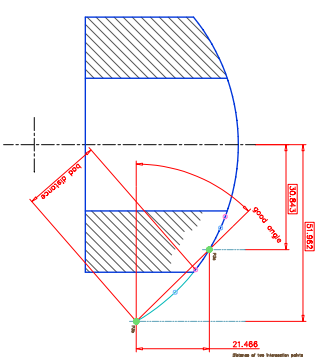
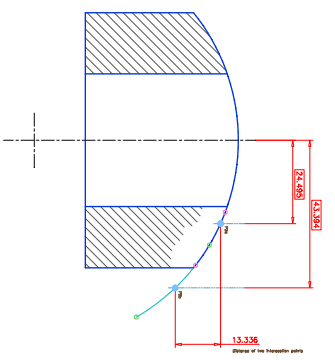
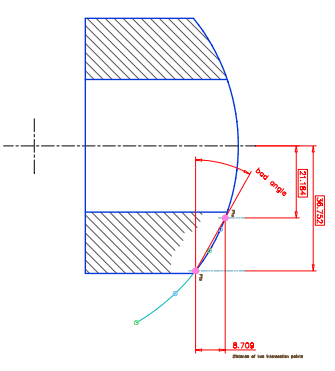
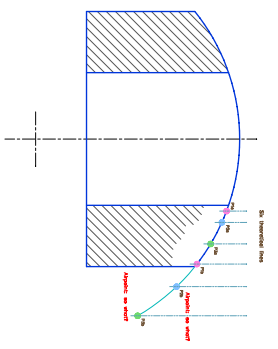
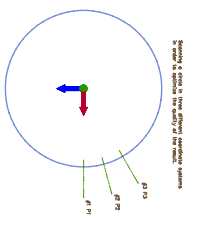
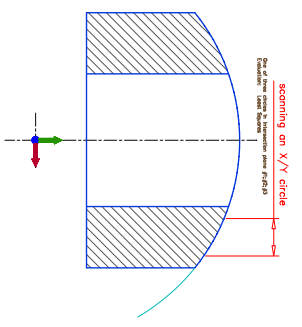
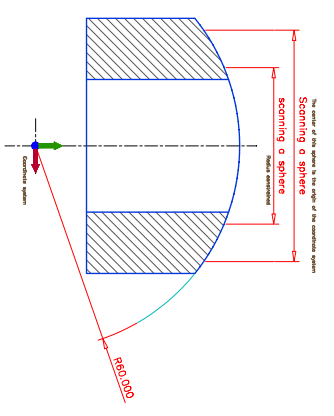
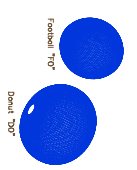


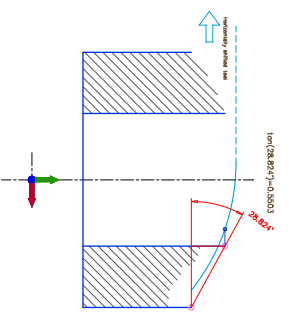
# Dealing with the "FO-D0"-problem

Or: give the machinist what he needs



Report			
	Actual	Nominal	Deviation
r1	8.718	8.709	0.009
r2	13.372	13.356	0.036
r3	21.532	21.486	0.066
x			0.037

A positive value indicates that the tool is shifted in the direction of the X-axis.  
Multiple steps required



Horizontal correction of tool position:  
 $\Delta x = 8.718 - 8.709 = 0.009$   
 $\Delta y = 13.372 - 13.356 = 0.036$   
 $\Delta z = 21.532 - 21.486 = 0.066$