

Jog an Offset Before Making a Cut

Pause and set and offset before a cut

This feature is very useful on large pipe that is out of round, or is distorting out of round as it is being turned.

By checking the Pause to set Offset box, the machine will pause and allow you to jog in an offset (typically about the pipe) to correct for pipe distortions.

The screenshot shows the 'Load To Machine' window with the following details:

- Load Part:** 44
- Instructions:** To increase bevel cut accuracy, enter the true dimensions of the actual pipe
- Range Limits:** 29.400 to 54.600
- Pipe Outer Diameter:** 42.000
- Pipe Wall Thickness:** 1.750
- Last Cut Is In Chuck:** ☐ ?
- Cuts Table:**

Cut Order	Cut Type	Cut Name	Skip Cuts	Pause to set offset
1	Straight	Right Endcut	<input checked="" type="checkbox"/>	<input type="checkbox"/>
2	Hole	N16C	<input type="checkbox"/>	<input type="checkbox"/>
3	Hole	N13	<input type="checkbox"/>	<input type="checkbox"/>
4	Hole	N6	<input type="checkbox"/>	<input type="checkbox"/>
5	Hole	N12	<input type="checkbox"/>	<input type="checkbox"/>
6	Hole	N15	<input type="checkbox"/>	<input type="checkbox"/>
7	Hole	N17	<input type="checkbox"/>	<input type="checkbox"/>
8	Hole	N16B	<input type="checkbox"/>	<input type="checkbox"/>
9	Hole	M1	<input type="checkbox"/>	<input type="checkbox"/>
10	Hole	N8A	<input type="checkbox"/>	<input type="checkbox"/>
11	Hole	N8B	<input type="checkbox"/>	<input type="checkbox"/>
12	Hole	N3	<input type="checkbox"/>	<input type="checkbox"/>
13	Hole	N14	<input type="checkbox"/>	<input type="checkbox"/>
14	Hole	N16A	<input type="checkbox"/>	<input type="checkbox"/>
15	Hole	N9B	<input type="checkbox"/>	<input type="checkbox"/>
16	Hole	N9A	<input type="checkbox"/>	<input type="checkbox"/>
17	Hole	N2	<input type="checkbox"/>	<input type="checkbox"/>
18	Hole	N11B	<input type="checkbox"/>	<input type="checkbox"/>
19	Hole	N11A	<input type="checkbox"/>	<input type="checkbox"/>
20	Hole	N4	<input type="checkbox"/>	<input type="checkbox"/>
21	Straight	Left Endcut	<input type="checkbox"/>	<input type="checkbox"/>

Torch Alignment: Align torch centerline at least one kerf width in from pipe end

Go to Machine Settings to change Beam Divergence, Torch Kerf, Lead In distance, Early Off and other torch settings

Buttons: Load Machine, Cancel Load

Another related feature:

Skip Cuts

You can select cuts to skip. This can be useful when you cut part of the part and had a problem. It is easy to reload up to the cuts you have not done.

You can still skip the first and last cuts as you would if you have a pre-cut pipe shell. See next diagram for the feature.