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## How to Switch from Run Mode to Teach Mode

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<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
</table>
| 1 | ![F1](image) | • Press F1.  
• MOVE UP / DOWN to TEACH/RUN.  
• Press ENTER. | ![Program Menu](image) |
| 2 | ![Home](image) | • Press HOME. If prompted, enter a password. | ![Teach Mode](image) |
How to Make a Dot

PREREQUISITES

- The system is in the Teach Mode. Refer to “How to Switch from Run Mode to Teach Mode” on page 3.

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td></td>
<td>• Jog the dispensing tip to the desired XYZR location for the dispense dot.</td>
<td></td>
</tr>
</tbody>
</table>
| 2  | Shift > Type | • Press SHIFT > TYPE to open the Dispense Dot screen.  
• Make XYZR coordinate changes as needed. | ![Dispense Dot 1/3](image) X: 130.93 mm  
Y: 37.39 mm  
Z: 45.54 mm  
R: 89.32 deg  
| 3  | F2 > F1 | • Press F2 to move through the Dispense Dot parameter screens.  
• Press F1 to save and exit. | ![Dispense Dot 3/3](image) Retract Distance: 100.00 mm  
Retract Low: 10.0 mm/s  
Retract High: 10.0 mm/s  
[F1] OK [F2] Next |
| 4  | Shift > End | • Press SHIFT > END to register the end of the program. |                                                            |
| 5  |          | • Press START to run the program. |                                                            |
How to Make a Line

PREREQUISITES

The system is in the Teach Mode. Refer to “How to Switch from Run Mode to Teach Mode” on page 3.

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td></td>
<td>• Jog the dispensing tip to an XYZR location for the first dispense point (Line Start).</td>
<td><img src="image" alt="Teach Pendant Display" /></td>
</tr>
<tr>
<td>2</td>
<td>Shift &gt; 1</td>
<td>• Press SHIFT &gt; 1 to register the location as a Line Start point.</td>
<td><img src="image" alt="Teach Pendant Display" /></td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Make XYZR coordinate changes as needed.</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>F2</td>
<td>• Press F2 to move to the Line Start parameter screen.</td>
<td><img src="image" alt="Teach Pendant Display" /></td>
</tr>
<tr>
<td></td>
<td>F1</td>
<td>• Press F1 to save and exit.</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td></td>
<td>• Jog the tip to the XYZR location of the second point (Line Passing).</td>
<td></td>
</tr>
<tr>
<td>5</td>
<td>Shift &gt; 2</td>
<td>• Press SHIFT &gt; 2 to register the location as a Line Passing point.</td>
<td><img src="image" alt="Teach Pendant Display" /></td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Make XYZR coordinate changes as needed.</td>
<td></td>
</tr>
<tr>
<td>6</td>
<td>F2</td>
<td>• Press F2 to move to the Line Passing parameter screen.</td>
<td><img src="image" alt="Teach Pendant Display" /></td>
</tr>
<tr>
<td></td>
<td>F1</td>
<td>• Press F1 to save and exit.</td>
<td></td>
</tr>
</tbody>
</table>

Continued on next page
How to Make a Line (continued)

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
<tbody>
<tr>
<td>7</td>
<td>![Jog Arrow]</td>
<td>• Jog the tip to the XYZR location of for the last dispense point (Line End).</td>
<td>![Teach Pendant Display]</td>
</tr>
<tr>
<td>8</td>
<td>Shift &gt; 3</td>
<td>• Press SHIFT &gt; 3 to register the location as a Line End point. • Make XYZR coordinate changes as needed.</td>
<td>![Teach Pendant Display]</td>
</tr>
<tr>
<td>9</td>
<td>F2 &gt; F1</td>
<td>• Press F2 to move through the Line End parameter screens. • Press F1 to save and exit.</td>
<td>![Teach Pendant Display]</td>
</tr>
<tr>
<td>10</td>
<td>Shift &gt; End</td>
<td>• Press SHIFT &gt; END to register the end of the program.</td>
<td>![Teach Pendant Display]</td>
</tr>
<tr>
<td>11</td>
<td>![Play Button]</td>
<td>• Press START to run the program.</td>
<td></td>
</tr>
</tbody>
</table>

Line End 1/4
---------------------
X: 130.93 mm
Y: 37.39 mm
Z: 45.54 mm
R: 89.32 deg

Line End 4/4
---------------------
Retract Distance: 0.00 mm
Retract Low: 20.0 mm/s
Retract High: 80.0 mm/s
[F1] OK [F2] Next
How to Make an Arc

PREREQUISITES

- The system is in the Teach Mode. Refer to “How to Switch from Run Mode to Teach Mode” on page 3.

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td></td>
<td>Jog the dispensing tip to an XYZR location for the first dispense point (Line Start).</td>
<td>![Teach Pendant Display](Line Start 1/2 X: 130.93 mm Y: 37.39 mm Z: 45.54 mm R: 89.32 deg [F1] OK [F2] Next [F3] Current)</td>
</tr>
<tr>
<td>2</td>
<td>Shift &gt; 1</td>
<td>Press SHIFT &gt; 1 to register the location as a Line Start point.</td>
<td>Line Start 1/2 X: 130.93 mm Y: 37.39 mm Z: 45.54 mm R: 89.32 deg [F1] OK [F2] Next [F3] Current</td>
</tr>
<tr>
<td>3</td>
<td>F2 &gt; F1</td>
<td>Press F2 to move to the Line Start parameter screen.</td>
<td>Line Start 2/2 Line Speed: 10.0 mm/s R Speed: 360.0 deg/s Pre-move Delay: 0.00 s Settling Distance: 0.00 mm Dispenser Off(0)/On(1): 1 [F1] OK [F2] Next</td>
</tr>
<tr>
<td>4</td>
<td></td>
<td>Jog the tip to the XYZR location of where the top of the arc should be (Arc Point).</td>
<td>![Teach Pendant Display](Arc Point)</td>
</tr>
<tr>
<td>5</td>
<td>Shift &gt;</td>
<td>Press SHIFT &gt; MENU1 to register the location as an Arc Point.</td>
<td>Arc Point X: 130.93 mm Y: 37.39 mm Z: 45.54 mm R: 89.32 deg [F1] OK [F3] Current</td>
</tr>
<tr>
<td>6</td>
<td>F1</td>
<td>Make XYZR coordinate changes as needed.</td>
<td><img src="F1" alt="Teach Pendant Display" /></td>
</tr>
</tbody>
</table>

• Jog the tip to the XYZR location where the arc should end (Line End).
## How to Make an Arc (continued)

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
</table>
| 7 | Shift > 3 | • Press SHIFT > 3 to register the location as a Line End point.  
• Make XYZR coordinate changes as needed. | ![Line End 1/4](attachment:line_end_1_4.png) |
| 8 | F2 > F1 | • Press F2 to move through the Line End parameter screens.  
• Press F1 to save and exit. | ![Line End 4/4](attachment:line_end_4_4.png) |
| 9 | Shift > End | • Press SHIFT > END to register the end of the program. |  |
| 10 |  | • Press START to run the program. |  |
# How to Make a Circle

## PREREQUISITES

- The system is in the Teach Mode. Refer to “How to Switch from Run Mode to Teach Mode” on page 3.

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
</table>
| 1 | Shift > 4 > F1 or F2 | • Press SHIFT > 4 to open the Circle menu.  
• Press F1 to make a circle by selecting three points on the diameter of the circle.  
• Press F2 to make a circle by entering the center point of the circle. | Circle  
[STI] 3-Point [F2] Center Point |
| 2 | | • Follow the directions on the display to enter the XYZR coordinates. | |
| 3 | F2 > F1 | • Press F2 to move through the Circle parameter screens.  
• Press F1 to save and exit. | Circle  
5/5  
Retract Distance: 0.00 mm  
Retract Low: 10.0 mm/s  
Retract High: 80.0 mm/s  
[F1] OK [F2] Next |
| 4 | Shift > END | • Press SHIFT > END to register the end of the program. | |
| 5 | | • Press START to run the program. | |
How to Fill an Area

PREREQUISITES

The system is in the Teach Mode. Refer to “How to Switch from Run Mode to Teach Mode” on page 3.

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
</table>
| 1 | Shift > 9 > 1 | • Press SHIFT > 9 to open the Fill Area menu, then select the Fill Type.  
• Press 1 RECTANGLE.  
**NOTE:** This procedure shows how to fill a rectangle. | Fill Area 1/2  
Fill Type: 2  
1 Rectangle 5 Circle Out  
2 Rectangle In 6 Polygon In  
3 Rectangle Out 7 Polygon Out  
4 Circle In  
[F1] OK [F2] Next |
| 2 | F2 > xx.xx > F1 | • Press F2 to move to the Fill Area parameter screen.  
• Enter the Width and Band settings for the area to be filled, then press F1 to save the setting and return to the program. | Fill Area 2/2  
Width: 0.00 mm  
Band: 0.00 mm  
[F1] OK [F2] Next |
| 3 | Shift > 1 | • Jog the dispensing tip to the top left corner of the area to be filled. | |
| 4 | Shift > 1 | • Press SHIFT > 1 to register the location as a Line Start point. | Line Start 1/2  
X: 130.93 mm  
Y: 37.39 mm  
Z: 45.54 mm  
R: 89.32 deg  
| 5 | F2 > F1 | • Press F2 to move to the Line Start parameter screen.  
• Press F1 to save and exit. | Line Start 2/2  
Line Speed: 10.0 mm/s  
Pre-move Delay: 0.00 s  
Settling Distance: 0.00 mm  
Dispenser Off(0)/On(1): 1  
[F1] OK [F2] Next |
| 6 | Shift > 1 | • Jog the dispensing tip to the bottom right corner of the area to be filled. | |

Continued on next page
# How to Fill an Area (continued)

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
<tbody>
<tr>
<td>7</td>
<td>Press SHIFT &gt; 3 to register the location as a Line End point.</td>
<td><img src="image1.png" alt="Image" /> Line End 1/4&lt;br&gt;X: 130.93 mm&lt;br&gt;Y: 37.39 mm&lt;br&gt;Z: 45.54 mm&lt;br&gt;R: 89.32 deg&lt;br&gt;[F1] OK [F2] Next [F3] Current</td>
<td></td>
</tr>
<tr>
<td>8</td>
<td>Press F2 to move through the Line End parameter screens. Press F1 to save and exit.</td>
<td><img src="image2.png" alt="Image" /> Line End 4/4&lt;br&gt;Retract Distance: 0.00 mm&lt;br&gt;Retract Low: 20.0 mm/s&lt;br&gt;Retract High: 80.0 mm/s&lt;br&gt;[F1] OK [F2] Next</td>
<td></td>
</tr>
<tr>
<td>9</td>
<td>Press SHIFT &gt; END to register the end of the program.</td>
<td><img src="image3.png" alt="Image" /></td>
<td></td>
</tr>
<tr>
<td>10</td>
<td>Press START to run the program.</td>
<td><img src="image4.png" alt="Image" /></td>
<td></td>
</tr>
</tbody>
</table>
How to Make an Array of Dots (Step & Repeat)

Use Step & Repeat to dispense the same pattern on multiple workpieces in an array.

PREREQUISITES

- The system is in the Teach Mode. Refer to “How to Switch from Run Mode to Teach Mode” on page 3.
- Multiple workpieces are properly positioned on the fixture plate.

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
</table>
| 1  | Shift > 8 > 2 > F1 | • Press SHIFT > 8 to open the Label screen.  
• Enter a Label number (in this example, the number 2).  
• Press F1 to save and exit. | ![Label screen](image) |
| 2  | | • Jog the dispensing tip to the desired XYZR location for the first dispense dot. | ![Dispense Dot screen](image) |
| 3  | Shift > Type | • Press SHIFT > TYPE to open the Dispense Dot screen.  
• Make XYZR coordinate changes as needed. | ![Dispense Dot screen](image) |
| 4  | F2 > F1 | • Press F2 to move through the Dispense Dot parameter screens.  
• Press F1 to save and exit. | ![Dispense Dot screen](image) |
| 5  | Shift > 5 > F1 | • Press SHIFT > 5 to open the Step & Repeat menu.  
• Press F1. | ![Step & Repeat menu](image) |

Continued on next page
## How to Make an Array of Dots (Step & Repeat) (continued)

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
<tbody>
<tr>
<td>6</td>
<td>F2</td>
<td>• Press F2 to move to the next screen.</td>
<td><img src="image" alt="Teach Pendant Display" /></td>
</tr>
<tr>
<td></td>
<td></td>
<td><img src="image" alt="Teach Pendant Display" /></td>
<td></td>
</tr>
</tbody>
</table>
| 7  | 2 > F1    | • Enter 2 in the Column field.  
  • Enter 2 in the Row field.  
  • Enter the label number from step 1 for Goto Label (in this example, 2).  
  • Press F1 to save and exit. | ![Teach Pendant Display](image) |
|    |           | ![Teach Pendant Display](image) | |
| 8  | Shift > End | • Press SHIFT > END to register the END of the program. | |
| 9  |          | • Press START to test the program. | |
How to Make a Rotating Circle

**PREREQUISITES**

- The system is in the Teach Mode. Refer to “How to Switch from Run Mode to Teach Mode” on page 3.

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td><img src="electron.png" alt="" /></td>
<td>• Jog the dispensing tip to the first XYZR dispense location (1. Line Start).</td>
<td></td>
</tr>
</tbody>
</table>
| 2 | Shift > 1 | • Press SHIFT > 1 to register the location as a Line Start point.  
• Rotate to 0 for coordinate R. | Line Start 1/2  
X: 130.93 mm  
Y: 37.39 mm  
Z: 45.54 mm  
R: 0 deg  
| 3 | F2 > F1 | • Press F2 to move to the Line Start parameter screen.  
• Press F1 to save and exit. | Line Start 2/2  
Line Speed: 10.0 mm/s  
Pre-move Delay: 0.00 s  
Settling Distance: 0.00 mm  
Dispenser Off(0)/On(1): 1  
[F1] OK [F2] Next |
| 4 | ![](electron.png) | • Jog the dispensing tip to the second XYZR dispense location (2. Arc Point). | |
| 5 | Shift > MENU1 > F1 | • Press SHIFT > MENU1 to register the location as an Arc Point.  
• Rotate to 90 for coordinate R.  
• Press F1 to save and exit. | Arc Point  
X: 130.93 mm  
Y: 37.39 mm  
Z: 45.54 mm  
R: 90.00 deg  
[F1] OK [F3] Current |
| 6 | ![](electron.png) | • Jog the dispensing tip to the third XYZR dispense location (3. Line Passing). | |
## How to Make a Rotating Circle (continued)

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
</table>
| 7 | Shift > 2 | Press SHIFT > 2 to register the location as a Line Passing point.  
  • Enter 180 for coordinate R. | Line Passing 1/2  
  X: 130.93 mm  
  Y: 37.39 mm  
  Z: 45.54 mm  
  R: 180.00 deg  
| 8 | F2 > F1 | Press F2 to move to the Line Passing parameter screen.  
  • Press F1 to save and exit. | Line Passing 2/2  
  Line Speed: 10.0 mm/s  
  Node Time: 0.00 s  
  Dispenser Off(0)/On(1): 1  
  [F1] OK [F2] Next |
| 9 | Jog the dispensing tip to the fourth XYZR dispense location (4. Arc Point). | Arc Point  
  X: 130.93 mm  
  Y: 37.39 mm  
  Z: 45.54 mm  
  R: 270.00 deg  
  [F1] OK |
| 10 | Shift > MENU1 > F1 | Press SHIFT > MENU1 to register the location as an Arc Point.  
  • Enter 270 for coordinate R.  
  • Press F1 to save and exit. | Arc Point  
  X: 130.93 mm  
  Y: 37.39 mm  
  Z: 45.54 mm  
  R: 270.00 deg  
  [F1] OK [F3] Current |
| 11 | Jog the dispensing tip to the fifth dispense location (5. Line End). | Line End 1/4  
  X: 130.93 mm  
  Y: 37.39 mm  
  Z: 45.54 mm  
  R: 360.00 deg  
| 12 | Shift > 3 | Press SHIFT > 3 to register the location as a Line End point.  
  • Enter 360 for coordinate R. | Line End 4/4  
  Retract Distance: 0.00 mm  
  Retract Low: 20.0 mm/s  
  Retract High: 80.0 mm/s  
  [F1] OK [F2] Next |
| 13 | F2 > F1 | Press F2 to move through the Line End parameter screens.  
  • Press F1 to save and exit. | Line End 1/4  
  X: 130.93 mm  
  Y: 37.39 mm  
  Z: 45.54 mm  
  R: 360.00 deg  
| 14 | Shift > END | Press SHIFT > END to register the END of the program. | Line End 4/4  
  Retract Distance: 0.00 mm  
  Retract Low: 20.0 mm/s  
  Retract High: 80.0 mm/s  
  [F1] OK [F2] Next |
| 15 | Press START to test the program. |
Calibrating the Tip Height

Systems without a Tip Aligner

Set a Calibration Point (Initial Setup for Needle Adjust)

PREREQUISITES

☐ The system is in the Teach Mode. Refer to “How to Switch from Run Mode to Teach Mode” on page 3.

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
</table>
| 1 | [Setup]  | • Press SETUP.  
    |           | • MOVE UP / DOWN to CALIBRATION POINT.  
    |           | • Press ENTER.  |  
| 2 | [CALIBRATION POINT]  | • Jog the tip down until it is as close to the fixture plate surface as possible.  
    |           | • Press F1 to save the setting.  |
Calibrating the Tip Height (continued)

Recalibrate the Tip (Needle Adjust)

Prerequisites

The tip height is calibrated. Refer to “Set a Calibration Point (Initial Setup for Needle Adjust)” on page 16.

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>• Press F1. • MOVE UP / DOWN to NEEDLE ADJUST. • Press ENTER.</td>
<td><img src="image1.png" alt="Image" /></td>
<td><img src="image2.png" alt="Image" /></td>
</tr>
<tr>
<td>2</td>
<td>• Press ENTER. The dispensing tip moves to the user-defined calibration point. <strong>NOTE:</strong> The tip will be 5 mm (0.2”) higher than the calibrated point to prevent possible crushing of the tip.</td>
<td><img src="image3.png" alt="Image" /></td>
<td><img src="image4.png" alt="Image" /></td>
</tr>
<tr>
<td>3</td>
<td>• Jog the tip until it is centered over the calibration point. • Press ENTER. The needle automatically rotates to 180 degrees.</td>
<td><img src="image5.png" alt="Image" /></td>
<td><img src="image6.png" alt="Image" /></td>
</tr>
<tr>
<td>4</td>
<td>• Jog the tip over the calibration point. • Press ENTER.</td>
<td><img src="image7.png" alt="Image" /></td>
<td><img src="image8.png" alt="Image" /></td>
</tr>
<tr>
<td>5</td>
<td>• Press F1 to adjust only the currently open dispense program for the re-calibrated tip height. <strong>or</strong> • Press F2 to adjust all dispense programs for the re-calibrated tip height.</td>
<td><img src="image9.png" alt="Image" /></td>
<td><img src="image10.png" alt="Image" /></td>
</tr>
</tbody>
</table>
Calibrating the Tip Height (continued)

Systems with a Tip Aligner

Set a Calibration Point (Initial Setup for Auto Needle Adjust)

PREREQUISITES

- The system is in the Teach Mode. Refer to “How to Switch from Run Mode to Teach Mode” on page 3.

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
</table>
| 1 | ![Setup](image1) | • Press SETUP.  
• MOVE UP / DOWN to NEEDLE DETECT SETUP.  
• Press ENTER. | ![SETUP](image2) 2/3  
08 Program Output Status  
09 Pause Status  
10 Auto Purge  
11 Pre-cycle Initialize  
12 Pre-dispense Wait Time  
13 Default Dispense Port  
14*Needle Detect Setup |
| 2 | ![Jog](image3) | • Jog the tip to the tip aligner and lower the tip until it is as close to the crosshairs (cross point) as possible  
• Press F1.  
The Needle Detect Setup screen appears. | ![Needle Detect Setup](image4)  
Jog tip to needle detect device cross point  
[F1] OK |
| 3 | ![F1](image5) | • Press F1.  
The system begins the calibration. | ![Needle Detect Setup](image6)  
Press [F1] to search for needle position |
| 4 | ![F1](image7) | • Press F1 to accept the calibration.  
**NOTE:** Press F2 to cancel the calibration. | ![Needle Detect Setup](image8)  
Reset position?  
[F1] Yes [F2] No |
## Calibrating the Tip Height (continued)

### Recalibrate the Tip (Auto Needle Adjust)

#### Prerequisites

- The needle detect position is calibrated. Refer to “Set a Calibration Point (Initial Setup for Auto Needle Adjust)” on page 18.

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Press F1.</td>
<td>MOVE UP / DOWN to AUTO NEEDLE ADJUST.</td>
<td><img src="image1" alt="Teach Pendant Display" /></td>
</tr>
<tr>
<td>2</td>
<td>Press ENTER.</td>
<td>The system automatically checks the tip height using the tip aligner and displays the offset updates needed to calibrate the tip height.</td>
<td><img src="image2" alt="Teach Pendant Display" /></td>
</tr>
<tr>
<td>3</td>
<td>Press F1.</td>
<td>After the search is complete, press F1 to accept the calibration.</td>
<td><img src="image3" alt="Teach Pendant Display" /></td>
</tr>
</tbody>
</table>
How to Open and Edit a Program

PREREQUISITES

The system is in the Teach Mode. Refer to “How to Switch from Run Mode to Teach Mode” on page 3.

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
</table>
| 1 |          | • Press F1.  
• MOVE UP / DOWN to PROGRAM LIST.  
• Press ENTER. | ![Program Menu] 1/1  
01 Teach/Run  
02 Program List  
03 Reset Counter  
04 Program Offset  
05 Needle Adjust  
06 Auto Needle Adjust |
| 2 |          | • MOVE UP / DOWN to select the desired program.  
• Press ENTER.  
The selected program becomes the current program and remains open until another program number is selected. | ![Program List]  
01 06  
02 07  
03*EXAMPLE 08  
04 09  
05 10  
[F1] OK |
| 3 |          | • MOVE UP / DOWN to select the command line to edit.  
• Press ENTER. | ![Dispense Dot]  
0001 Line Start 10.0,1  
0002 Line Passing 10.0,1  
0003 Arc Point  
0004*Dispense Dot  
0005 EMPTY  
0006 EMPTY  
0007 EMPTY  
0008 EMPTY |
| 4 |          | • Enter the new coordinates manually.  
or  
• Press F3 to update the XYZ values to the current tip location.  
• Press F1 to save and exit or ESC to cancel the changes. | ![Dispense Dot]  
X: 130.93 mm  
Y: 37.39 mm  
Z: 45.54 mm  
R: 89.32 deg  
| 5 |          | • Make other changes as needed.  
• Press F1 to save and exit. |
How to Name a Program

PREREQUISITES
The system is in the Teach Mode. Refer to “How to Switch from Run Mode to Teach Mode” on page 3.

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Press MENU1.</td>
<td>• MOVE UP / DOWN to PROGRAM NAME.</td>
<td>[MENU 1] 1/2 01 Group Edit 02 Ex. Step &amp; Repeat 03*Program Name 04 Axis Limit 05 Initialize Output 06 Jog Acceleration 07 Teach Move Z Clearance</td>
</tr>
<tr>
<td>1</td>
<td>Press Enter.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>Press the X jog buttons to move left / right and the Y jog buttons to move up / down through the characters.</td>
<td>• Press ENTER to select characters. • Press CLEAR to delete characters. • Press F1 to save and exit.</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>Program Name</td>
<td>Example</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td></td>
<td></td>
<td>D123456789-._ ABCDEFGHIJKLMNOPQRSTUVWXYZ</td>
</tr>
<tr>
<td>2</td>
<td></td>
<td>[F1] OK</td>
<td></td>
</tr>
</tbody>
</table>
How to Clear or Copy a Program

**PREREQUISITES**

- The system is in the Teach Mode. Refer to “How to Switch from Run Mode to Teach Mode” on page 3.
- The program you want to clear or copy is currently open. Refer to “How to Open and Edit a Program” on page 20.

<table>
<thead>
<tr>
<th>#</th>
<th>Key Press</th>
<th>Step</th>
<th>Teach Pendant Display</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Press MENU1.</td>
<td>• MOVE UP / DOWN to UTILITY MENU. • Press ENTER.</td>
<td>[MENU 1] 2/2 08*Utility Menu 09 Diagnostic</td>
</tr>
<tr>
<td>2</td>
<td></td>
<td>• MOVE UP / DOWN to PROGRAM. • Press ENTER.</td>
<td>[UTILITY] 1/1 01*Program 02 Memory 03 Key BEEP 04 Online Signals 05 Barcode Scanner 06 System Lockout</td>
</tr>
<tr>
<td>3</td>
<td>Press 1 CLEAR</td>
<td>• Press 1 CLEAR to empty all addresses in the current program. • Press 2 COPY to copy the current program. • Press F1 to continue.</td>
<td>Program Utility Program 1 1 Clear 2 Copy Select: _ [F1] OK</td>
</tr>
<tr>
<td>4</td>
<td>F1 or F2</td>
<td>• If you pressed 1 (Clear), the system prompts for confirmation. • Press F1 to accept the clear or F2 to cancel the clear.</td>
<td>Program Utility Clear Program 1 [F1] Yes [F2] No</td>
</tr>
<tr>
<td>5</td>
<td>XX &gt; F1</td>
<td>• If you pressed 2 (Copy), the system prompts for the program number to copy to (program number 1–99). • Press F1 to copy all program contents to the selected program number. <strong>NOTE:</strong> If the destination program is not empty, the program contents are overwritten by the copied program.</td>
<td>Program Utility Copy Program 1 To: _ [F1] OK</td>
</tr>
</tbody>
</table>