Setting Tool Lengths on the HAAS MiniMill

1. Remove any tools from the mill spindle.
2. Set a 1-2-3 Block or the 2” Electronic Preset Gage either on top of the workpiece, or on the vise.
3. Using the HANDLEJOG carefully bring the nose into contact with the block or electronic gage (the LED will light).

To Origin the POS-OPER Display - This display is used for reference only. Each axis can be zeroed out independently, to then show its position relative to where you selected to zero that axis.

4. To zero out a specific axis, PAGE UP or PAGE DOWN in the POSIT display to the POS-OPER large-digit display page. When you HandleJog the X, Y or Z axis and then press ORIGIN, the axis that is selected will be zeroed. Zero out the Z axis. (Or, you can press an X, Y or Z letter key and then ORIGIN to zero that axis display.)
5. Make sure the Z axis is current and carefully HANDLEJOG up in the Z axis.
6. Insert Tool #1 and carefully HANDLEJOG the tip of the tool to the top of the setup block or the Electronic Preset Gage.
7. Observe the Z axis value on the POS-OPER large-digit display page.
8. Type this value in using the numeric keypad.
9. Press the OFSET button and page to the tool #1 offset register, and place the cursor under length.
10. Press F1 to enter the value into the Tool Length register area.

OFSET

• Entering Offsets - Pressing WRITE/ENTER will add the number in the input buffer to the cursor-selected offset value. Pressing F1 will replace the selected offset with the number in the input buffer.
• Entering Offsets - Pressing OFSET again will toggle back and forth between the Tool Length Offsets and Work Zero Offsets pages.
• Entering Offsets - In the OFSET display, F1 will set the entered value into the offsets. F2 will set the negative of the entered value into the offsets.