

## How do I set the controller to pause during a tool change?

To set the HPGL controller to pause involves two steps. The first step is to configure the HPGL controller via [Machine Parameters](#) to turn the pause on during a tool change. The second step is to set up the job so the controller is able to recognize when a tool change has occurred.

### Step 1:

1. Start up the [Machine Parameters](#).
2. Select Input/Output Parameters located on the left.
3. Change the Spindle Setup parameter to Single Pneumatic.
4. Change the Spindle Mode to Pause.
5. Save the changes to the file and update the controller. (File Menu + Update Machine Tool)

The controller is now configured to operate the left solenoid only. If a tool ID changes the controller will now pause.

### Step 2:

1. Create or open a job in JLS.
2. In element mode net the object that is to have a tool change. Edit the Attributes and change the tool.
3. In Toolbox change the Spindle ID for that particular tool.

For example:

A JLS job contains three lines. The first and third lines are set to left spindle ID. The second line Spindle ID is set to right. During the execution of the job the controller will Pause before engraving the second line.

### Note:

By design the Pause feature is used only for users with one spindle. Users who have two spindles will set the controller to Automatic Spindle mode.

