

## MOVE-SELECT TOOL...



There is a special dialog box for controlling the tool change or if tool length measurement is activated. It can be activated using the menu function or the tool list button.

**The dialog box contains the following possible functions:**

- Place an inserted tool in the magazine
- Pick up a new tool
- Measure the length of a tool
- Identify the tool which has just been inserted

As a rule, **WinPC-NC** always remembers which tool was used last and the status of the collet chuck. As a result, this information is retained over more than one session.

---

**In order to be able to use each function of this dialog at least one tool length sensor should be available and set up.**

**Using an automatic tool changer requires the corresponding activation in the parameter functions and equipment of an automatic or pneumatic collet chuck.**

---

Select current tool...

Select	Length	
1	1	1 Werkzeug 1
2	2	2 Werkzeug 2
3	3	3 Werkzeug 3
4	4	4 Werkzeug 4
5	5	5 Werkzeug 5
6	6	6 Werkzeug 6
7	7	7 Werkzeug 7
8	8	8 Werkzeug 8
9	9	9 Werkzeug 9
10	10	10 Werkzeug 10

Release [Wrench Icon] Stop OK

Dialog box for selecting, picking up, putting down and measuring tools

---

*Rapid  
operation with  
buttons*

**Function of buttons :**

- Release takes the currently clamped tool and puts it down in the magazine
- The molette button closes or opens the molette. There is a security prompt prior to opening it
- Stop cancels a movement, e.g. to the changer or a measuring movement
- OK closes the dialog box

---

**To inform WinPC-NC which tool is currently inserted, all you have to do is click the tool number or name on the right. This may be necessary after the initial startup or following a cancel..**

---

*Mode of  
application*

Concerning length measuring and length compensation please proceed as follows...

1. Insert a tool – at best the one you want to use first.
  2. Load the required job if it is not already activated and visible in the graphics.
  3. Information to **WinPC-NC** concerning the current active tool via the tool change dialog and ensuing manual measurement. For this please simply click the measurement button for the corresponding tool. The new tool number is immediately displayed in the status bar and **WinPC-NC** moves the tool to the length sensor for automatic length measuring. The information concerning which tool and the corresponding length is now available.
  4. The next step is loading the job and defining the zero point by inserted tool, especially defining the Z zero point. This can be effected as usual, e. g. by scratching the surface
  5. Finally please start the job. **WinPC-NC** asks for a change with each new tool and then measures the tool length automatically. The exact length differences to the reference tool are calculated and respected with subsequent tools concerning the Z height.
-