



# Retract

Sets the height that the tool moves up to before the next tool pass.

☒ Retract...

☒ Absolute  
☐ Incremental  
☐ Associative

(0)  

| Setting / Parameter                                  | Affect   |
|--|--|
| Chained Geometry Location                            | No direct affect on Clearance.   |
| Clearance Value                                      | No direct affect on Clearance.   |
| Feed Plane Value                                     | No direct affect on Clearance, Retract Plane should be above the Feed Plane.   |
| Top of Stock Value                                   | Will affect Retract Height if Retract is set to incremental.   |
| Depth Value  | No direct affect on Clearance.   |
| Absolute setting                                     | Retract is set at a specific height relative to origin. The Retract Height is at a fixed location and can only move if the origin is changed or modified.                      |
| Incremental setting                                  | Retract is a distance from the Top of Stock. The Retract Height only moves if the Top of Stock moves.  |
| Associative setting                                  | Retract is a distance from a selected point in the file. The Retract will change if the location of this point changes.  |
| Clearance Disabled                                   | The operation will still use a Clearance Height but the value used will come from the Retract setting. If Retract is disabled as well, Feed Plane Height will be used instead. |
| Use Clearance Only at the Start and End of Operation | Retracts within the toolpath will use the Retract Height instead of the Clearance Height if enabled. If disabled, all retracts will go to the Clearance Height.                |