

## Tool-dimension

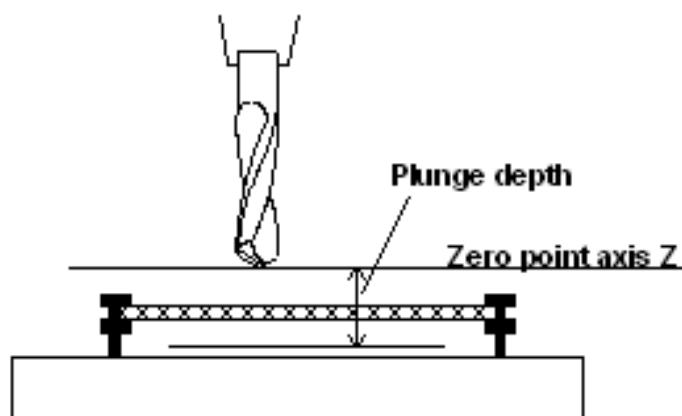
The screenshot shows the 'Parameter' dialog box with the 'Tool measurement' tab selected. The dialog has a title bar 'Parameter' and a close button. Below the title bar are tabs: 'Co-ordinates', 'Tools', 'Misc. parameters', 'Technology', 'Macro', 'Data format', and 'Basic Settings'. The 'Tools' tab is active, and within it, the 'Dimensions' sub-tab is selected. The 'Tool measurement' section contains three columns of input fields: 'Depth', 'Repetitions', and 'Z feed correction'. There are 10 rows of tools, numbered 1 to 10. The 'Depth' column has values: 1.00, 2.00, 3.00, 1.00, 1.00, 1.00, 1.00, 1.00, 1.00, 1.00. The 'Repetitions' column has values: 0, 0, 0, 0, 0, 0, 0, 0, 0, 0. The 'Z feed correction' column has values: 1.00, 2.00, 1.50, 0.00, 0.00, 0.00, 0.00, 0.00, 0.00, 0.00. At the bottom of the dialog are three buttons: 'OK', 'Abort', and 'Save...'. The 'OK' button is highlighted with a green checkmark.

Tool	Depth	Repetitions	Z feed correction
1	1.00	0	1.00
2	2.00	0	2.00
3	3.00	0	1.50
4	1.00	0	0.00
5	1.00	0	0.00
6	1.00	0	0.00
7	1.00	0	0.00
8	1.00	0	0.00
9	1.00	0	0.00
10	1.00	0	0.00

Parameter-Tools Speeds

## Plunge depth

The plunge depth specifies the distance by which the Z-axis of each tool is moved downwards into the workpiece. The depth is defined in millimeters and is always measured starting from the plane of the zero point.



Plunge depth measured from the zero point of the Z-axis

## Repetitions

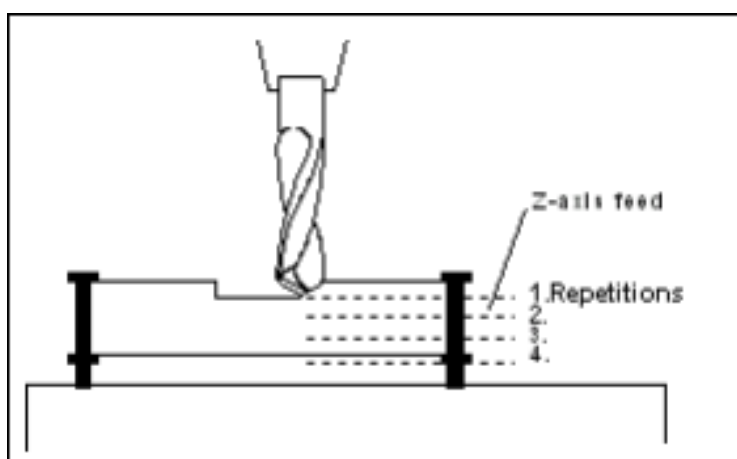
### *Routing in stages*

Frequently, several passes are required when routing thick or hard materials. The parameters Repetitions and Z feed correction mean you do not have to restart a working process several times in succession using different plunge depths.

The repetition always applies to a complete contour line or for a hole, i.e. **WinPC-NC** remembers every insertion point and returns to it after the tool is next withdrawn, in order to start the next pass.

## Z-axis feed correction

During a series of repetitions, the Z-axis feed correction causes the Zaxis to be moved downwards by the specified value.



Repetitions and feed correction

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