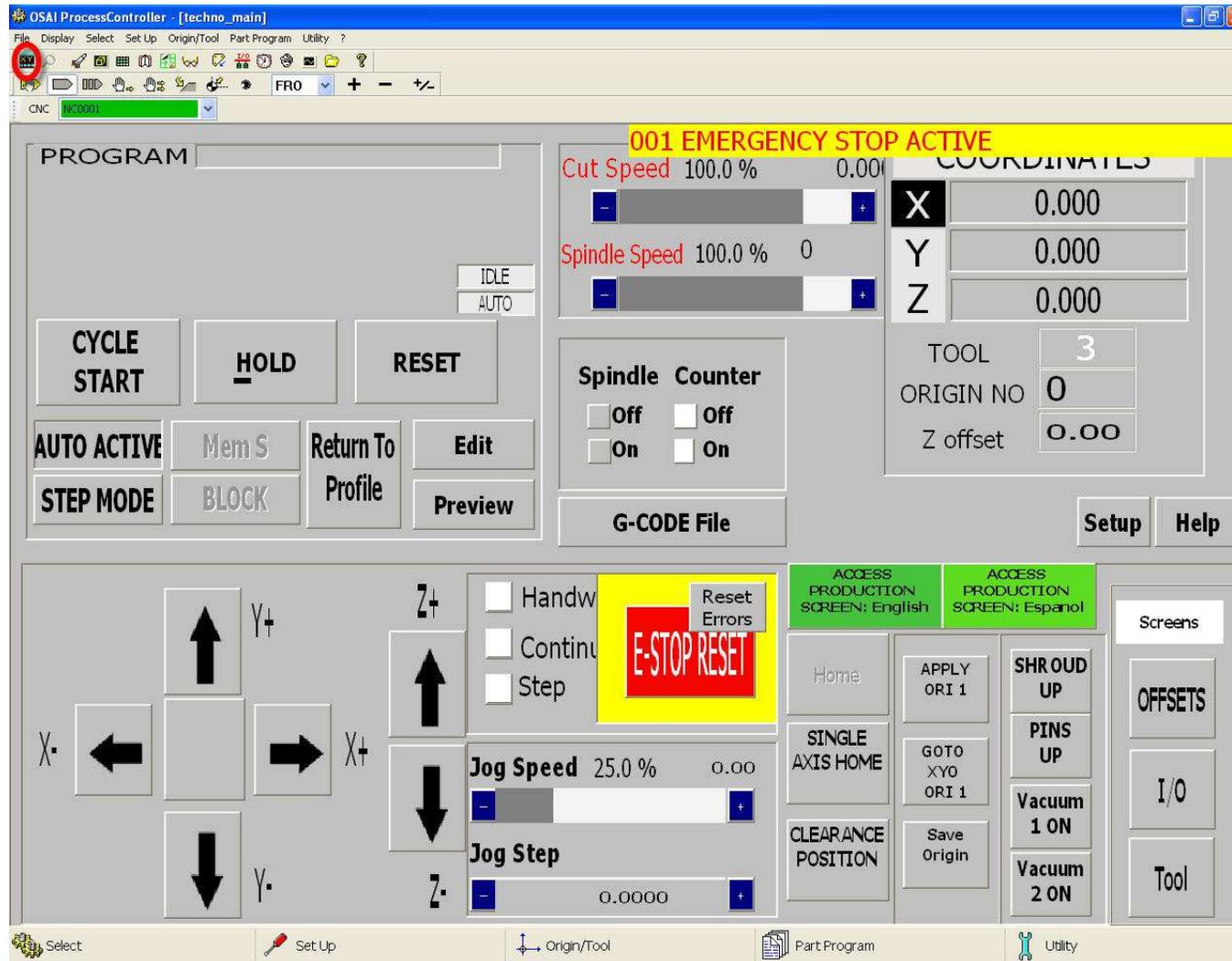


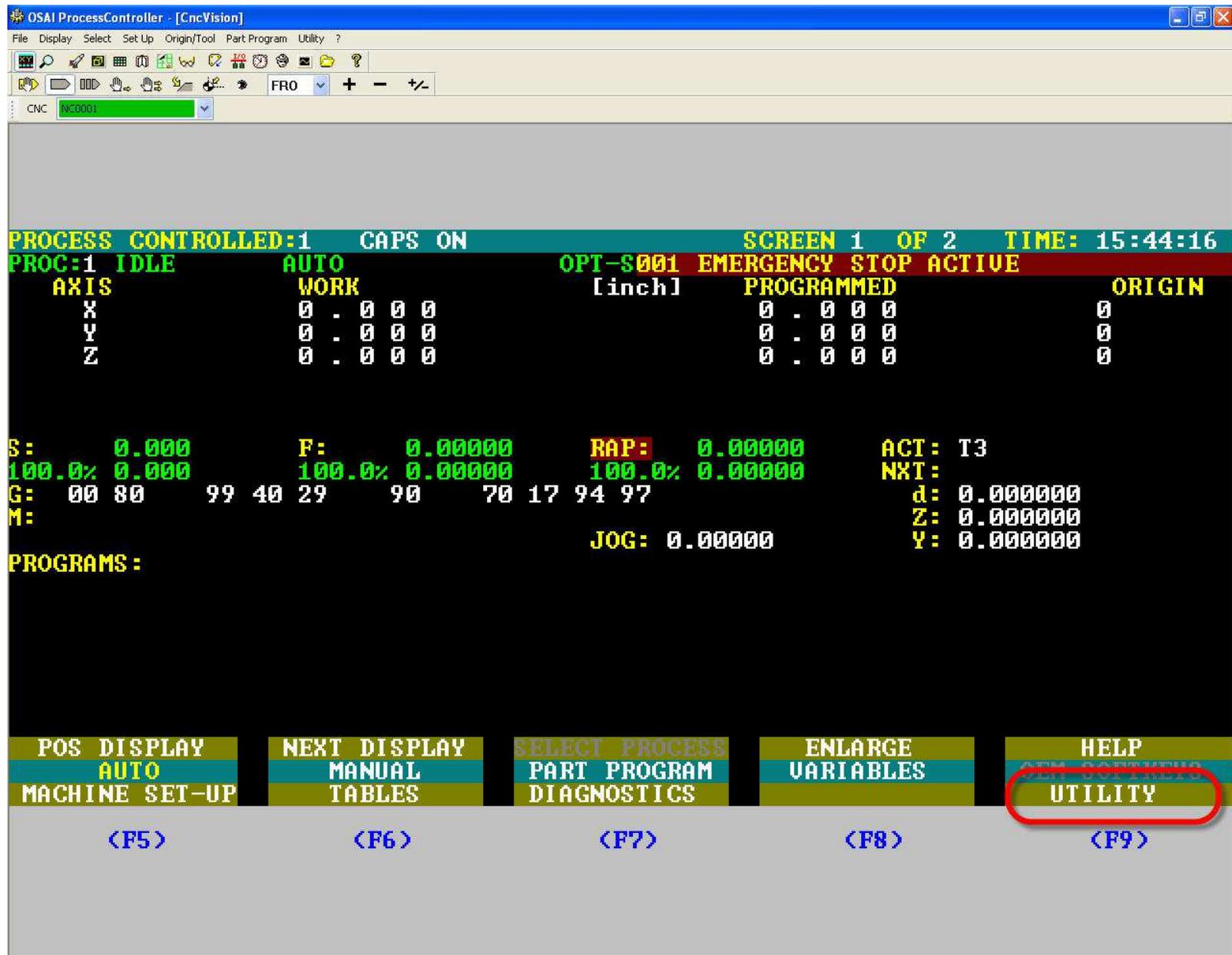
How to Adjust The Software Limits on an HDS Machine

This is a quick, step-by-step tutorial for how to change the axis parameters. This should NOT be done without the guidance of a Techno technician.

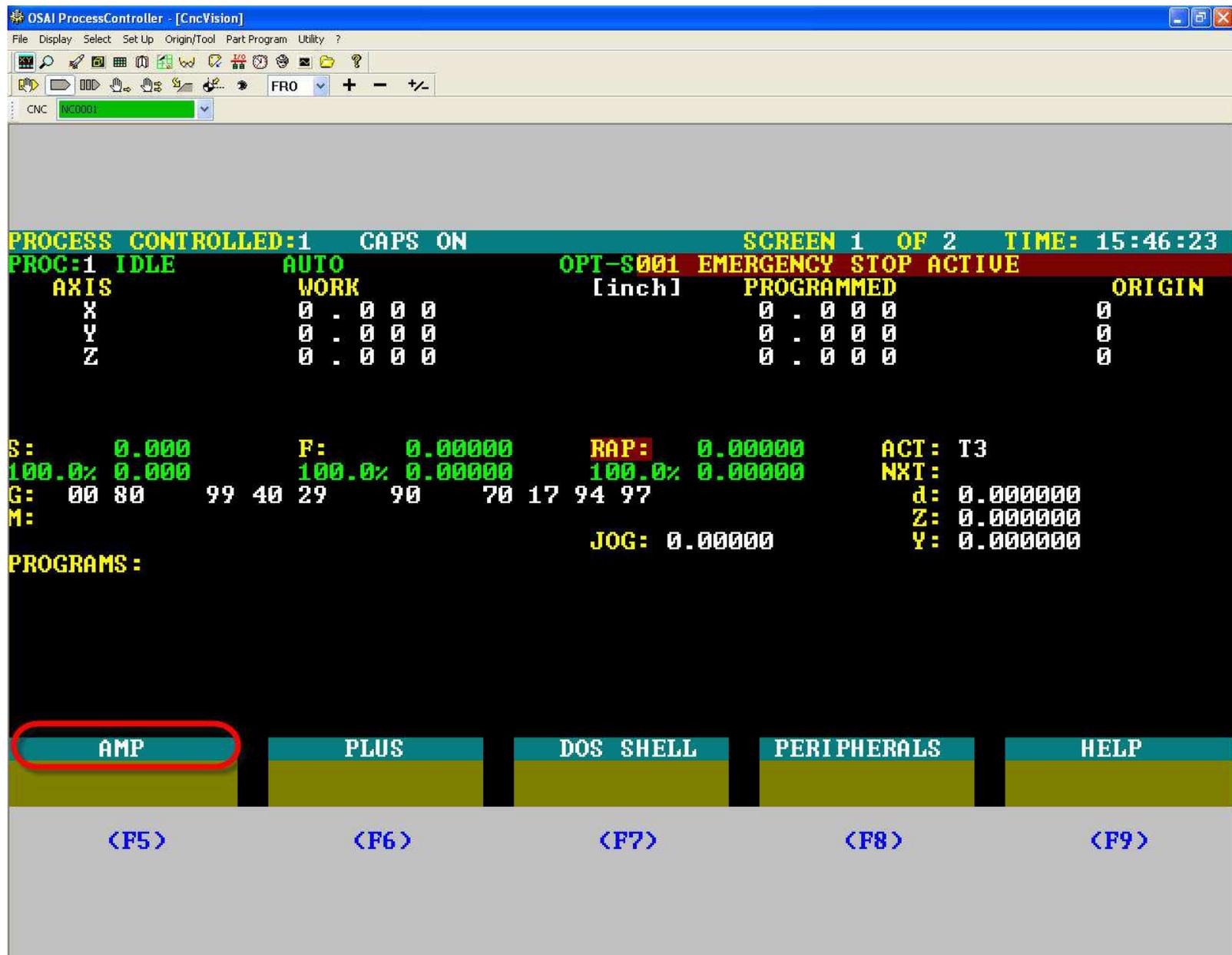


Click on the 'CNC Vision' icon to bring up the controller screen.

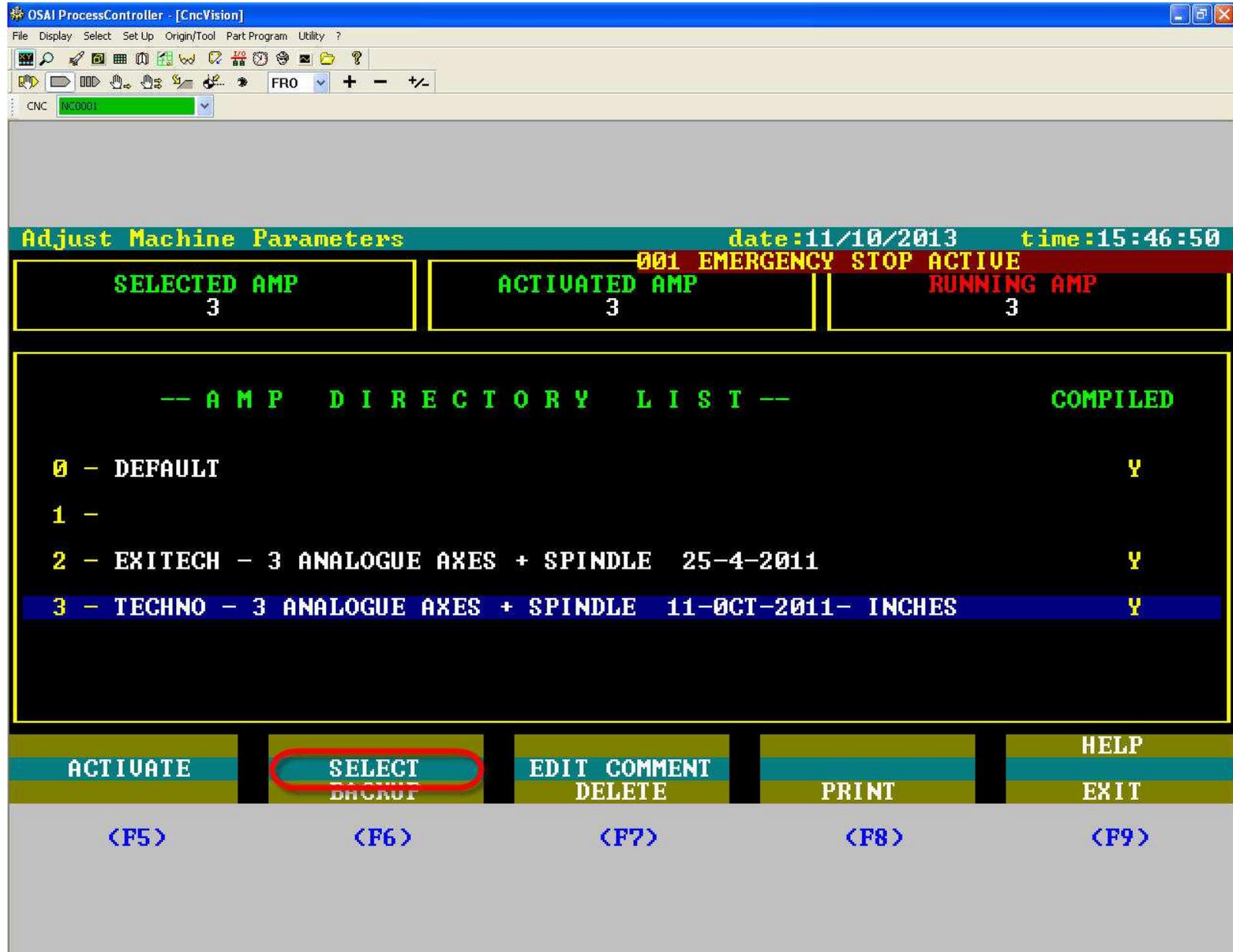
Note: To navigate through the menus in the controller screens: use F10 to scroll the highlight bar and then the corresponding function key to select what's highlighted.



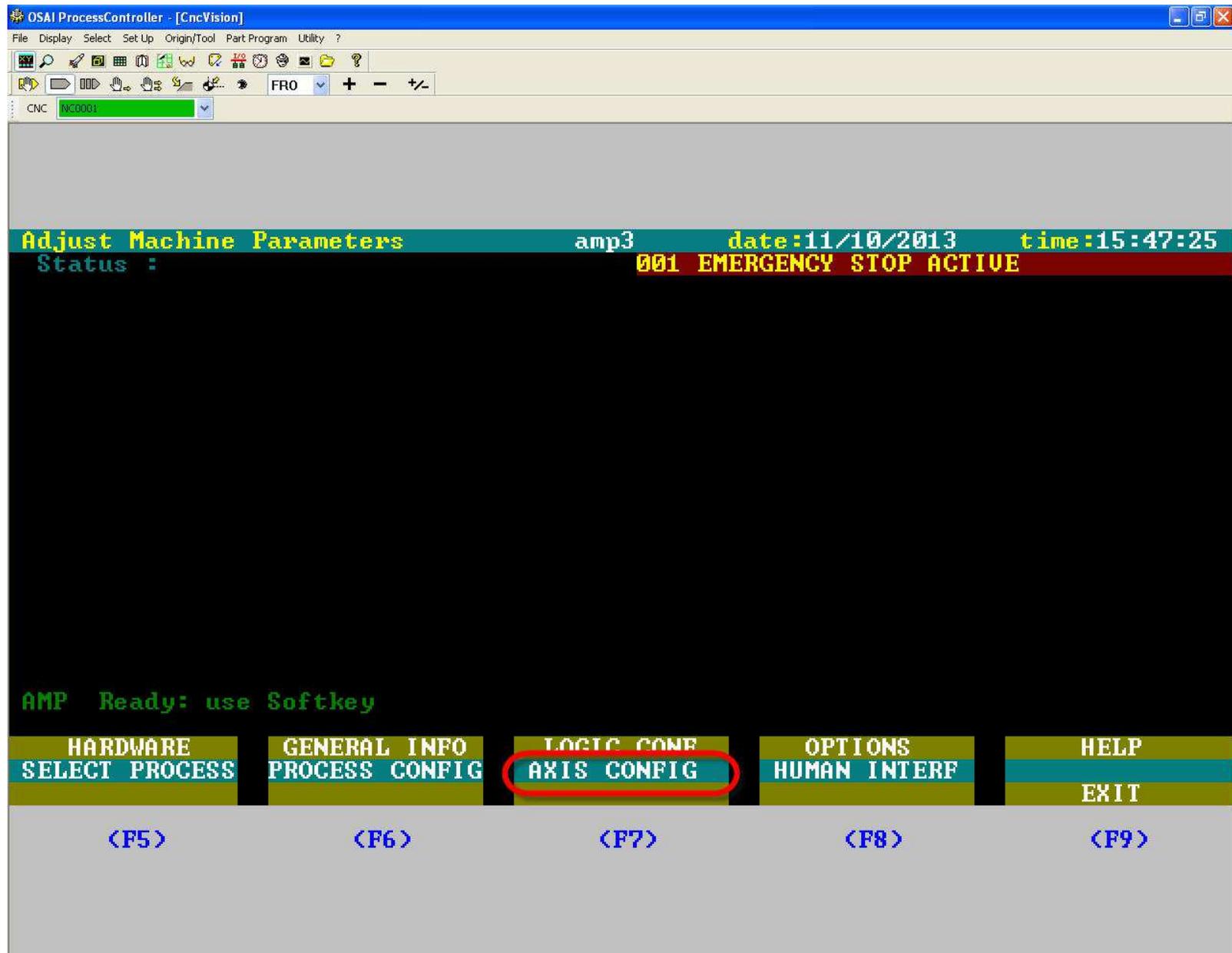
Hit F4 to go to the top menu. Use F10 to move the highlight bar until it is on the bottom line, and then hit F9 to go to the 'Utility' menu.



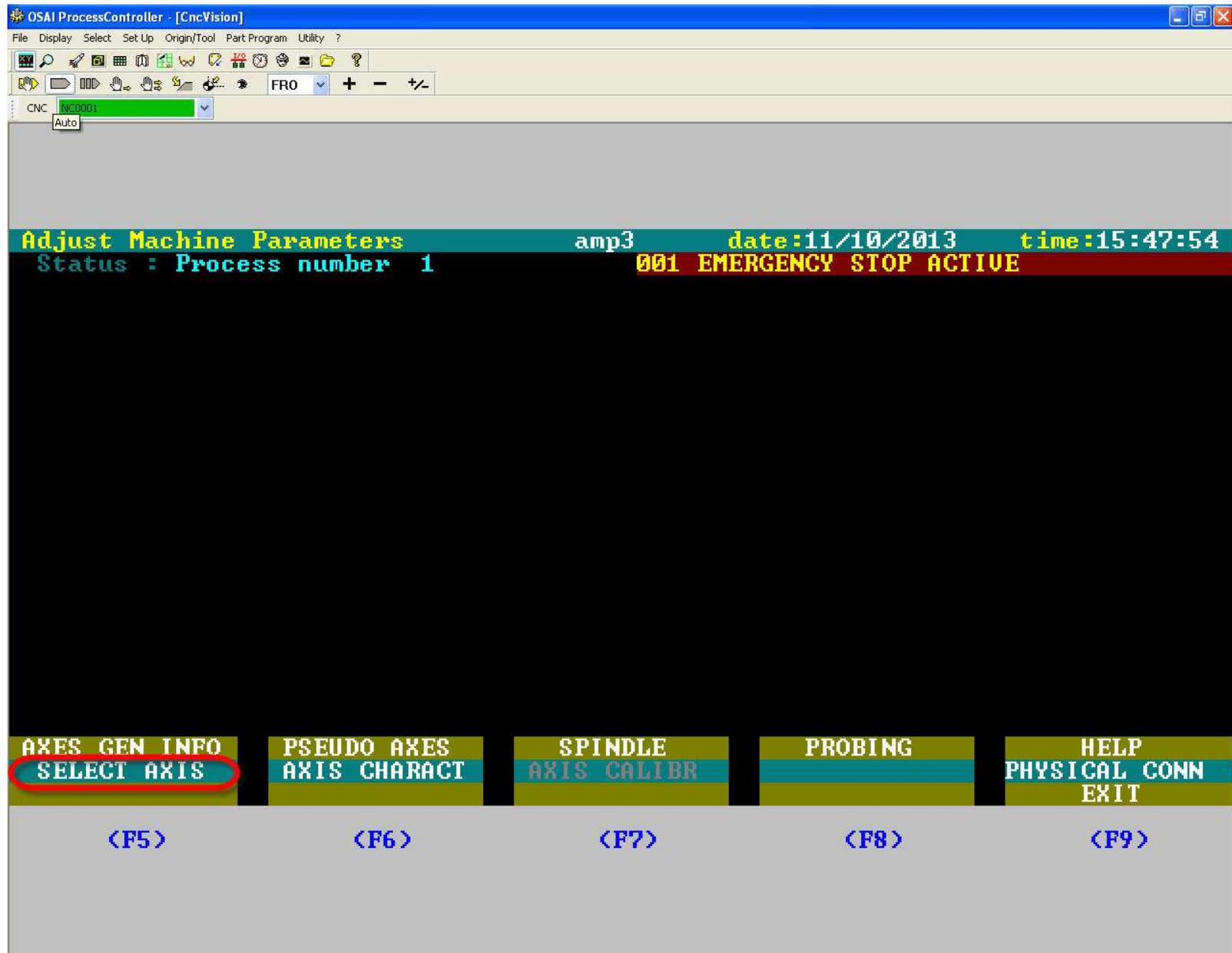
Go to 'AMP'



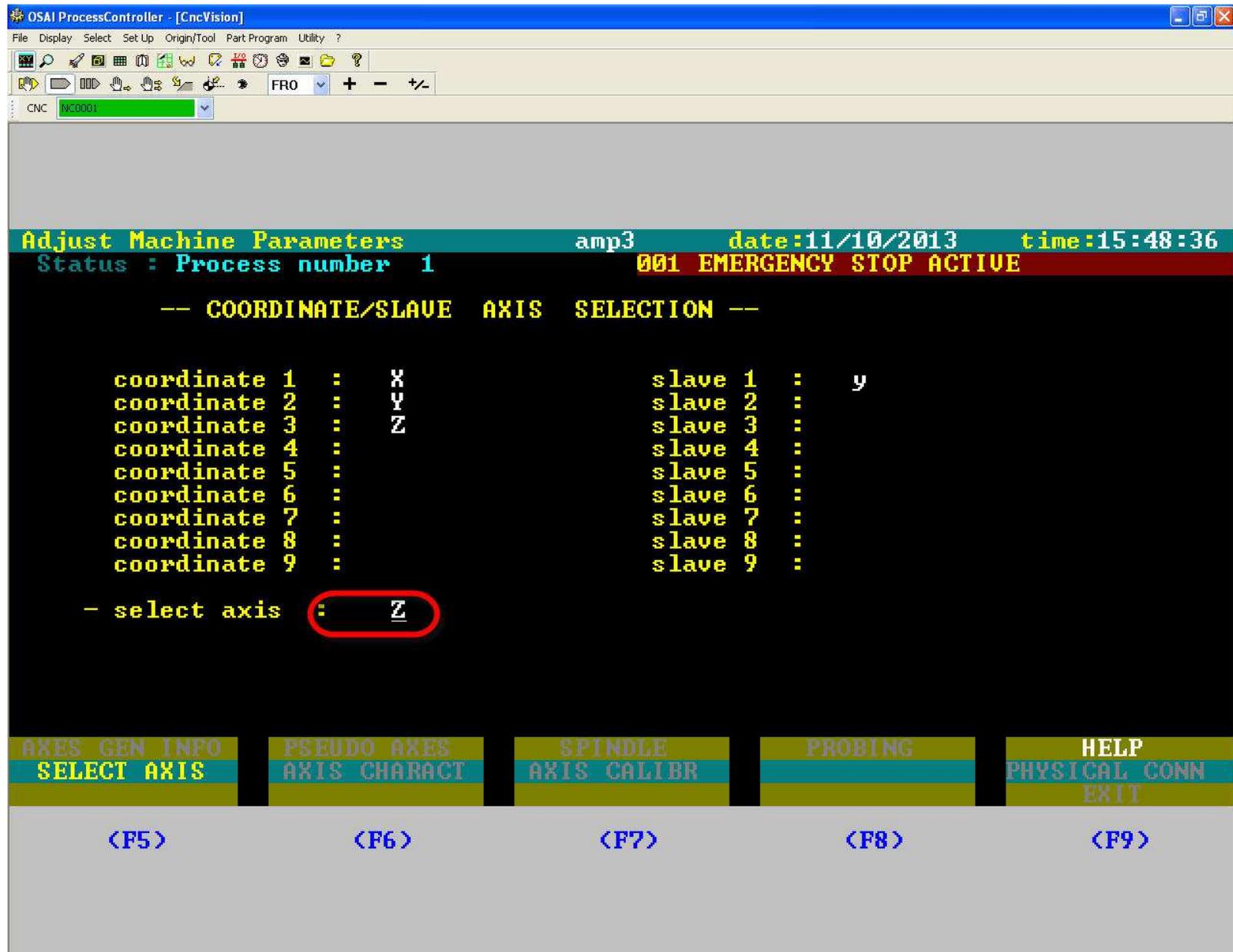
'Select' the appropriate setting configuration. It should be #3.



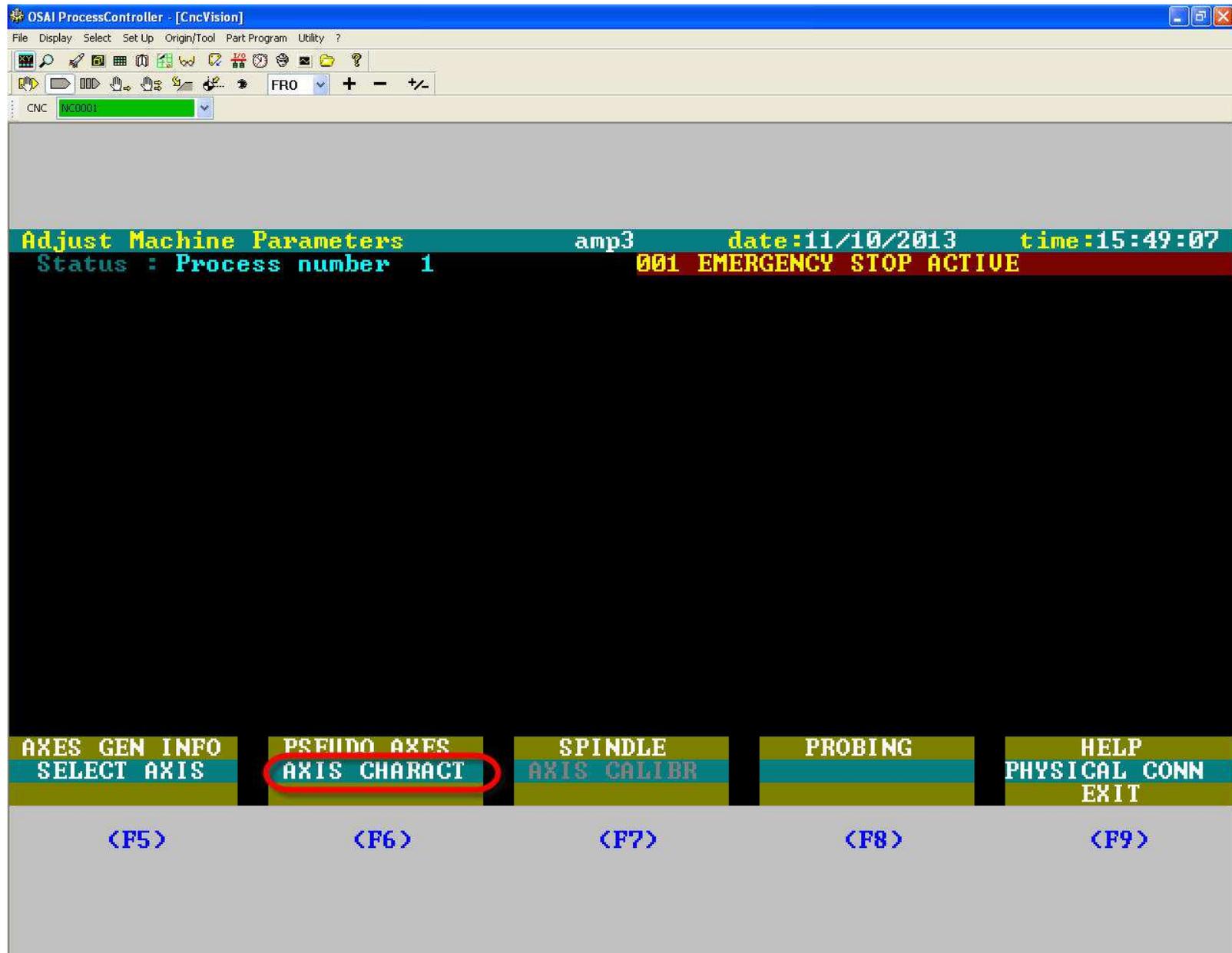
'Axis Config'



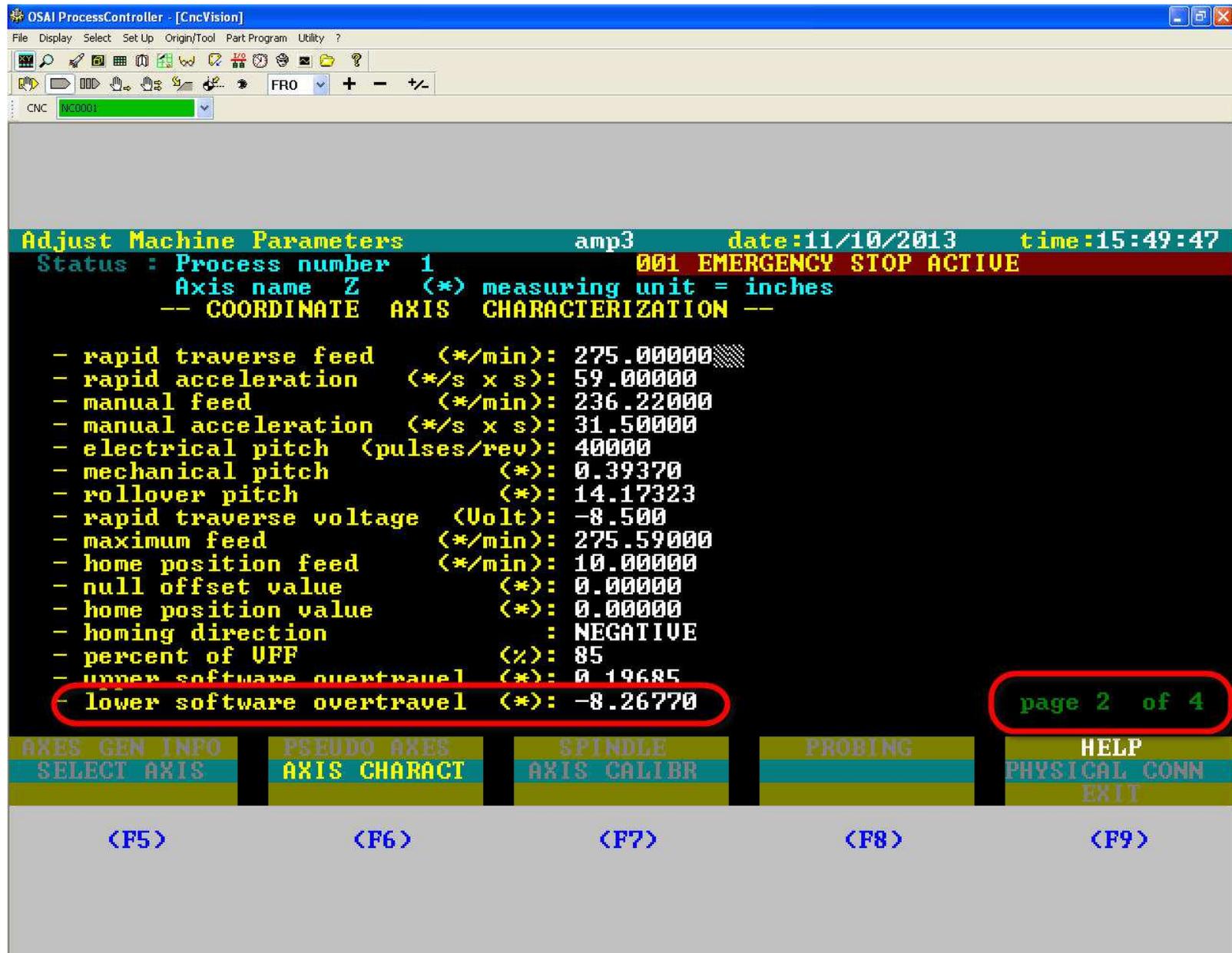
'Select Axis'



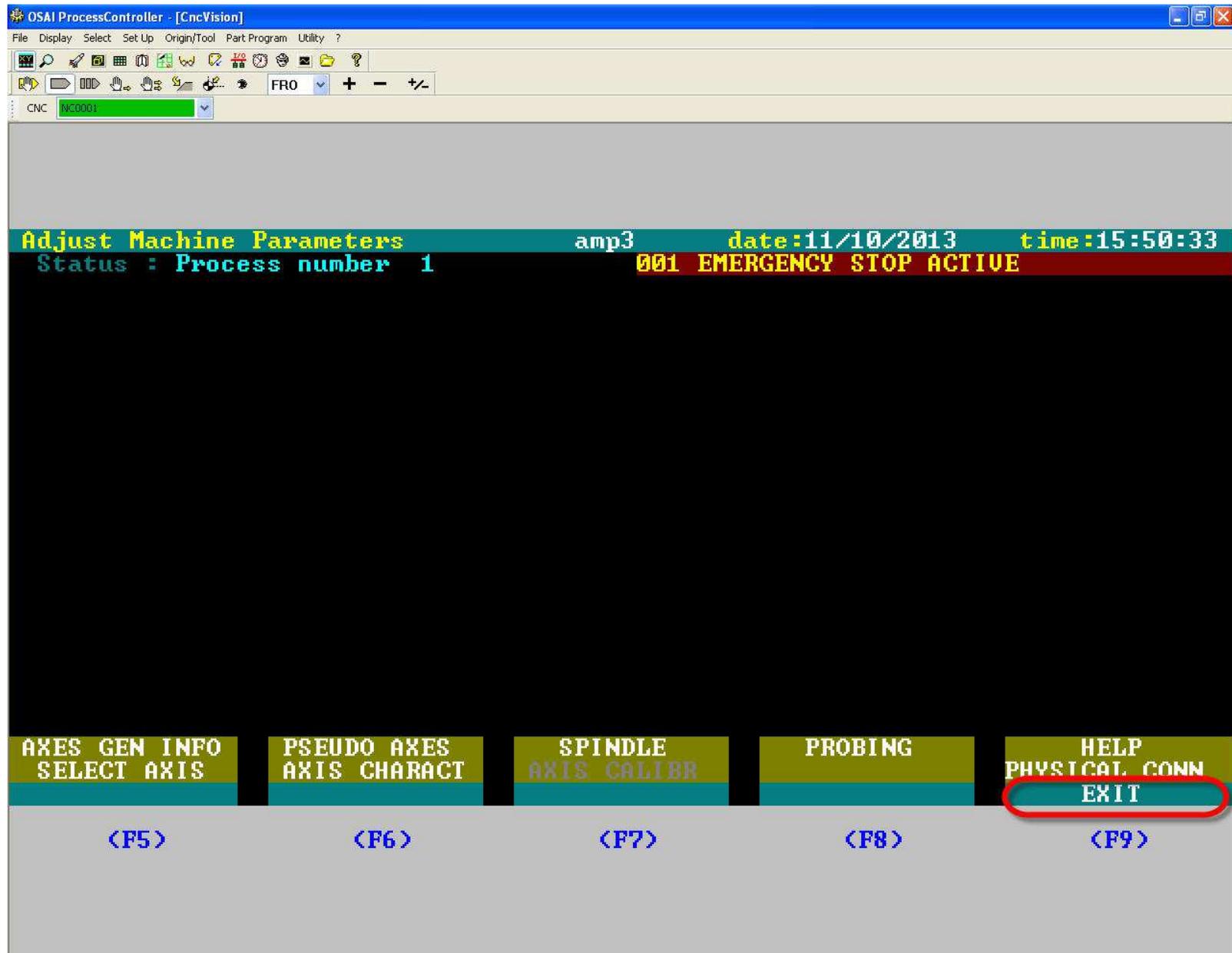
Type 'Z' into the field, hit ENTER. Note: must be capital letter and only ENTER on the number pad works.



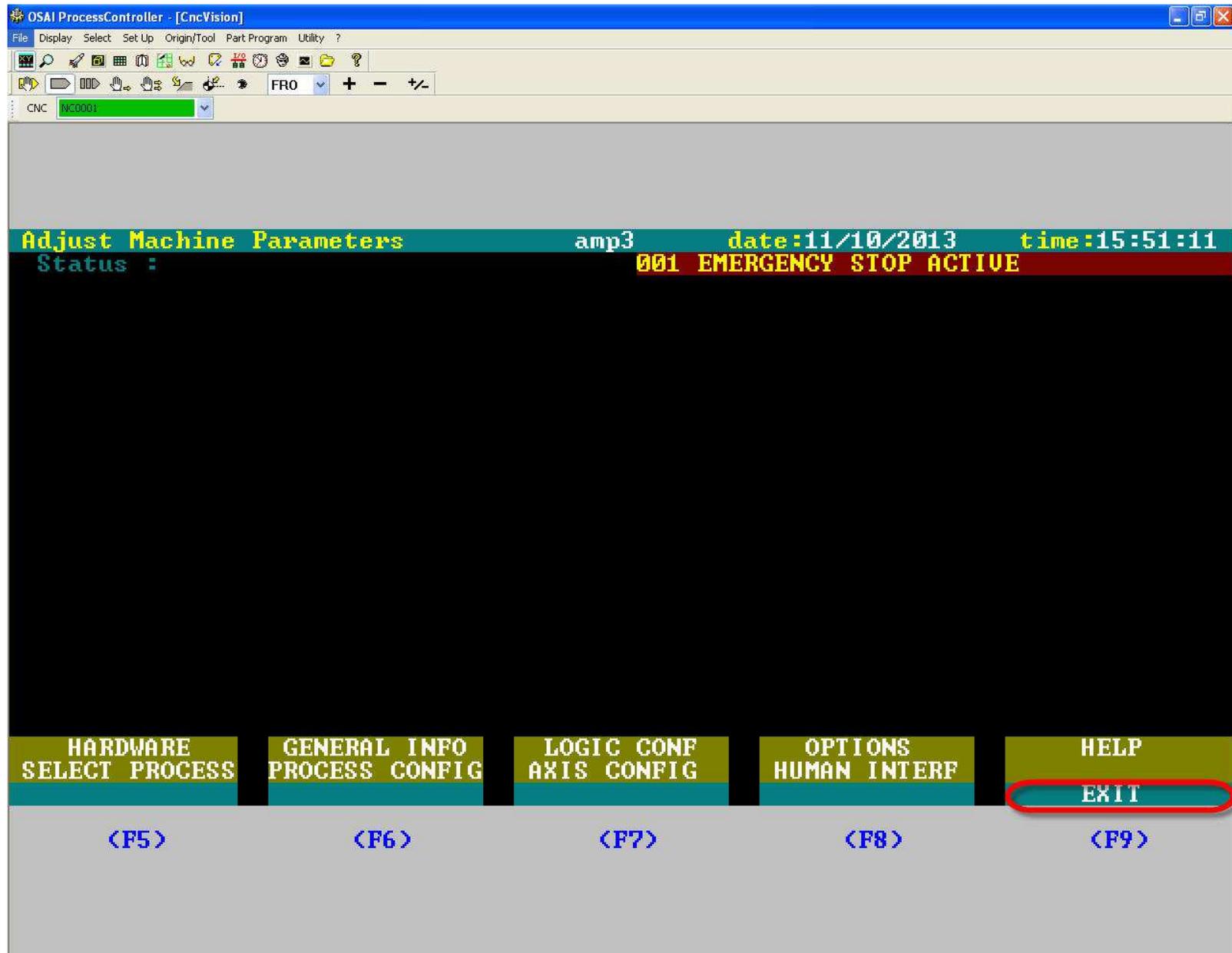
Now, 'Axis Charact'



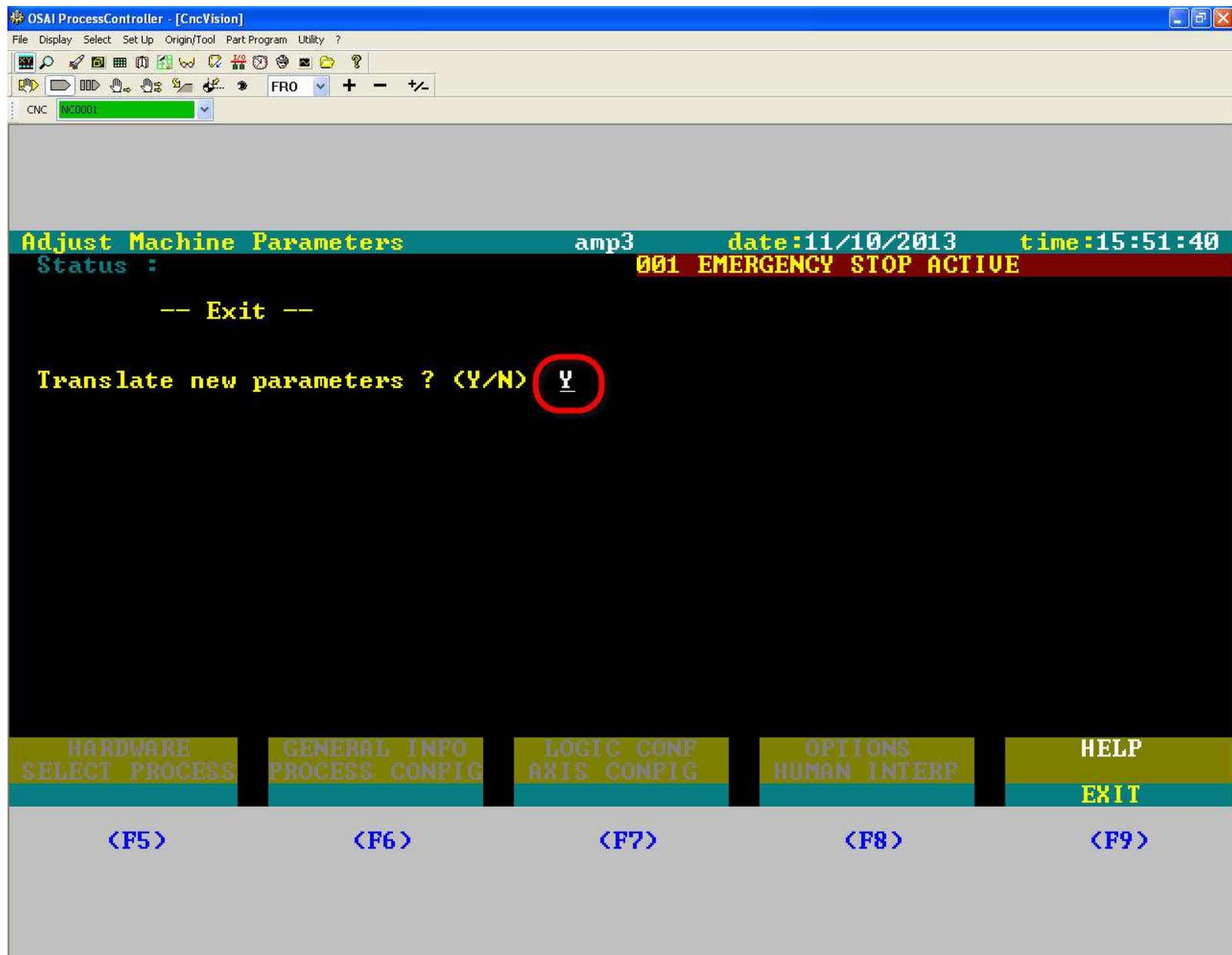
Hit the PAGE DOWN button on your keyboard to scroll through the pages. Adjust lower limit as needed. Hit ENTER on the number pad.



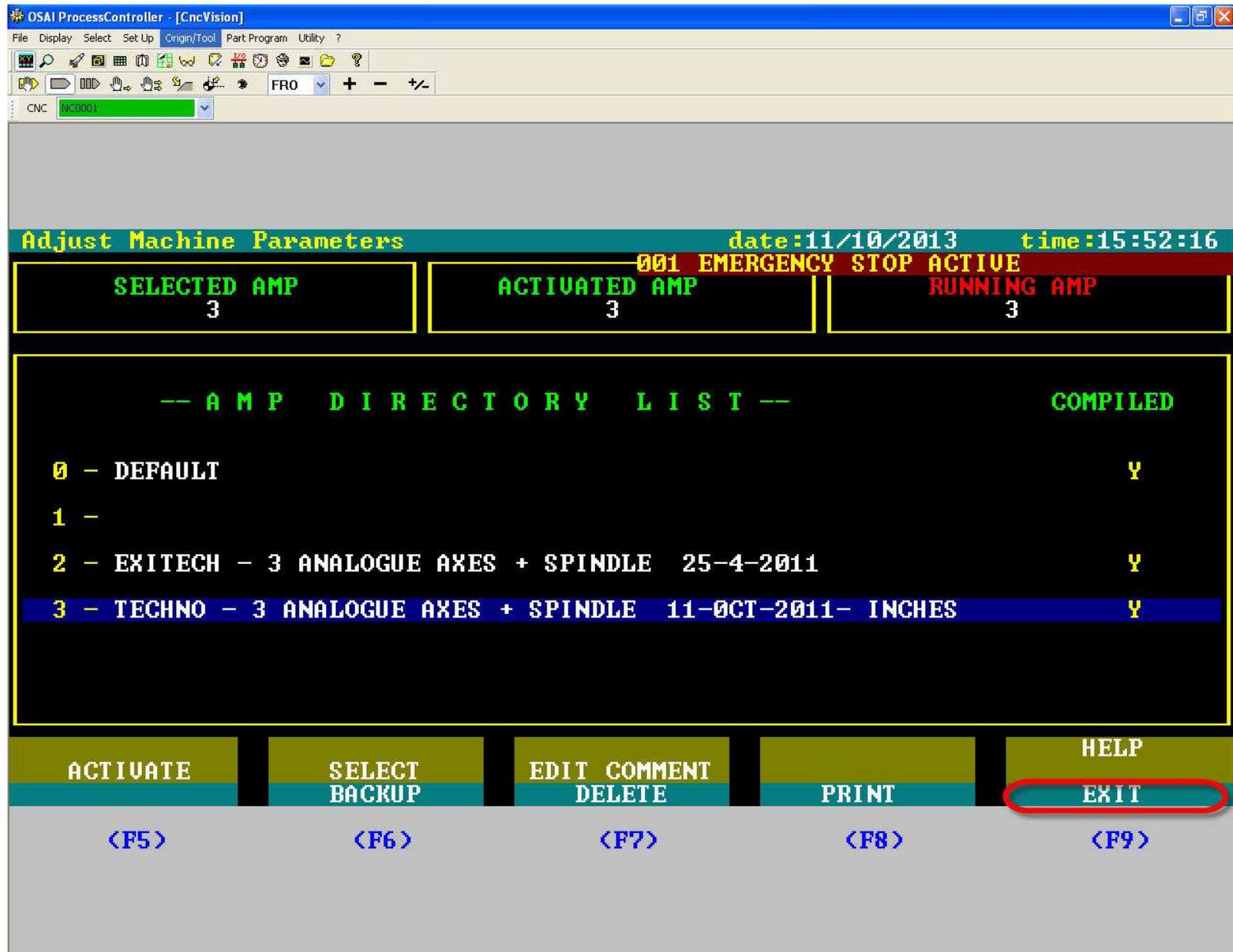
Now exit the APM screens...



Exit...



Type 'Y' to save the changes you've made.



Exit...

Reminder: You will have to re-start the controller for these changes to take effect.

IMPORTANT!! DO NOT exit out of the AMP settings without determining if you want to 'Translate New Parameters'. This could result in the controller settings not being compiled – which would mean that the machine WILL NOT run.

Even if you say 'N', that's fine. However, the changes you made will not be saved.