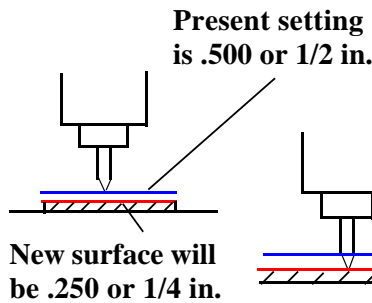


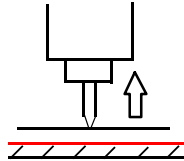
Surface/Up/Z altitude

As an example, say you were cutting 1/2 inch thick material and the surface has a setting of .500. You replace it with 1/4 inch material. You now need to set the new surface.

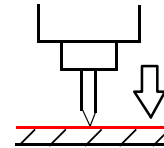


Select "setsurf". Left click in short intervals. You can make very small moves until the tip nearly touches the surface.

Press the enter key. The new surface number is recorded in the program.



Select the "surface" command. The tool will go down to the new position for 1/4 inch stock.



The tool retracts to the last surface position.



Selecting the "up" command will move the tool up from the surface to the Z altitude position. This is the distance the tool is away from the surface when traveling between cuts.



IG S# 994904
Z Altitude During Tool Movements (0.2000 inch): .1000

Select the "zalt" command. Accept the present value or type in a new one and press enter.

In the example above, we set surface on a new piece of material that was thinner than the previous. After pressing the enter key, the tool moved up to the previous surface position. Because the tool will return to its last surface position immediately after recording the new surface, care must be taken when loading a piece of material that is higher than the last thickness being cut. (continued next page)

