



17. Push and hold “release”, press “mach. set-up”, and move “Z” axis in the minus direction by handle until “alarm 506” goes out.
18. Press “reset”.
19. Check the machine position and move the “Z” axis 1.0 inch more in the minus direction.
20. Press “system” and change parameter 1815 to “110000” for both axes.
21. Press “offset/setting” until setting (handy) is displayed.
22. Change “parameter write” to “0”.
23. Perform “reference return” in the normal way.