

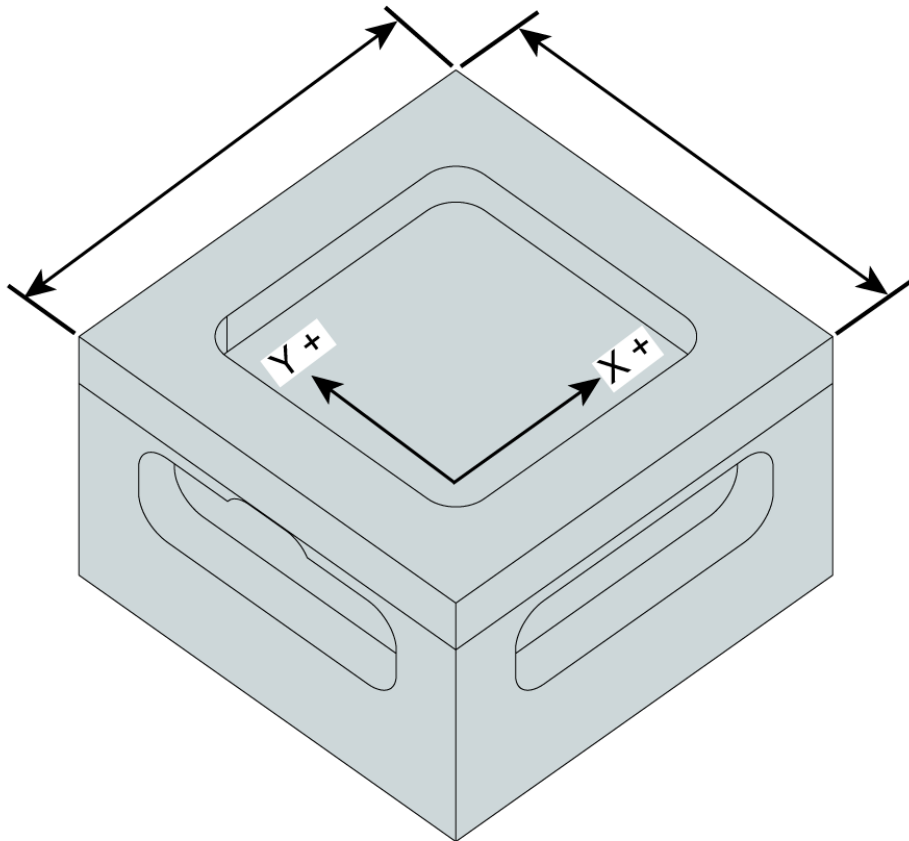
HDC-3-5AX - MRZP - Test Cut Kit - AD0830

HDC-3-5AX - MRZP Test Cut - X/Y Squareness

Measure the outside square cut with the side of the End Mill.

This should measure 3.95" +/- .001" (99.0mm +/- .025mm) along the X and Y axis.

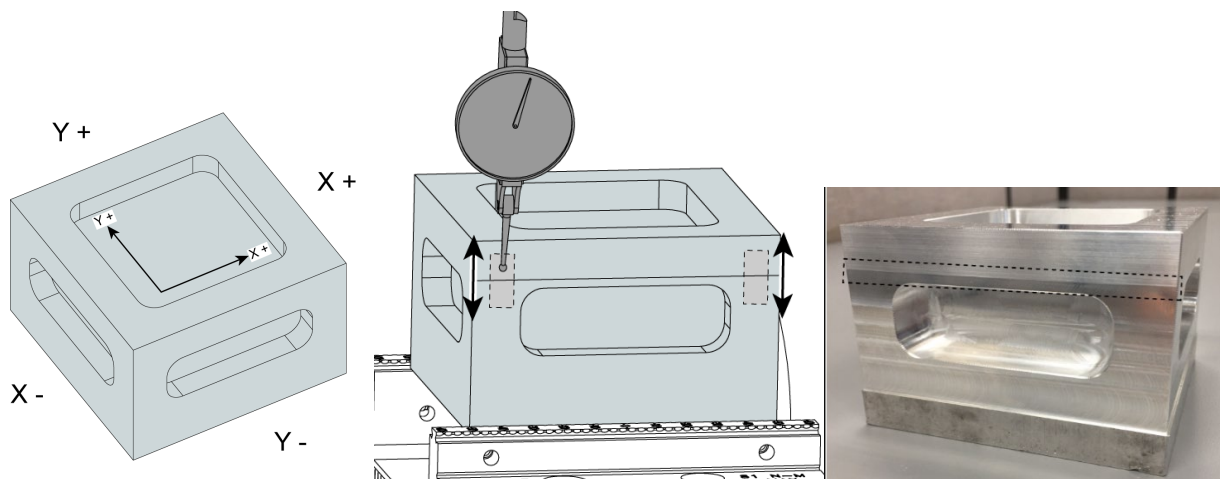
	Distance
X Direction	
Y Direction	



HDC-3-5AX - MRZP Test Cut - MRZP Settings 300 & 301 Adjustment

With the part in the vise, use an indicator to measure the step between the two tool paths. Measure the step on either side of the pocket. Measure these two locations on all four sides of the part and use the Y+ and X+ arrows to record the measurements below. If there is a step out from the top surface to the bottom surface, record a positive value. If there is a step in from the top surface to the bottom surface, record a negative value.

	Left Side Distance	Right Side Distance
X+		
X-		
Y+		
Y-		



HDC-3-5AX - MRZP Test Cut - MRZP Setting 303 Adjustment

With a micrometer, measure the distance between the top face and pocket. Record the measured values for the two sides of the part. This distance should be as close as possible to 0.500" (12.0mm).

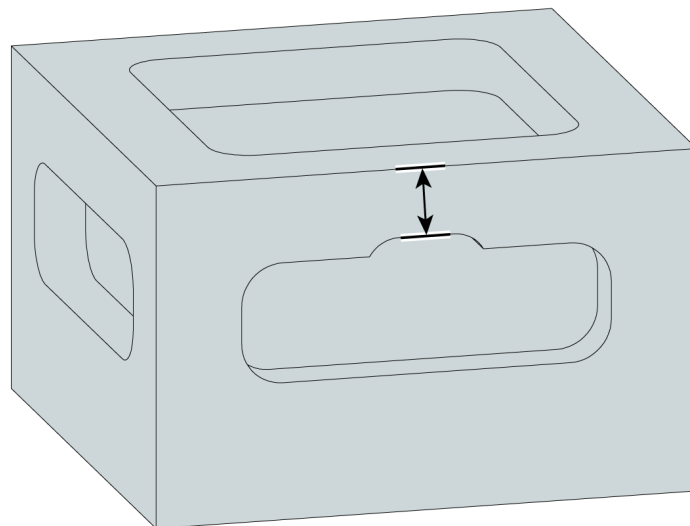
Adjust Setting 303 MRZP X AXIS SLAVE.

- If X+ side is larger than the X- side, adjust these settings by the half the difference of the two measurements in the negative direction.
- If X- side is larger than the X+ side, adjust these settings by the half the difference of the two measurements in the positive direction.

Adjust this setting until the X+ and X- sides measure as close as possible. They do not need to be 0.500" (12.0mm). The next adjustment will change the measurement of both sides.

Note: Adjusting setting 303 will also change the depth of these two cutouts.

	Distance
X+	
X-	



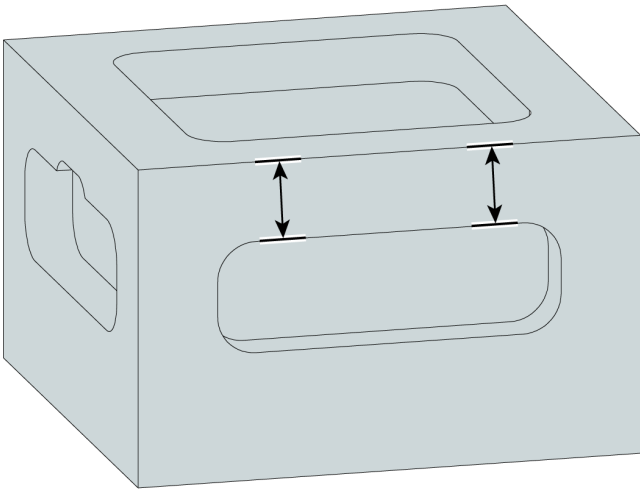
HDC-3-5AX - MRZP Test Cut - MRZP Setting 305 Adjustment

With a micrometer, measure the distance between the top face and pocket. Measure in two locations, the left and right side of the pocket. Record the measured values for all four sides of the part. This distance should be as close as possible to 0.625" (15.0mm). If all four sides have the same error, adjust setting 305 MRZP Z AXIS SLAVE until all four sides are as close as possible to 0.625" (15.0mm).

- If all four sides are too large, adjust the settings of the measured error in the negative direction.
- If all four sides are too small, adjust the settings of the measured error in the positive direction.

This adjustment will also change the measurement in step # 2 and step # 3

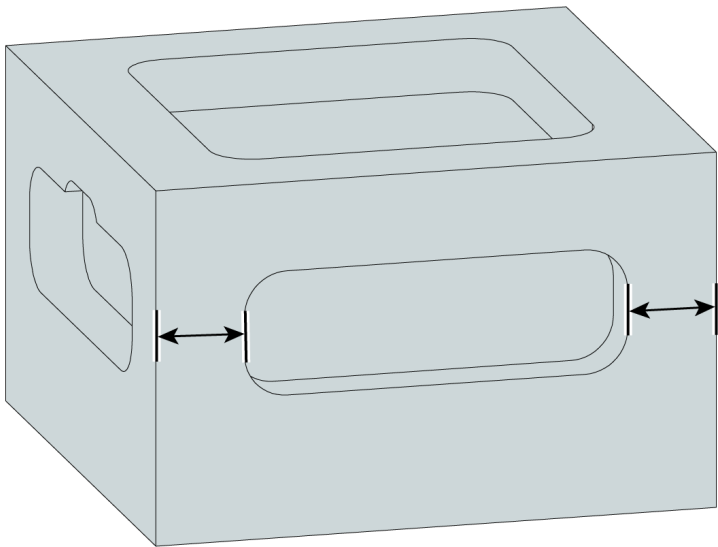
	Left Side Distance	Right Side Distance
X+		
X-		
Y+		
Y-		



HDC-3-5AX - MRZP Test Cut - B/C Geometry

With a micrometer, measure the distance between the side face and pocket. Measure in two locations, the left and right side of the pocket. Record the measured values for all four sides of the part. This distance should as close as possible to 0.625” (15.0mm). These values should be correct if the values in MRZP Settings 300 & 301 Adjustment are set correctly.

	Left Side Distance	Right Side Distance
X+		
X-		
Y+		
Y-		



MRZP Settings Values

	Value
Setting 300	
Setting 301	
Setting 303	
Setting 305	

Settings

Settings

Network

Rotary

User Positions

Alias Codes

Group
View details
ALTER
Search
F1
Machine Setup

	Name		Value	Unit
300	MRZP X Offset Master		0.0000	IN
301	MRZP Y Offset Master		0.0000	IN
302	MRZP Z Offset Master		0.0000	IN
303	MRZP X Offset Slave		0.0000	IN
304	MRZP Y Offset Slave		0.0000	IN
305	MRZP Z Offset Slave		8.5000	IN
372	Parts Loader Type	>	None	
375	APL Gripper Type	>	None	
376	Light Curtain Enable	>	Off	
378	Safe Zone Calibrated Geometry Reference Point X		-13.5138	IN
379	Safe Zone Calibrated Geometry Reference Point Y		18.4048	IN
380	Safe Zone Calibrated Geometry Reference Point Z		0.0000	IN
408	Exclude Tool From Safe Zone	>	Off	

ORIGIN
Restore default settings menu.

300 - MRZP X Offset Master

This setting defines the distance, in inches or mm, between the master rotary axis center and the X-Axis machine zero position. This is similar to Setting 255, except

HELP
View full text.