

Internal Execution Principle of Mechanical Homing Sequence in M350

1: When performing full-axis mechanical homing using the F key on the system interface:

File: fndzero.nc

You can adjust the order of the following codes:

```
M98 P501 X2    // Z-axis
M98 P501 X0    // X-axis
M98 P501 X1    // Y-axis
M98 P501 X3    // 4th axis
M98 P501 X4    // 5th axis
```

2: For automatic mechanical homing on startup:

Files: sysstart.nc → slib-m.nc → M115

You can adjust the order of the following codes:

```
O10115
```

```
...
```

```
IF #1992 == 0 GOTO2    // The internal system parameter #127 is passed to #1992
```

```
M98 P501 X2    // Z-axis
```

```
M98 P501 X0    // X-axis
```

```
M98 P501 X1    // Y-axis
```

```
M98 P501 X3    // 4th axis
```

```
M98 P501 X4    // 5th axis
```

```
... ..
```