






SETTIN X0 Y0 ON FADAL

1)  TO GET IN MANUAL MODE (ENTER NEXT COMMAND)

2) UT 


3) 2 

4) ENTER NUMBER OF FIXTURE OFFSET (E NUMBER) 

5) .200  (IF USING AN EDGE FINDER. IF USING AN INDICATOR TO LOCATE A SETPOINT, ENTER 0.0)

6) 800 

7) 


8) 2 

9) 

10)  +  (TO TURN SPINDLE ON)

11) JOG TO LOCATION EDGE

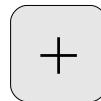
12) 

13) 3 

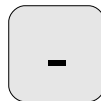
14) X

15) DETERMINE IF EDGEFINDER IS ON POSITIVE OR NEGATIVE SIDE OF LOCATION EDGE

IF EDGEFINDER IS ON POSITIVE SIDE, PRESS




IF EDGEFINDER IS ON NEGATIVE SIDE, PRESS



IF USING AN INDICATOR TO LOCATE A SETPOINT, SKIP THIS STEP

16) 

17) 2 

18) 

19) JOG TO LOCATION EDGE

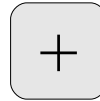
20) 

21) 3 

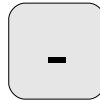
22) Y

23) DETERMINE IF EDGEFINDER IS ON POSITIVE OR NEGATIVE SIDE OF LOCATION EDGE

IF EDGEFINDER IS ON POSITIVE SIDE, PRESS



IF EDGEFINDER IS ON NEGATIVE SIDE, PRESS



IF USING AN INDICATOR TO LOCATE A SETPOINT, SKIP THIS STEP

24)  TO EXIT

25) TO DOUBLECHECK, MAKE SURE SPINDLE IS UP AND IN NO DANGER OF HITTING

VICES, TOOLING, OR 4TH AXIS, THEN HIT  
( MANUAL DATA INPUT)

 MANUAL

TO ENTER MDI MODE

ONCE IN MDI, ENTER E\_G90G0X0Y0 AND HIT

 ENTER

THEN HIT

 START

TABLE WILL MOVE TO XOYO POSITION. JOG SPINDLE DOWN AND LOOK TO SEE IF CENTERLINE OF SPINDLE IS WHERE YOU SET X AND Y