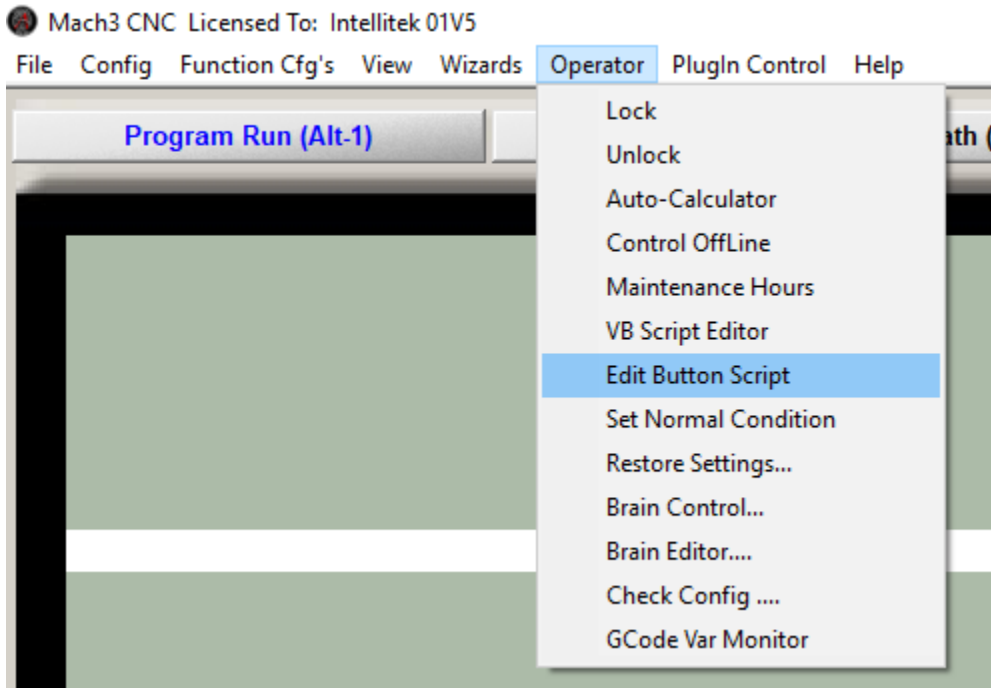
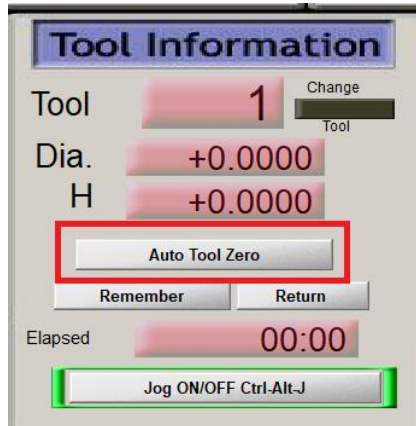


How to Enable the Auto Tool Zero in Mach3

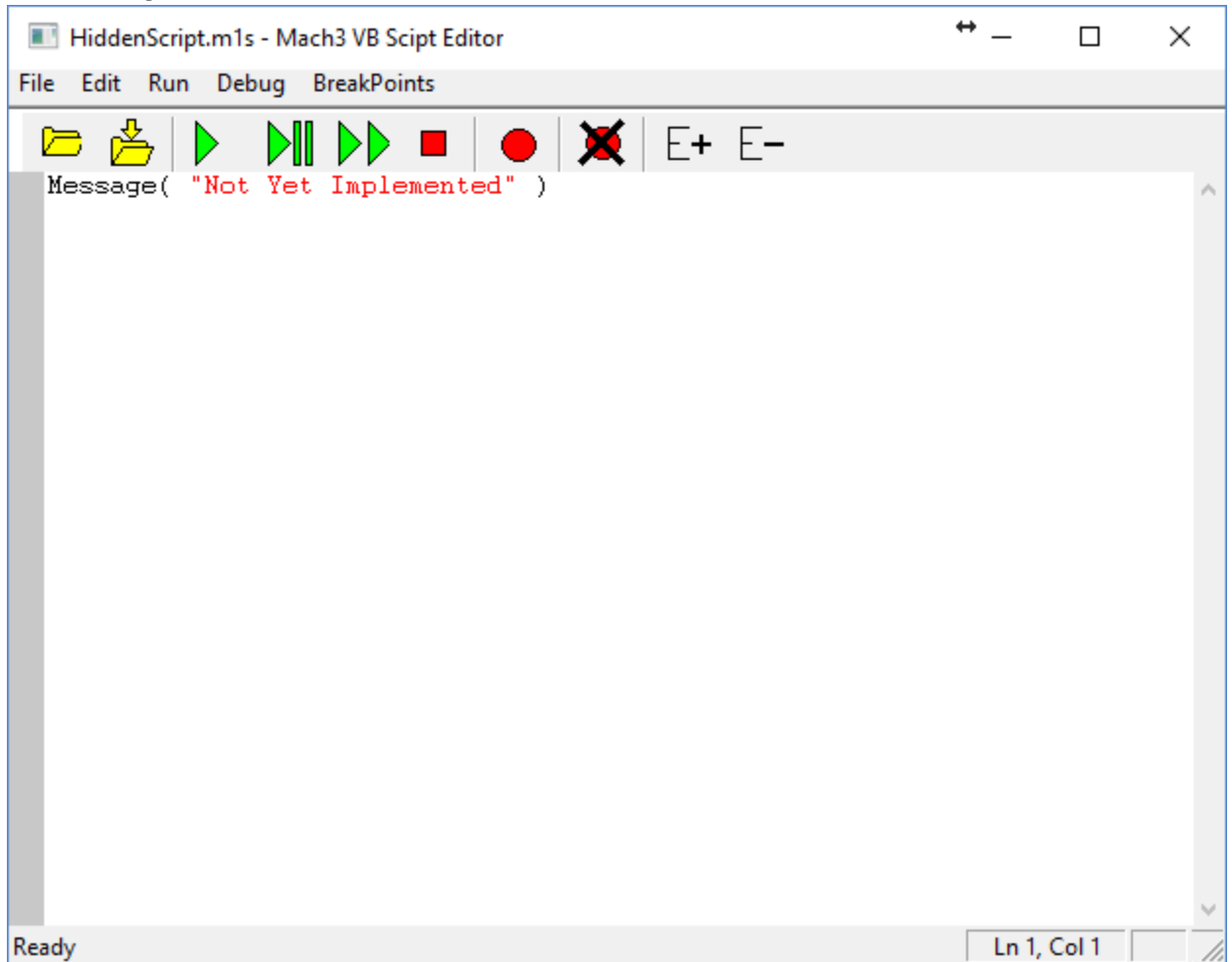
1. Open Mach3
2. Goto Operator -> Edit Button Script



3. Some buttons on the screen will start flashing, click **Auto Tool Zero**



4. You should get a screen that looks like this.



5. Delete the line Message (Not Yet Implemented)
6. Browse to Select Z_setter_Script.txt and Open it.
7. Copy the contents and Paste it into the above shown window.

8. After that the window should fill with text that looks as shown.

```

Sub Main()
If( GetLED(86) = false)Then
If(GetLED(7) = true)Then
'The X has not been homed and is enabled
Code("( Machine not referenced. Please Ref All Home)")
Exit Sub
End If
End If

If(GetLED(87) = false)Then
If(GetLED(8) = true)Then
'The y has not been homed and is enabled
Code("( Machine not referenced. Please Ref All Home)")
Exit Sub
End If
End If

If(GetLED(88) = false)Then
If(GetLED(9) = true)Then
'The z has not been homed and is enabled
Code("( Machine not referenced. Please Ref All Home)")
Exit Sub
End If
End If

'If you get to this part of the Code"( Setting Z Axis zero)"
If IsSuchSignal (22) Then
code "g20 g31 G90 z-30 f10"
While IsMoving()
Wend

code"g0"
code "G4 p0.5"
code "G92Z0.2500" ' 0.2500 = Enter Metal Plate thickness
code"g0"
While IsMoving()
Wend

code "(Moving to safe Z )"
code"g53 g00 l z0 f 150"
code "( Z Axis has been zeroed )"
End If

End Sub

```

9. Optionally, the thickness of the tool offset plate can be calibrated. To do this measure with dial calipers or a micrometer the thickness of the aluminum plate.

Modify the line that reads, **code "G92Z0.2500"** '0.2500 = Enter Metal Plate thickness

Replace the Z0.2500 with the thickness of your plate.



10. Click on the close 'X' and Yes to save HiddenScript.m1s



Sub Main()

If(GetLED(86) = false)Then

If(GetLED(7) = true)Then

'The X has not been homed and is enabled

Code("(Machine not referenced. Please Ref All Home)")

Exit Sub

End If

End If

If(GetLED(87) = false)Then

If(GetLED(8) = true)Then

'The y has not been homed and is enabled

Code("(Machine not referenced. Please Ref All Home)")

Exit Sub

End If

End If

If(GetLED(88) = false)Then

If(GetLED(9) = true)Then

'The z has not been homed and is enabled

Code("(Machine not referenced. Please Ref All Home)")

Exit Sub

End If

End If

'If you get to this part of the Code"(Setting Z Axis zero)"

If IsSuchSignal (22) Then

code "g20 g31 G90 z-30 f10"

While IsMoving()

Wend



```
code"g0"
```

```
code "G4 p0.5"
```

```
code "G92Z0.2500" ' 0.2500 = Enter Metal Plate thickness
```

```
code"g0"
```

```
While IsMoving()
```

```
Wend
```

```
code "(Moving to safe Z )"
```

```
code"g53 Z-0.25 F40"
```

```
code "( Z Axis has been zeroed )"
```

```
End If
```

```
End Sub
```