

ELROD MACHINE & MFG.

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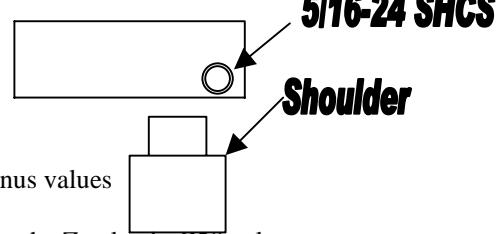
Set Z Home Instructions

Follow these instructions to reestablish Z Home on your machine.

Jog the quill down to its fully extended position

Loosen up your ball nut block by turning the 5/16-24 S.H.C.S. CCW. Roll the quill down using the manual handle in your tool box until the block and ball nut back are back in place (Ball nut journal completely capture by the ball nut block. And against the shoulder of the ball nut journal)

1. Go to the main screen on your controller
2. F2 Load cursor to the CNC7 Sub directory and Enter
3. Cursor to the file CNC7.hom F10 to accept
4. F6 Edit and delete the 2nd line if it has a G91 in it. For example : G91 G1 Z.085 F3 and save file
5. Esc to the main screen
6. F1 Setup
7. F3 Config
8. 137 enter
9. F2 machine
10. F1 Jog
11. Cursor over to Z travel limit section and enter .500 for Z plus and -6.000 Z minus values
12. F10 Save
13. Press ESC until at the main screen then F1 Setup F9 WCS F1 Return then clear the Z value in G28 column.
14. F10 Save
15. Turn off machine and re home
16. After homing machine Press ALT -D DRO should be set to machine coordinates (Machine will be above DRO)
17. Now jog the Z Axis up until the the Z + limit switch is tripped.
18. Record this value on the Z axis Display. For example lets say .100
19. Now Press F1 Setup F9 WCS F1 Return and enter the recorded value .010 in the Z section of Return G28
20. F10 Save
21. Esc. to main menu
22. F1 Setup F3 Config password 137 enter.
23. F2 Mach, F1 Jog , cursor to Z Plus limit value
24. Make sure DRO still says machine
25. Enter the Z plus value entered in the G28 Z value
26. Jog the Z down until the Z minus limit is tripped, subtract .010 from this value and enter this value in the Z minus section .
27. F10 Save, Now software travel limits are saved.
28. Shut off and Re Home the machine
29. To load a program F2 Load Cursor to ncfiles subdirectory enter pick a file F10 accept.



You have just reset your home position in Z and you can now load your old program and start running again.

Sincerely,

Dwayne Elrod