



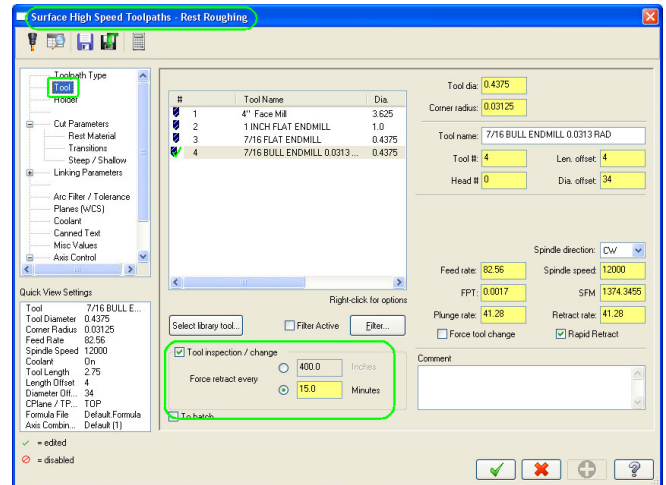
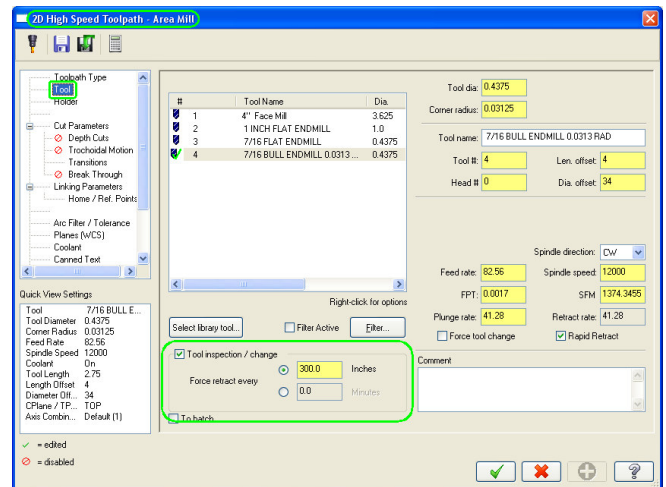
Services Four Automation

S4A Training Programs

Tool wear checking with HST

2D and 3D High speed toolpaths now offer an option to post retract moves and operator prompts for monitoring cutter performance.

You can choose to set the interval either by elapsed time in cut or distance travelled at feed rate.



*Inspection points are only created at the end of a cut pass.
Inspection points are not created along a cut even if the specified distance or time interval is reached.
Some users may need additional fine tuning of their post processors for optimized performance with this feature.
Contact S4A for more information...*

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N4886 X-2.094 Y-.5175 Z-.0037
N4888 X-2.0931 Y-.5217 Z.0029
N4890 X-2.0924 Y-.5252 Z.0099
N4892 X-2.0918 Y-.5279 Z.0172
N4894 X-2.0914 Y-.5299 Z.0248
N4896 X-2.0911 Y-.5311 Z.0326
N4898 X-2.091 Y-.5315 Z.0404
N4900 G0 Z3.
N4902 X-2.2808 Y-.4569
N4904 M00 (TOOL INSPECTION POINT - POST CUSTOMIZATION REQUIRED)
N4906 Z.0654
N4908 G1 Z.0404 F41.28
N4910 X-2.2807 Y-.4573 Z.0326
N4912 X-2.2805 Y-.4585 Z.0248
N4914 X-2.28 Y-.4604 Z.0172
N4916 X-2.2794 Y-.4632 Z.0099
  
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