

# PART SETUP WITHOUT A PROBE

## Instructions:

Note: the default configuration for the part setup screen is in the Universal Rotary setting. Regardless of the machine configuration (3-axis, 4-axis, or 5-axis) there will be data fields for a IV and V axis. This is normal, and the fields can be ignored for standard 3-axis machines.

1. Press INPUT on control panel
2. Select PART SETUP softkey
3. Jog the desired axis into position using the handwheel
4. Place the cursor in the corresponding data field for the desired axis
5. Select the STORE MACHINE POSITION softkey
6. Verify the data is correct

Note: the SHIFT field can be used to incrementally shift the Z-axis. For example: a value of 2.0000" will shift the Z-axis zero in the positive direction by two inches. Both positive and negative values can be input.