OmniTurn Technical Support

Setting metric as default mode



1: Start machine, get to the Jog mode and Home the machine normally



2: After homing press A for Automatic and select any program



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Enter-Select 4 exit
Partic plant
C - copy file
D - white file
D - whit

3: Select any program



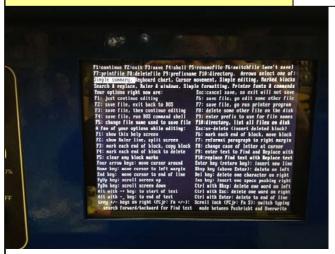
4: Press F3 to go to the editor Then press ESC key to not create a new file



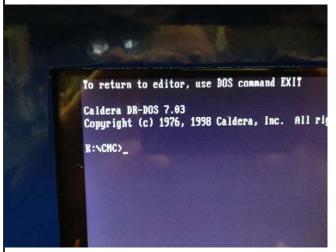
5: When you see the program press F1 to go to the help menu

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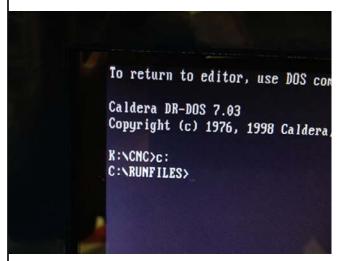
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6: On the help screen press F4 to go to DOS



7: After pressing F4 you will land on this screen.



8: Type **C:** and then **enter**, you will land on the C:\RUNFILES> directory



9: type **edit filepath.cfg** and then **enter**. This will start the editor, then press ESC for no backup

```
Fi Help. Push JustOff. 98% Free. 0% Thru. Read "filepath.cfg"
c:\runfiles\tcnp."tool offset file
c:\runfiles\sectcmp."secondary offset file
c:\runfiles\sectcmp."secondary offset file
c:\runfiles\sectcmp."secondary offset file
c:\runfiles\sectcmp."secondary programs
CX2"axes recognized(in alpha order)
100"nax feedrate in enc. cts./ns
4800"nax rpm
1"0 for single, naintained collet signal, 1 for pulsed
1"background color
15"foreground color
8"secondary foreground color
15"background color for active selections
1"foreground color for active selections
4"background color for banners
15"foreground color f
```

10: You land on this page. You need to change the 0 to a 1 as shown below.

```
c:\runfiles\tcnp.~teol offset file
c:\runfiles\tcnp.~secondary offset file
c:\runfiles\sectcnp.~secondary foreground
100 max feedrate in enc. cts./ms
4000 max rpm
1~0 for single, maintained collet signal, 1 for pulsed
1~background color
15~foreground color
6~secondary foreground color
15~background color for active selections
1~foreground color for active selections
1~foreground color for banners
15~foreground color for banners
15~foreground color for banners
1~1 for bipolar spindle ref.0 for + only
1~1 for default metric mode.0 for inch
yask~yask for yask c:baum or inv denote other spin types
The control software only reads each line up to the ~
```

11: After changing to a 1, press F1, then F2 to exit and save. Now reboot the machine in the metric mode.