99 G61

Tool No Tip Dir TIP HELP Tip Radius Turret Deg.

X OFFSET Z OFFSET

Front ☒ Rear ☒ X WEAR Z WEAR

TOUCH X TOUCH Z

TOOL TABLE (TT)

OPEN TT SAVE TT EXPORT TT IMPORT TT RESET TT QC Tool Table BUTTON HELP

Z1 CLEAR

SETTER DIA.

SLOW PROBE DIS

SETTER WIDTH

X1 CLEAR

X2

Z2

Probe Feeder

PROBE ACTIVE PROBE HELP

Tool No BEST TOOL

Probe X2

Probe Z2

Probe X1

Probe Z1

MODIFY CURRENT TOOL OFFSETS

TOOL SETTER / PART PROBING

OFFSET ADJUSTMENT VALUE X Z

TOOL CHANGE LOCATION (ABS X Z

SET TC LOCATION RESERVED RESERVED

MDI

RESET MAIN SCREEN DIAG. SCREEN

Emergency STOP

Auto Tool Adjust Tool Adjust

OPTIONAL PROBING

VMR LATHE TOOL SETUP SCREEN CLEAR