

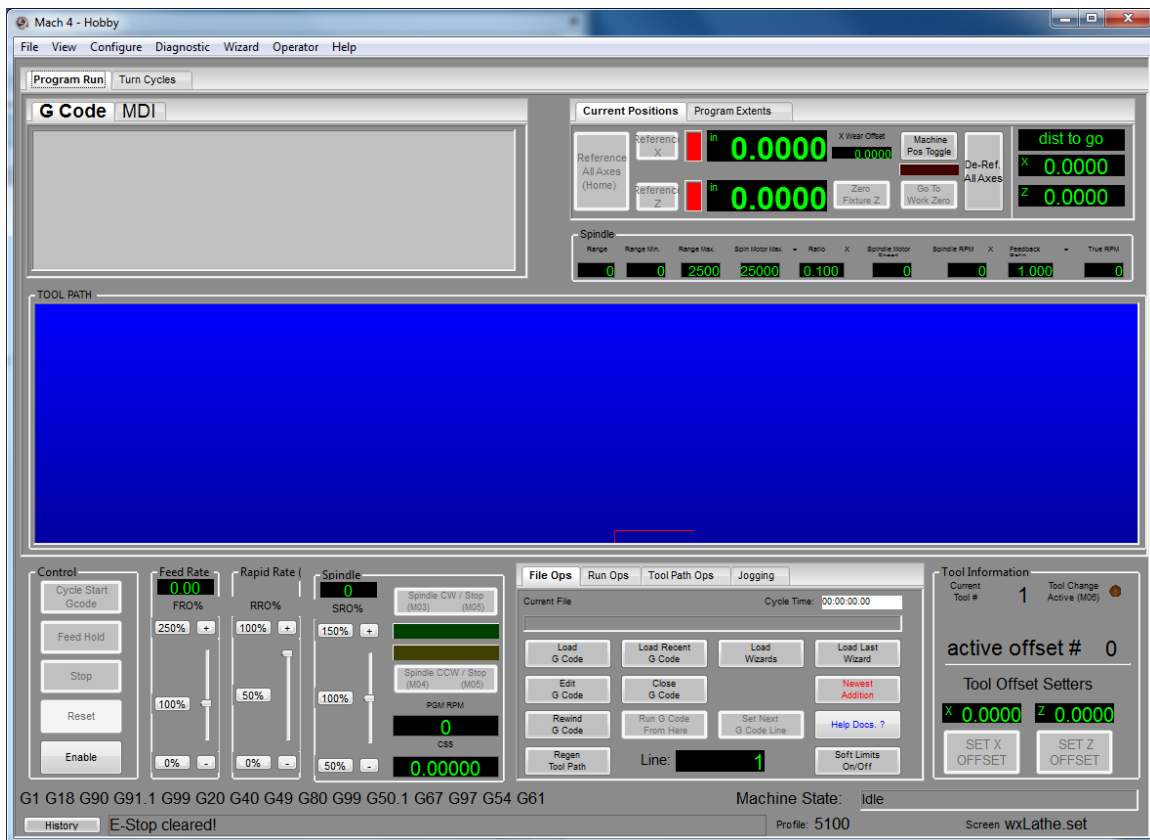
Initial Startup

Note: Already setup tool one X offset per Ron Ginger video. In lathe diameter mode (config > control > defaults).

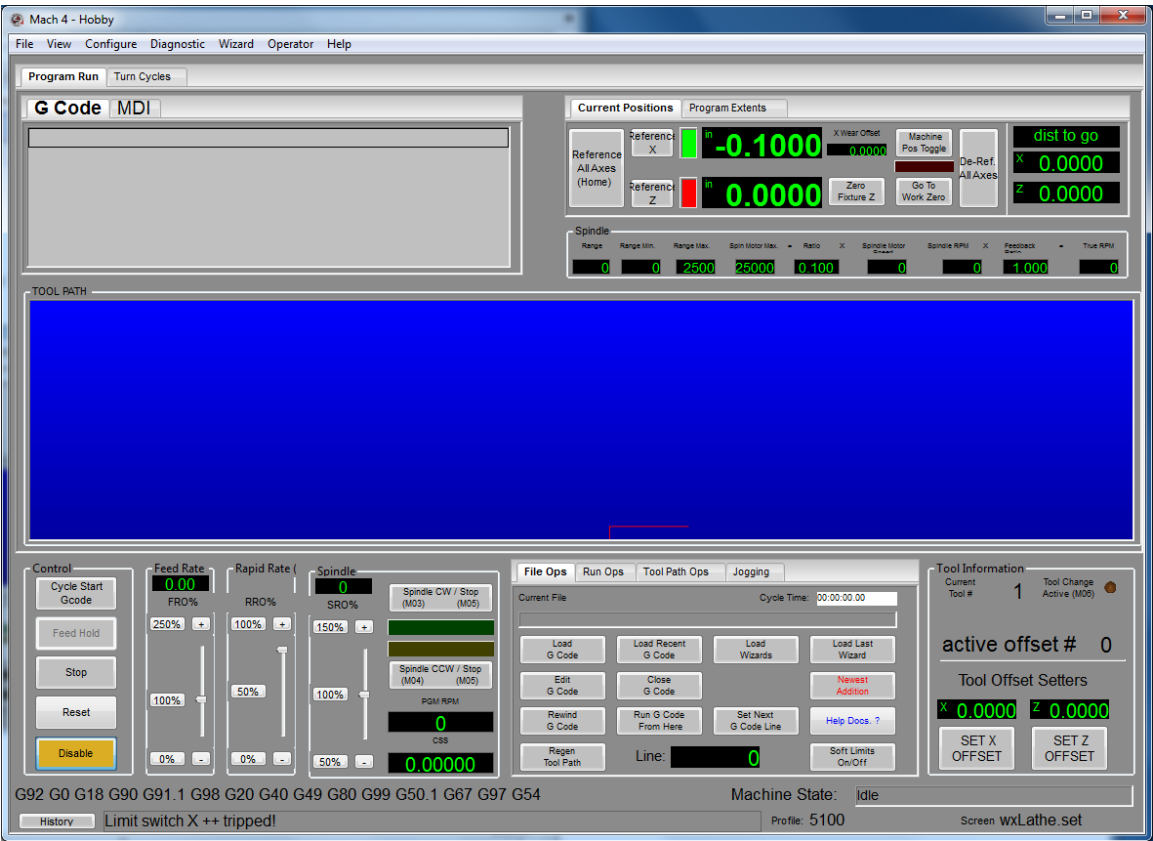
Power on Pokeys box

Start Mach4 Loader and select 5100 profile.

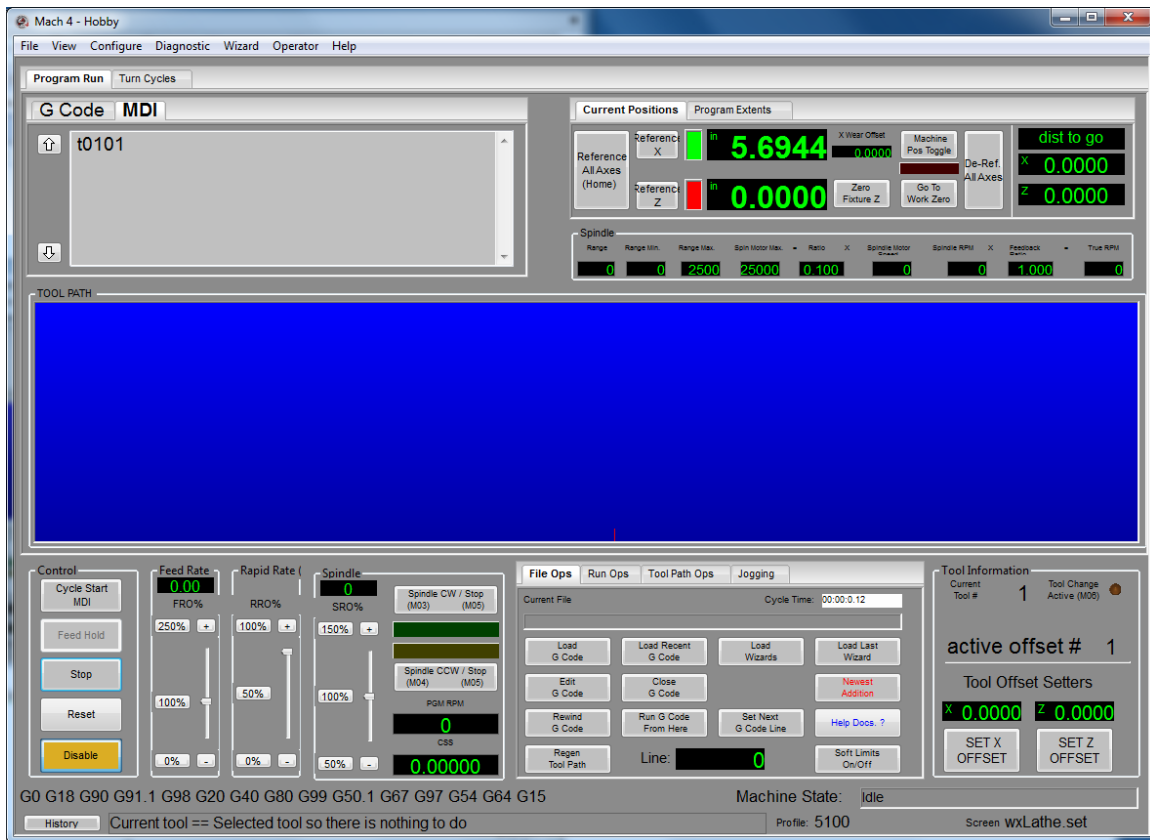
Startup screen:



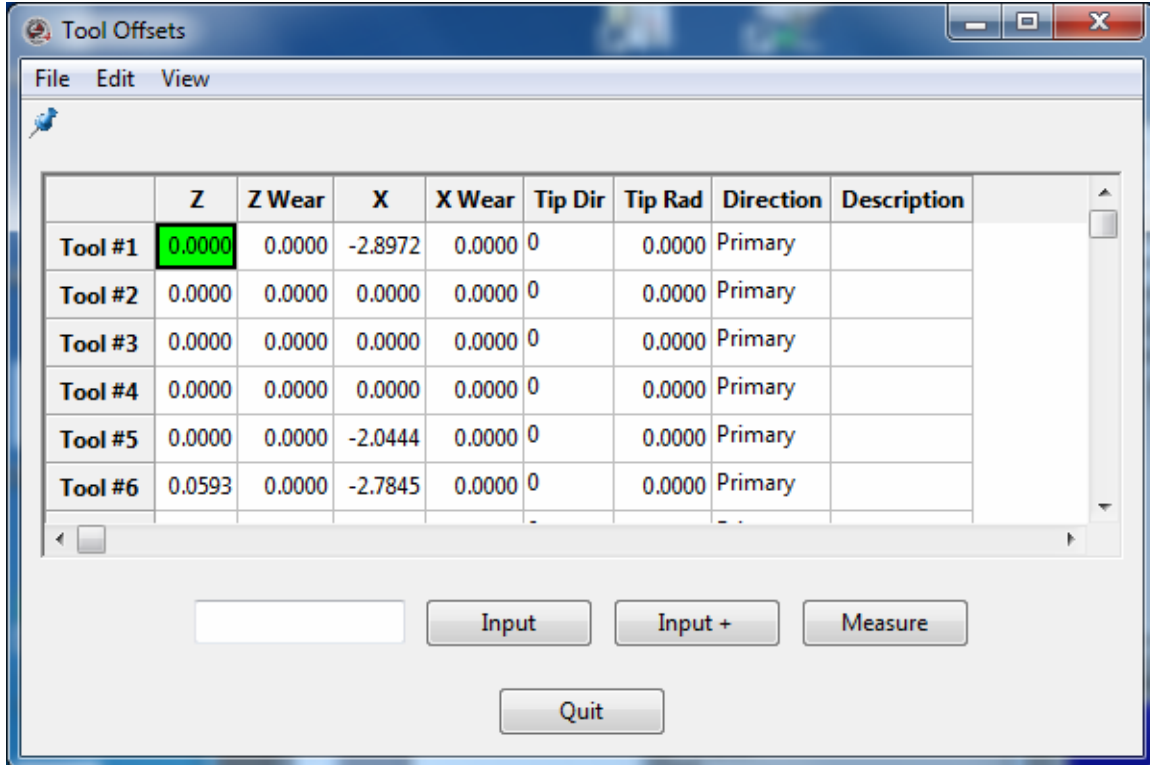
Enable; lower left.
Reference X.



Select tool in MDI tab; upper left – t0101. Stands for tool one, tool offset one.
 “Cycle Start MDI”; lower left selects tool 1 offset 1. (Get an Estop condition. Punch physical Estop button, reset and then can “Cycle Start MDI”).



As info; tool offset table. (Ignore tool 5 and 6)



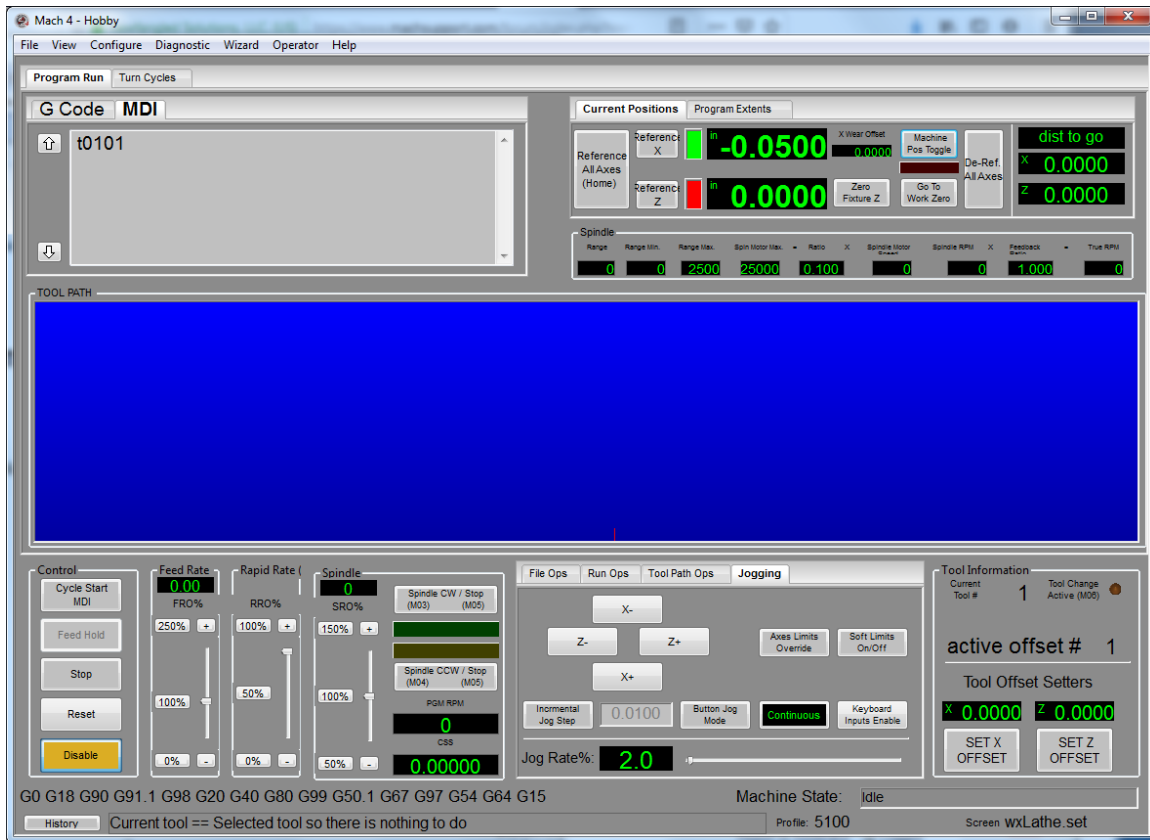
The screenshot shows a software window titled "Tool Offsets" with a menu bar (File, Edit, View) and a toolbar. The main area contains a table with 10 columns: Tool #, Z, Z Wear, X, X Wear, Tip Dir, Tip Rad, Direction, Description, and an empty column. The table lists data for 6 tools. The 'Z' value for Tool #1 is highlighted in green. Below the table is a horizontal input field and three buttons: "Input", "Input +", and "Measure". At the bottom center is a "Quit" button.

Tool #	Z	Z Wear	X	X Wear	Tip Dir	Tip Rad	Direction	Description	
Tool #1	0.0000	0.0000	-2.8972	0.0000	0	0.0000	Primary		
Tool #2	0.0000	0.0000	0.0000	0.0000	0	0.0000	Primary		
Tool #3	0.0000	0.0000	0.0000	0.0000	0	0.0000	Primary		
Tool #4	0.0000	0.0000	0.0000	0.0000	0	0.0000	Primary		
Tool #5	0.0000	0.0000	-2.0444	0.0000	0	0.0000	Primary		
Tool #6	0.0593	0.0000	-2.7845	0.0000	0	0.0000	Primary		

Input Input + Measure

Quit

Punch “Machine Pos Toggle” (Machine Position Toggle) yields this:



But tool 1 tip is ~ 1-3/16 from centerline.

“Go To Work Zero” puts tool 1 tip ~ 15/16 from end of round stock.