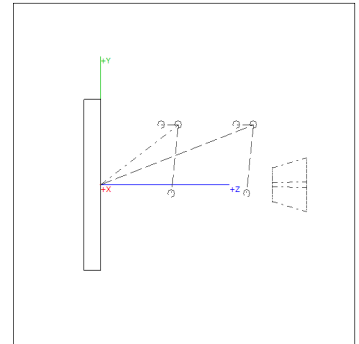


DATUM CALCULATOR

For 4 and 5 Axis machines

An invaluable aid to saving time, costs and improving your manufacturing process



N35 MSG("LOADING ZERO OFFSETS")

N40 \$P_UIFR[56]=CTTRANS(X,138.13,Y,202.001,Z,601.676,B,90);G556 B0.0

N45 \$P_UIFR[57]=CTTRANS(X,-60

(PALLET B TOP OFFSETS)

G90G10L2P1X-433.1Y-153.661Z-

G90G10L2P2X0.31Y0.06Z0B0 (G5

G90G10L2P3X-407.65Y-125.1Z-9

G90G10L2P4X-406.9Y-153.661Z-

G90G10L2P5X-432.52Y-125.1Z-9

N20L961 R00 1 R01 0 R02 0

N30L961 R00 2 R01 188 R02 188

N40G59 N2 X0 Y481.4 Z,49.5

N50G59 N3 X0 Y481.4 Z,49.5

N60G59 N3 X53 Y481.4 Z150

1170 CYCL DEF 19.0 WORKING P

1171 CYCL DEF 19.1 A+0 B+0 C+

1172 CYCL DEF 19.0 WORKING P

1173 CYCL DEF 19.1

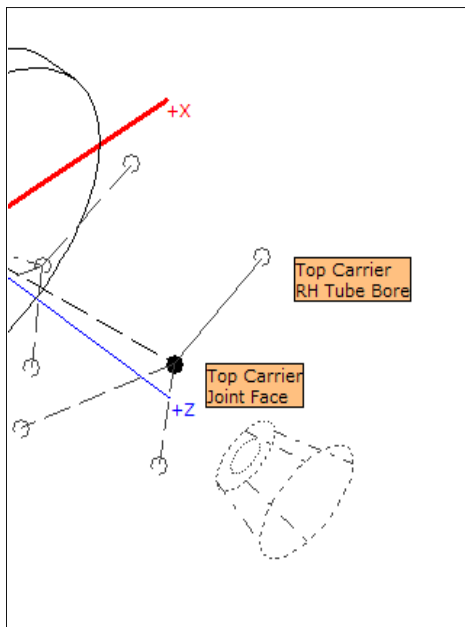
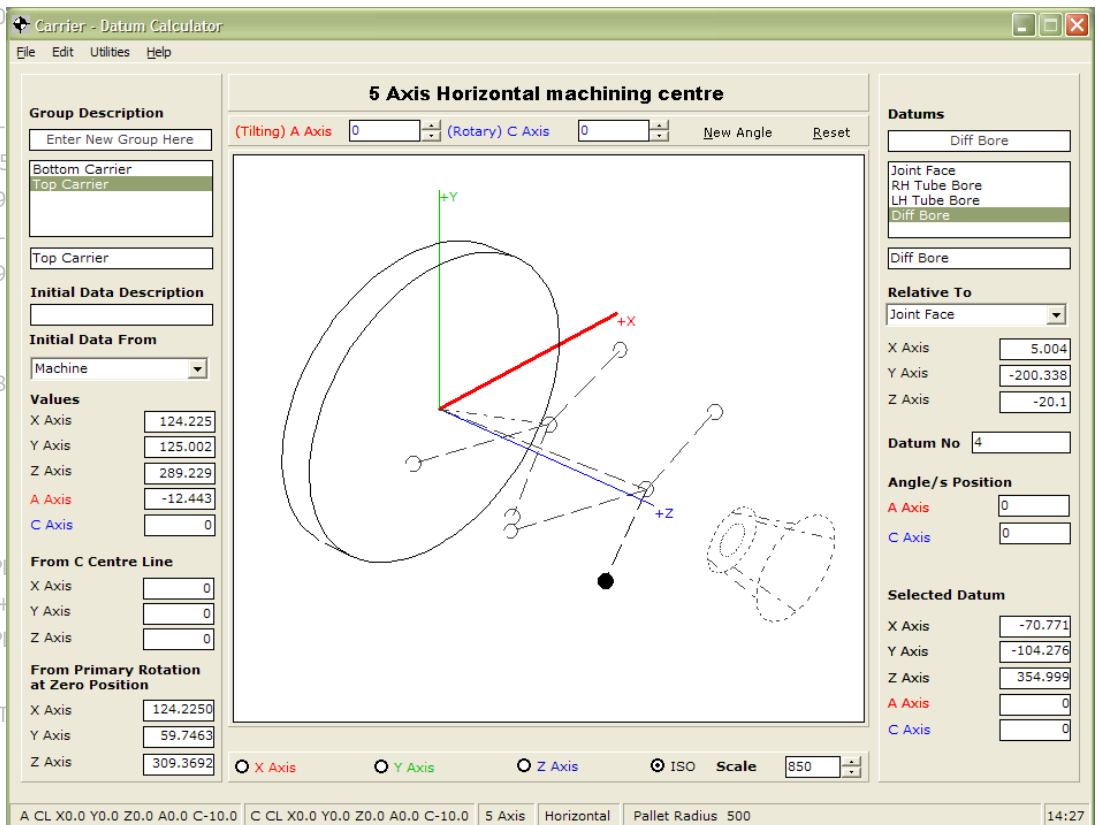
1174 CYCL DEF 7.0 DATUM SHIF

1175 CYCL DEF 7.1 X+0

1176 CYCL DEF 7.2 Y+0

1177 CYCL DEF 7.3 Z+0

1178 CYCL DEF 7.4 A+0

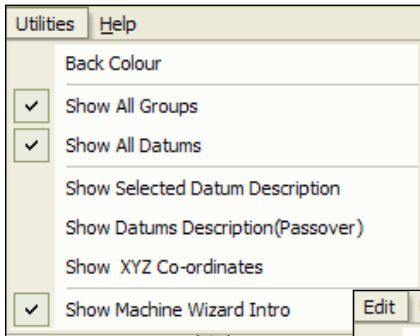


What is a Datum Calculator

Datum Calculator calculates track able points or datum's around a pallet as it indexes through different positions on 4 or 5 Axis, Horizontal or vertical machines. Making it easy to **calculate coordinate positions** for work offsets within your part programme, whether it be a **one off or multiple parts** on the pallet

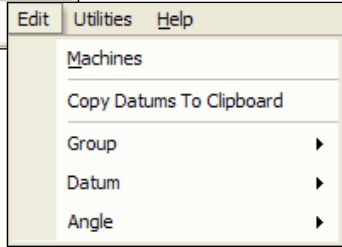
It saves angled positions for further reference and gives you the opportunity to **change machines** or original reference positions quickly providing up to date live information.

The data output or programmable work offset line can be **configured exactly** for your machine and lets you copy and paste it direct into your NC part programme.



Customize your workspace

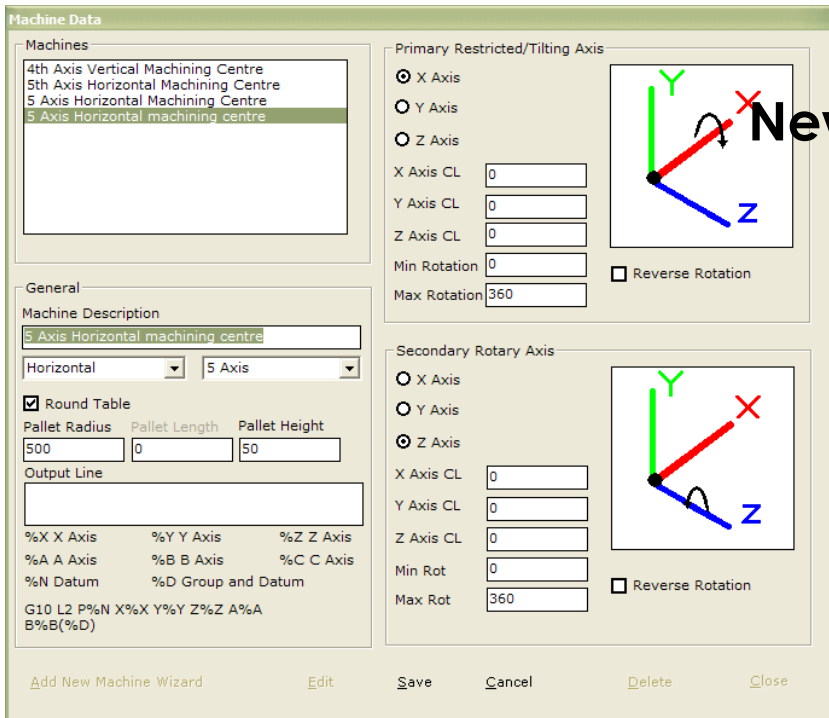
Change the background colour of the display and turn different options on or off.



Finding **compound angles** and **work offset datum's** can be challenging at the best of times and if a small dimensional change or offset is introduced the whole process has to start again.

Using the **DATUM CALCULATOR** will save valuable time and expensive mistakes, with the click of a button all **datum's** can be re-calculated instantly.

Moving components from one machine to another is now just a matter of selecting the machine from the drop down menu and this will bring in the **new centre of rotation** for that machine and with the press of a button re-calculation is done.



New Machine wizard

Vertical or Horizontal
Four or Five Axis

```
N45 $P_UIFR[57]=CTTRANS(X,-601.676,Y,202.001,Z,138.13,B,90);G557 B90.0
N50 $P_UIFR[58]=CTTRANS(X,601.676,Y,202.001,Z,-138.13,B,90);G558 B270.0
```

```
1170 CYCL DEF 19.0 WORKING PLANE
1171 CYCL DEF 19.1 A+0 B+0 C+0
1172 CYCL DEF 19.0 WORKING PLANE
1173 CYCL DEF 19.1
1174 CYCL DEF 7.0 DATUM SHIFT
1175 CYCL DEF 7.1 X+0
1176 CYCL DEF 7.2 Y+0
```

