SHERLINE PRODUCTS
INCORPORATED 1974

MASSO Machine Positioning Options

Machine Positioning Options for MASSO Accu-Pro Machines

You have several different options to move your tool to a designated position.

1. To move your tool to the "Program Zero Position," go to the F2 screen. Touch MDI (Manual data input). Then type in "G90 G00 X0 Y0 Z0," then touch "Run." This will move the current tool to the part "Zero" position in each axis, or any individual axis that you type in. (see Figure 1).
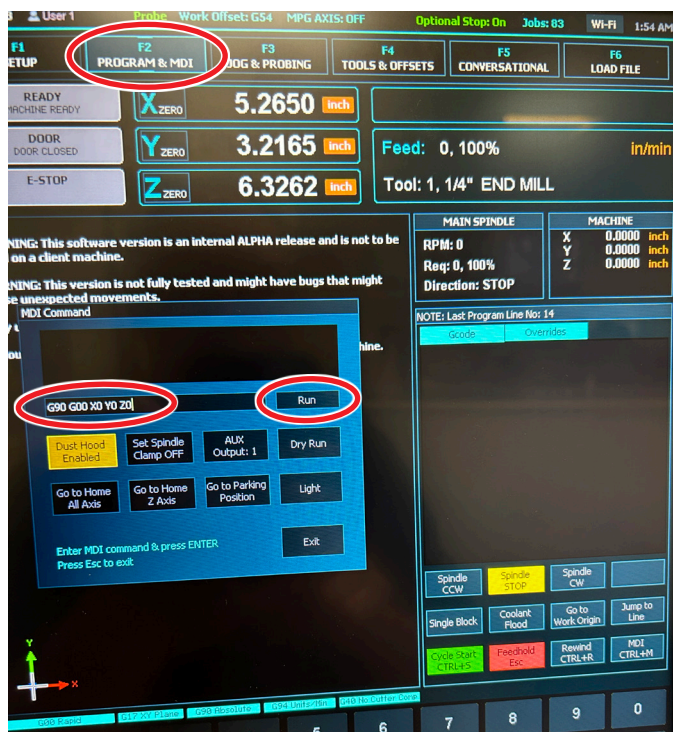

FIGURE 1—The red ovals indicate the touch-screen input areas.

2. If you want to move your axis to the "Machine Zero" position (to each homing switch), use the same MDI Command page and touch "Go Home Z Axis" for the Z-axis only (this is very useful), or touch "Go Home All Axis" and all axes will go to machine zero in the same order that the machine goes to home when you turn it on (see Figure 2).
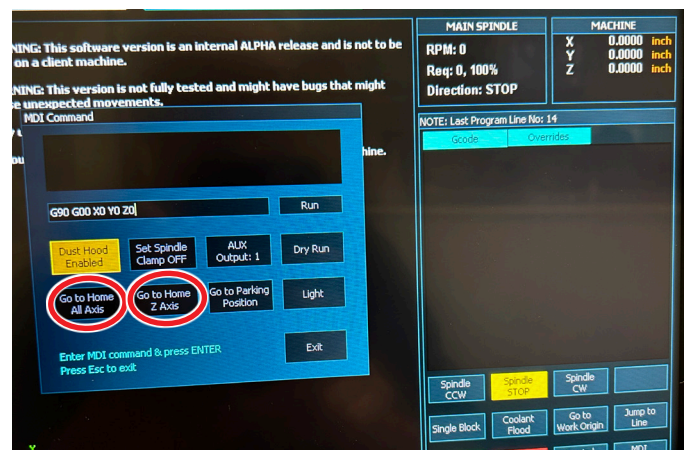

FIGURE 2

3. You can also set up a "Park Position" by moving your axis to a clearance position. Then write down the actual "Machine Position" for each axis (see Figure 4). Then enter these axis positions on the F4 screen. Double-tap the "Parking" line and enter the axis positions (see Figure 3).
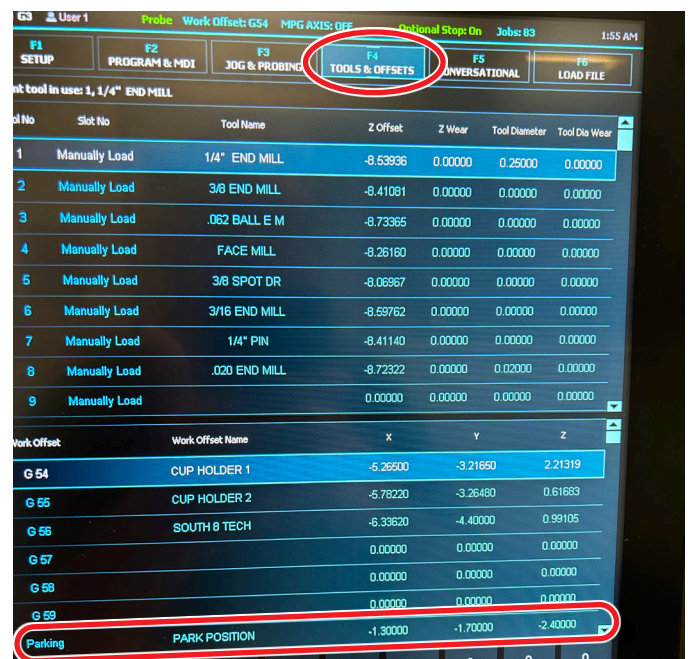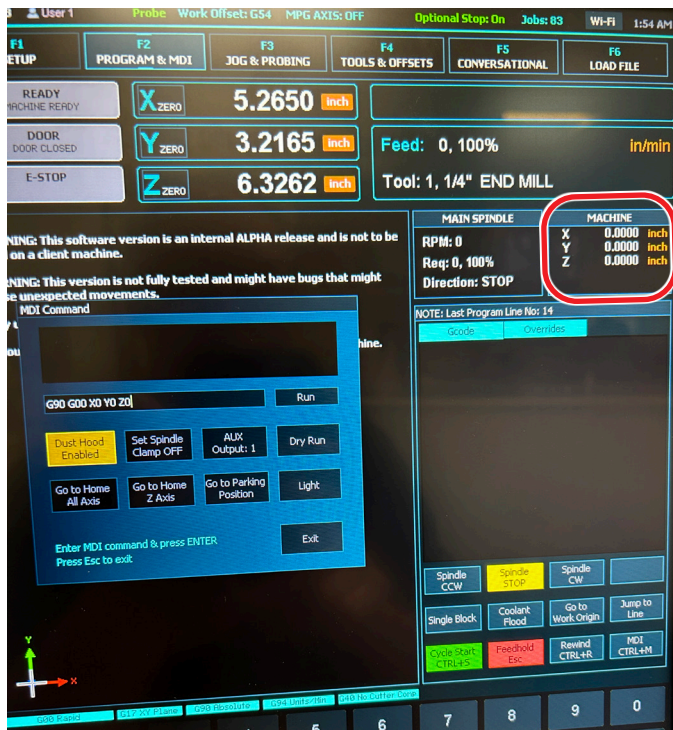

FIGURE 3—Park Position.

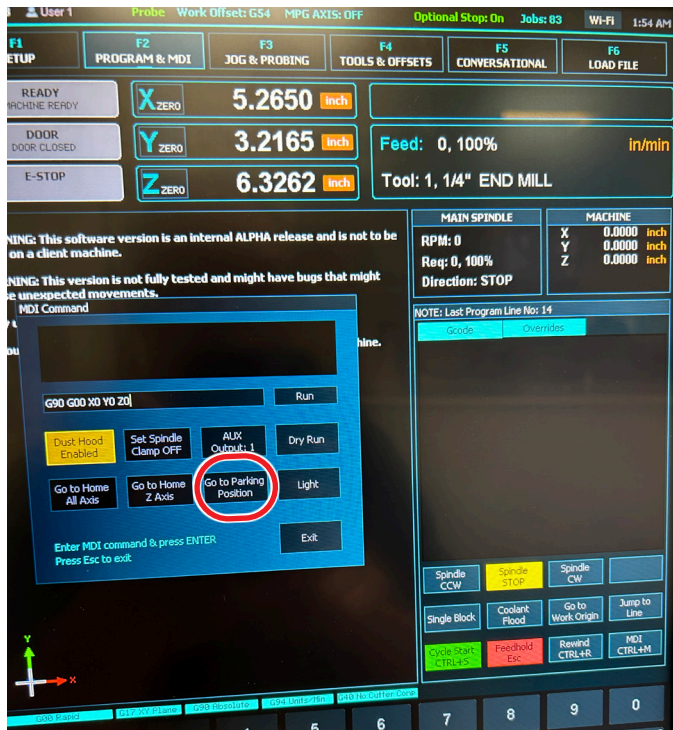*FIGURE 4—See the red outline for Machine axes positions.*

FIGURE 5—Go to Parking Position.

NOTE: You can also make your machine move to the park position by entering a "G30" in your program at any point in your program. This is generally done at the end of the program.

Thank you,
Sherline Products Inc.