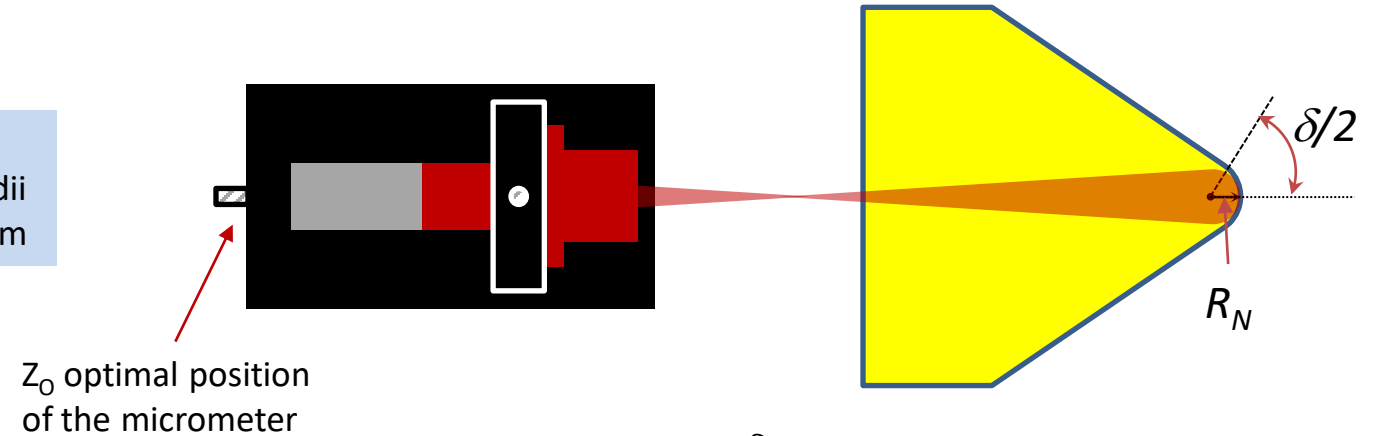


# Z micrometer position equation (T+1 toolpost)

## Measurement conditions

- Expression describes optimal position for different tool radii
- $Z_f$  varies from system to system but typically around 4.5 mm



$$Z_O = Z_f + \frac{\delta}{12} R_N + 1.3$$

## Example

- Tool radius 0.3 mm
- Sweep of 120°
- $Z_f = 4.5$  mm

$$Z_O = 4.5 \text{ mm} + \frac{120}{12} 0.3 \text{ mm} + 1.3 \text{ mm} = 8.8 \text{ mm}$$

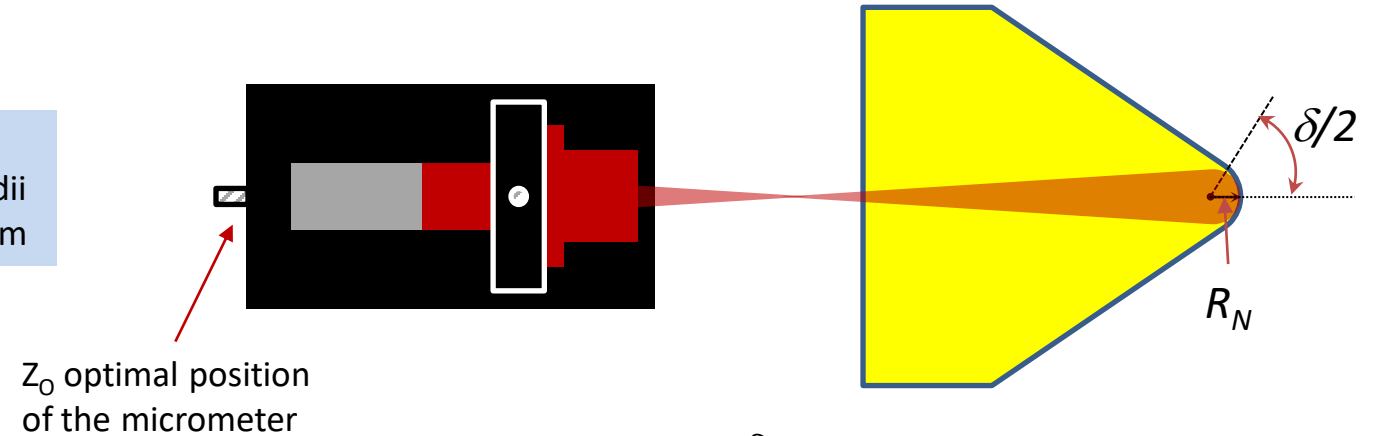


For the tool geometry in the example you need to set the Z micrometer position on **8.8 mm**

# Z micrometer position equation (T2 toolpost)

## Measurement conditions

- Expression describes optimal position for different tool radii
- $Z_f$  varies from system to system but typically around 4.5 mm

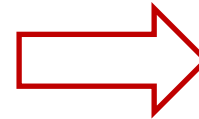


$$Z_0 = Z_f - \frac{\delta}{12} R_N - 1.3$$

## Example

- Tool radius 0.3 mm
- Sweep of  $120^\circ$
- $Z_f = 9$  mm

$$Z_0 = 9 \text{ mm} - \frac{120}{12} 0.3 \text{ mm} - 1.3 \text{ mm} = 4.8 \text{ mm}$$



For the tool geometry in the example you need to set the Z micrometer position on **5.7 mm**