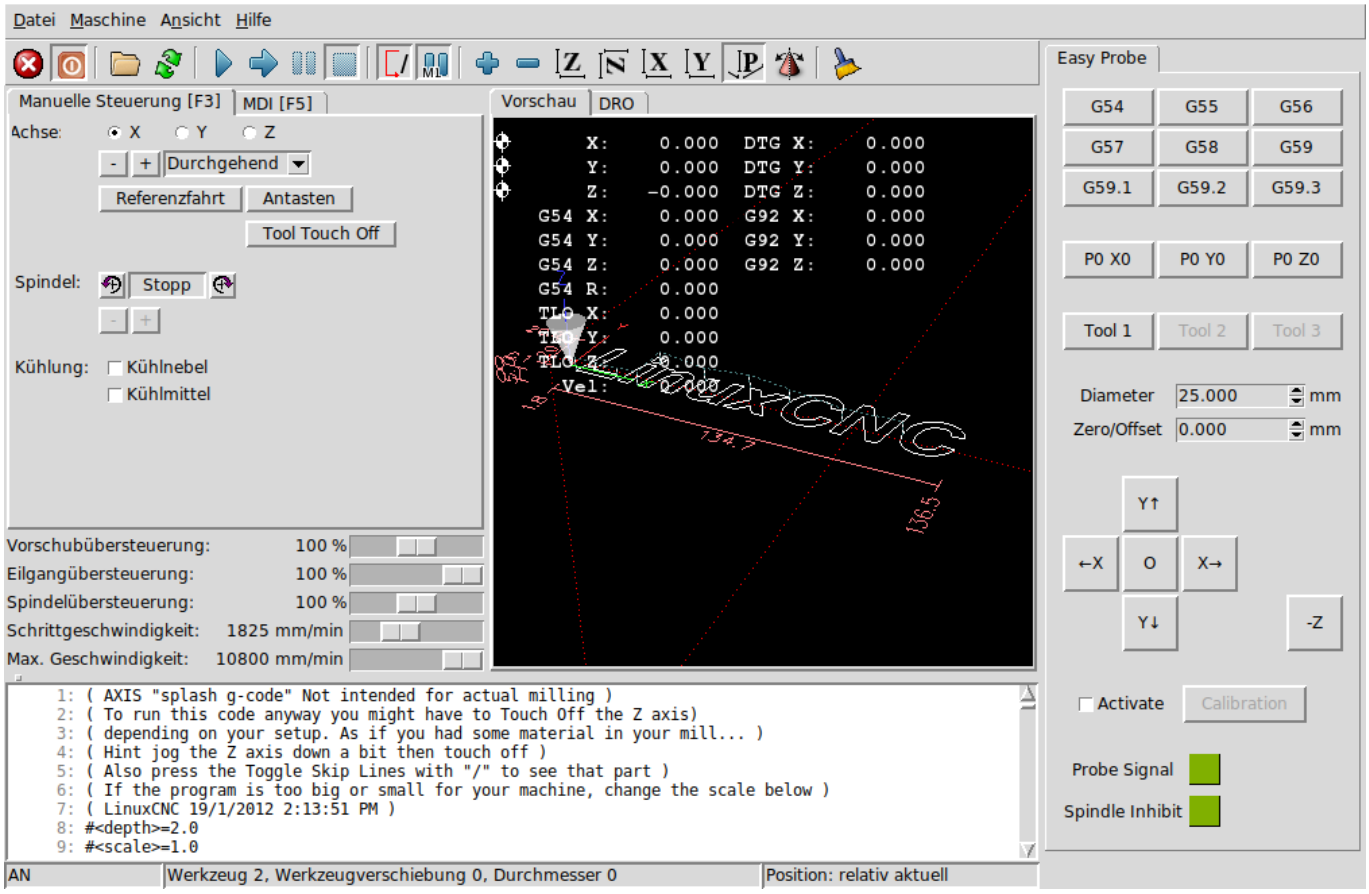
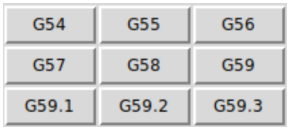
[easy]probe Manual

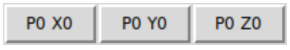


1) Coordinate system



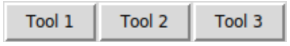
Select the current coordinate system with the buttons G54 to G59.3 before you start probing.

2) Reset axis to zero



If you just need a rough zero position and there is no need for a precise probing, you can use the buttons to zero your current position. Note that it only affects the currently selected coordinate system.

3) Probe tool



Select your probe tool here. Up to three different probe tools or one probe tool with up to three different probe tips can be user defined in your machine.ini. Each probe tool will be calibrated individually.

Note: Buttons for unused probe tools will automatically be disabled.

Be aware that pressing the tool buttons leads to a toolchange (M6) and also adds a tool length offset (G43) to the system.

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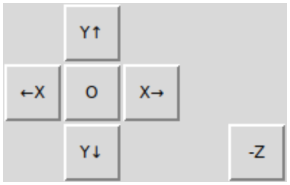
4) Diameter

a) In case of a probe tool calibration, enter the exact diameter of the calibration ring.
b) In case of a pocket probe, enter the estimated diameter of the pocket.
Note: Instead of scrolling you can cklick on the number, enter a new value and hit enter.

5) Zero/Offset

If your probe target value should be anything else than zero, set it to the desired value before probing.
Note: Instead of scrolling you can cklick on the number, enter a new value and hit enter.

6) Probe buttons

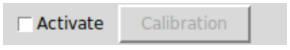


Perform any of the six probe actions. Please make sure that
a) the right coordinate system has been selected
b) the right tool has been selected and calibrated once before
c) zero/offset has been set to the desired value

For pocket probe the tip should be moved as close to the center as possible
For edge probe move the tip at least as close to the edge as the MAX_XY_DISTANCE value from your INI file.
For top probe move the tip at least as close to the top as the MAX_Z_DISTANCE value from your INI file.

Please note that any probe action only affects the currently selected coordinate system.

7) Calibration



Each probe tool and tip combination must be calibrated at least once before use.
To perform a calibration, check the checkbox to activate the calibration button, hit the button and follow the LinuxCNC messages. Once a tool is calibrated, its values will be stored permanently.
However, it is recommended to recalibrate your tools from time to time.

8) Probe signal

The square LED indicates an active probe signal. This may help you to check your probe tool manually and make sure that it is properly connected and in working order.

9) Spindle inhibit

The square LED indicates that spindle.0.inhibit has been set to true. This is the case when you switch to one of the three defined probe tools. For enabling the spindle again, simply switch to any other tool.