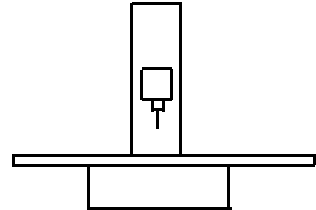


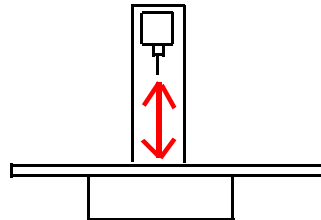
Set Z limit/Set Z

Two commands are used to set up the relationship of the cutting head to the machine table. First, mount an average length cutting tool in the chuck or collet. Use the “page up” and “page down” keys to jog the cutting head up and down.

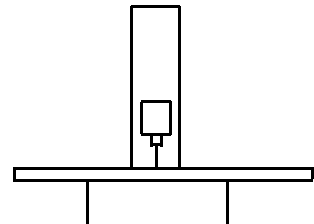


Now, use the “page up” key to move the cutting head to its upper mechanical limit. Leave a little space before you actually bump into the physical limit of travel.

Measure the distance from the table to the tip of the cutting tool. Say the total distance is 4 and 1/2 inches. This is the range of the Z axis.



Return the cutting tool to the table surface. The table is 0.00 and as the tool moves up, the numbers climb to the number that is your maximum limit. In the above example, 4.5 inches.



```
Command:SETZLMT  
Z Limit Maximum <3.0000> : 4.500  
Z Limit Minimum <-1.0000> : 0.000
```

“setzlimit” is a keyboard command. Type it in and press enter. The command line asks for Z limit maximum. Type 4.5 inches-press enter. Next, type value for Z minimum, which is 0.00 and enter. Now select the “setz” command The current position of the tool tip is on the table. “setz” will allow you to assign a number value to the present Z position. Type 0.00 and press enter. (continued on next page)

A logo consisting of three stacked rectangular boxes. The top box is red with the text 'SETXYLOC' in white. The middle box is green with the text 'SETZ' in white. The bottom box is red with the text 'SET SU' in white. To the right of the bottom box is a small icon of a hand holding a tool.