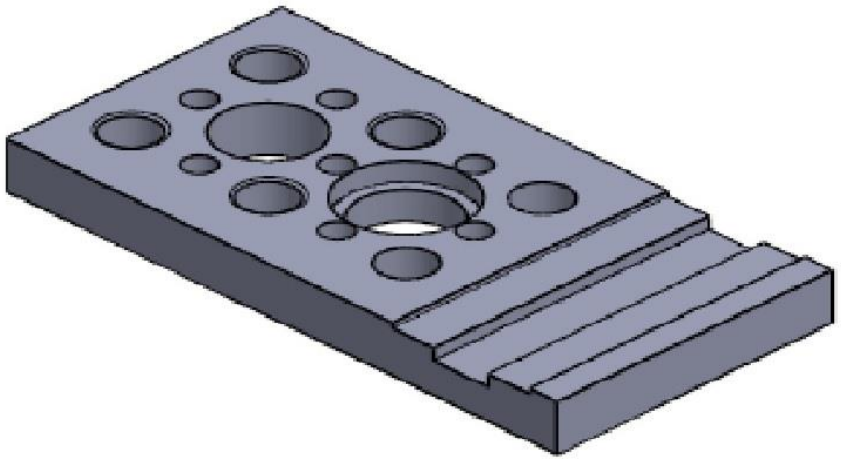
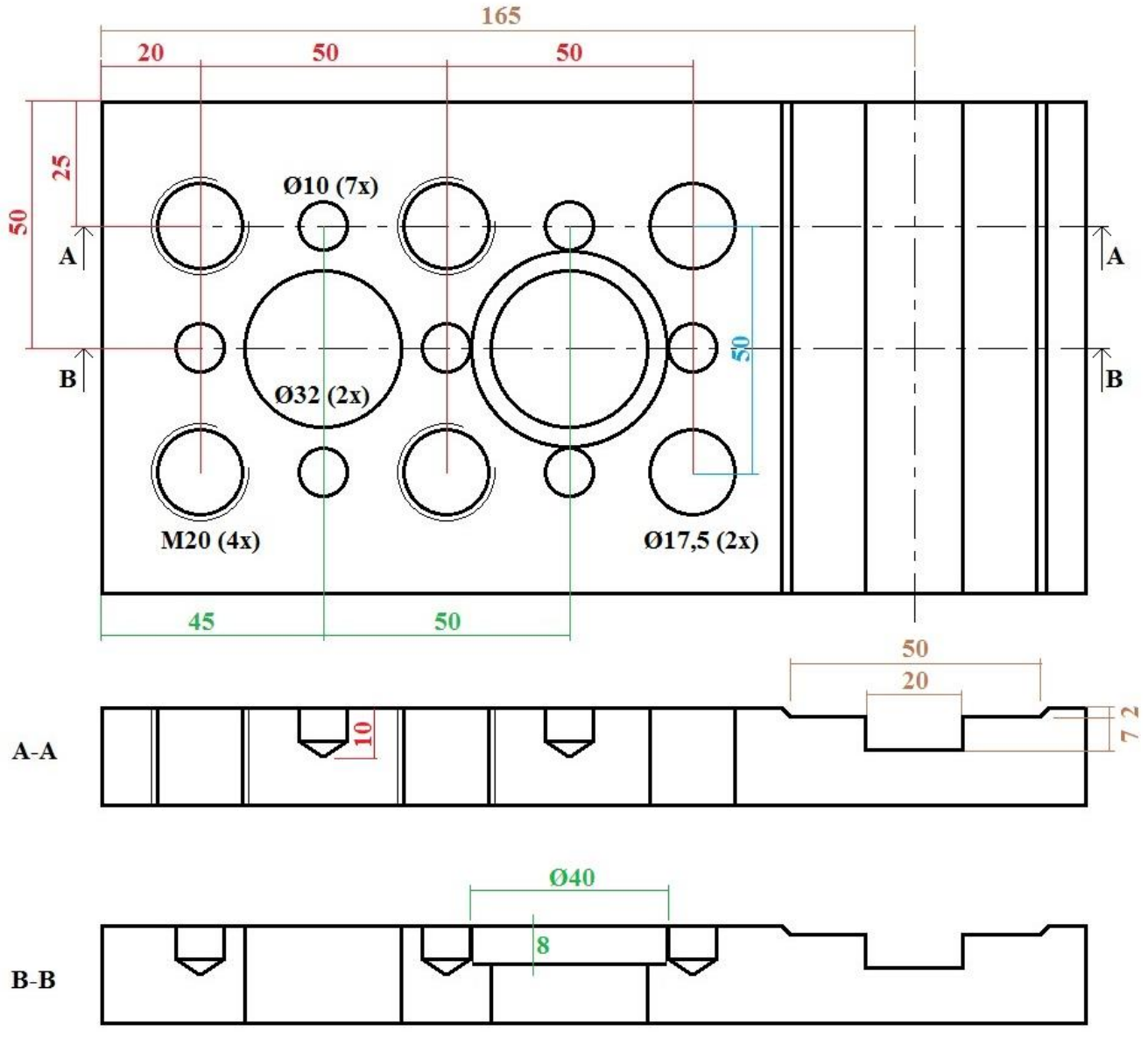
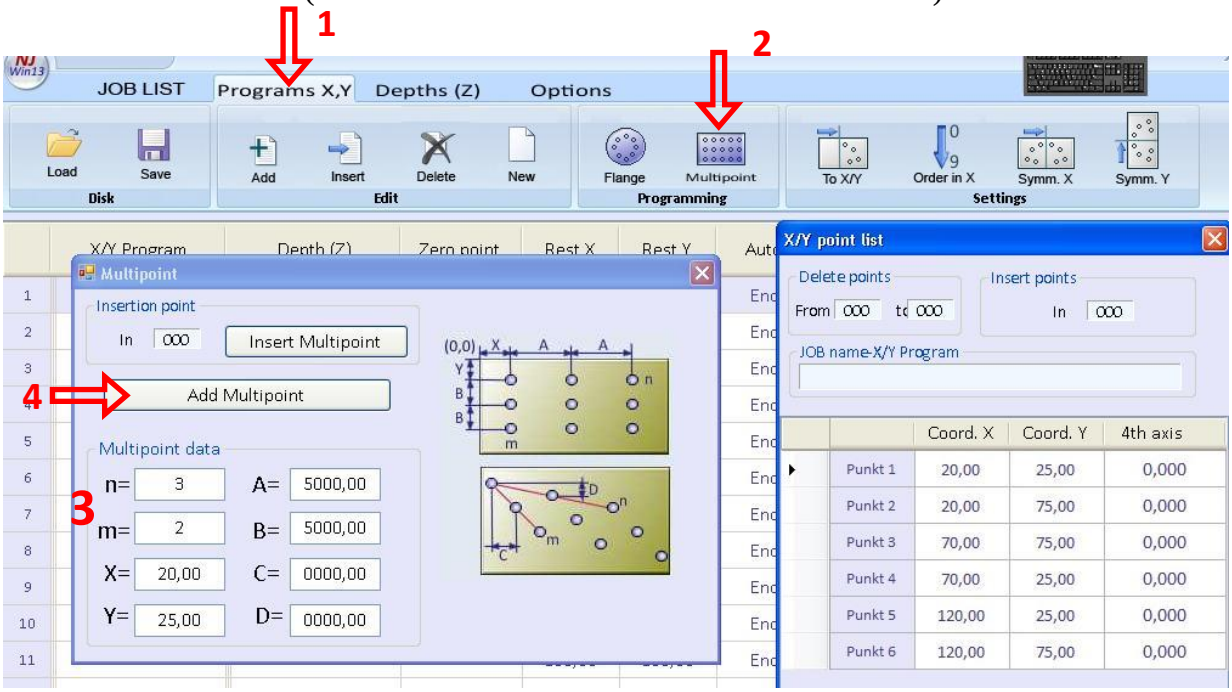
**Example Drawing—Part Number 2458:**





**1st line to program:**

**Drill 6 holes 17.5 mm** (of which 4 will be countersunk & threaded M20)

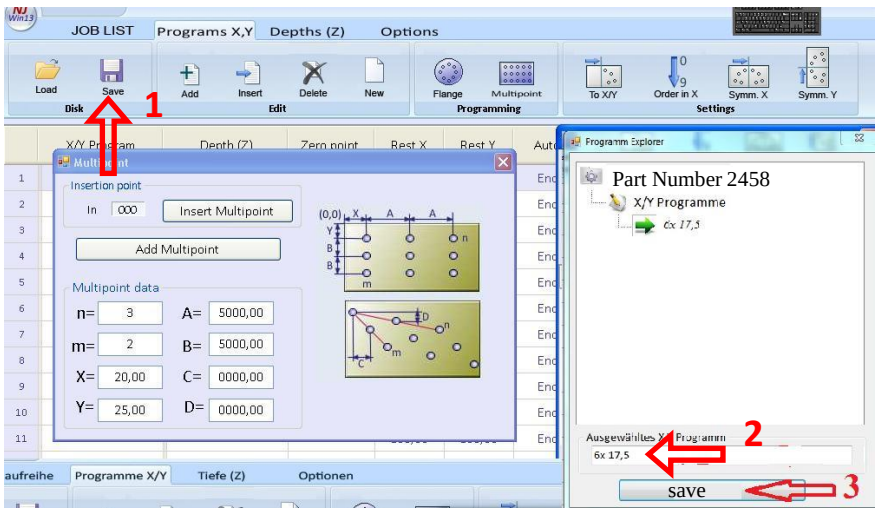



1. Enter **programs X / Y** button (XY Empty list comes up)
2. Press button **Insert Multipoint**
3. Enter the **data** (see below)
4. Press button **Add Multipoint** (coordinates appear in the X / Y-list)

Meaning entered data:

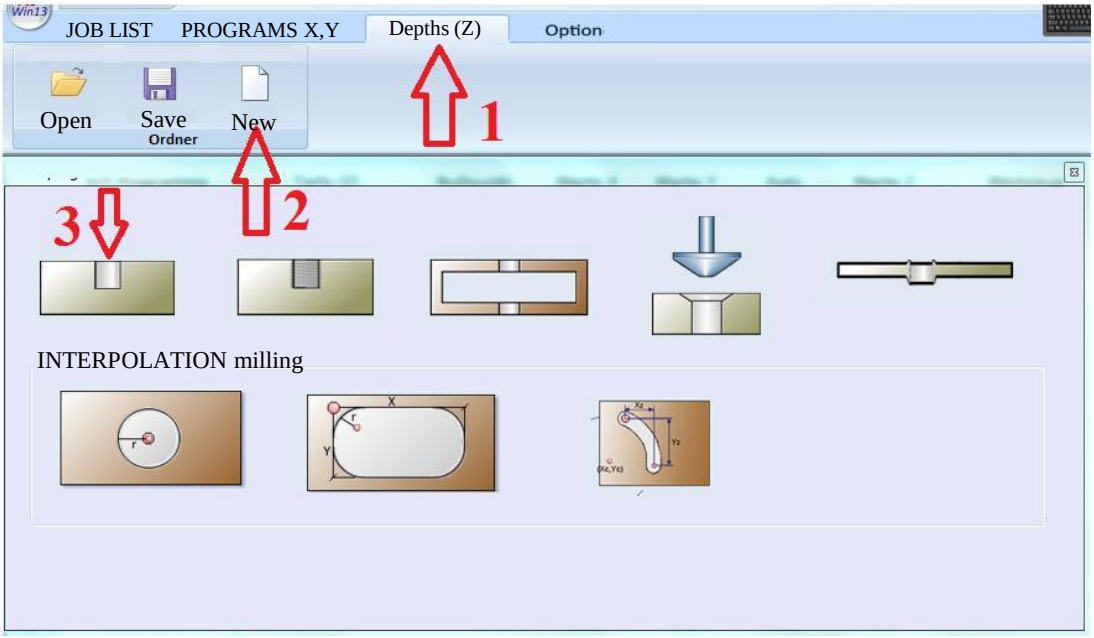
n = Number of holes in X-direction = 3
m = Number of rows in Y direction = 2
X = Position 1st hole in X measured from the part zero position = 20.00
Y = Position 1st hole in Y measured from the part zero position = 25.00
A = Hole spacing in X direction = 50.00
B = Hole spacing in Y direction = 50.00

Save program



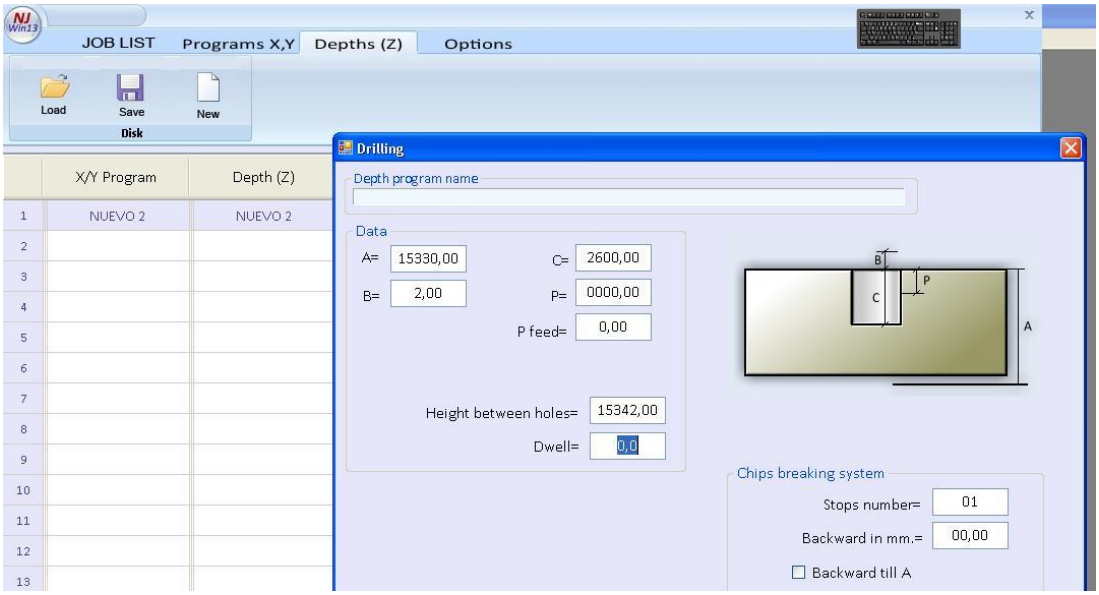

1. Press **Save** (List appears)
2. Add **Logical Name** (6x 17.5)
3. Press **Save** button.

Depth program (= type of machining)




1 Press **depth (Z)**
2 Press **NEW**
3 Press **Drilling**

Menu appears: Drilling




Enter data:
A = **Product Height** above the table (= top clamping fixture + material thickness)
B = **Safety distance** (with drilling it is 2-3 mm)
C = **Depth** (in through holes material thickness + 0.3x drill diameter)
P = Feed rate desired other than what is programmed in the tool library
example: helps with initial penetration without allowing the drill to walk/slip.

*Program is saved as described in X / Y program, logical name is 17.5*