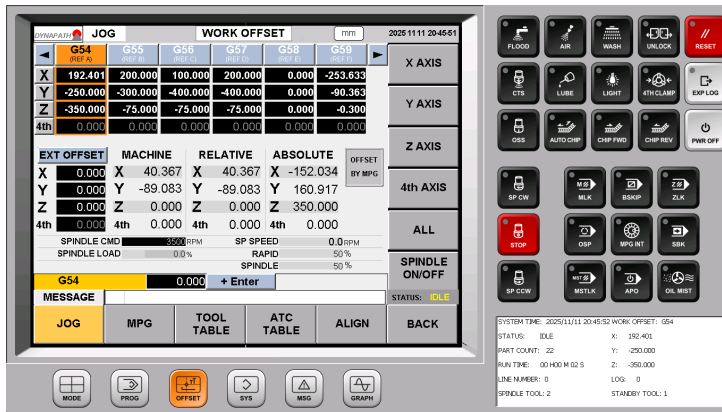


Setting Work Offsets (Part Zero)

DynaPath WinDelta CNC Mill Control · Operator Quick Guide

A work offset tells the control where part zero is. Programs call it with **G54–G59** (or G54.1 P1–P48 if extended offsets are fitted). After every RESET the control returns to G54. [4.10, 8.1]

The work offset screen — MODE → 6 OFFSET Manual 8.2



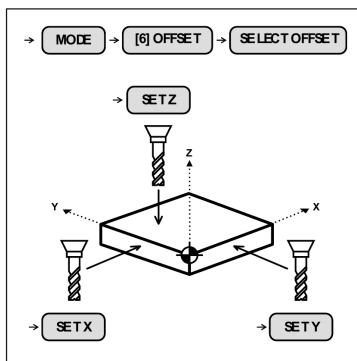
WORK OFFSET screen: X/Y/Z AXIS set buttons and ALIGN on the right [Fig. 8.2-1]

- 1 Select the work offset to set (G54–G59) with the arrows at the top of the table.
- 2 Load the reference tool or edge finder. Jog or MPG until it touches the part or fixture.
- 3 Press **X AXIS**, **Y AXIS** or **Z AXIS** on the right to set that axis' zero at the current position. Or type machine-coordinate values straight into the table.
- 4 If needed, use **EXT OFFSET** (EXOF5) to shift the zero. It applies on top of every work offset and is always active.

Choose where part zero goes Manual 8.2.1, 8.3

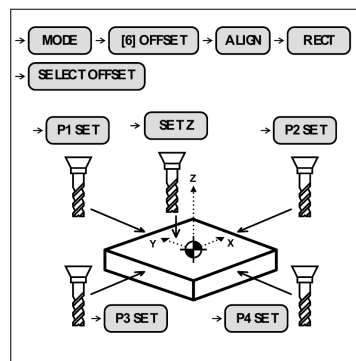
Part zero at	Path	Touch off
Any point (corner, edge)	OFFSET → select offset	Touch each face, press SET X , SET Y , SET Z
Centre of a rectangle	OFFSET → ALIGN → RECT	P1 SET to P4 SET on four sides, then SET Z on top
Centre of a circle / bore	OFFSET → ALIGN → CIRCLE	P1 SET to P3 SET at three points, then SET Z on top

SET PART ZERO TO ANY POINT



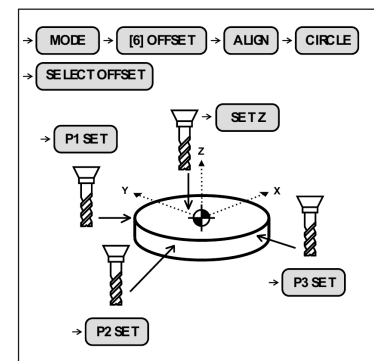
Any point [Fig. 8.2-2]

SET PART ZERO TO RECTANGULAR CENTER



Rectangle centre [Fig. 8.3-1]

SET PART ZERO TO CENTER OF CIRCLE



Circle centre [Fig. 8.3-2]

NOTE

Set tool lengths first (Guide 3). With Method B, always touch off Z with the reference tool. Check the program calls the same offset you set, e.g. G54.