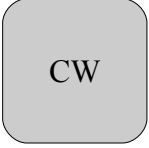


LOCATE X/Y ON HAAS

- 1) SET UP EDGEFINDER IN TOOL HOLDER
- 2) ON THE SIDE OF CONTROL, TURN THE LOWEST KEY CW TO TURN ON SET UP MODE


3) TURN SPINDLE ON BY PRESSING 

4) 

5) JOG TO LOCATE X/Y

6) 

7) USE ARROWS TO HIGHLIGHT X/Y IN CORRECT OFFSET # (EX. G54)

8) 

9) DETERMINE IF EDGEFINDER IS ON POSITIVE OR NEGATIVE SIDE OF LOCATING EDGE

10) USE ARROWS TO HIGHLIGHT X/Y IN CORRECT OFFSET # (EX. G54), THEN

IF EDGEFINDER IS ON POSITIVE SIDE, THEN ADD  $-.100$

IF EDGEFINDER IS ON NEGATIVE SIDE, THEN ADD  $.100$

11) RETURN TO STEP 4