



INI File Parameters.

Spindle Height = 12.718"
Tool Setter = 3.663"

Tool Table

T03 2.747" 5/16" End Mill
T99 4.784" Versa Probe

REVISIONS

ZONE	REV	DESCRIPTION	DATE	APPROVED
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Determine Tool Length

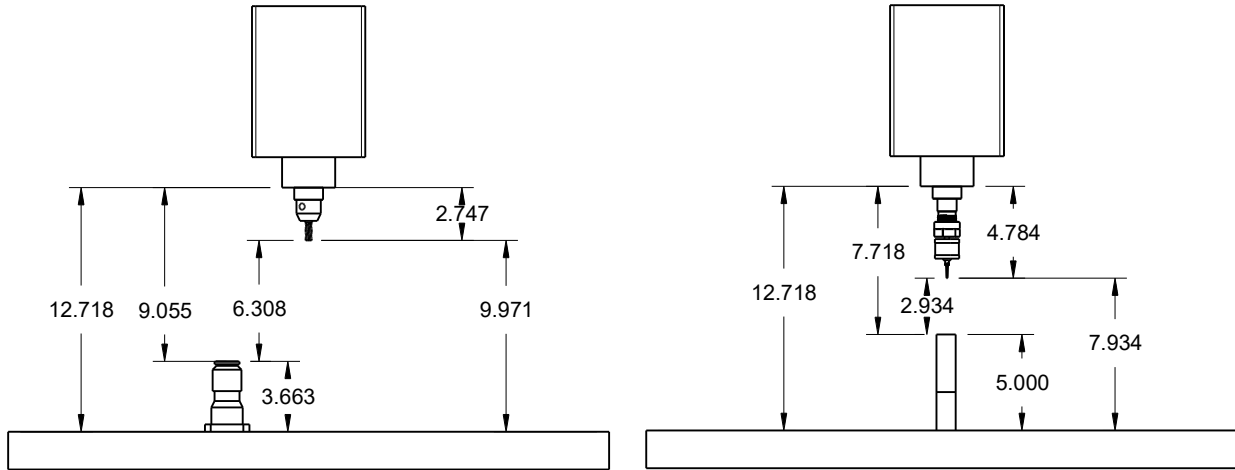
Probe top of tool setter with
G49
G91
G38.3 Z-3 F2.5

#<touch_result> = #5063
#<SetterHeight> = #<_hal[probe.SetterHeight]>
#<SpindleHeight> = #<_hal[probe.SpindleHeight]>

G10 L1 P#<tool> Z[#<SpindleHeight> + #<touch_result>] - #<SetterHeight>
G43
G90

Probe Workpiece

Workpiece block on table is 5.000" high.
Table to quill registration surface is -12.718"
T99 Probe is 4.784" long
Table moves towards quill -2.934" to trigger probe.
Touch Off G54.Z] is set to -7.718" so workspace Z=0.000
Now issuing T03 M06 G43 results in a tool change
Move to Z=0.000 now has T03 even with the top of the 5" block.



DRAWN	DATE	P:\Milling Machine\Drawings\Mockup\MillMockup.AD_DRW		
	08JAN2023			
	CHECKED			
QA				
MFG	SIZE	FSCM NO.	DWG NO.	REV
APPROVED	A			
	SCALE	1:10	SHEET	1 OF 1

