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**Category: CONTROL**  
**Model: MC / VB / MB-R**  
**Control: Touch 2100**

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**PART 1**

1. Line up the home markers for all axis (or just the axis you need to reset home)
2. If you are unable to complete step 1. due to the control thinking it is hitting the limit skip to Part 2 of this document
3. Once the home markers are aligned you can safely proceed
4. E-Stop In
5. Menu Select
6. CNC ISO
7. CNC ISO √
8. Menu Select
9. Machine Data
10. Start-Up
11. Axis MD
12. Find
13. 34210 (This will read ENC\_REFP\_STATE[0])
14. OK
15. Select the proper axis with the Axis + and Axis – soft keys
16. Change Parameter 34210 to a 1
17. Input
18. Turn the feed rate over ride all the way down
19. E-Stop Out
20. Reset
21. Home Return (Should say Jog Ref at the top of the screen)
22. For a mill press Axis + (refers to the hard key for the axis you have selected) For a lathe press Cycle Start
23. 34210 should than change to a 2
24. Repeat steps 13. to 19. for every axis you need to re-set home on
25. When done make sure parameter 34210 show a 2 for all axis
26. Proceed to Part 2 next page

## **PART 2**

1. If you were unable to align the home markers complete this part first than return to step 4. of Part 1
2. Menu Select
3. CNC ISO
4. CNC ISO ✓
5. Menu Select
6. Start-Up
7. Axis MD
8. Find
9. 34210 (This will read ENC\_REFP\_STATE[0])
10. OK
11. Select the proper axis with the Axis + and Axis – soft keys
12. Change Parameter 34210 to a 0
13. Input
14. NCK Reset (Control will reset)
- 15. BE EXTREMELY CAREFUL AS YOU CAN NOW CRASH THIS AXIS!!!**
16. Repeat steps 2. through 15. for every axis which you were unable to align the markers on
17. Once this is done and the markers are aligned return to step 3. on the main procedure