



Instruction:	Rev Date: 5/20/2005
Issued Date: 5/11/2001	Rev Num: Draft #1
Issuer: Customer Service	
Approved By:	

## Procedure for Axis Re-Homing 16, 18I, 21I, 180I & 210I Controls

### Axis Re-homing 16, 18I, 21I, 180I & 210I Controls 300APZ

1. If you are just changing the home position, you will first need to change the appropriate axis to a zero. See note below.
2. Select MDI mode.
3. Press OFFSET/SETTING key, then soft key SETTING to select a setting screen.
4. Set the cursor to PARAMETER WRITE, hit 1 then INPUT.
5. You will get a PS 100 alarm, hold in CANCEL and press RESET
6. There are scribe lines on each axis that line up the machine home positions. Locate the one for the axis you are homing.
7. The axis that is being homed must be at least 3 inches away from the scribe mark in the negative direction and then jogged to the scribe mark in a positive direction only. If you go past the scribe mark in the positive direction, back up 3 inches and re-jog to the scribe line.
8. 16, 18, 21, 180I, 210I controls use parameter #1815.4
9. To find parameter 1815, press the SYSTEM hard key, type in 1815, then a NO. SRH soft key will appear, press that button and it will take you to the parameter.
10. When at scribe mark, change parameter 1815.4 (APZ), see note below, back to 1. The control will want you to cycle power. If you are changing more than 1 axis, go back to SYSTEM, and change the next axis to a 1, then power the control off.
11. In MDI mode, set PARAMETER WRITE back to 0, press the reset button and the 100 alarm will go away.
12. Check home position.
13. Twin table machines will have a V axis under the Z axis (See note below).

#### Parameter 1815.4 Example

		APC APZ	
		↓ ↓	
1815	X	0 0 1 1 0 0 0 0	←This is the way it should look with no alarms. You need to change the APZ to 0 first, before Change the home position. You will <u>not</u> get an Alarm for the X axis, as it is set to a one.
	Y	0 0 1 0 0 0 0 0	←You <u>will</u> get the APZ alarm since it is at 0.
	Z	0 0 1 1 0 0 0 0	←You will <u>not</u> get the APZ alarm since it is at 1.
	V	0 0 1 1 0 0 0 0	←This axis will only appear if you have Have a twin table machine.
		↑ ↑	

#### (NOTES)



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1815.            7 6 5 4 3 2 1 0 ← The .4 in step 8 corresponds to the APZ column.