

## RoboDrill Tool Offset Instructions

### Items Needed:

- Touch Off Light or 1,2,3 Block or Ground Block

1. Place Touch Off Light or 1,2,3 Block or Ground Block on surface of clamp (top of clamp not in)
2. Reference with an empty turret pocket
3. Press the Position button and then the All softkey
4. Z down on to the Touch Off Light or 1,2,3 Block or Ground Block
5. Press the Z button, then press the Origin softkey, then the Execute softkey; Relative Z should become 0
6. Change to the tool you want to set by using the Quick NC Tool Change process
7. Once the tool you want to set is selected, press the Offset Settings button
8. Press the Offset softkey
9. Z Down to the same place you referenced Z in the steps above
10. Make sure you are in the offset number that corresponds to the turret you are on in the GEOM (Length) column (ie. if the tool you are trying to set the offset for is in turret position 2, then you will want to be in NO. 002 in the GEOM (Length) Column on the Offset Page
11. Press the Z button and then the Inp C softkey
12. Make sure the value in the GEOM (Length) Column matched the Relative Z Value shown on the top right side of your screen