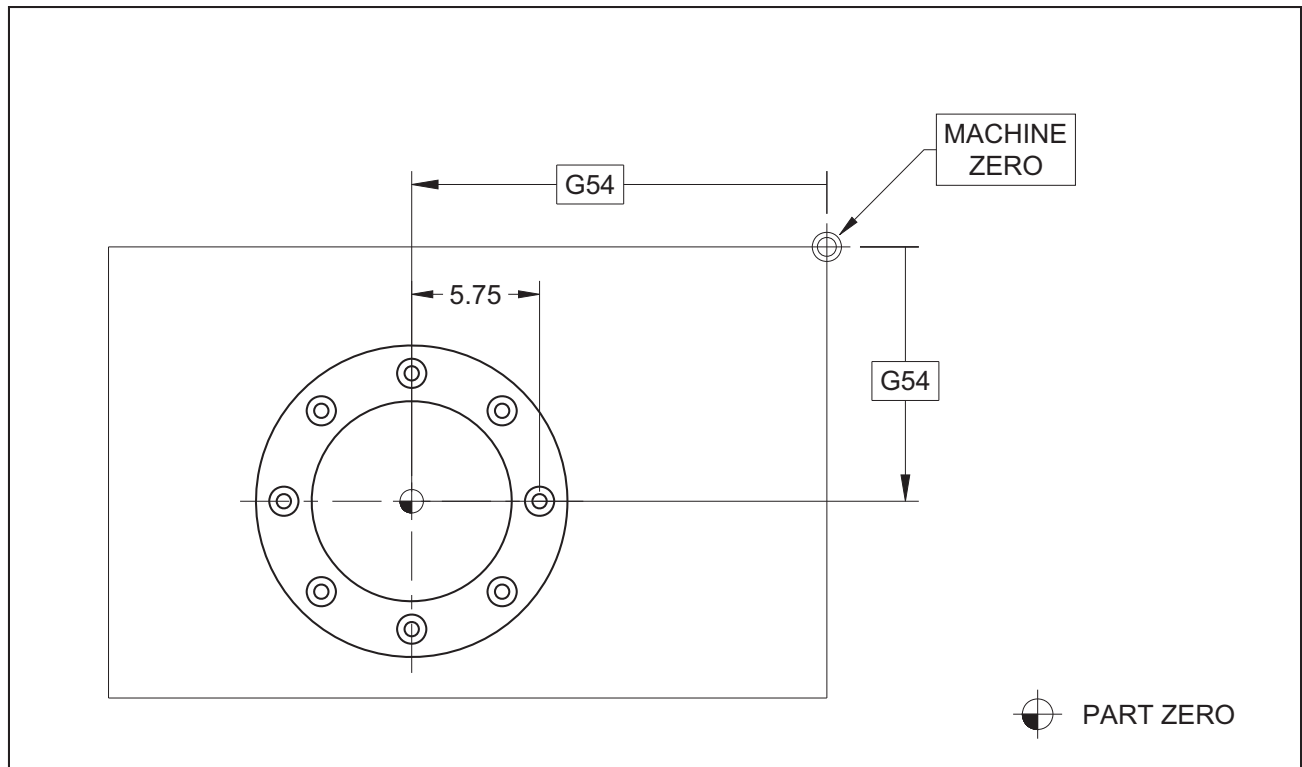


Applying Work Offset

1. The first part of the project solution is shown in the illustration below:



2. The second part is the program development block:

```
N17 G90 G54 G00 X5.75 Y0 S1300 M03 T06
```