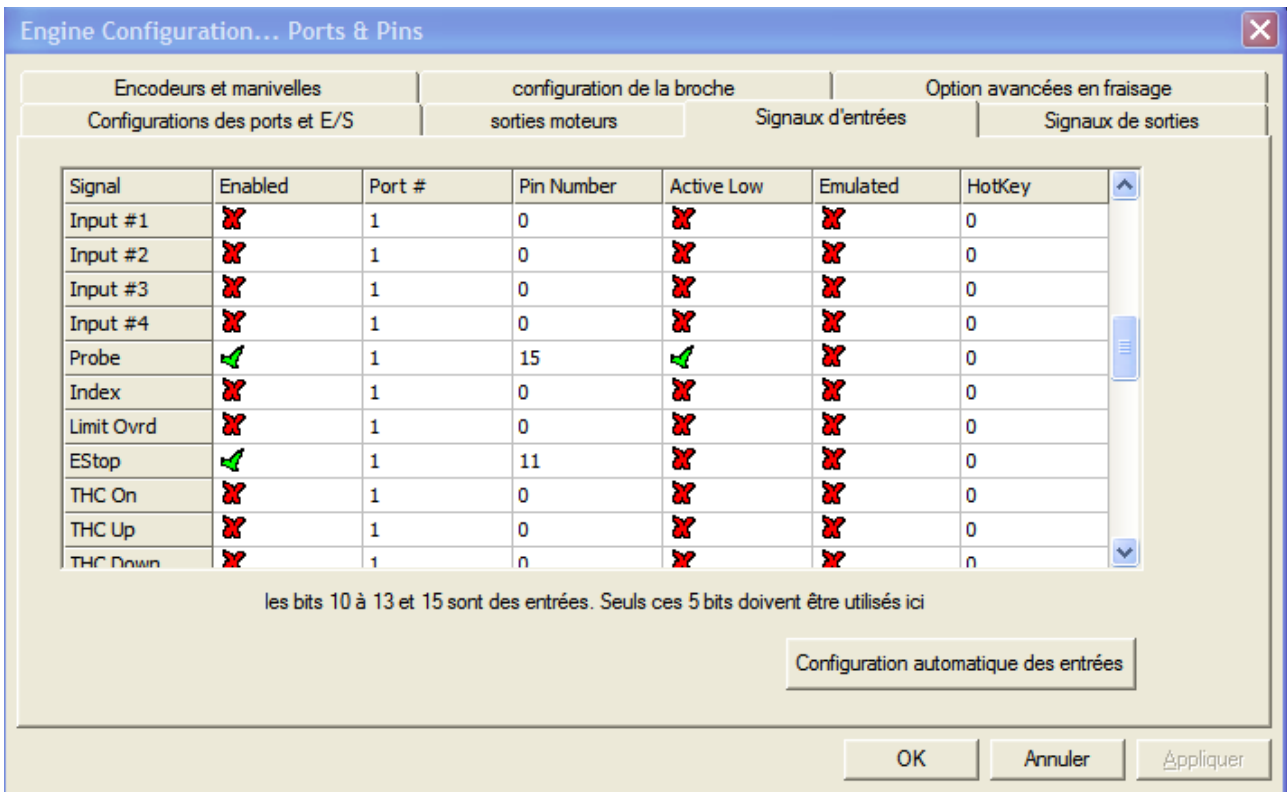


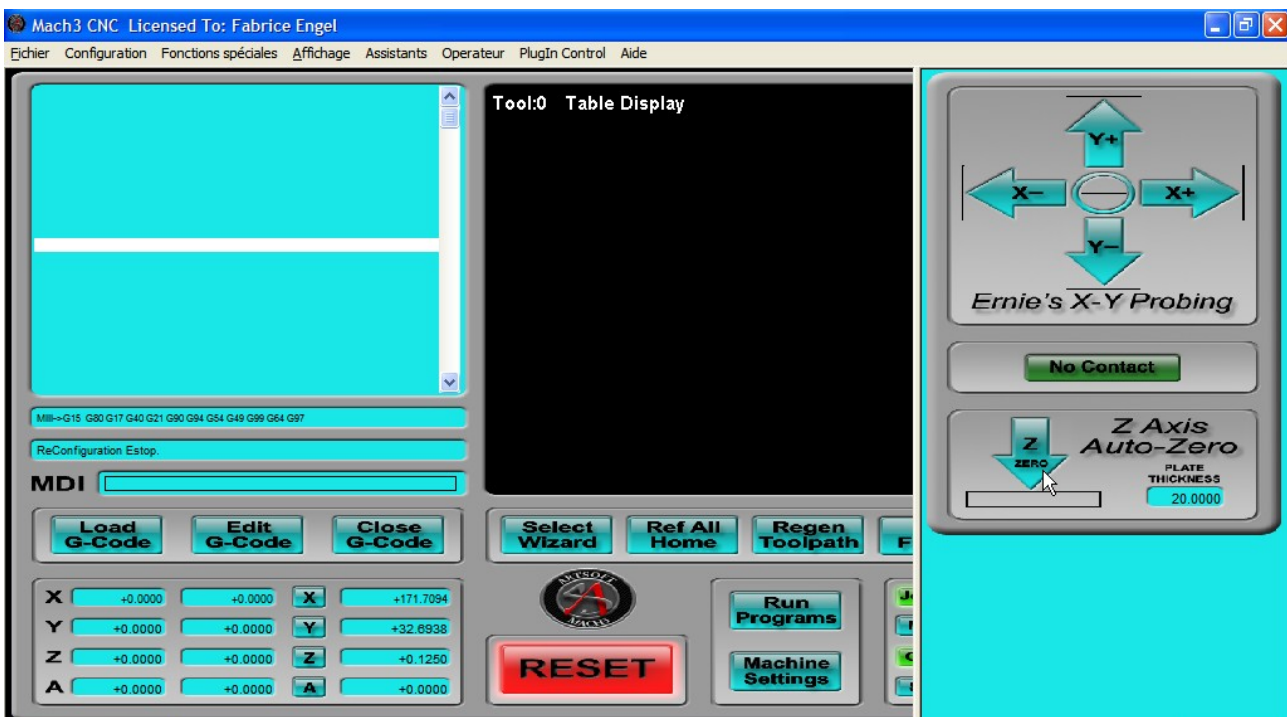
Paramétrage d'un palpeur dans Mach3

Définir le port pour la sonde 'Probe' :

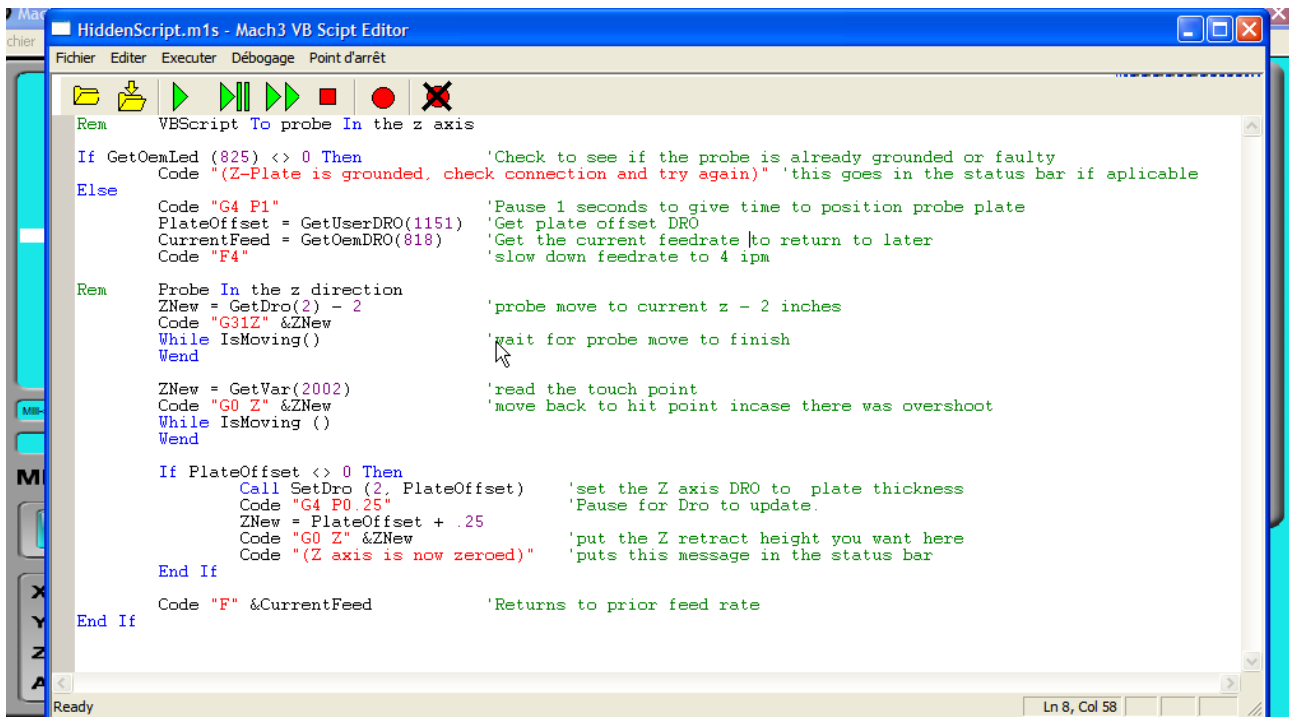


S'assurer dans les diags de Mach3 que le switch fonctionne bien sur le port indiqué.

Utiliser un screen Mach3 permettant l'usage du palpeur, exemple Aqua Screen :



Editer la macro associée au bouton Z Zéro :



```
HiddenScript.m1s - Mach3 VB Script Editor
Fichier  Editer  Executer  Débogage  Point d'arrêt
Rem    VBScript To probe In the z axis
If GetOemLed (825) <> 0 Then      'Check to see if the probe is already grounded or faulty
    Code "(Z-Plate is grounded, check connection and try again)" 'this goes in the status bar if applicable
Else
    Code "G4 P1"                  'Pause 1 seconds to give time to position probe plate
    PlateOffset = GetUserDRO(1151) 'Get plate offset DRO
    CurrentFeed = GetOemDRO(818)   'Get the current feedrate to return to later
    Code "F4"                      'slow down feedrate to 4 ipm

Rem    Probe In the z direction
    ZNew = GetDro(2) - 2           'probe move to current z - 2 inches
    Code "G31Z" &ZNew              'wait for probe move to finish
    While IsMoving()
    Wend

    ZNew = GetVar(2002)            'read the touch point
    Code "G0 Z" &ZNew              'move back to hit point incase there was overshoot
    While IsMoving ()
    Wend

    If PlateOffset <> 0 Then
        Call SetDro (2, PlateOffset) 'set the Z axis DRO to plate thickness
        Code "G4 P0.25"              'Pause for Dro to update.
        ZNew = PlateOffset + .25
        Code "G0 Z" &ZNew            'put the Z retract height you want here
        Code "(Z axis is now zeroed)" 'puts this message in the status bar
    End If
    Code "F" &CurrentFeed          'Returns to prior feed rate
End If
```

Voici la même version en métrique :

Rem VBScript To probe In the z axis

If GetOemLed (825) <> 0 Then 'Check to see if the probe is already grounded or faulty

Code "(La plaque Z est à la terre, veuillez vérifier)" 'this goes in the status bar if applicable

Else

Code "G4 P4" 'Pause 1 seconds to give time to position probe plate

PlateOffset = GetUserDRO(1151) 'Get plate offset DRO

CurrentFeed = GetOemDRO(818) 'Get the current feedrate to return to later

Code "F40" 'slow down feedrate to 40

Rem Probe In the z direction

ZNew = GetDro(2) - 20 'probe move to current z - 20mm

Code "G31Z" &ZNew

While IsMoving() 'wait for probe move to finish

Wend

```

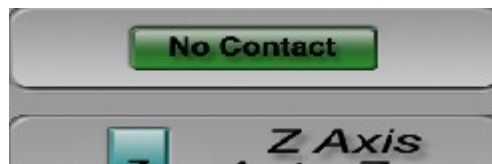
ZNew = GetVar(2002)      'read the touch point
Code "G0 Z" &ZNew       'move back to hit point incase there was overshoot
While IsMoving ()
Wend

If PlateOffset <> 0 Then
    Call SetDro (2, PlateOffset)  'set the Z axis DRO to plate thickness
    Code "G4 P0.25"              'Pause for Dro to update.
    ZNew = PlateOffset + 5
    Code "G0 Z" &ZNew            'put the Z retract height you want here
    Code "(L'axe Z est maintenant en position 0)" 'puts this message in the status bar
End If

Code "F" &CurrentFeed      'Returns to prior feed rate
End If

```

La Led Contact s'allume lors de l'activité du switch associé à la sonde :



Désolé mais dans l'écran ci dessus elle n'est pas active car pas de liaison machine sur mon pc internet.