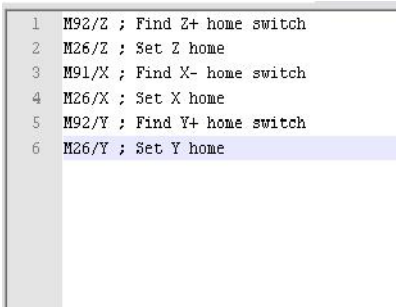


TB022 (Rev3) - Modifying the "HOM" File

Instructions for CNC11 HOME file (Windows7) v3.02 - present

1. Exit CNC11 software by pressing F10(Shut Down)->F9(Exit CNC11).
2. Double-click on My Computer.
3. Double-click on C:\.
4. Double-click on the CNCM or CNCT folder.
5. Double-click on the cncm.hom or cnc11.hom file to open it up using Notepad as is seen on Figure 1.
6. Modify as needed and save the file by pressing CTRL + S or selecting Save from the File menu.
7. Reboot the system and verify the changes work.

Figure 1: Notepad

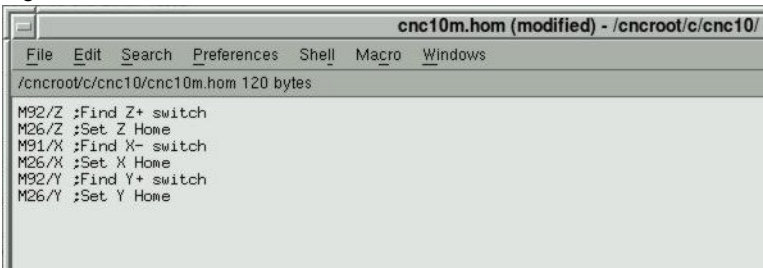


```
1 M92/Z ; Find Z+ home switch
2 M26/Z ; Set Z home
3 M91/X ; Find X- home switch
4 M26/X ; Set X home
5 M92/Y ; Find Y+ home switch
6 M26/Y ; Set Y home
```

Instructions for CNC10 HOM file (Linux) v1.50 - v2.7x

1. Bring up a Linux window by pressing ALT + F6.
2. Type **edit cnc10m.hom** or **edit cnc10t.hom**. You should see something very similar to Figure 2.
3. Modify the file as needed.
4. Save the file and exit the editor by pressing CTRL + Q and then pressing ENTER to save the changes. **YES is the default answer**
5. Reboot the control and verify the changes work.

Figure 2: Modern Linux Editor



```
cnc10m.hom (modified) - /cncroot/c/cnc10/
File Edit Search Preferences Shell Macro Windows
/cncroot/c/cnc10/cnc10m.hom 120 bytes
M92/Z ;Find Z+ switch
M26/Z ;Set Z Home
M91/X ;Find X- switch
M26/X ;Set X Home
M92/Y ;Find Y+ switch
M26/Y ;Set Y Home
```

Instructions for CNC10 HOM file (Linux) v1.00 - v1.27

1. Bring up a Linux window by pressing F10(Shut Down)->F6(System Prompt) from the main menu.
2. Type **cncedit.exe cnc10m.hom** or **cncedit.exe cnc10t.hom** (cnc10.hom for v1.15 and below). You should see something very similar to Figure 3.
3. Modify the file as needed.
4. Save the file by pressing F1(File)->F3(Save).
5. Exit the editor by pressing F9(Exit).
6. Reboot the control and verify the changes work.

Figure 3: Original Linux Editor

```
File: cnc10m.hom Line:1 Column:1
M92Z ;Find Z+ Home Switch
M26Z ;Set Z Home
M91X ;Find X- Home Switch
M26X ;Set X Home
M92Y ;Find Y+ Home Switch
M26Y ;Set Y Home
```

File F1 Search F3 Help F10

Instructions for CNC7.HOM (DOS)

1. Exit to DOS by pressing CTRL + ALT + X at the same time. You should see the DOS prompt C:\CNC7>.
2. Type **EDIT CNC7.HOM** and press ENTER. You should see something very similar to Figure 4.
3. Modify the file as needed
4. Save the file by pressing ALT + F, then S.
5. Exit the editor by pressing ALT + F, then X.
6. You should now be at the DOS prompt again. Turn the control off and then back on after 15 seconds. Check to see if homing is as desired.

Figure 4: DOS Editor

```
File Edit Search View Options Help
C:\cnc7\CNC7.HOM
-----
M92/Z
M26/Z
M91/X
M26/X
M92/Y
M26/Y
```

F1=Help

Line:1 Col:1

NOTE:

*M91 = Send to the - limit

*M92 = Send to the + limit

*M26 = Set home

Document History

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