



## ELROD MACHINE & MFG.

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### Aux Key “One Shots”

Your mill Aux keys have been configured with “One Shot” codes. They can be used by pushing the Aux keys while in the **main screen**.

The Aux keys are configured in the following order

Aux 1 = One Shot - Drill Bolt Hole Circle

Aux 2 = One Shot - Drill Array

Aux 3 = One Shot - Circular Pocket

Aux 4 = One Shot - Rectangular Pocket

Aux 5 = One Shot - Frame

Aux 6 = One Shot - Face

Aux 7 = Input X Axis Position

Aux 8 = Input Y Axis Position

Aux 9 = Input Z Axis Position

Aux 12 = Set Absolute Zero (Aux 12 is the last blue button below numbered Aux keys see Figure 1)



Aux 12 Key

### Using Aux 7-9

From the main screen press Aux 7 and a set X position window will appear. Enter the Absolute value you wish to be set or leave at Default “0” and the press Aux 12 key. X,Y or Z position will be set.

One Shot Keys are a subset of Intercon. Intercon is Centroid’s conversational program the is inside the control.