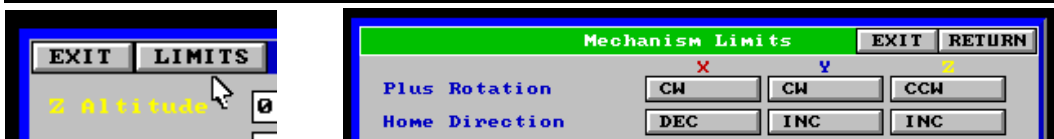


Configuration screen/Motion delays/Limit switches setup/Home

Initial Delay	0	MS	After the machine has moved into position to cut, a delay can be inserted before it will
Dwell Down Delay	100	MS	After the tool plunges to cut, a delay can be inserted to allow the tool to settle in before cut-
Dwell Up Delay	10	MS	At the end of the cut, the tool can be paused before retracting.
Direction Dwell	0	MS	The tool will pause before changing direction.
Line Setup Delay	20	US	Relates to the length of the parallel port cable from computer to controller. 20 ms sufficient for 50 Ft. length.
Step Mode	FreqSyn		Computer must be 200 MHZ pentium to utilize frequency synthesis. Helps machine run smoother and faster. Clicking on the button will bring up "CLASSIC" for older computers. The ramp sample time is for frequency synthesis only.
Ramp Sample Time	0.001	MS	



Select the limits button. The mechanism limits screen appears. Plus rotation means a positive gain will be made on the number line for that axis. You can reverse motor direction between clockwise and counter-clockwise to accomplish that end, depending on the machine.



The home direction is the direction the machine will move in to encounter the limit switches. Incremental is going up the number line. Decremental is going down on the number line. In this example, when the "home" command is selected, the axis motors are instructed to seek the limit switches. X will seek decrementally, Y and Z will seek incrementally.

(Continued next page)