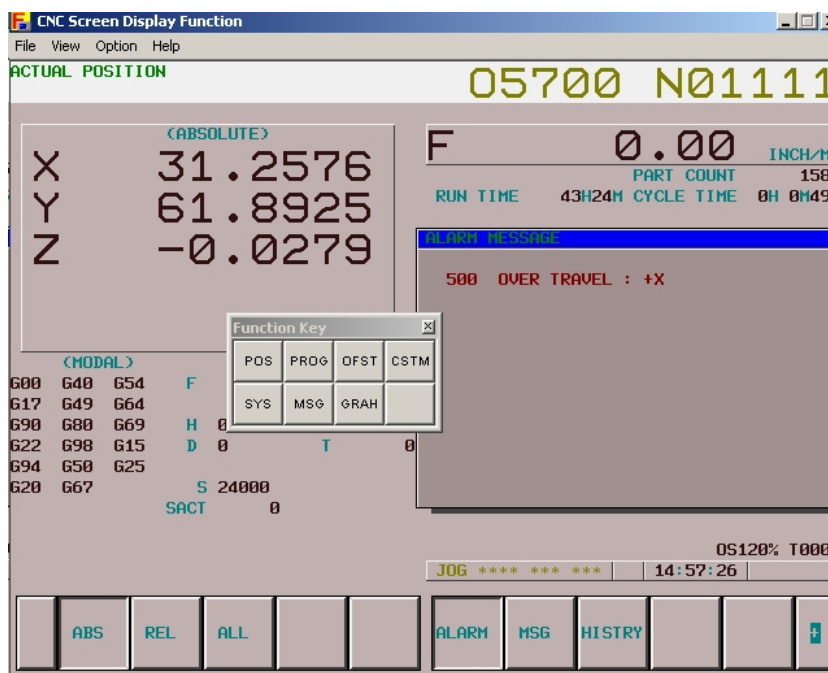
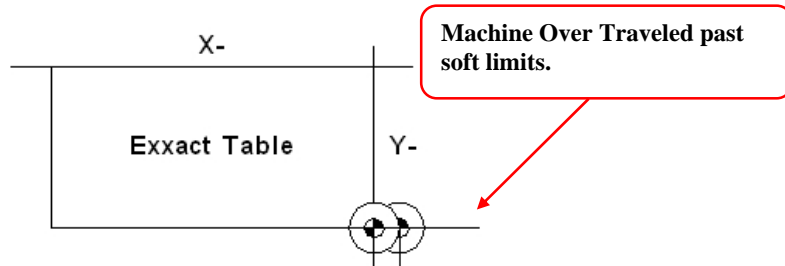


Soft Over Travel Procedure

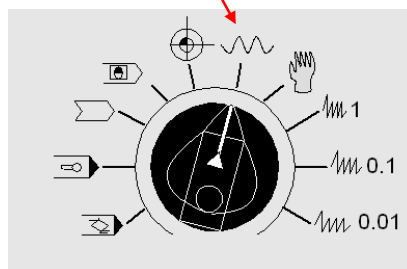
When to use: If a program or jog move forces either the X, Y, Z or optional V axes past the work envelop of the machine the machine will display and over travel position error.

There are two types of over travel errors. **Soft Over travel** which occurs when the machine travels past its controller limits. **Hard Over** occurs when the machine passes both the soft over travel limits and physical limit switches. This bulletin covers a soft over travel situation.

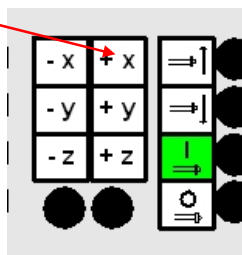
To clear the **500 Over Travel** error switch the machine into Jog Mode and jog the machine in the opposite position of the over travel. Finally, press to rest button to clear the error.



Place controller in jog mode



Jog machine off Limits



Press the reset button

Hit the rest button to clear error.

