

## PROCEDURE TO CHANGE IAI

### POSITION TABLE WITH HANDHELD

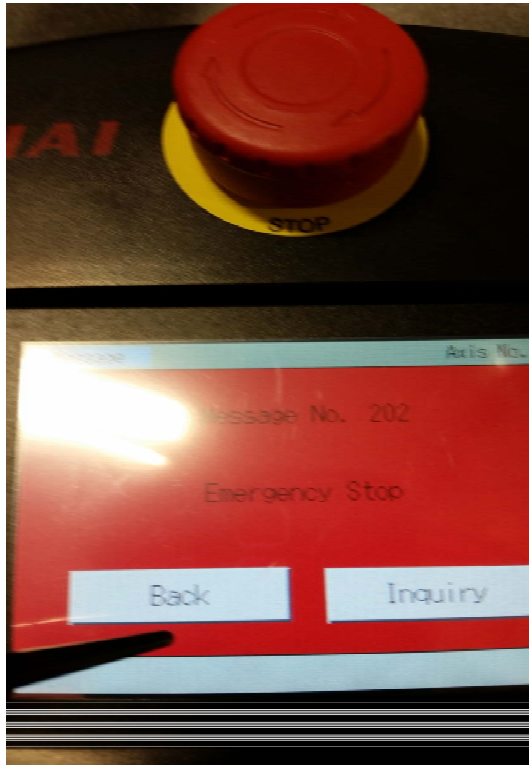
1. Turn off electrical power to machine and toggle switch on front of servo drive to “MANU” and connect the handheld cable to the circular connector on the front of the drive.
2. Turn the power on to the machine and the handheld controller will go thru diagnostic and then will eventually connect.
3. Click on the back tab with the stylus
4. Click on the edit position tab with the stylus.
5. Click the position data area you want to change. Decreasing the number makes the head go higher and increasing the number makes it go lower.
6. Using the pop up keyboard input the new number and then press the “ENT” tab.
7. Press the menu tab at the bottom of the screen to get back to original menu.
8. Turn off power and move the toggle switch back to the “AUTO” position.
9. Remove the handheld cable from the front of the drive.
10. Re-start the machine and check your changes.



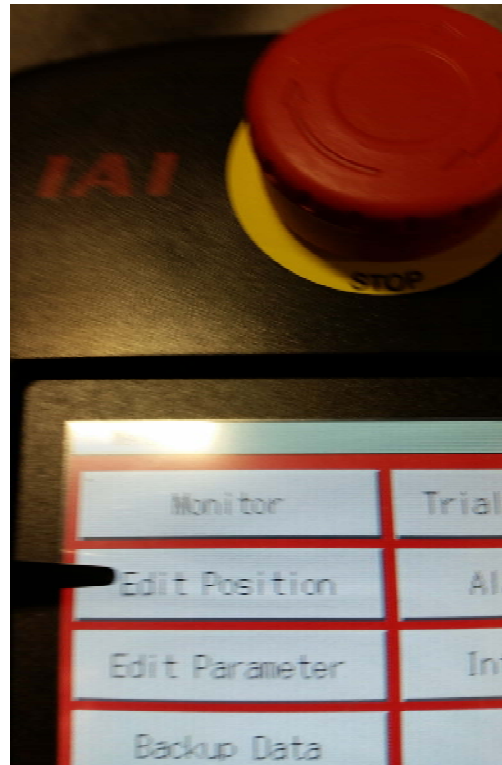
Mode toggle switch

Handheld interface  
cable

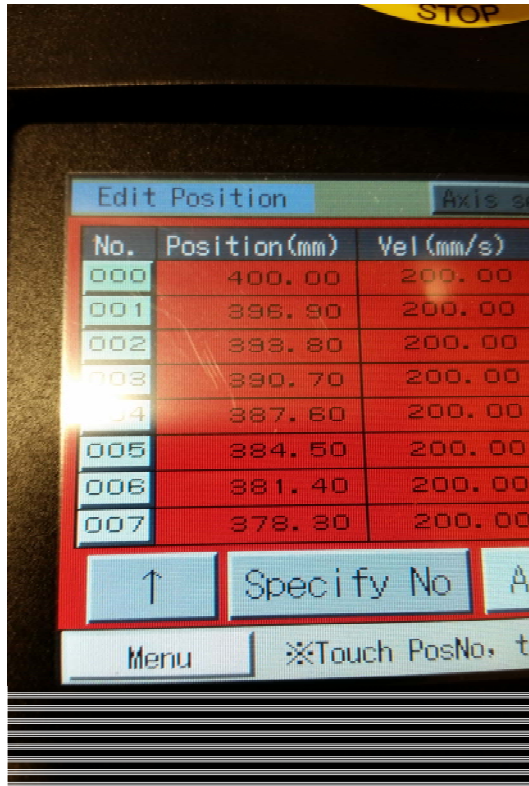
Steps 1, 8 and 9



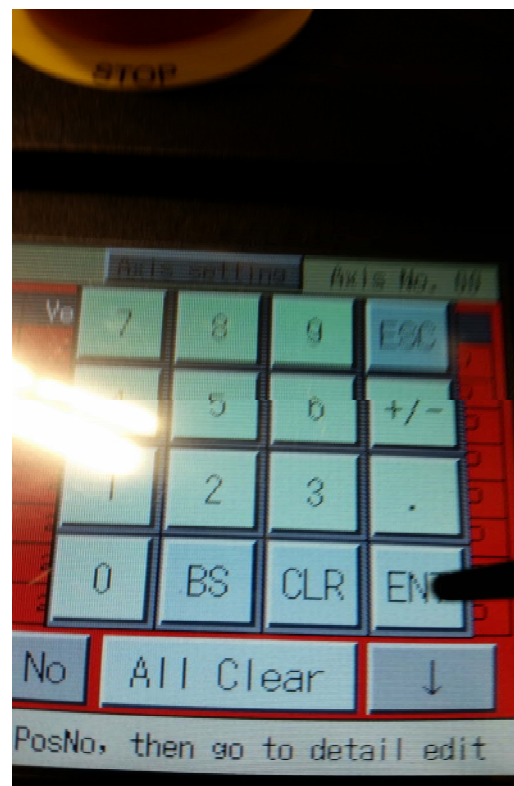
Steps 2 and 3



Step 4

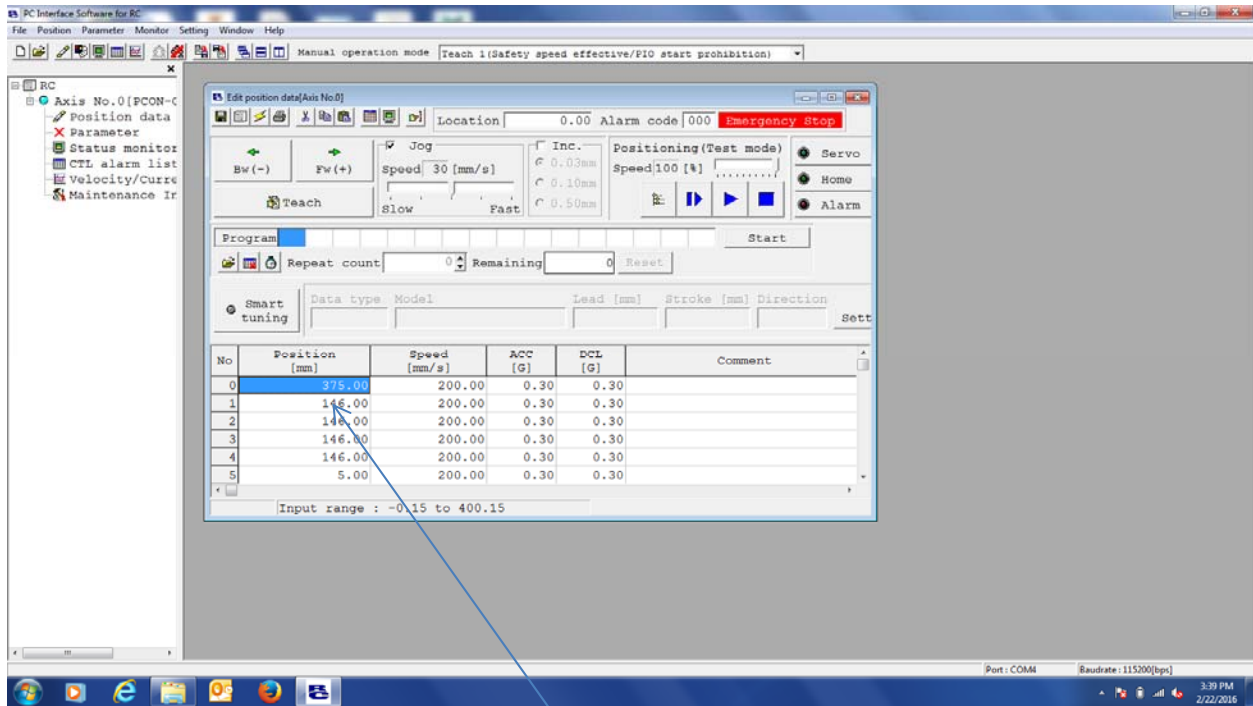


Steps 5 and 7



Step 6

Z



Change the value to a smaller value to get the head to stop at a higher distance