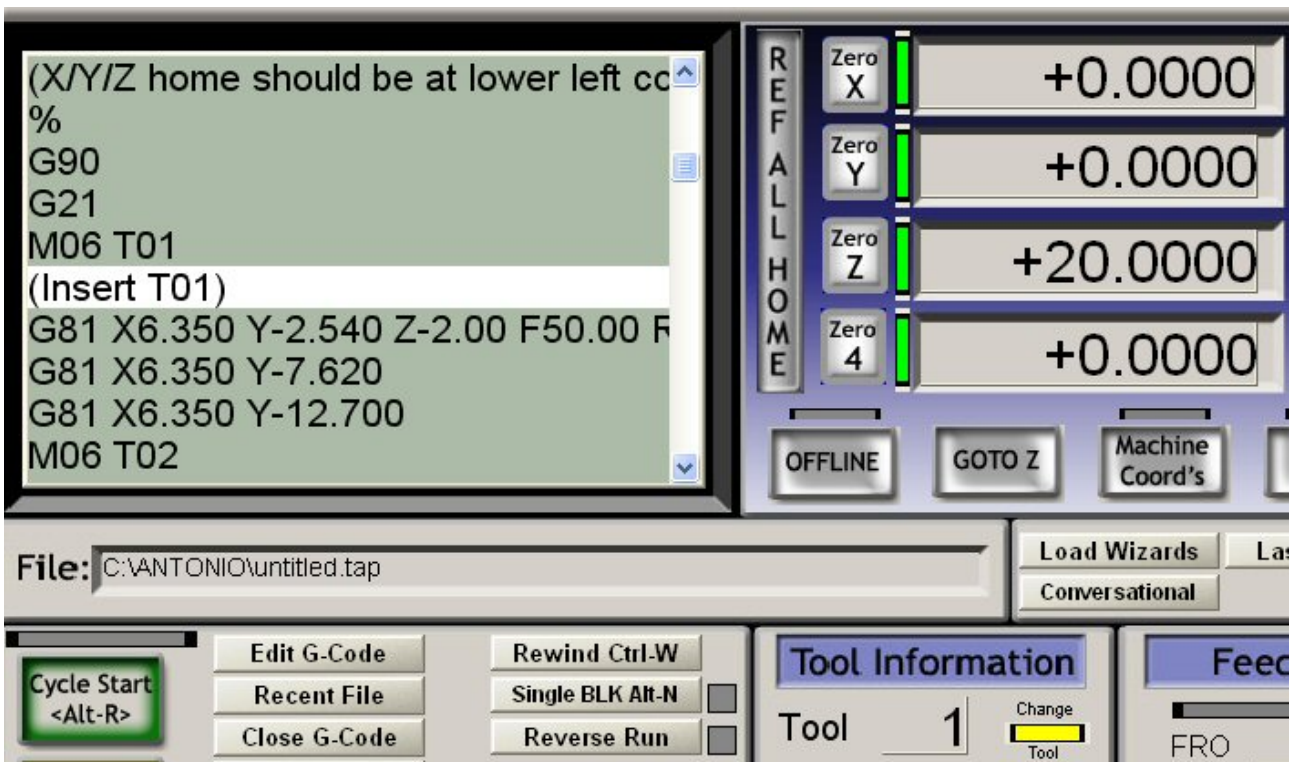


Hi Brian. During the workmanship the Z axle must move in the altitude suitable in change tool location.

Tool Change Location	
X	+0.0000
Y	+0.0000
Z	+20.0000

Safe Height Retraction in Current Coords	
Safe_Z	+20.0000

If the distance from the surface of job is few it is not possible remove the utensil. In the version R1.83.017 with which I worked the order M06 T1 stayed the mandrel and the Z axle one move in the suitable position.



With the new version to the order M06 this doesn't happen more and the Z axle moves only to the quota +2.0000. Salutations, Giordano