

## 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.

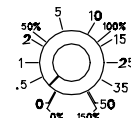
### [SELECTOR KNOB] Calibration Procedure

*Step 1:* Enter SETUP mode:

While holding down the [MANUAL] key, press the [SET<sub>M</sub>] key. Then release both keys. The [MANUAL] status light will start BLINKING.



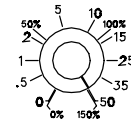
*Step 2:* Turn the [SELECTOR KNOB] counterclockwise to a position halfway between .5 and ZERO.



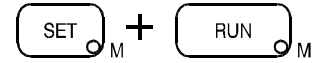
*Step 3:* While holding down the [CLEAR<sub>M</sub>] key, press the [RUN<sub>M</sub>] key. Then release both keys.



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



*Step 5:* While holding down the [SET<sub>M</sub>] key, press the [RUN<sub>M</sub>] key. Then release both keys.



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

