1. Prep and pre-position
   1. Save G20/G21
   2. Save G91/G90
   3. Save position
   4. Go to Safe Z
   5. Go to G30 G91 X0Y0
   6. G91
2. Probe existing tool
   1. Wait for Run/Pause button with optional jogging
   2. G38.2 Z{max\_travel}F{fast\_probe}
   3. G0Z{tool lift off}
   4. G38.2 Z{max\_travel}F{slow\_probe}
   5. Record Z
   6. Go to Safe Z
3. Tool change & Probe new tool
   1. Wait for Run/Pause button with optional jogging
   2. G38.2 Z{max\_travel}F{fast\_probe}
   3. G0Z{tool lift off}
   4. G38.2 Z{max\_travel}F{slow\_probe}
   5. Move to new Z probe point (remove overshoot)
   6. Set new Z equal to old Z
4. Restore state and position
   1. Got to Safe Z
   2. Got to initial position
   3. Restore G91/G90
   4. Restore G20/G21