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## Procedure for Axis Re-Homing 0 Controls

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### Axis Re-homing 0 Controls 300APZ

1. For a 0-M control, press DGNOS/PARAM hard key.
2. Press PARAMETER softkey. You will now be on a screen that says SETTING 1.
3. Press PAGE DOWN key to get to SETTINGS 2 page.
4. Cursor up or down to get to PWE.
5. Press MDI key.
6. Press number 1 and then INPUT.
7. You will get PS 100 alarm, hold cancel and press reset to clear.
8. Press DGNOS/PARAM hard key.
9. There are scribe lines on each axis that line up the machine home positions. Locate the one for the axis you are homing.
10. The axis that is being homed must be at least 3 inches away from machine (scribe mark) home in the negative direction when starting. Jog or MPG axis to scribe mark in positive direction only to the scribe mark. If you go past, jog it back and start over.
11. Make sure specific parameter for axis being homed is turned to a zero.

Example:

OMC control: Parameter #22 bit 0, 1 and 2 are for X, Y and Z.

00000111

The #1 at the right is X', moving to the left, Y then Z

12. You will see a 000 PS alarm when changing these parameters. This means to cycle CRT power on and off.
13. .
14. When at scribe mark, change parameter back to 1. 000 PS alarm will want you to cycle power again.
15. Press DGNOS/PARAM hard key.
16. Disable PWE. Press PARAMETER softkey. You will now be on a screen that says SETTING 1.
17. Press PAGE DOWN key to get to SETTINGS 2 page.
18. Cursor up or down to get to PWE.
19. Press MDI key.
20. Press number 0 and INPUT.
21. Check home position.