

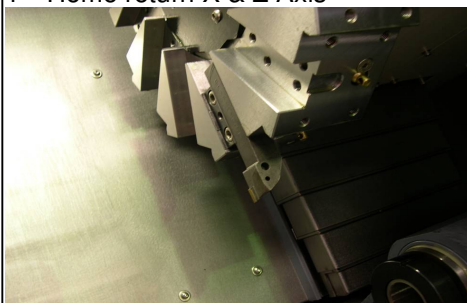
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Renishaw tool setting by manual

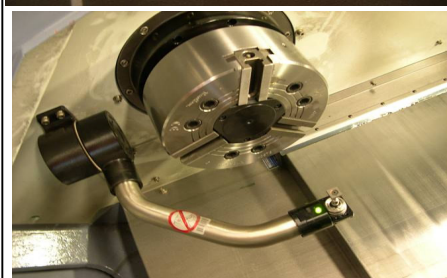
1. Home return X & Z Axis



2. Choose tool no. to be calibrated

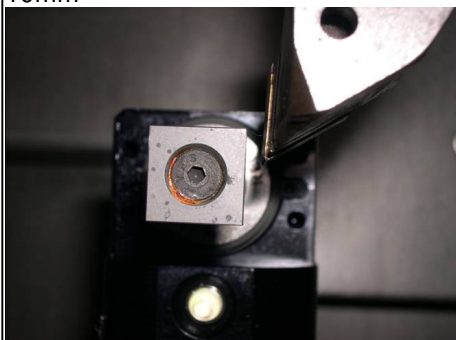
3. Push tool setter key

4. Tool setter arm down



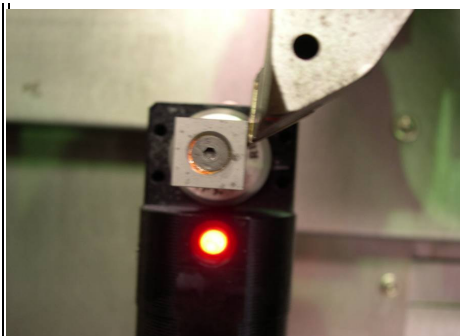
5. Calibrate Z Axis

5.1 MPG Mode move Z Axis till close to tool setter head about 10mm



5.2 Change to jog mode move Z Axis and touch tool setter head, tool setter led red light lit, it will stop automatically.

OVERHAUL  
OF  
PROCESS



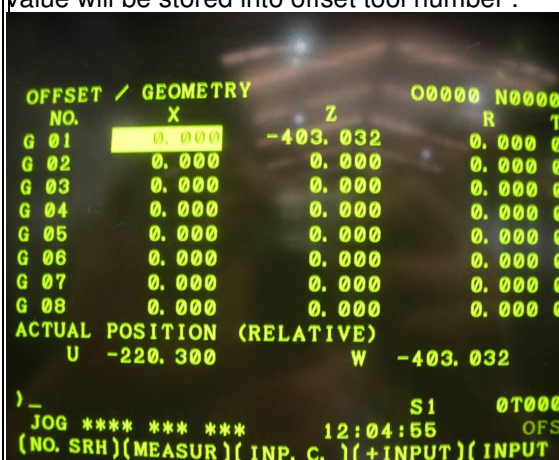
6. When the value goes?

6.1 In offset page (under geometry).

Generally the tool number we use, the offset number just the same

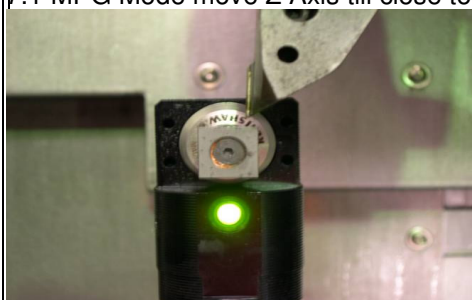
Ex.: For tool no. 10, its offset no. was in number 10

※ put cursor at OFFSET tool number, after finish calibration, its value will be stored into offset tool number.



7. Calibrate X Axis

7.1 MPG Mode move Z Axis till close to setter head about 10mm



7.2 Change to jog mode move Z Axis and touch tool setter head, tool setter led red light lit, it automatically stop.



8. APPLICATION:

8.1 use MDI mode select a standard tool.

Ex:T0101(tool no.1, tool no 1 offset) °

8.2 Use MPG mode move to work piece to machine and find work piece coordinate

8.3 Measure and find out work piece diameter measurement.

8.4 input OFFSET W.SHFT of X axis position of work piece dimension.

8.5 At work piece end face middle set Z axis as original coordinate, under OFFSET W.SHFT set Z as 0

8.6At this moment W.SHFT coordinate finished, the other tool will be machined by this standard coordinate

