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'PROGRAM TO LOAD THE Z OFFSETS OF THE TOOL HOLDERS.
'PUT ZERO PLATE ON TABLE AT OFFSET OF 4,4
'REMOVE ANY TOOL HOLDERS FROM THE ROUTER
'ZERO TABLE AT MACHINE ZERO
'DELETE ALL VARIABLES
SL
MS,2,0.75
JS,3,2
&XOFFSET=0.0
&YOFFSET=0.0
FP,VARIABLES.SBP
J2,4,4
'PLACE ZEROPLATE UNDER ROUTER
PAUSE 2
ON INP(2,1) GOSUB STOPRETURN
&TEMP=1
MZ,-10.0
&TEMP=1
ON INP(2,1) GOSUB SETZZERO
&TEMP=1
MZ,-10.0
&TEMP=1

JY,&YZEROLLOCATION
JX,&XZEROLLOCATION
&TEMP=1
ON INP(2,1) GOSUB STOPRETURN
&TEMP=1
MZ,-10.0
&TEMP=1
ON INP(2,1) GOSUB PLATFORMZERO
&TEMP=1
MZ,0
&TEMP=1
JZ,4.0
FP,HIGHTSET.SBP
JX,&PRESTAGEX

INPUT "TOOL # TO OFFSET OR -A- FOR ALL->" &TOOL
PAUSE

IF &TOOL=8 THEN GOTO TOOL8
IF &TOOL=7 THEN GOTO TOOL7
IF &TOOL=6 THEN GOTO TOOL6
IF &TOOL=5 THEN GOTO TOOL5
IF &TOOL=4 THEN GOTO TOOL4
IF &TOOL=3 THEN GOTO TOOL3
IF &TOOL=2 THEN GOTO TOOL2
IF &TOOL=1 THEN GOTO TOOL1

'PICKUP TOOL FROM HOLDER #1
TOOL1:
SO,1,0
JZ,&ABOVEHEIGHT
J2, &PRESTAGEX,&PRESTAGE1Y
J2,&TOOL1X,&TOOL1Y

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SO,2,1
PAUSE .3
SO,2,0
PAUSE .3
SO,2,1
PAUSE .3
SO,2,0
PAUSE .3
SO,2,1
JZ,&GETOOLHEIGHT
SO,2,0
JZ,&GETOOLHEIGHT -&ZADD
J2, &PRESTAGEX,&PRESTAGE1Y
J3,,&YZEROLOCATION ,%(3)+3.5
JX,&XZEROLOCATION
ON INP(2,1) GOSUB STOPRETURN
&TEMP=1
MZ,-10.0
&TEMP=1
ON INPUT(2,1) GOSUB OFFSET1
MZ,-1.0
&TEMP=1
JX,&PRESTAGEX

'Put Tool in Holder #1
SO,1,0
J3, &PRESTAGEX,&PRESTAGE1Y,&PUTOOLHEIGHT
J2,&TOOL1X,&TOOL1Y-&XADD
JZ,&PUTOOLHEIGHT+&ZADD
SO,2,1
PAUSE .2
JZ,&ABOVEHEIGHT
SO,2,0
J2,&PRESTAGEX,&PRESTAGE1Y
OPEN C:\MRTPROG\OFFSETT1.SBP FOR OUTPUT AS #1
WRITE #1; "&OFFSET1="; &OFFSET1
CLOSE #1
IF &TOOL=1 THEN END

'PICKUP TOOL FROM HOLDER #2
TOOL2:
SO,1,0
JZ,&ABOVEHEIGHT
J2, &PRESTAGEX,&PRESTAGE2Y
J2,&TOOL2X,&TOOL2Y
SO,2,1
PAUSE .3
SO,2,0
PAUSE .3
SO,2,1
PAUSE .3
SO,2,0
PAUSE .3
SO,2,1
JZ,&GETOOLHEIGHT
SO,2,0

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JZ,&GETOOLHEIGHT -&ZADD
J2, &PRESTAGEX,&PRESTAGE2Y
J3,,&YZEROLLOCATION ,%(3)+3.5
JX,&XZEROLLOCATION
ON INP(2,1) GOSUB STOPRETURN
&TEMP=1
MZ,-10.0
&TEMP=1
ON INPUT(2,1) GOSUB OFFSET2
MZ,-1.0
&TEMP=1
JX,&PRESTAGEX

'Put Tool in Holder #2
SO,1,0
J3, &PRESTAGEX,&PRESTAGE2Y,&PUTOOLHEIGHT
J2,&TOOL2X,&TOOL2Y-&XADD
JZ,&PUTOOLHEIGHT+&ZADD
SO,2,1
PAUSE .2
JZ,&ABOVEHEIGHT
SO,2,0
J2,&PRESTAGEX,&PRESTAGE2Y
OPEN C:\MRTPROG\OFFSET2.SBP FOR OUTPUT AS #1
WRITE #1; "&OFFSET2="; &OFFSET2
CLOSE #1
IF &TOOL=2 THEN END

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'PICKUP TOOL FROM HOLDER #3
TOOL3:
SO,1,0
JZ,&ABOVEHEIGHT
J2, &PRESTAGEX,&PRESTAGE3Y
J2,&TOOL3X,&TOOL3Y
SO,2,1
PAUSE .3
SO,2,0
PAUSE .3
SO,2,1
PAUSE .3
SO,2,0
PAUSE .3
SO,2,1
JZ,&GETOOLHEIGHT
SO,2,0
JZ,&GETOOLHEIGHT -&ZADD
J2, &PRESTAGEX,&PRESTAGE3Y
J3,,&YZEROLLOCATION ,%(3)+3.5
JX,&XZEROLLOCATION
ON INP(2,1) GOSUB STOPRETURN
&TEMP=1
MZ,-10.0
&TEMP=1
ON INPUT(2,1) GOSUB OFFSET3
MZ,-1.0
&TEMP=1

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JX,&PRESTAGEX

'Put Tool in Holder #3
SO,1,0
J3, &PRESTAGEX,&PRESTAGE3Y,&PUTOOLHEIGHT
J2,&TOOL3X,&TOOL3Y-&XADD
JZ,&PUTOOLHEIGHT+&ZADD
SO,2,1
PAUSE .2
JZ,&ABOVEHEIGHT
SO,2,0
J2,&PRESTAGEX,&PRESTAGE3Y
OPEN C:\MRTPROG\OFFSETT3.SBP FOR OUTPUT AS #1
WRITE #1; "&OFFSET3="; &OFFSET3
CLOSE #1
IF &TOOL=3 THEN END

'PICKUP TOOL FROM HOLDER #4
TOOL4:
SO,1,0
JZ,&ABOVEHEIGHT
J2, &PRESTAGEX,&PRESTAGE4Y
J2,&TOOL4X,&TOOL4Y
SO,2,1
PAUSE .3
SO,2,0
PAUSE .3
SO,2,1
PAUSE .3
SO,2,0
PAUSE .3
SO,2,1
JZ,&GETOOLHEIGHT
SO,2,0
JZ,&GETOOLHEIGHT -&ZADD
J2, &PRESTAGEX,&PRESTAGE4Y
J3, ,&YZEROLLOCATION ,%(3)+3.5
JX,&XZEROLLOCATION
ON INP(2,1) GOSUB STOPRETURN
&TEMP=1
MZ,-10.0
&TEMP=1
ON INPUT(2,1) GOSUB OFFSET4
MZ,-1.0
&TEMP=1
JX,&PRESTAGEX

'Put Tool in Holder #4
SO,1,0
J3, &PRESTAGEX,&PRESTAGE4Y,&PUTOOLHEIGHT
J2,&TOOL4X,&TOOL4Y-&XADD
JZ,&PUTOOLHEIGHT+&ZADD
SO,2,1
PAUSE .2
JZ,&ABOVEHEIGHT

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SO,2,0
J2,&PRESTAGEX,&PRESTAGE4Y
OPEN C:\MRTPROG\OFFSETT4.SBP FOR OUTPUT AS #1
WRITE #1; "&OFFSET4="; &OFFSET4
CLOSE #1
IF &TOOL=4 THEN END
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'PICKUP TOOL FROM HOLDER #5
TOOL5:
SO,1,0
JZ,&ABOVEHEIGHT
J2, &PRESTAGEX,&PRESTAGE5Y
J2,&TOOL5X,&TOOL5Y
SO,2,1
PAUSE .3
SO,2,0
PAUSE .3
SO,2,1
PAUSE .3
SO,2,0
PAUSE .3
SO,2,1
JZ,&GETOOLHEIGHT
SO,2,0
JZ,&GETOOLHEIGHT -&ZADD
J2, &PRESTAGEX,&PRESTAGE5Y
J3,,&YZEROLOCATION ,%(3)+3.5
JX,&XZEROLOCATION
ON INP(2,1) GOSUB STOPRETURN
&TEMP=1
MZ,-10.0
&TEMP=1
ON INPUT(2,1) GOSUB OFFSET5
MZ,-1.0
&TEMP=1
JX,&PRESTAGEX
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'Put Tool in Holder #5
SO,1,0
J3, &PRESTAGEX,&PRESTAGE5Y,&PUTOOLHEIGHT
J2,&TOOL5X,&TOOL5Y-&XADD
JZ,&PUTOOLHEIGHT+&ZADD
SO,2,1
PAUSE .2
JZ,&ABOVEHEIGHT
SO,2,0
J2,&PRESTAGEX,&PRESTAGE5Y
OPEN C:\MRTPROG\OFFSETT5.SBP FOR OUTPUT AS #1
WRITE #1; "&OFFSET5="; &OFFSET5
CLOSE #1
IF &TOOL=5 THEN END
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'PICKUP TOOL FROM HOLDER #6
TOOL6:
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SO,1,0
JZ,&ABOVEHEIGHT
J2, &PRESTAGEX,&PRESTAGE6Y
J2,&TOOL6X,&TOOL6Y
SO,2,1
PAUSE .3
SO,2,0
PAUSE .3
SO,2,1
PAUSE .3
SO,2,0
PAUSE .3
SO,2,1
JZ,&GETOOLHEIGHT
SO,2,0
JZ,&GETOOLHEIGHT -&ZADD
J2, &PRESTAGEX,&PRESTAGE6Y
J3,,&YZEROLOCATION ,%(3)+3.5
JX,&XZEROLOCATION
ON INP(2,1) GOSUB STOPRETURN
&TEMP=1
MZ,-10.0
&TEMP=1
ON INPUT(2,1) GOSUB OFFSET6
MZ,-1.0
&TEMP=1
JX,&PRESTAGEX

'Put Tool in Holder #6
SO,1,0
J3, &PRESTAGEX,&PRESTAGE6Y,&PUTOOLHEIGHT
J2,&TOOL6X,&TOOL6Y-&XADD
JZ,&PUTOOLHEIGHT+&ZADD
SO,2,1
PAUSE .2
JZ,&ABOVEHEIGHT
SO,2,0
J2,&PRESTAGEX,&PRESTAGE6Y
OPEN C:\MRTPROG\OFFSETT6.SBP FOR OUTPUT AS #1
WRITE #1; "&OFFSET6="; &OFFSET6
CLOSE #1
IF &TOOL=6 THEN END

'PICKUP TOOL FROM HOLDER #7
TOOL7:
SO,1,0
JZ,&ABOVEHEIGHT
J2, &PRESTAGEX,&PRESTAGE7Y
J2,&TOOL7X,&TOOL7Y
SO,2,1
PAUSE .3
SO,2,0
PAUSE .3
SO,2,1
PAUSE .3

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SO,2,0
PAUSE .3
SO,2,1
JZ,&GETOOLHEIGHT
SO,2,0
JZ,&GETOOLHEIGHT -&ZADD
J2, &PRESTAGEX,&PRESTAGE7Y
J3,,&YZEROLOCATION ,%(3)+3.5
JX,&XZEROLOCATION
ON INP(2,1) GOSUB STOPRETURN
&TEMP=1
MZ,-10.0
&TEMP=1
ON INPUT(2,1) GOSUB OFFSET7
MZ,-1.0
&TEMP=1
JX,&PRESTAGEX

'Put Tool in Holder #7
SO,1,0
J3, &PRESTAGEX,&PRESTAGE7Y,&PUTOOLHEIGHT
J2,&TOOL7X,&TOOL7Y-&XADD
JZ,&PUTOOLHEIGHT+&ZADD
SO,2,1
PAUSE .2
JZ,&ABOVEHEIGHT
SO,2,0
J2,&PRESTAGEX,&PRESTAGE7Y
OPEN C:\MRTPROG\OFFSET7.SBP FOR OUTPUT AS #1
WRITE #1; "&OFFSET7="; &OFFSET7
CLOSE #1
IF &TOOL=7 THEN END

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'PICKUP TOOL FROM HOLDER #8
TOOL8:
SO,1,0
JZ,&ABOVEHEIGHT
J2, &PRESTAGEX,&PRESTAGE8Y
J2,&TOOL8X,&TOOL8Y
SO,2,1
PAUSE .3
SO,2,0
PAUSE .3
SO,2,1
PAUSE .3
SO,2,0
PAUSE .3
SO,2,1
JZ,&GETOOLHEIGHT
SO,2,0
JZ,&GETOOLHEIGHT -&ZADD
J2, &PRESTAGEX,&PRESTAGE8Y
J3,,&YZEROLOCATION ,%(3)+3.5
JX,&XZEROLOCATION
ON INP(2,1) GOSUB STOPRETURN

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&TEMP=1
MZ,-10.0
&TEMP=1
ON INPUT(2,1) GOSUB OFFSET8
MZ,-1.0
&TEMP=1
JX,&PRESTAGEX

'Put Tool in Holder #8
SO,1,0
J3,&PRESTAGEX,&PRESTAGE8Y,&PUTOOLHEIGHT
J2,&TOOL8X,&TOOL8Y-&XADD
JZ,&PUTOOLHEIGHT+&ZADD
SO,2,1
PAUSE .2
JZ,&ABOVEHEIGHT
SO,2,0
J2,&PRESTAGEX,&PRESTAGE8Y
OPEN C:\MRTPROG\OFFSETT8.SBP FOR OUTPUT AS #1
WRITE #1; "&OFFSET8="; &OFFSET8
CLOSE #1

END
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STOPRETURN:
ON INP(2,1)
&TEMP=1
JZ,%(3)+.25
&TEMP=1
MS,,0.125
RETURN
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SETZZERO:
ON INP(2,1)
&TEMP=1
VA,,, &ZEROPLATETHICK
PAUSE .2
JZ,&DELTAZEROPLATES+.5
'REPLACE THE ZERO PLATE AND HIT ENTER
PAUSE
&TEMP=1
MS,,0.75
RETURN
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```
PLATFORMZERO:
ON INP(2,1)
&TEMP=1
&ZEROPLATE=%(3)
MS,,0.75
RETURN
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OFFSET1:
&OFFSET1=%(3)-&ZEROPLATE
JZ,%(3)+.25
&TEMP=1
MS,,0.75
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RETURN

OFFSET2:

&OFFSET2=%(3)-&ZEROPLATE
JZ,%(3)+.25
&TEMP=1
MS,,0.75
RETURN

OFFSET3:

&OFFSET3=%(3)-&ZEROPLATE
JZ,%(3)+.25
&TEMP=1
MS,,0.75
RETURN

OFFSET4:

&OFFSET4=%(3)-&ZEROPLATE
JZ,%(3)+.25
&TEMP=1
MS,,0.75
RETURN

OFFSET5:

&OFFSET5=%(3)-&ZEROPLATE
JZ,%(3)+.25
&TEMP=1
MS,,0.75
RETURN

OFFSET6:

&OFFSET6=%(3)-&ZEROPLATE
JZ,%(3)+.25
&TEMP=1
MS,,0.75
RETURN

OFFSET7:

&OFFSET7=%(3)-&ZEROPLATE
JZ,%(3)+.25
&TEMP=1
MS,,0.75
RETURN

OFFSET8:

&OFFSET8=%(3)-&ZEROPLATE
JZ,%(3)+.25
&TEMP=1
MS,,0.75
RETURN