CAPSturn post configuration

for linear tooling machines

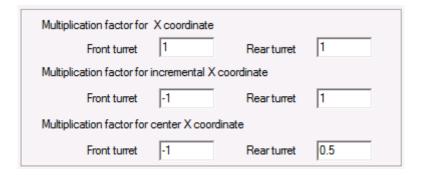
On a typical lathe with a turret type tool changer, there is a single turret that is at the rear or in front. On a linear tooling lathe, some of the tools will be used at the rear and some in front. Rear and front refer to the upper and lower part of the axis, looing from the operator's position. The signs of the X coordinate are different for these cases. Also, CAPSturn checks for tool numbers being beyond the machine's range, so the range of tool numbers for the front and rear turret must be specified.

You need to make changes in these areas to configure for lathes linear tooling:

- Machine mechanical data
- Tool numbers
- Signs of X coordinate for front and rear turret
- Circular interpolation commands
- 1. Click on Machine data and select Turret position as Both.
- 2. Click on General program format → Tool and offsets and enter the values as shown below.



3. Click on Tool motions tab and enter the multiplication factors for the X coordinate. Default signs of X coordinate are + for rear turret and - for front turret. Enter -1 if you want a sign to be reversed.



4. Click on G codes and specify the codes for CW and CCW motions for the front and rear turrets.

