



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).

B 🚨 User 1 Probe Work Offset: G54 MPG AXIS: OFF	Optional Stop: On Jobs: 83 Wi-Fi 1:54 AM
F1 F2 F3 F4 ETUP PROGRAM & MDI BOG & PROBING TOOLS & OFFS	SETS F5 F6 LOAD FILE
READY RACHINE READY X2ER0 5.2650 Inch	
DOOR CLOSED YZERO 3.2165 Inch	d: 0, 100% in/min
	I: 1, 1/4" END MILL
NING: This software version is an internal ALPHA release and is not to be on a client machine. NING: This version is not fully tested and might have bugs that might e unexpected movements.	MAIN SPINULE MACHINE RPM: 0 X 0.0000 inch Req: 0, 100% Z 0.0000 inch Direction: STOP
	NOTE: Last Program Line No: 14 Goode Overnidas
(690 G00 X0 Y0 20) Run	
Dust Hood Enabled Set Spindle AUX Clamp OFF Output: 1 Dry Run	
Go to Home All Axis Z Axis Go to Parking Position Light	
Enter MDI command & press ENTER Exit	
	Spindle Spindle Spindle CW Stop Constraints Go to Jump to
	Single Block Flood Work Origin Line
	CTRL+S ESC CTRL+R CINL+NV
Celo Raski G17 XV PLance G98 Rosolute G94 Units Itin 249 No Cution Con	7 8 9 0

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).

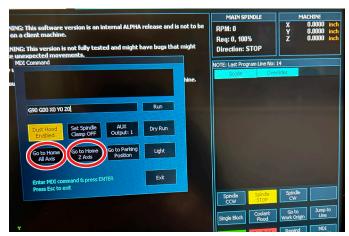


FIGURE 2

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).

F1	F2			onal Stop: On		1:55 A
SETU		1& MDI JOG & PROBING	F4 TOOLS & OFFSETS	ONVERS		F6 LOAD FILE
nt tool	in use: 1, 1/4" END M	m				
No	Slot No	Tool Name	Z Offset	Z Wear	Tool Diamet	er Tool Dia Wear 着
1	Manually Load	1/4" END MILL	-8.53936	0.00000	0.25000	0.00000
2	Manually Load	3/8 END MILL	-8.41081	0.00000	0.00000	0.00000
	Manually Load	.062 BALL E M	-8.73365	0.00000	0.00000	0.00000
	Manually Load	FACE MILL	-8.26160	0.00000	0.00000	0.00000
	Manually Load	3/8 SPOT DR	-8.06967	0.00000	0.00000	0.00000
	Manually Load	3/16 END MILL	-8.59762	0.00000	0.00000	0.00000
	Manually Load	1/4" PIN	-8.41140	0.00000	0.00000	0.00000
	Manually Load	.020 END MILL	-8.72322	0.00000	0.02000	0.00000
	Manually Load		0.00000	0.00000	0.00000	0.00000
lork Off	iset	Work Offset Name	×			z 📩
G 54		CUP HOLDER 1	-5.26500	-3.21	650	2.21319
G 55	5	CUP HOLDER 2	-5.78220	-3.26	480	0.61683
G 5	6	SOUTH 8 TECH	-6.33620	-4.400	000	0.99105
G 5			0.00000	0.000	00	0.00000
GS			0.00000	0.000	00	0.00000
GE			0.00000	0.000	00	0.00000
Parl		PARK POSITION	-1.30000	-1.700	00	2.40000

FIGURE 3—Park Position.

8 🚢 User 1 🛛 Pr	obe Work Offset: G54	MPG AXIS: OFF		Optional Stop: On	Jobs: 83	Wi-Fi 1:54 AM
F1 F2 ETUP PROGRAM			F4 LS & OFFSI	ETS CONVERSA		F6 LOAD FILE
READY HACHINE READY	Kzero 5.2	650 🔤				
DODR DOOR CLOSED	Yzero 3.2	2165 🔤	Feed	: 0, 100%		in/min
E-STOP	Z _{ZER0} 6.3	3262 🔤	Tool	: 1, 1/4" ENI) MILL	
NING: This software versi on a client machine. NING: This version is not a unexpected movemen	fully tested and might			MAIN SPINDL RPM: 0 Req: 0, 100% Direction: STO	X Y Z	MACHINE 0.0000 inch 0.0000 inch 0.0000 inch
MDI Command			ine.	NOTE: Last Program I	ine No: 14 Overrides	
G90 G00 X0 Y0 Z0 Dust Hood Enabled Cla	: Spindle AUX mp OFF Output: 1	Run Dry Run				
Go to Home Go	to Home Z Axis Go to Parking Position	Light				
Enter MDI command Press Esc to exit	l & press ENTER	Exit		Spindle	indle Spir	idle
				Single Block	iolant Go lood Work	Origin Line
+×				Cycle Start CTRL+5	edhold Rev Esc CTR	
G00 Rapid G17 X	Y Plane G98 Absolute	694 Units/Nin 640 Ho	6	7	8 9	0

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

3 🚨 User 1	Probe Work O	ffset: G54 I	MPG AXIS: OFF		Optional S	top: On Jol	os: 83	Wi-Fi	1:54 AM
F1 ETUP PROG	F2 RAM & MDI	F3 JOG & PROE		F4 .5 & OFF9	ETS CO	F5 INVERSATION	AL	F6 Load fil	E
READY MACHINE READY	XZERO	5.26	50 🔤						
DOOR DOOR CLOSED	YZERO	3.21	65 🔤	Fee	d: 0, 1	00%		i	n/min
E-STOP		6.32	62 🔤	Тоо	I: 1, 1/4	' END MI	LL		
NING: This software ve on a client machine. NING: This version is n te unexpected movem	not fully tested a				MAIN RPM: 0 Req: 0, 1 Directio		X Y Z	0.000	D inch D inch D inch
MDI Command	Set Spindle Clamp OFF Go to Home Z Axis Cond Cond Cond Cond Cond Cond Cond Cond	to Parking Position	Run Dry Run Light	ne.	NOTE: Last Good Spindle CCW Single Blo Cycle 23:6 Cycle 23:6	Spride STOP dt Coolert Flood	2 14 errides Spino Work O Rewit	o Jun rigin Li vd M tR	
G00 Rapid G1	7 XY Plane G98 B	osolute 694	Units/Min G48140	6	7	8	9		0

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.