FINGERBIT ALIGNMENT

1. In Alphacam draw a 20x20 rectangle, then insert and offset of 1" as geometry inside your rectangle to simulate an internal cut. sink cut-out with a 3" radius on 2 of the 4 corners. Measure the amount the finger-bit digs into the top, outside the blade kerf and correct the finger-bit accordingly.

2. Find :C:\Alphacam\LICOMDAT\SPosts.Alp\SASSOMECCANICA (open with Alphaedit)

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            :ADDED X_SHIFT TO ACCOMIDATE TOOLING SHIFT FOR MILLING TOOLS
            :ADDED FEED RATE SETTING TO COMPENSATE FOR MISSING FEED
      :Added shift for Mill tool\core
      :added Pat(101) to frack saw angle and set angle
      :added Rotation line to make sure angle is picked up at rapid
      :CONVERT VALUES TO MM
$------------------------- PROGRAM LEADING/TRAILING LINES -------------------
$5
$STORE C:\ALPHACAM\LICOMDIR\SUPPORT.OUT
$---------------------- LINEE INIZIALI/FINALI DEL PROGRAMMA -----------------
$10 Linee iniziali del file
''***** SET THE FOLLOWING 2 VALUES BASED ON THE CURRENT MACHINE PARAMETERS******
''
$LET SHIFT_FOR_MILL = 84.7598        ''ADJ X axis Position of Fingerbit or Core
$LET MACHINE_OFFSET = -139.904       ''ADJ Y axis Position of FingerBit or Core
$LET SCA_FAC = 25.4                  ENTER SCALE FACTOR FOR OUTPUT  IE 25.4 WILL S
''
''
''
```

NOTE: Most of these files are in Millimeters (as seen above) if your values are much smaller, than your file is in inches.

NOTE: To move the Fingerbit in the negative direction subtract from the value.

Example: Needing to shift Fingerbit left (negative in X) 1/8th. We would take 1/8= .125 X 25.4= 3.175mm

Then we would subtract from our value found in our file:

84.7598 - 3.175 = 81.5848

So we would insert our new value for X then save and close the file.

NOTE: To move the Fingerbit in the positive direction add to the value.

NOTE: You must have all instances of Alphacam closed when making changes to the Post.

3. Now draw another sink cut-out to verify your alignment changes are correct.