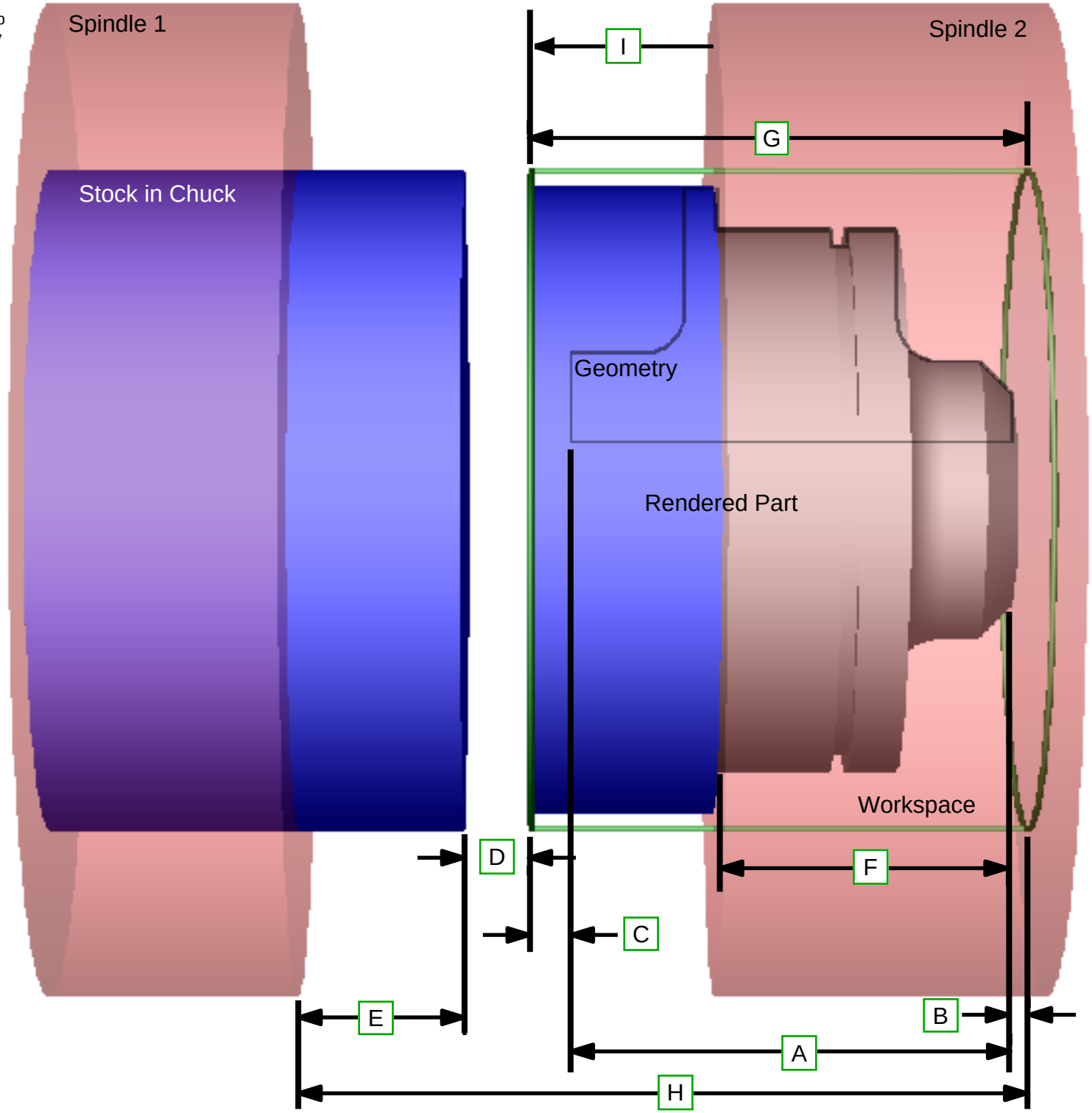
This image represents a part. The sub spindle is gripping the part and a cut off has been done. The sub spindle has not yet returned. You can see the partially cut part, the geometry, workspace and stock in the chuck as well as the spindles.

- What is the distance of the part face from Z0? (pos. or neg. # is okay) **0.0000**
- What is the length of the part geometry? See A **4.0000**
- What is the facing allowance on Spindle 1? See B **0.1500**
- What is the facing allowance for Spindle 2? See C **0.1500**
- What is the width of the cut off? See D **0.3170**
- What is the cut off clearance? See E **0.4250**
- How far on the part does the sub Spindle grip (what is the Grip Z value)? Enter a positive number. See F **1.5000**

Results	
Total length of the stock (see G):	4.3000
Part face distance from spindle face (see H):	5.0420
Distance to feed the stock on reload:	4.6170
Amount part sticks out of Sub Spindle (see I):	2.6500