



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



3: Select any program



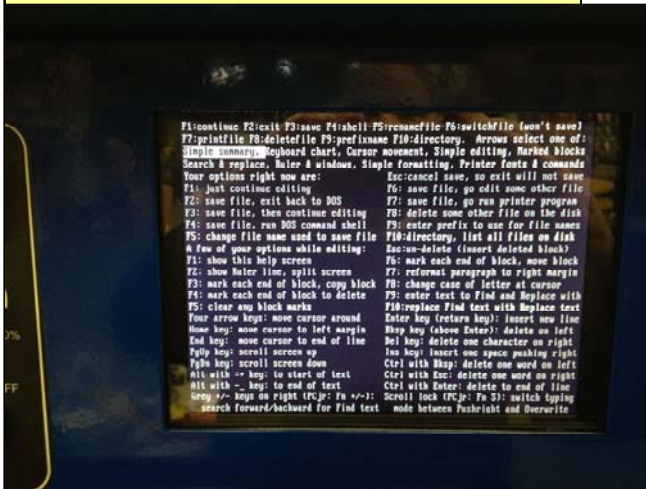
2: After homing press A for Automatic and select any program



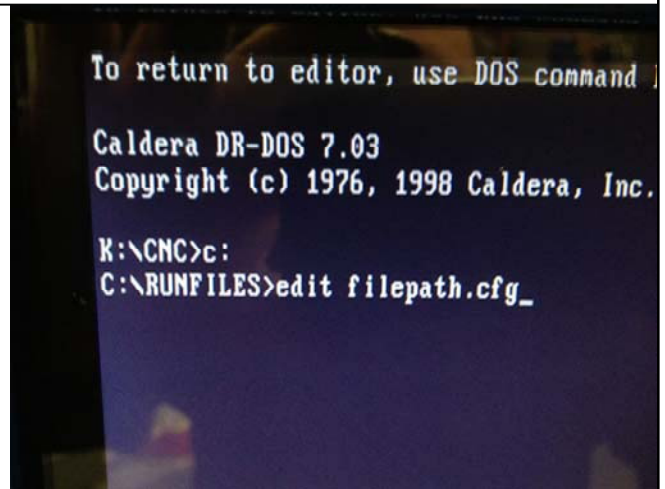
4: Press F3 to go to the editor Then press ESC key to not create a new file



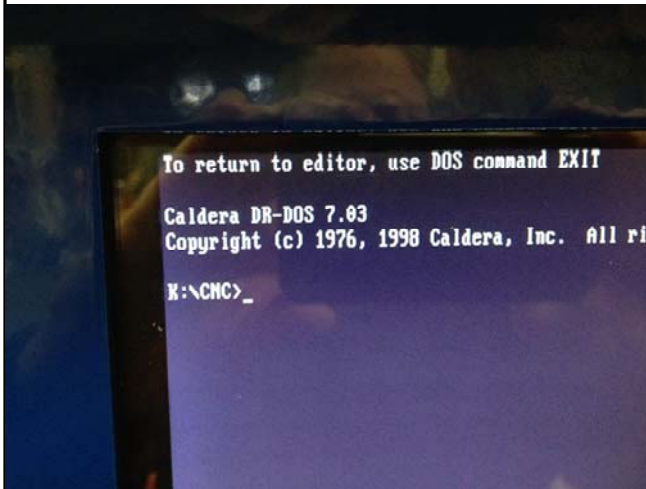
5: When you see the program press F1 to go to the help menu



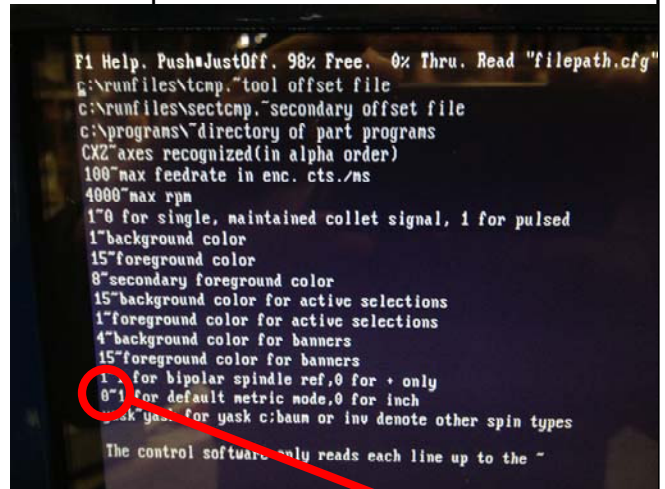
6: On the help screen press F4 to go to DOS



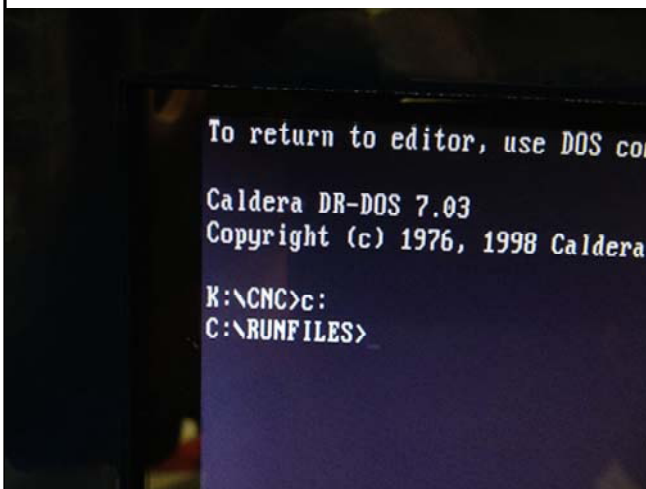
9: type **edit filepath.cfg** and then **enter**. This will start the editor, then press ESC for no backup



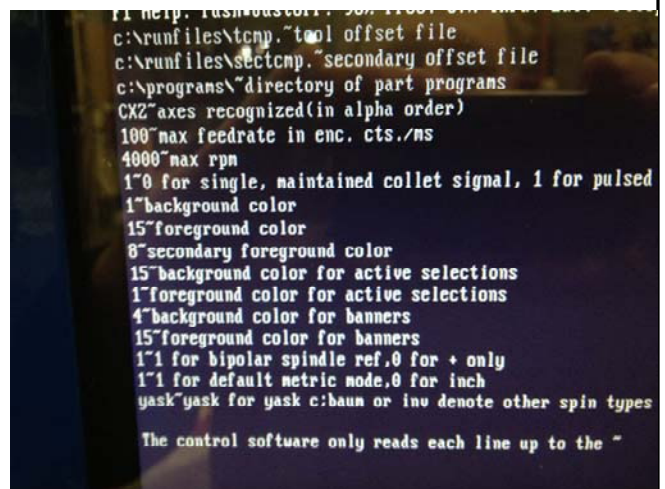
7: After pressing F4 you will land on this screen.



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



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



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