

G38.2 Zn arguments – probe error

Define Z-target to be 0.25" or 6.35mm

mZ = 0.000

G20

```
{"Lbs":0}
{"r":{"f":[1,0,4,4397]}}
$mpo
{"ej":""}
X machine posn:      0.000 mm
Y machine posn:      0.000 mm
Z machine posn:      0.000 mm
A machine posn:      0.000 deg
B machine posn:      0.000 deg
C machine posn:      0.000 deg
tinyg [inch] ok>
{"Lbs":0}
{"r":{"ej":1},"f":[1,0,10,7782]}}
G38.2 Z-.25 F1
{"Lbs":0}
{"r":{"f":[1,0,15,74]}}
{"r":{"msg":"Probing error - invalid probe destination"},"f":[1,250,0,8644]}}
{"sr":{"momo":4}}
{"qr":32}
```

Set mZ=-0.250"

\$mpo

```
{"ej":""}
X machine posn:      0.000 mm
Y machine posn:      0.000 mm
Z machine posn:      -6.350 mm
A machine posn:      0.000 deg
B machine posn:      0.000 deg
C machine posn:      0.000 deg
tinyg [inch] ok>
{"Lbs":0}
{"r":{"ej":1},"f":[1,0,10,7782]}}
```

pb.target – pb.start_position = (-0.255 – (-0.250)) = -0.005

G38.2 Z-.255 F1

```
{"Lbs":0}
{"r":{"f":[1,0,16,75]}}
{"sr":{"stat":7}}
{"qr":32}
{"qr":31}
{"sr":{"posz":-0.254,"vel":1.00,"momo":1,"mpoz":-6.452}}
{"sr":{"posz":-0.255,"vel":0.00,"mpoz":-6.477}}
{"qr":32}
```

```
{"r":{"prb":{"e":0,"x":0.000,"y":0.000,"z":-6.477,"a":0.000,"b":0.000,"c":0.000}},"f":  
:[1,0,0,1428]}  
{"sr":{"stat":3,"momo":4}}  
{"qr":32}
```

Define Z-target to be 0.25" or 6.35mm

mZ = 0.000

```
g21  
{"Lbs":0}  
{"r":{"f":[1,0,4,4397]}  
{"sr":{"unit":1,"feed":25.40}}  
$mpo  
{"ej":""}  
X machine posn:      0.000 mm  
Y machine posn:      0.000 mm  
Z machine posn:      0.000 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-.25 F25  
{"Lbs":0}  
{"r":{"f":[1,0,16,75]}  
{"sr":{"feed":25.00}}  
{"r":{"msg":"Probing error - invalid probe destination"},"f":[1,250,0,8644]}  
{"sr":{"momo":4}}  
{"qr":32}
```

Set mZ=4.000mm

```
$mpo  
{"ej":""}  
X machine posn:      0.000 mm  
Y machine posn:      0.000 mm  
Z machine posn:      -4.000 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]}
```

pb.target – pb.start_position = (-4.250 – (-4.000)) = -0.250mm

```
G38.2 Z-4.25 F25
```

```

+{"Lbs":0}
{"r":{,"f":[1,0,17,76]}
{"r":{"msg":"Probing error - invalid probe destination"},"f":[1,250,0,8644]}
{"sr":{"momo":4}}
{"qr":32}

```

pb.target – pb.start_position = (-4.254 – (-4.000)) = -0.254mm

G38.2 Z-4.254 F25

```

{"Lbs":0}
{"r":{,"f":[1,0,18,77]}
{"sr":{"stat":7}}
{"qr":32}
{"qr":31}
{"sr":{"posz":-4.101,"vel":25.00,"momo":1,"mpoz":-4.101}}
{"sr":{"posz":-4.202,"mpoz":-4.202}}
{"sr":{"posz":-4.254,"vel":0.00,"mpoz":-4.254}}
{"qr":32}
{"r":{"prb":{"e":0,"x":0.000,"y":0.000,"z":-4.254,"a":0.000,"b":0.000,"c":0.000},"f":
:[1,0,0,3404]}
{"sr":{"stat":3,"momo":4}}
{"qr":32}

```

Set mX = 1.000, mZ=4.000mm

pb.target – pb.start_position = (-4.250 – (-4.000)) = -0.250mm

\$mpo

```

{"ej":""}
X machine posn:      1.000 mm
Y machine posn:      0.000 mm
Z machine posn:      -4.000 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-4.250 F25
{"Lbs":0}
{"r":{,"f":[1,0,18,77]}
{"sr":{"stat":7}}
{"qr":32}
{"qr":31}
{"sr":{"posz":-4.250,"momo":1,"mpoz":-4.250}}
{"qr":32}
{"r":{"prb":{"e":0,"x":1.000,"y":0.000,"z":-4.250,"a":0.000,"b":0.000,"c":0.000},"f":
:[1,0,0,4450]}
{"sr":{"stat":3,"momo":4}}
{"qr":32}

```

Set mX = 0.000, mZ=-12.286mm
pb.target - pb.start_position = (-12.500 - (-12.286)) = -0.214mm

g21

```
{"Lbs":0}
{"r":{"f":[1,0,4,4397]}}
{"sr":{"posz":-12.286,"unit":1,"feed":25.40}}
  $mpo
  {"ej":""}
X machine posn:      0.000 mm
Y machine posn:      0.000 mm
Z machine posn:      -12.286 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-12.5 F25
{"Lbs":0}
{"r":{"f":[1,0,17,76]}}
{"sr":{"feed":25.00}}
{"r":{"msg":"Probing error - invalid probe destination"},"f":[1,250,0,8644]}}
{"qr":32}
```

Set mX = 1.000, mZ=-12.286mm
pb.target - pb.start_position = (-12.500 - (-12.286)) = -0.214mm

\$mpo

```
{"ej":""}
X machine posn:      1.000 mm
Y machine posn:      0.000 mm
Z machine posn:      -12.286 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-12.5 F25
{"Lbs":0}
{"r":{"f":[1,0,17,76]}}
{"sr":{"stat":7}}
{"qr":32}
{"qr":31}
{"sr":{"posz":-12.382,"vel":25.00,"momo":1,"mpoz":-12.382}}
{"sr":{"posz":-12.486,"mpoz":-12.486}}
{"sr":{"posz":-12.500,"vel":0.00,"mpoz":-12.500}}
{"qr":32}
{"r":{"prb":{"e":0,"x":1.000,"y":0.000,"z":-12.500,"a":0.000,"b":0.000,"c":0.000}},"f":
":[1,0,0,160]}}
{"sr":{"posz":-12.500,"mpoz":-12.500}}
{"sr":{"stat":3,"momo":4}}
{"qr":32}
```