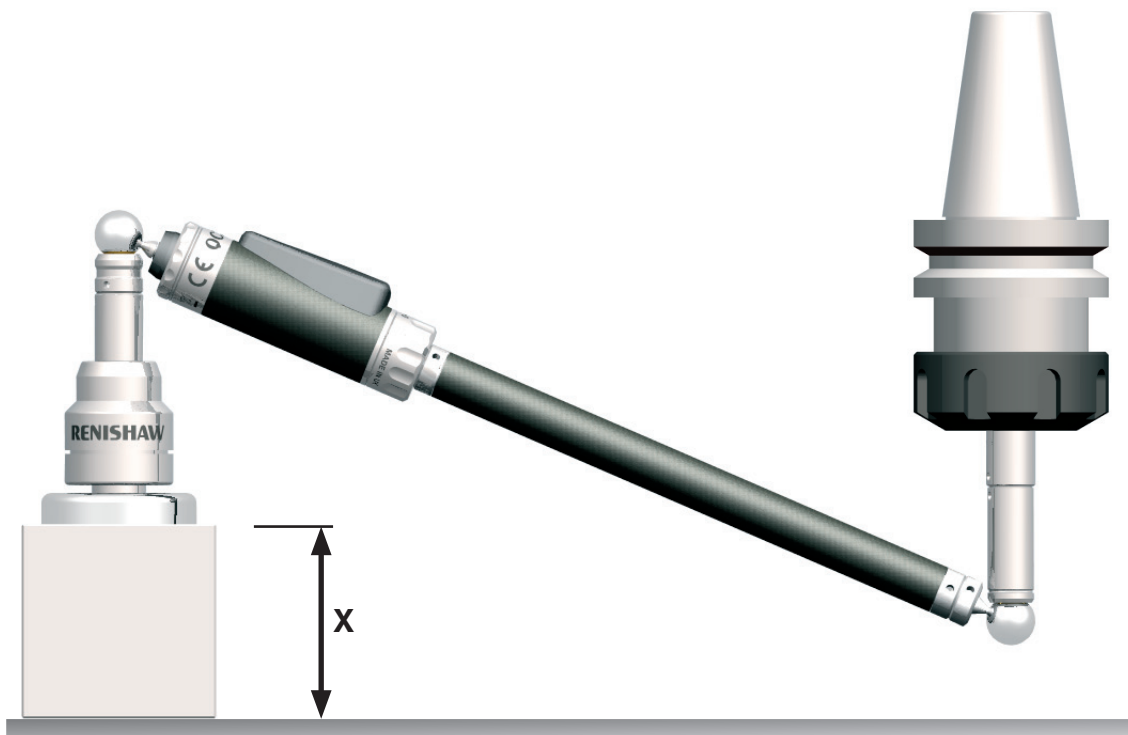


# Risers for partial arc tool paths

## Overview

Partial arc testing can be performed using ballbars of up to 150 mm in length with no additional components. For longer ballbars a riser block must be used under the centre pivot to prevent a collision with the machine bed.



Ballbar length (mm)	Riser block height 'X' (mm) minimum
100	Not Required
150	Not Required
250	38
300	56
400	94
450	112
550	150
600	169

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