

When exceeding **Lower Limits**, look for the value in the ISO limit row from X,Y, and Z that is **lower** than the machine limit.

In this scenario the lower limit causing the error is in **Z**. To fix the problem we must take the Machine limit and subtract it from the ISO limit.

Machine Limit: 10.591

ISO Limit: -10.012

Solution= Add 0.579 to plunge depth value in Alphacam

In **Alphasoft** from the main screen go ahead and **Purge Cuts** then go to **Cut Parts>Cut Parameters>Straight Line Cuts>Plunge Depth**

Example: If my Plunge Depth is set at -3.5 we must add 0.579 to plunge depth to get **-2.921** (negative value means add to achieve correct value)

After changing your plunge depth go ahead and hit cut parts to retool path and when finished Output NC and try the program at the saw again.

NOTE: When reducing your plunge depth you must pay attention to overcuts. Watch the simulation because you may need to offset your geometry more to account for the smaller plunge depth.



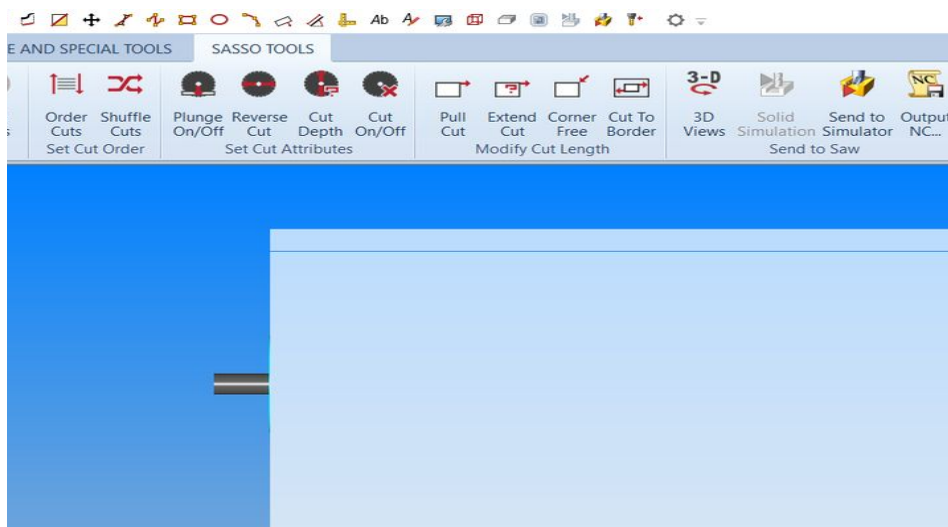
When exceeding **Lower Limits**, look for the value in the ISO limit row from X,Y, and Z that is **lower** than the machine limit.

In this scenario the lower limit causing the error is in **Y**. To fix the problem we must take the Machine limit and subtract it from the ISO limit.

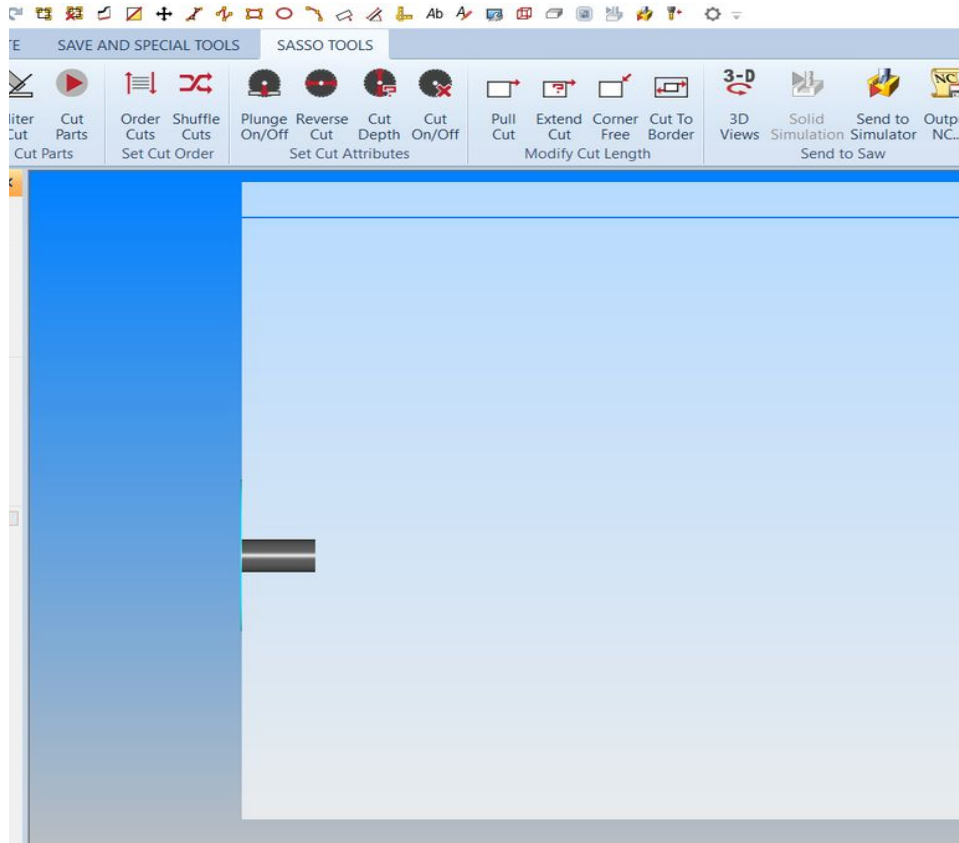
Machine Limit: 0
ISO Limit: -.471

Solution=

1. Verify your machine is at P1.
2. Watch the simulation in Alphasoft to verify the motor is not off the table. If the motor is not on the inside of the table you must reverse the cut.
3. If the motor position is correct check for cuts that are extending far (Roughly 4"-5") past the table.
4. Finally, if motor position is okay and your cuts are not far off the table you must move your geometry **positive Y** in Alphasoft by .471.

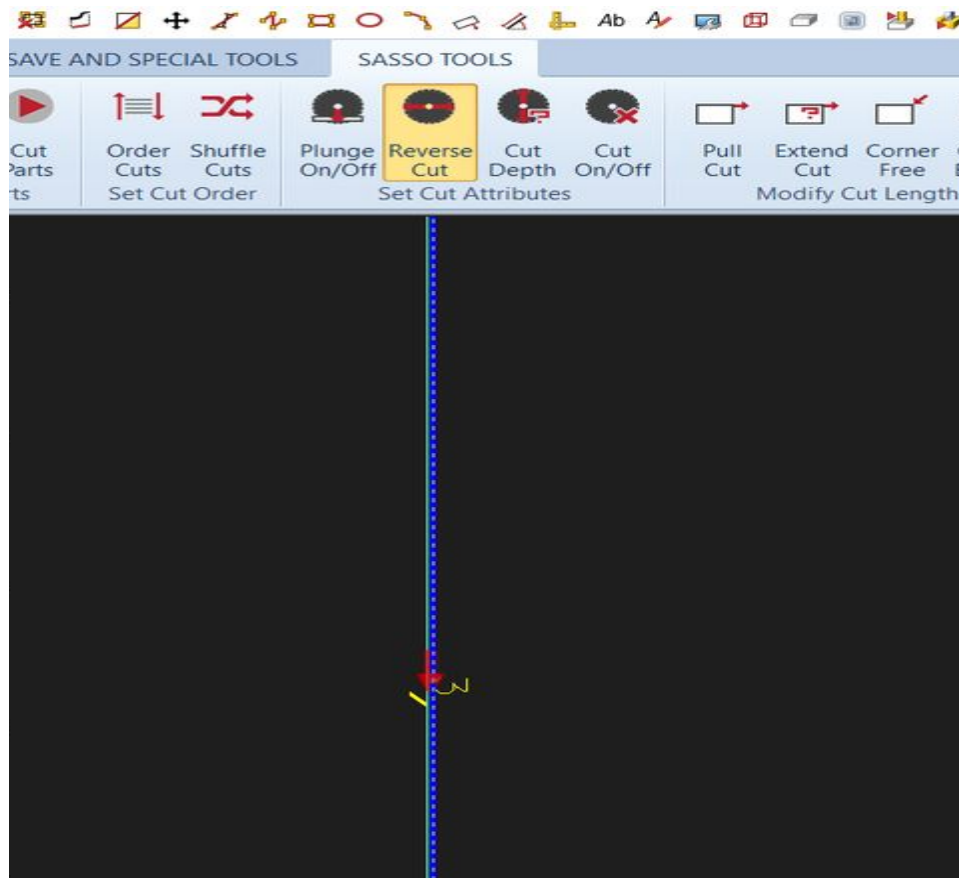


Incorrect with motor hanging off of the table. This will cause your file to exceed limits.

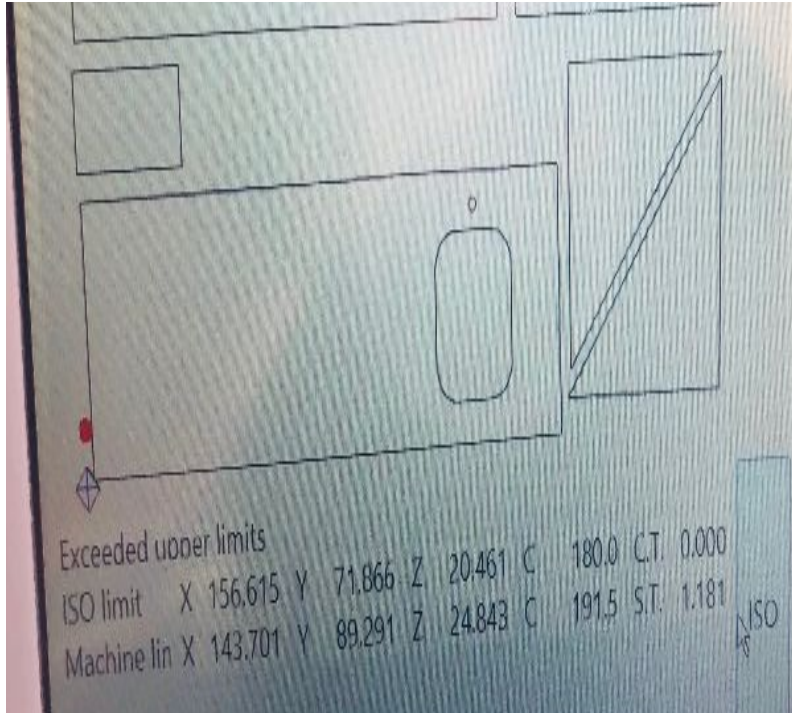


Correct motor position over table.

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To reverse the cut select **“Reverse Cut”** under Sasso Tools then select the cut you want to reverse.



When exceeding **Upper Limits**, look for the value in the ISO limit row from X,Y, and Z that is **Higher** than the machine limit.

In this scenario the upper limit causing the error is in **X**. To fix the problem we must take the Machine limit and subtract it from the ISO limit.

Machine Limit: 143.701
ISO Limit: 156.615

Solution=

1. Verify your machine is at P1.
2. Watch the simulation in Alphacam to verify the motor is not off the table. If the motor is not on the inside of the table you must reverse the cut. (Seen in pictures above)
3. If the motor position is correct check for cuts that are extending far past the table.
4. Finally, if motor position is okay and your cuts are not extended far off of the table (Roughly 4"-5") you must move your geometry **negative in X** in Alphacam by -12.914