

Testing for Minimum Probe Travel error statements

In each script, the command was allow to reach pb.target without having the Z-min circuit close.

pb.start_condition – pb.target = 2.000

```
$mpo
{"ej":""}
X machine posn:      20.000 mm
Y machine posn:      20.000 mm
Z machine posn:      -40.000 mm
A machine posn:       0.000 deg
B machine posn:       0.000 deg
C machine posn:       0.000 deg
tinyg [mm] ok>
{"Lbs":0}
{"r":{"ej":1}, "f":[1,0,10,7782]}
```

G38.2 Z-42 F25

```
{"Lbs":0}
{"r":{"f":[1,0,15,74]}}
{"sr":{"posx":20.000,"posy":20.000,"posz":-40.000,"stat":7,"coor":0}}
{"qr":32}
{"qr":31}
{"sr":{"posz":-40.098,"vel":25.00,"momo":1,"mpoz":-40.098}}
{"sr":{"posz":-40.200,"mpoz":-40.200}}
{"sr":{"posz":-40.302,"mpoz":-40.302}}
{"sr":{"posz":-40.404,"mpoz":-40.404}}
{"sr":{"posz":-40.506,"mpoz":-40.506}}
{"sr":{"posz":-40.608,"mpoz":-40.608}}
{"sr":{"posz":-40.710,"mpoz":-40.710}}
{"sr":{"posz":-40.812,"mpoz":-40.812}}
{"sr":{"posz":-40.914,"mpoz":-40.914}}
{"sr":{"posz":-41.016,"mpoz":-41.016}}
{"sr":{"posz":-41.118,"mpoz":-41.118}}
{"sr":{"posz":-41.220,"mpoz":-41.220}}
{"sr":{"posz":-41.322,"mpoz":-41.322}}
{"sr":{"posz":-41.424,"mpoz":-41.424}}
{"sr":{"posz":-41.527,"mpoz":-41.527}}
{"sr":{"posz":-41.629,"mpoz":-41.629}}
{"sr":{"posz":-41.731,"mpoz":-41.731}}
{"sr":{"posz":-41.833,"mpoz":-41.833}}
{"sr":{"posz":-41.935,"mpoz":-41.935}}
{"sr":{"posz":-42.000,"vel":0.00,"mpoz":-42.000}}
{"qr":32}
{"r":{"prb":{"e":0,"x":20.000,"y":20.000,"z":-42.000,"a":0.000,"b":0.000,"c":0.000}},
"f":[1,0,0,2656]}}
{"sr":{"posz":-42.000,"mpoz":-42.000}}
{"sr":{"posx":0.000,"posy":0.000,"posz":-2.000,"stat":3,"coor":1,"momo":4}}
{"qr":32}
```

pb.start_condition – pb.target = 0.300

```
$mpo
{"ej":""}
X machine posn:      20.000 mm
Y machine posn:      20.000 mm
Z machine posn:      -42.000 mm
A machine posn:       0.000 deg
B machine posn:       0.000 deg
C machine posn:       0.000 deg
tinyg [mm] ok>
{"Lbs":0}
{"r":{"ej":1},"f":[1,0,10,7782]}
  G38.2 Z-42.3 F25
{"Lbs":0}
{"r":{"f":[1,0,17,76]}}
{"sr":{"posx":20.000,"posy":20.000,"posz":-42.000,"stat":7,"coor":0}}
{"qr":32}
{"qr":31}
{"sr":{"posz":-42.097,"vel":25.00,"momo":1,"mpoz":-42.097}}
{"sr":{"posz":-42.199,"mpoz":-42.199}}
{"sr":{"posz":-42.300,"vel":18.12,"mpoz":-42.300}}
{"sr":{"posz":-42.300,"vel":0.00,"mpoz":-42.300}}
{"qr":32}
{"r":{"prb":{"e":0,"x":20.000,"y":20.000,"z":-42.300,"a":0.000,"b":0.000,"c":0.000}},
"f":[1,0,0,8961]}}
{"sr":{"posz":-42.300,"mpoz":-42.300}}
{"sr":{"posx":0.000,"posy":0.000,"posz":-2.300,"stat":3,"coor":1,"momo":4}}
{"qr":32}
```

pb.start_condition – pb.target = 0.200

```
$mpo
{"ej":""}
X machine posn:      20.000 mm
Y machine posn:      20.000 mm
Z machine posn:      -42.000 mm
A machine posn:       0.000 deg
B machine posn:       0.000 deg
C machine posn:       0.000 deg
tinyg [mm] ok>
{"Lbs":0}
{"r":{"ej":1},"f":[1,0,10,7782]}
  G38.2 Z-42.2 F25
{"Lbs":0}
{"r":{"f":[1,0,17,76]}}
{"sr":{"posx":20.000,"posy":20.000,"posz":-42.000,"stat":7,"coor":0}}
{"qr":32}
{"qr":31}
{"sr":{"posz":-42.101,"vel":25.00,"momo":1,"mpoz":-42.101}}
{"sr":{"posz":-42.200,"vel":6.88,"mpoz":-42.200}}
{"qr":32}
{"sr":{"posz":-42.200,"vel":0.00,"mpoz":-42.200}}
```

```
{"r":{"prb":{"e":0,"x":20.000,"y":20.000,"z":-42.200,"a":0.000,"b":0.000,"c":0.000}},
"f":[1,0,0,7769]}
{"sr":{"posz":-42.200,"mpoz":-42.200}}
{"sr":{"posx":0.000,"posy":0.000,"posz":-2.200,"stat":3,"coor":1,"momo":4}}
{"qr":32}
```

pb.start_condition – pb.target = 0.005

\$mpo

```
  {"ej":""}
X machine posn:      20.000 mm
Y machine posn:      20.000 mm
Z machine posn:      -42.000 mm
A machine posn:        0.000 deg
B machine posn:        0.000 deg
C machine posn:        0.000 deg
tinyg [mm] ok>
{"Lbs":0}
{"r":{"ej":1},"f":[1,0,10,7782]}
  G38.2 Z-42.005 F2.5
{"Lbs":0}
{"r":{"f":[1,0,20,100]}}
{"sr":{"feed":2.50}}
{"sr":{"posx":20.000,"posy":20.000,"posz":-42.000,"stat":7,"coor":0}}
{"qr":32}
{"qr":31}
{"qr":32}
{"sr":{"posz":-42.005,"momo":1,"mpoz":-42.005}}
{"r":{"prb":{"e":0,"x":20.000,"y":20.000,"z":-42.005,"a":0.000,"b":0.000,"c":0.000}},
"f":[1,0,0,3889]}
{"sr":{"posz":-42.005,"mpoz":-42.005}}
{"sr":{"posx":0.000,"posy":0.000,"posz":-2.005,"stat":3,"coor":1,"momo":4}}
{"qr":32}
```