Y-Axis Tool Setup on Multi-Task Machines

Cutting edge is located: 1 30.82mm from machine center TGTBY line (🗣) in Y Axis 2 3mm from for TGAQ adapter and 6.4mm for DGAQ adapter (see sketches below) *30.82 REF *3 REF Υ Machine Probe Х Option 1 Option 2 For **DGAQ** For **TGAQ** Adapters Adapters 6.4 REF A BEF Setup cutting edge level on center line

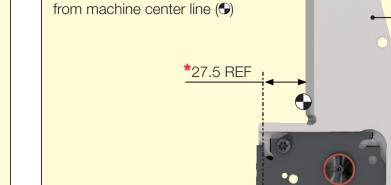
Parting and Setup in Y Axis Direction

* For Y Axis cut off, compensate 30.82mm in Y Axis direction and compensate 3mm for TGAQ adapters or 6.4mm for DGAQ adapters in X Axis direction.

Set the cutting edge on the center line:

Option 1 - Gauge the cutting edge - this is preferable due to better accuracy

Option 2 - Gauge the blade and compensate 3mm / 6.4mm



Cutting edge is located 27.5mm

Υ

Correct

Position

Parting and Setup in X Axis Direction - Optional

TGTBY

V

Correct

Position

* For X Axis cut off, compensate 27.5mm in Y Axis direction. Location pin should be removed

Setup cutting edge level on center line

Χ

Click Link to See Short Video

https://youtu.be/CoJFg_LSUGw

For setup, use the dimensions marked on the tool block

