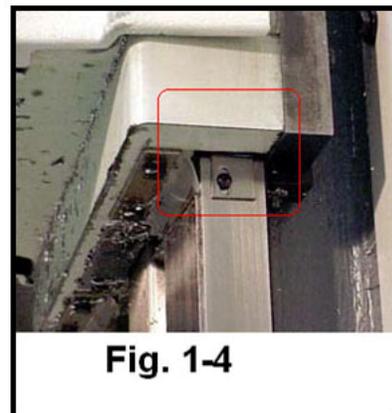
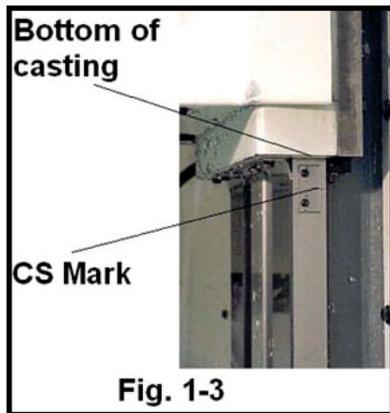
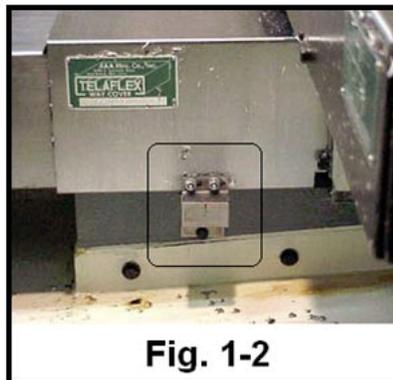
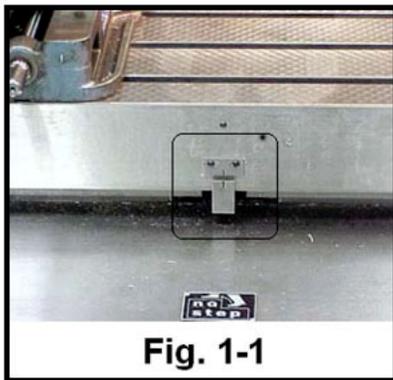


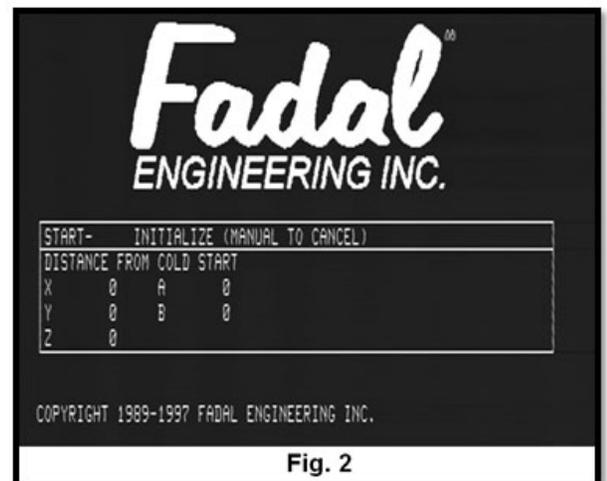
How to Set a Second Home Position

Often times, it is convenient to set a home position somewhere other than cold start position for loading/removing parts from vises and fixturing after the machine cycle is complete. The Fadal control makes it very easy. Here's how it's done:

1. Cold Start the machine as follows:
 - a. Align the cold start marks as indicated in (Fig. 1-1) X-axis, (Fig. 1-2) Y axis & (Fig. 1-3) / (Fig. 1-4) Z axis if needed, by jogging the machine.

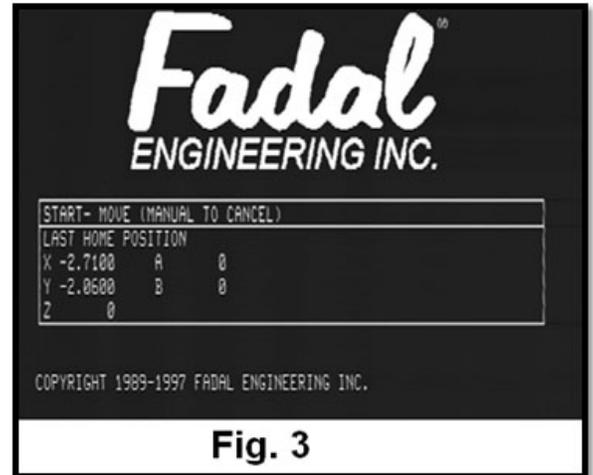


- b. On newer systems press start button when prompted see (Fig. 2).
- c. On older systems at the **(ENTER NEXT COMMAND)** prompt type in **CS** and press **[ENTER]**.



2. Setting the second Home position.
 - a. Jog the machine to the desired second home position.
 - b. At the **(ENTER NEXT COMMAND)** prompt type in **SETH** and press **[ENTER]**.

Now that the second home position is set, the **HO** command will send the machine to the second home position. The machine will also ask if you want to move to the second home position after the cold start procedure (Fig. 3) until the second home position is cancelled. Just press **[START]** and the machine will move to your second home position.



3. Changing, or cancelling the second home position:
 - a. Changing:
 - i. Jog the machine to the new desired position.
 - ii. At the **(ENTER NEXT COMMAND)** prompt type in **SETH** and press **[ENTER]**
 - iii. Done.
 - b. Canceling:
 - i. After you cold start the machine, do not press the **[START]** button, press **[MANUAL]** instead.
 - ii. At the **(ENTER NEXT COMMAND)** prompt type in **SETH** and press **[ENTER]**.
 - iii. Done. The machine is now using the **CS** position for its home position.
4. Shutting down the machine:
 - a. At the **(ENTER NEXT COMMAND)** prompt type in **SETCS** and press **[ENTER]**.
 - b. At the **(ENTER NEXT COMMAND)** prompt type in **HO** and press **[ENTER]**.
 - c. ****Warning**** The machine is going to return to the cold start positions. Press the **[START]** button.
 - d. Now the machine is ready to be shut down.