m. Record the daylight value of the measured tool. The value can be obtained from the DAYLIGHT caption on the monitor or the Tool Manager. The measured DAYLIGHT value is: _____

Summary: The "SET SWITCHSPOIL =" value is the height difference between the spoilboard and the sensor. When this value is changed to zero (0), then the measured daylight for the chosen tool will be the true distance to the sensor.

Step 3 Calculate Difference

a. Calculate the diffrence between the two recorded values from Steps 1 and 2.

Step 2 Tool Sensor's Daylight Value: _____

Step 1 Manual Daylight Value: _____

Difference: _____

Press Ctrl Alt then C to open the Calculator. Press Alt then F4 to close.

Step 4 Record Switchspoil Value

a. M999. Return to the line in the TOOL_LEN.NC3 program that says M999.
b. Press BLOCK STEP (+). Answer Yes to continue.
c. SET SWITCHSPOIL = 0.00. Find the line that states SET SWITCHSPOIL. To find it the quickest, press the PgDn key three times then use the ⇧ ⇩ arrows to move the cursor.
d. Press Tab to edit the line.
e. Replace the value of zero (0.000) with the value found in Step 3 for the difference.
Note: If the sensor is below the table then the value entered must be positive, whereas if the sensor is above the table, the value must be negative.
f. Press the End to move the cursor to the M99 at the end of the program.
g. Press BLOCK STEP (+). Answer Yes to continue.
h. Press NC RESET and BLOCK STEP (-) to reset the machine.