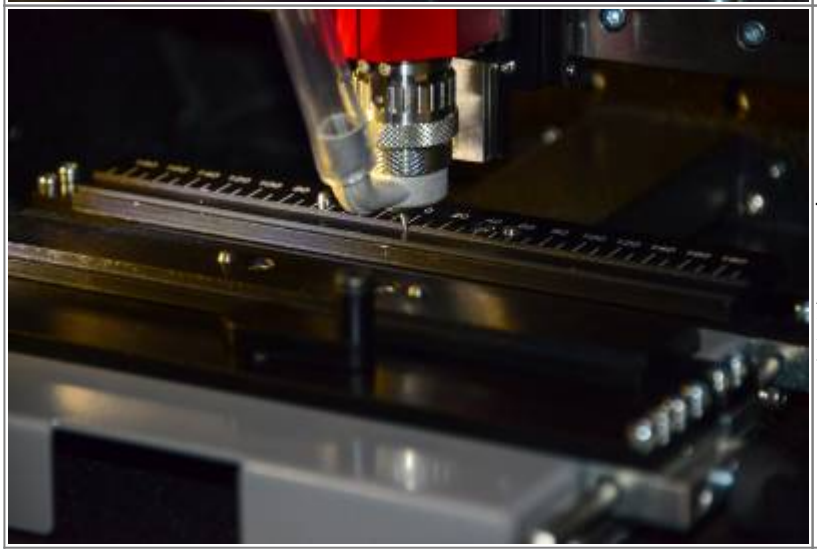
6.2 Quick lock vise home position setup.

The quick lock vise is not a self centering vise.
This means that the rear jig is always at the same spot, hence the reference origin for this vise is not in the centre between the 2 jigs,
but it is in the centre on the X-axis (from left to right) and on the clamping edge of the rear jig.
If a specific set of jigs has more than one clamping border, such as the jig set for small plates, then 2 different reference points can be defined (2 different home positions).

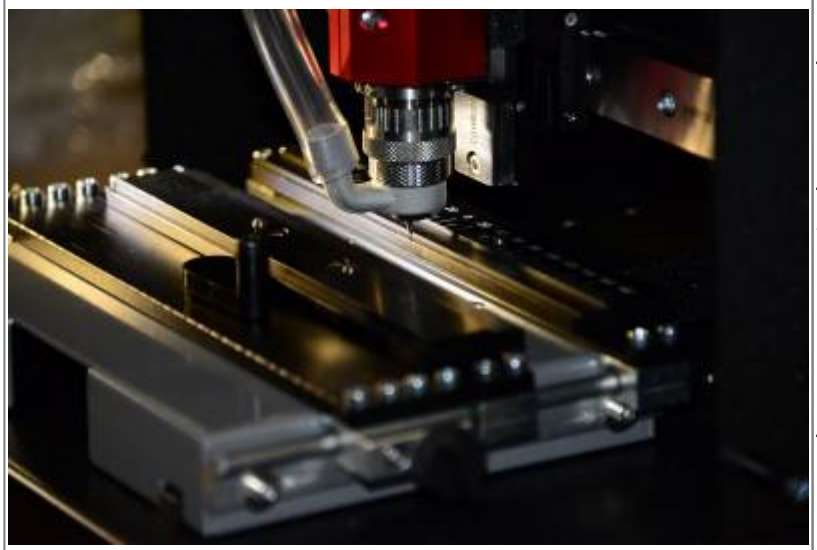
	The small plate jigs have 2 clamping edges, as you can see on the image on the left. To make this visible we have drawn a green rectangle over each of the clamping edges.
	Starting from the machine home position (upper left corner of the table) jog the spindle to the middle of the upper jig and align the flat side of the cutter with the rear clamping edge. Alternatively you can use the **“move to XYZ”** button to move to the X middle of the table. That way you only have to move the spindle to the correct Y position.



To save the actual position of the spindle as a new home position:
1) click on the Shift button.
2) Then click on the icon which shows the actual home position.



Click on one of the numbers from 1 to 9. In this example click on the number 1. The position of the spindle is now permanently saved as “Home 1”. It cannot be erased, it can only be overwritten by another XY position.



Next, save clamping border 2 under Home 2.
To do so move the spindle to the front (= table to the rear) and align the flat side of a cutter with clamping border 2.
Then push the Shift button and then the Home icon.
In the little window which pops up, click on number 2.
Clamping edge 2 is now saved under Home 2.

To retrieve one on these saved home positions, just click on the “Home” icon and the on the number of the home you want to recall.

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