

CALIBRATING THE [SELECTOR KNOB]

How to tell when the [SELECTOR KNOB] needs to be calibrated:

- Motors all initialize but will not move except in RAPID.
- Axis does not stop when the [SELECTOR KNOB] is at zero.
- [DIRECTION] keys move **only** in RAPID.
- [SELECTOR KNOB] functions such as feed rates or jog steps don't work correctly.

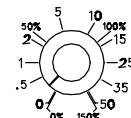
[SELECTOR KNOB] Calibration Procedure

Step 1: Enter SETUP mode:

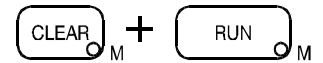
While holding down the [MANUAL] key, press the [SET_M] key. Then release both keys. The [MANUAL] status light will start BLINKING.



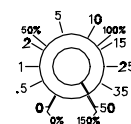
Step 2: Turn the [SELECTOR KNOB] counterclockwise to a position halfway between .5 and ZERO.



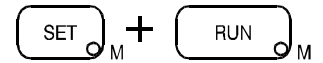
Step 3: While holding down the [CLEAR_M] key, press the [RUN_M] key. Then release both keys.



Step 4: Turn the [SELECTOR KNOB] clockwise to the 50/150% position.



Step 5: While holding down the [SET_M] key, press the [RUN_M] key. Then release both keys.



Step 6: Press and release the [MANUAL] key to exit SETUP mode.

