

# DC

## FUNCTION

**F**

All of operation for function starts from F key

- F**
- 1. LATHE : Summing function for lathe (38p)
  - 2. CIRCLE : Bolt hole circle (22 ~ 24p)
  - 3. SCALE : Changing resolution
  - 4. DIR : Changing processing direction
  - 5. RATE : Rate, Correction or Compensation.
  - 6. DIA : Double counting for lathe (39 ~ 40p)
  - 7. RESET: Initializing function
  - 8. TEST: FND (Flexible Numeric Display) testing

# 1. Changing resolution (SCALE)

1) 5/1000mm (3.SCALE)  
(0.0002 inch)

<b>F</b> → <b>▶</b> → <b>▶</b> → <b>ENT</b> → <b>X</b> → <b>ENT</b> → <b>5</b> → <b>ENT</b>	After applying new resolution, 0.000 will be displayed. Resolution should be set according to the scale's resolution																																			
<div style="display: flex; justify-content: space-between; align-items: flex-start;"> <div style="width: 20%;"> <p><b>F</b> <b>▶</b> <b>▶</b> (Double)</p> <p><b>ENT</b></p> <p><b>X</b></p> <p><b>ENT</b></p> <p><b>5</b></p> <p><b>ENT</b></p> </div> <div style="width: 75%; text-align: center;"> <table border="1" style="margin-bottom: 5px;"> <tr><td>X</td><td>35cALE</td></tr> <tr><td>Y</td><td>0.000</td></tr> <tr><td>Z</td><td>0.000</td></tr> </table> <p><b>ENT</b></p> <table border="1" style="margin-bottom: 5px;"> <tr><td>X</td><td>35cALE</td></tr> <tr><td>Y</td><td>SEL RH 15</td></tr> <tr><td>Z</td><td>0.000</td></tr> </table> <p><b>ENT</b></p> <table border="1" style="margin-bottom: 5px;"> <tr><td>X</td><td>5.000</td></tr> <tr><td>Y</td><td>SEL RH 15</td></tr> <tr><td>Z</td><td>0.000</td></tr> </table> <p><b>ENT</b></p> <table border="1" style="margin-bottom: 5px;"> <tr><td>X</td><td>5.000</td></tr> <tr><td>Y</td><td>SEL RH 15</td></tr> <tr><td>Z</td><td>0.000</td></tr> </table> <p><b>ENT</b></p> <table border="1" style="margin-bottom: 5px;"> <tr><td>X</td><td>5.000</td></tr> <tr><td>Y</td><td>SEL RH 15</td></tr> <tr><td>Z</td><td>0.000</td></tr> </table> <p><b>ENT</b></p> <table border="1" style="margin-bottom: 5px;"> <tr><td>X</td><td>0.000</td></tr> <tr><td>Y</td><td>0.000</td></tr> <tr><td>Z</td><td>0.000</td></tr> </table> </div> </div>	X	35cALE	Y	0.000	Z	0.000	X	35cALE	Y	SEL RH 15	Z	0.000	X	5.000	Y	SEL RH 15	Z	0.000	X	5.000	Y	SEL RH 15	Z	0.000	X	5.000	Y	SEL RH 15	Z	0.000	X	0.000	Y	0.000	Z	0.000
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2) 1/1000mm (3.ScALE)  
 (0.00004 inch)

**F** → **▶** → **▶** → **ENT** → **X** → **ENT** → **1** → **ENT**

After applying new resolution, 0.000 will be displayed.  
 Resolution should be set according to the scale's resolution

**F** **▶** **▶**  
 (Double)

X	35cALE
Y	0.000
Z	0.000

**ENT**

**ENT**

X	35cALE
Y	SEL RH 15
Z	0.000

**ENT**

**X**

X	5.000
Y	SEL RH 15
Z	0.000

**ENT**

**ENT**

X	5.000
Y	SEL RH 15
Z	0.000

**ENT**

**1**

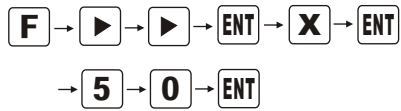
X	1.000
Y	SEL RH 15
Z	0.000

**ENT**

**ENT**

X	0.000
Y	0.000
Z	0.000

3) 5/100mm (3.SCALE)  
(0.002 inch)



After applying new resolution, 0.000 will be displayed.  
Resolution should be set according to the scale's resolution

**F** **▶** **▶**  
(Double)

X	35cALE
Y	0.000
Z	0.000

ENT

**ENT**

X	35cALE
Y	SEL AH 15
Z	0.000

ENT

**X**

X	5.000
Y	SEL AH 15
Z	0.000

ENT

**ENT**

X	5.000
Y	SEL AH 15
Z	0.000

ENT

**5** **0**

X	50.000
Y	SEL AH 15
Z	0.000

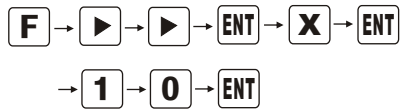
ENT

**ENT**

X	0.000
Y	0.000
Z	0.000

4) 1/100mm (3.ScALE)

(0.0004 inch)



After applying new resolution, 0.000 will be displayed.  
Resolution should be set according to the scale's resolution

F ▶ ▶  
 (Double)

X 35cALE  
 Y 0.000  
 Z 0.000  
 FUN

ENT

X 35cALE  
 Y SEL RH 15  
 Z 0.000  
 FUN

X

X 5.000  
 Y SEL RH 15  
 Z 0.000  
 FUN

ENT

X 5.000  
 Y SEL RH 15  
 Z 0.000  
 FUN

1 0

X 10.000  
 Y SEL RH 15  
 Z 0.000  
 FUN

ENT

X 0.000  
 Y 0.000  
 Z 0.000

## 2. Changing direction (4.dlr)

	Processing direction can be changed as below Left (+), Right(-) → Left (-), Right (+)																																						
<p>                   (3 times)             </p> <p> </p> <p> </p> <p> </p> <p> </p>	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 20px; text-align: right;">X</td> <td style="border: 1px solid black; padding: 2px;">4d lr</td> </tr> <tr> <td style="text-align: right;">Y</td> <td style="border: 1px solid black; padding: 2px;">0.000</td> </tr> <tr> <td style="text-align: right;">Z</td> <td style="border: 1px solid black; padding: 2px;">0.000</td> </tr> <tr> <td colspan="2" style="text-align: center;"></td> </tr> <tr> <td style="text-align: right;">X</td> <td style="border: 1px solid black; padding: 2px;">4d lr</td> </tr> <tr> <td style="text-align: right;">Y</td> <td style="border: 1px solid black; padding: 2px;">SEL RH IS</td> </tr> <tr> <td style="text-align: right;">Z</td> <td style="border: 1px solid black; padding: 2px;">0.000</td> </tr> <tr> <td colspan="2" style="text-align: center;"></td> </tr> <tr> <td style="text-align: right;">X</td> <td style="border: 1px solid black; padding: 2px;">d lr ---]</td> </tr> <tr> <td style="text-align: right;">Y</td> <td style="border: 1px solid black; padding: 2px;">SEL RH IS</td> </tr> <tr> <td style="text-align: right;">Z</td> <td style="border: 1px solid black; padding: 2px;">0.000</td> </tr> <tr> <td colspan="2" style="text-align: center;"></td> </tr> <tr> <td style="text-align: right;">X</td> <td style="border: 1px solid black; padding: 2px;">d lr [----</td> </tr> <tr> <td style="text-align: right;">Y</td> <td style="border: 1px solid black; padding: 2px;">SEL RH IS</td> </tr> <tr> <td style="text-align: right;">Z</td> <td style="border: 1px solid black; padding: 2px;">0.000</td> </tr> <tr> <td colspan="2" style="text-align: center;"></td> </tr> <tr> <td style="text-align: right;">X</td> <td style="border: 1px solid black; padding: 2px;">0.000</td> </tr> <tr> <td style="text-align: right;">Y</td> <td style="border: 1px solid black; padding: 2px;">0.000</td> </tr> <tr> <td style="text-align: right;">Z</td> <td style="border: 1px solid black; padding: 2px;">0.000</td> </tr> </table>	X	4d lr	Y	0.000	Z	0.000			X	4d lr	Y	SEL RH IS	Z	0.000			X	d lr ---]	Y	SEL RH IS	Z	0.000			X	d lr [----	Y	SEL RH IS	Z	0.000			X	0.000	Y	0.000	Z	0.000
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### 3. Rate or Correction (5.rAtE)

<p><b>F</b> → <b>▶</b> → <b>▶</b> → <b>▶</b> → <b>▶</b> → <b>ENT</b> → <b>X</b> → <b>ENT</b></p> <p>→ <span style="border: 1px dashed black; padding: 2px;">Input RATE</span> → <b>ENT</b></p>	<ul style="list-style-type: none"> <li>• In case measured distance(value) is different from real distance.</li> <li>• Initial value from factory is "1.000000".</li> <li>• Input range is 0.000001~9.999999.</li> <li>• If 0.000000 is set, there will not be displayed anything but "0".</li> </ul>
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<p><b>F</b> <b>▶</b> <b>▶</b> <b>▶</b> <b>▶</b> (4 times)</p> <p><b>ENT</b></p> <p><b>X</b></p> <p><b>ENT</b></p> <p><span style="border: 1px dashed black; padding: 2px;">Input RATE</span></p> <p><b>ENT</b></p>	<table style="width: 100%; border-collapse: collapse;"> <tr><td style="border-right: 1px solid black; padding: 2px;">X</td><td style="padding: 2px;">5.rAtE</td></tr> <tr><td style="border-right: 1px solid black; padding: 2px;">Y</td><td style="padding: 2px;">0.000</td></tr> <tr><td style="border-right: 1px solid black; padding: 2px;">Z</td><td style="padding: 2px;">0.000</td></tr> <tr><td colspan="2" style="text-align: center; padding: 2px;"><b>FUN</b></td></tr> </table> <table style="width: 100%; border-collapse: collapse;"> <tr><td style="border-right: 1px solid black; padding: 2px;">X</td><td style="padding: 2px;">5.rAtE</td></tr> <tr><td style="border-right: 1px solid black; padding: 2px;">Y</td><td style="padding: 2px;">SEL RH IS</td></tr> <tr><td style="border-right: 1px solid black; padding: 2px;">Z</td><td style="padding: 2px;">0.000</td></tr> <tr><td colspan="2" style="text-align: center; padding: 2px;"><b>FUN</b></td></tr> </table> <table style="width: 100%; border-collapse: collapse;"> <tr><td style="border-right: 1px solid black; padding: 2px;">X</td><td style="padding: 2px;">1.000000</td></tr> <tr><td style="border-right: 1px solid black; padding: 2px;">Y</td><td style="padding: 2px;">SEL RH IS</td></tr> <tr><td style="border-right: 1px solid black; padding: 2px;">Z</td><td style="padding: 2px;">0.000</td></tr> <tr><td colspan="2" style="text-align: center; padding: 2px;"><b>FUN</b></td></tr> </table> <table style="width: 100%; border-collapse: collapse;"> <tr><td style="border-right: 1px solid black; padding: 2px;">X</td><td style="padding: 2px;">1.000000</td></tr> <tr><td style="border-right: 1px solid black; padding: 2px;">Y</td><td style="padding: 2px;">SEL RH IS</td></tr> <tr><td style="border-right: 1px solid black; padding: 2px;">Z</td><td style="padding: 2px;">0.000</td></tr> <tr><td colspan="2" style="text-align: center; padding: 2px;"><b>FUN</b></td></tr> </table> <table style="width: 100%; border-collapse: collapse;"> <tr><td style="border-right: 1px solid black; padding: 2px;">X</td><td style="padding: 2px;">1.000000</td></tr> <tr><td style="border-right: 1px solid black; padding: 2px;">Y</td><td style="padding: 2px;">SEL RH IS</td></tr> <tr><td style="border-right: 1px solid black; padding: 2px;">Z</td><td style="padding: 2px;">0.000</td></tr> <tr><td colspan="2" style="text-align: center; padding: 2px;"><b>FUN</b></td></tr> </table> <table style="width: 100%; border-collapse: collapse;"> <tr><td style="border-right: 1px solid black; padding: 2px;">X</td><td style="padding: 2px;">0.000</td></tr> <tr><td style="border-right: 1px solid black; padding: 2px;">Y</td><td style="padding: 2px;">0.000</td></tr> <tr><td style="border-right: 1px solid black; padding: 2px;">Z</td><td style="padding: 2px;">0.000</td></tr> </table>	X	5.rAtE	Y	0.000	Z	0.000	<b>FUN</b>		X	5.rAtE	Y	SEL RH IS	Z	0.000	<b>FUN</b>		X	1.000000	Y	SEL RH IS	Z	0.000	<b>FUN</b>		X	1.000000	Y	SEL RH IS	Z	0.000	<b>FUN</b>		X	1.000000	Y	SEL RH IS	Z	0.000	<b>FUN</b>		X	0.000	Y	0.000	Z	0.000	<p>Input "1.000000" as a rate value</p>
X	5.rAtE																																															
Y	0.000																																															
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#### Correct or Compensation



Ex. 1

$$\frac{\text{Real distance (100.000)}}{\text{Measured distance (100.100)}} = 0.999000$$

Ex. 2

$$\frac{\text{Real distance (100.000)}}{\text{Measured distance (099.900)}} = 1.001001$$

REF.

$$\frac{\text{Value from a check master or a block gauge}}{\text{Value of display unit}}$$

Ex.3

Real distance = 100mm  
Measured distance = 100.4mm

$$\frac{100}{100.4} = 0.996015$$

**F** **▶** **▶** **▶** **▶**  
(4 times)

X	SCALE
Y	0.000
Z	0.000

**FUN**

**ENT**

X	SCALE
Y	SEL RH 15
Z	0.000

**FUN**

**X**

X	1000000
Y	SEL RH 15
Z	0.000

**FUN**

**ENT**

X	1000000
Y	SEL RH 15
Z	0.000

**FUN**

**0** **.** **9** **9** **6** **0** **1** **5**

X	0.996015
Y	SEL RH 15
Z	0.000

**FUN**

**ENT**

X	0.000
Y	0.000
Z	0.000



## 4.Reset function (7.rESEt)

### 1) ABS Reset (Delete ABS data)

<p> <span style="border: 1px solid black; padding: 2px;">F</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">ENT</span>  <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">ENT</span> </p>	<p>Be careful to use ABS reset, as this will delete all saved ABS data.</p>																														
<p> <span style="border: 1px solid black; padding: 2px;">F</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span>              (6 times)         </p> <p><span style="border: 1px solid black; padding: 2px;">ENT</span></p> <p><span style="border: 1px solid black; padding: 2px;">ENT</span></p>	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 20px;">X</td> <td style="border: 1px solid black; padding: 2px;">7rESEt</td> </tr> <tr> <td>Y</td> <td style="border: 1px solid black; padding: 2px;">0.000</td> </tr> <tr> <td>Z</td> <td style="border: 1px solid black; padding: 2px;">0.000</td> </tr> <tr> <td></td> <td style="text-align: center; border: 1px solid black; padding: 2px;">FUN</td> </tr> </table> <p style="text-align: right; margin-top: 10px;">Move to No.7</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 20px;">X</td> <td style="border: 1px solid black; padding: 2px;">1rSt Abs</td> </tr> <tr> <td>Y</td> <td style="border: 1px solid black; padding: 2px;">0.000</td> </tr> <tr> <td>Z</td> <td style="border: 1px solid black; padding: 2px;">0.000</td> </tr> <tr> <td></td> <td style="text-align: center; border: 1px solid black; padding: 2px;">FUN</td> </tr> </table> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 20px;">X</td> <td style="border: 1px solid black; padding: 2px;">1rSt Abs</td> </tr> <tr> <td>Y</td> <td style="border: 1px solid black; padding: 2px;">-- In It --</td> </tr> <tr> <td>Z</td> <td style="border: 1px solid black; padding: 2px;">0.000</td> </tr> <tr> <td></td> <td style="text-align: center; border: 1px solid black; padding: 2px;">FUN</td> </tr> </table> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 20px;">X</td> <td style="border: 1px solid black; padding: 2px;">0.000</td> </tr> <tr> <td>Y</td> <td style="border: 1px solid black; padding: 2px;">0.000</td> </tr> <tr> <td>Z</td> <td style="border: 1px solid black; padding: 2px;">0.000</td> </tr> </table>	X	7rESEt	Y	0.000	Z	0.000		FUN	X	1rSt Abs	Y	0.000	Z	0.000		FUN	X	1rSt Abs	Y	-- In It --	Z	0.000		FUN	X	0.000	Y	0.000	Z	0.000
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2) Program Reset (Delete all saved data)

<p> <span style="border: 1px solid black; padding: 2px;">F</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">ENT</span>                  → <span style="border: 1px solid black; padding: 2px;">▶</span> → <span style="border: 1px solid black; padding: 2px;">ENT</span> </p>	<p>1) All saved data deleted and return factory setting;</p> <ul style="list-style-type: none"> <li>* Resolution : 5/100.</li> <li>* Bolt hole circle : set as X &amp; Y-axis, radius</li> <li>* Direction : the state from factory</li> <li>* Rate : 1.000000</li> <li>* Removal of double counting function</li> </ul>
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<p> <span style="border: 1px solid black; padding: 2px;">F</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span> <span style="border: 1px solid black; padding: 2px;">▶</span>                  (6 times)             </p> <p><span style="border: 1px solid black; padding: 2px;">ENT</span></p> <p><span style="border: 1px solid black; padding: 2px;">▶</span></p> <p><span style="border: 1px solid black; padding: 2px;">ENT</span></p>	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td style="text-align: right;">X</td><td>7rESEt</td></tr> <tr><td style="text-align: right;">Y</td><td>0.000</td></tr> <tr><td style="text-align: right;">Z</td><td>0.000</td></tr> <tr><td colspan="2" style="text-align: center;"><span style="border: 1px solid black; padding: 2px;">RUN</span></td></tr> </table> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td style="text-align: right;">X</td><td>1r5t Abs</td></tr> <tr><td style="text-align: right;">Y</td><td>0.000</td></tr> <tr><td style="text-align: right;">Z</td><td>0.000</td></tr> <tr><td colspan="2" style="text-align: center;"><span style="border: 1px solid black; padding: 2px;">RUN</span></td></tr> </table> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td style="text-align: right;">X</td><td>2r5t ALL</td></tr> <tr><td style="text-align: right;">Y</td><td>0.000</td></tr> <tr><td style="text-align: right;">Z</td><td>0.000</td></tr> <tr><td colspan="2" style="text-align: center;"><span style="border: 1px solid black; padding: 2px;">RUN</span></td></tr> </table> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td style="text-align: right;">X</td><td>2r5t ALL</td></tr> <tr><td style="text-align: right;">Y</td><td>-- In It --</td></tr> <tr><td style="text-align: right;">Z</td><td>0.000</td></tr> <tr><td colspan="2" style="text-align: center;"><span style="border: 1px solid black; padding: 2px;">RUN</span></td></tr> </table> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td style="text-align: right;">X</td><td>0.000</td></tr> <tr><td style="text-align: right;">Y</td><td>0.000</td></tr> <tr><td style="text-align: right;">Z</td><td>0.000</td></tr> </table>	X	7rESEt	Y	0.000	Z	0.000	<span style="border: 1px solid black; padding: 2px;">RUN</span>		X	1r5t Abs	Y	0.000	Z	0.000	<span style="border: 1px solid black; padding: 2px;">RUN</span>		X	2r5t ALL	Y	0.000	Z	0.000	<span style="border: 1px solid black; padding: 2px;">RUN</span>		X	2r5t ALL	Y	-- In It --	Z	0.000	<span style="border: 1px solid black; padding: 2px;">RUN</span>		X	0.000	Y	0.000	Z	0.000	<p>Move to No.7</p>
X	7rESEt																																							
Y	0.000																																							
Z	0.000																																							
<span style="border: 1px solid black; padding: 2px;">RUN</span>																																								
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## 5. Testing FND (8.tESt)

<p> <b>F</b> → <b>▶</b> → <b>▶</b> → <b>▶</b> → <b>▶</b> → <b>▶</b> → <b>▶</b> → <b>▶</b>          → <b>ENT</b> → <b>CE</b> </p>	<p>Check FND (Flexible Numeric Display)</p>
<p> <b>F</b> <b>▶</b> <b>▶</b> <b>▶</b> <b>▶</b> <b>▶</b> <b>▶</b> <b>▶</b>          (7 times)       </p> <p style="text-align: right;"> <b>X</b> <b>8.tESt</b>  <b>Y</b> <b>0.000</b>  <b>Z</b> <b>0.000</b>  <b>FUN</b> </p> <p style="text-align: right;"> <b>X</b> <b>11111111</b> •  <b>Y</b> <b>11111111</b> •  <b>Z</b> <b>11111111</b> •  <b>DIA INCH FULL REF ABS CIR 11</b> </p> <p style="text-align: right;"> <b>X</b> <b>0.000</b>  <b>Y</b> <b>0.000</b>  <b>Z</b> <b>0.000</b>  <b>FUN</b> </p> <p style="text-align: right;"> <b>X</b> <b>0.000</b>  <b>Y</b> <b>0.000</b>  <b>Z</b> <b>0.000</b> </p> <p><b>CE</b></p>	<p>Move to No.8</p> <p>During the test, all of the numbers changing from 1 to 8. This is repeated 3 times.</p> <p>To quit testing, push <b>CE</b> key.</p>