

(T) Var.

G65 P9995 Tool Probe Macro Call

Ex: G65 P9995 A0.0 B3.0 C3.0 T1.0 E4.0 D3.0 K0.2

(E) Var.

(K) Var.

(C) Var.

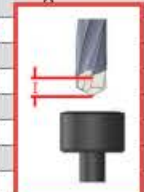
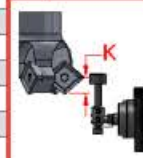
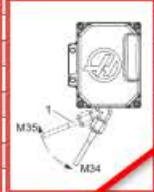
(B) Var.

(D) Var.

(I) Var.

Offsets											Offsets					Offsets				
Tool Offset	Length Geometry	H(Length) Wear	Diameter Geometry	Diameter Wear	Coolant Position	Flutes	Actual Diameter	Tool Type	Tool Material	Tool Pocket	Category	Approximate Length	Approximate Diameter	Edge Measure Height	Tool Tolerance	Probe Type				
1	5.0000	0.	0.	0.	2	2	0.	Shell Mill	Carbide	4	*	4.0000	0.2000	0.	0.	3-Len & Dia				
2 Spindle	0.	0.	0.	0.	2	2	0.	End Mill	User	Spindle		4.0000	0.5000	0.1000	0.	1-L Rotatng				
3	0.	0.	0.	0.	2	2	0.	None	User	1		0.	0.	0.	0.	None				
4	0.	0.	0.	0.	2	2	0.	End Mill	User	6		4.0000	0.2500	0.	0.	1-L Rotatng				
5	0.	0.	0.	0.	2	2	0.	None	User	3		0.	0.	0.	0.	None				
6	0.	0.	0.	0.	2	2	0.	None	User	2		0.	0.	0.	0.	None				
7	0.	0.	0.	0.	2	2	0.	None	User	7		0.	0.	0.	0.	None				
8	0.	0.	0.	0.	2	2	0.	None	User	8		0.	0.	0.	0.	None				
9	0.	0.	0.	0.	2	2	0.	None	User	9		0.	0.	0.	0.	None				
10	0.	0.	0.	0.	2	2	0.	None	User	10		0.	0.	0.	0.	None				
11	0.	0.	0.	0.	11	2	0.	None	User	11		0.	0.	0.	0.	None				
12	0.	0.	0.	0.	12	2	0.	None	User	12		0.	0.	0.	0.	None				
13	0.	0.	0.	0.	13	2	0.	None	User	13		0.	0.	0.	0.	None				
14	0.	0.	0.	0.	14	2	0.	None	User	14		0.	0.	0.	0.	None				
15	0.	0.	0.	0.	15	2	0.	None	User	15		0.	0.	0.	0.	None				
16	0.	0.	0.	0.	16	2	0.	None	User	16		0.	0.	0.	0.	None				
17	0.	0.	0.	0.	17	2	0.	None	User	17		0.	0.	0.	0.	None				
18	0.	0.	0.	0.	18	2	0.	None	User	18		0.	0.	0.	0.	None				

Set by Probe



Enter A Value

TOOL OFFSET MEAS

Tool Offset Measure F1 Set Value ENTER Add To Val

Spindle

Main Spindle

STOP

Spindle Speed: 0 RPM

Spindle Load: 0.0 KW

Surface Speed: 0 FPM

Chip Load: 0.00000

Feed Rate: 0.0000

Active Feed: 0.0000

Overrides

Feed: 100%

Spindle: 100%

Rapid: 100%

Spindle Load(%) 0%

Setup Power Save

Tool Types

Drill Tap Shell Mill End Mill Spot Drill Ball Nose Probe

1 2 3 4 5 6 7

Tool Measure

0 1 2

Active Tool 2 Next Pocket 4

Pocket	Category	Tool
Spindle		2
1		3
2		6
3		5
4*		1
5		40
6		4
7		7
8		8
9		9
10		10
11		11
12		12
13		13
14		14
15		15

Set pocket as large [L]

Set pocket as heavy [H]

Set pocket as N [N]

Clear category [SPACE]

Set tool [###] + [ENTER]

Clear tool [0] + [ENTER]

Reset table [ORIGIN]

Automatic Probe Options

1: * Probe selected tool.

2: * Probe selected tool manually.

3: * Probe selected tool for breakage/wear.

4: * Probe all tools.

TOOL OFFSET MEAS

Exit [CANCEL]

Selected The Type Of Probing To Be Performed:

0 - No tool probing to be performed.

1 - Length probing (Rotating).

2 - Length probing (Non-Rotating).

3 - Length and Diameter probing (Rotating).

If 1,2,5,6 or 7, always probes along tool centerline for length



If 3 or 4, it shifts tool, probing at the tool's edge, for Probe Types 1 and 3



(A) Var.

A0.0 = Probe selected tool

A1.0 = Probe selected tool manually

A2.0 = Probe selected tool for breakage

If (4) "Probe All Tools" selected, it probes all tools with a Probe Type other than "None"

