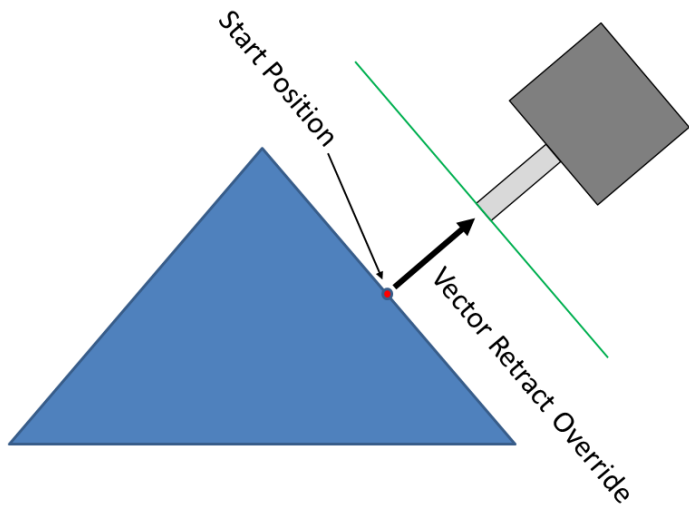


Conversational ASR Parameter Settings

- **VECTOR RETRACT OVERRIDE** - is an incremental retract distance, from the current tool tip position, for the tool to retract along the current tool vector. **Note:** the approach distance above the newly created work plane is controlled by the RETRACT CLEARANCE program parameter setting.
- **Z LIMIT OVERRIDE** - is the maximum MACHINE POSITION you want the Z-axis to retract to for a plane change (transform plane). If the RETRACT OVERRIDE setting above, causes the Z-axis to raise above the position in this setting, then the Z-axis will remain at that height for the plane change.

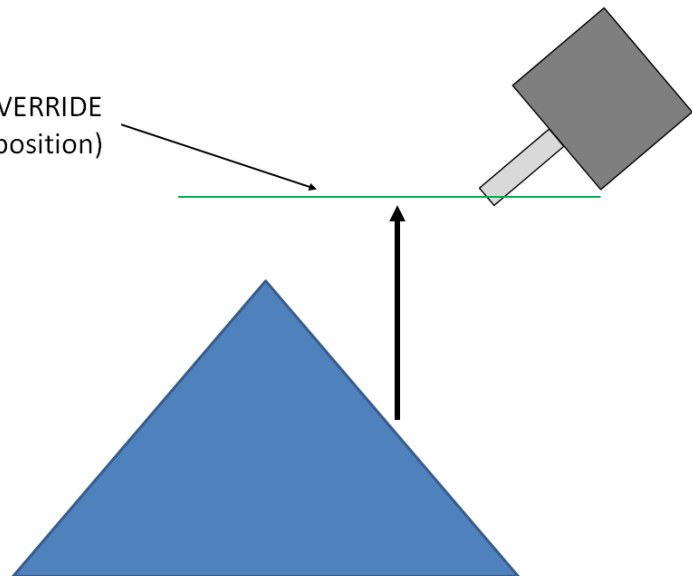
PROGRAM PARAMETERS				
HOLES	PROBING	PERFORMANCE		F1
GENERAL 1	GENERAL 2	MILLING 1	MILLING 2	F2
DEPLETION RETRACT			0.0050	
INTERRUPT CYCLE Z RETRACT			YES ▾	F3
FIRST PECK OFFSET			0.0000	
MOVE TO SAFE POS DURING TC			NO ▾	
TOOL CHANGE OPTIMIZATION			YES ▾	
AUTOMATIC SAFE REPOSITIONING				
VECTOR RETRACT OVERRIDE		OFF ▾	0.000	
Z LIMIT OVERRIDE		OFF ▾	0.000	
Select parameter tab.				
PRESS MANUAL MODE, POWER, AND START CYCLE TO RESTORE POWER.				
				F4
				F5
				F6
NC PARAMETERS				F7
EXIT				F8

1



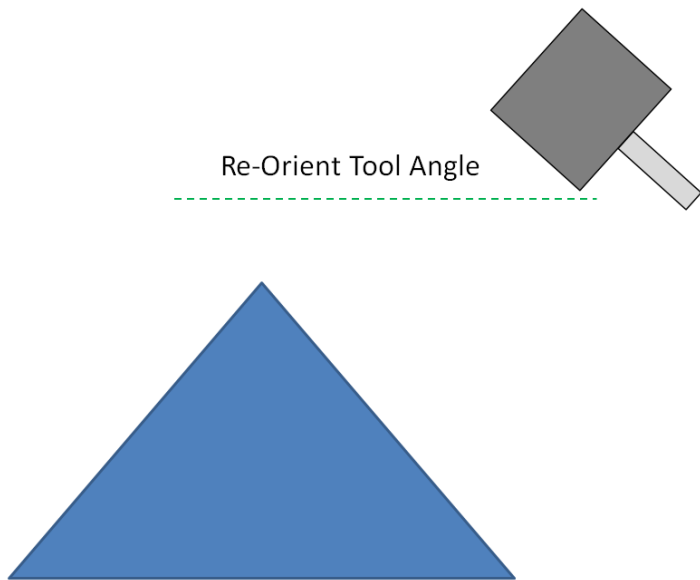
2

Z LIMIT OVERRIDE
(machine position)



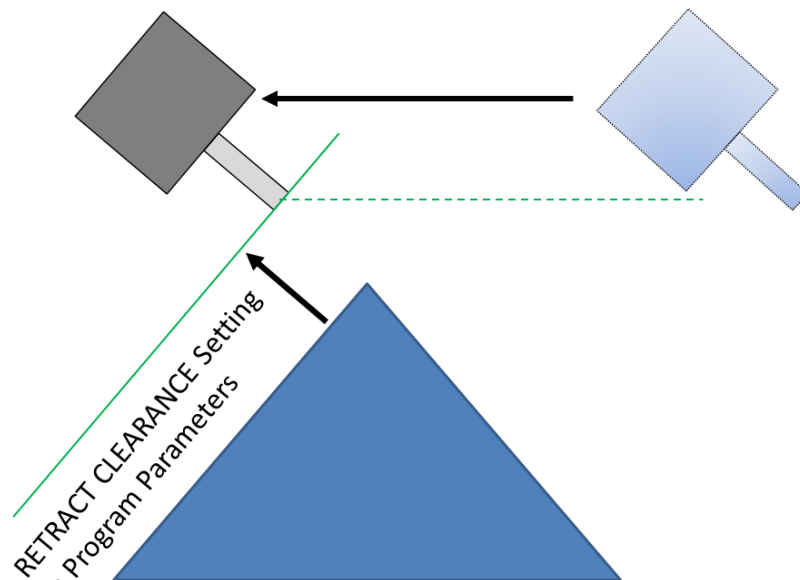
3

Re-Orient Tool Angle

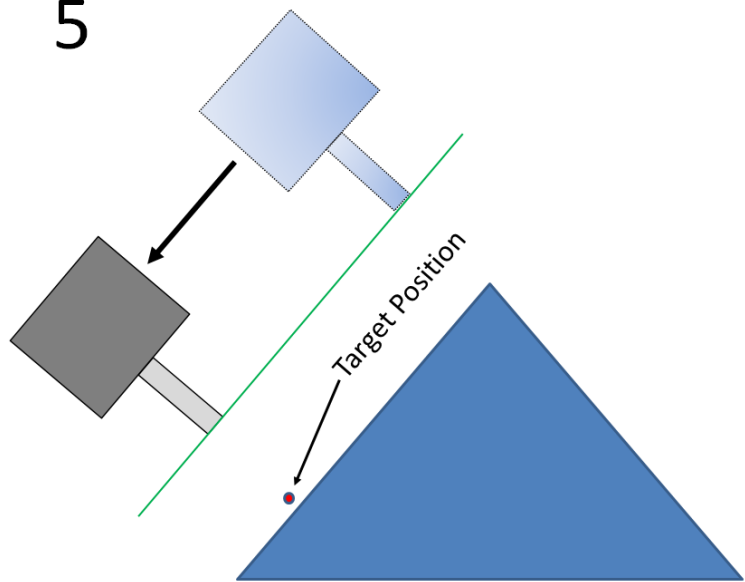


4

RETRACT CLEARANCE Setting
in Program Parameters



5



6

