

Initialize the machine

- First, in the lower left corner of the screen **ENABLE** the controller so that the controller is active, this will enable **START, STOP, RESET, DISABLE** buttons
- Each time** you power the machine on, you need to “Home” the machine so that the machine knows the X,Y,Z zero for its working volume. From this Machine Coordinate point all other coordinates can be defined. One at a time, click the **Home** buttons for **X, Y** and **Z**. When each axis is homed, the home light will illuminate **green**.
- The first time** you power the machine on, and the first test piece you machine, it is strongly recommended that you change the **Rapid Rate, Feed Rate, Jog** to **10%**. This will ensure that the machine is moving in the direction you expect, and give you time to respond and click the STOP button if something is not moving as expected. The machine moves very fast at 100%, if a crash is imminent you will not have time to respond.
- Low rates are particularly important at the start of a new nc-code program. If there was an error in your Working Coordinates, e.g., you forgot to zero or set the Working Coordinates, or an error in the nc-code, e.g., you programmed a negative Z move = 1000mm/min (the machine will rapidly plunge into the workpiece). To prevent crashes, at least initially, keep the **Rapid Rate, Feed Rate, Jog** to **10%**.

