

**CNC SYSTEM**

**OSP-P300S/P300M/P300S-e/P300M-e**

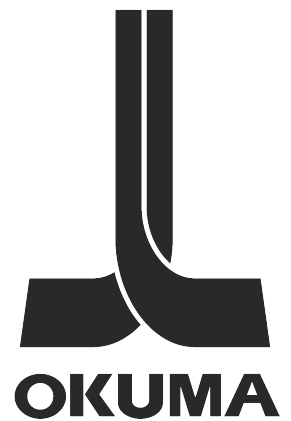
**OSP-P300SA/P300MA/P300SA-e/P300MA-e**

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**SPECIAL FUNCTIONS MANUAL No. 2**  
**(14th Edition)**

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### 3-4. Setting Nose Radius Compensation Value and Position Number

The cutter radius compensation value and the the nose R compensation value are treated the same. Set the position no. to set the nose R compensation value and the center of the nose R on the setting screen (TOOL OFFSET/COMPENSATION screen) below. It is also possible to set the position no. to DA, DB, and DC by setting NC optional parameter bit No.115 Bit4 to ON. When setting the position no. DA, DB, and DC, use the TOOL DATA screen.

**Note**

If the setting of NC optional parameter bit No.115 Bit4 is changed, the power must be cycled.

**Setting procedure:**

**Procedure :** \_\_\_\_\_

- 1** Select tool data setting mode.
- 2** Have the tool length offset and tool radius compensation screen shown below displayed using the ITEM keys for tool data display.
- 3** Using the page key, have the screen for the desired nose radius compensation number displayed.
- 4** Using the cursor keys, move the cursor to the data setting position for the nose radius compensation number.
- 5** Set the desired nose radius compensation amount.  
[The setting of the nose radius compensation amount is completed.]
- 6** Move the cursor right to the position number setting position (the position of P).