



Enabling Your Ideas

Service Bulletin

File name: SB0027_Digitizing_Probe_Race_Condition.pdf

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Product Identification: Digitizing Probe and Mach 3

Background: When doing an X and or Y move for a probing function the Z axis can on occasion unexpectedly move as well. This issue relates to characteristics of the control computer and is caused by a race condition in Mach3. Most systems will not experience this problem.

Other Symptoms: The Mach3 authors are struggling with a variety of these race conditions. The sudden Z move seems to occur only on probing moves which need to know the tip diameter. Symmetrical operations like Find Hole Center are not affected as the routine does not have to discover the diameter of the tip from the tool table.

Remedy for problem: The suggested fix is to change the active tool number to (T99) before doing the X and or Y probe functions. See image 1 below.

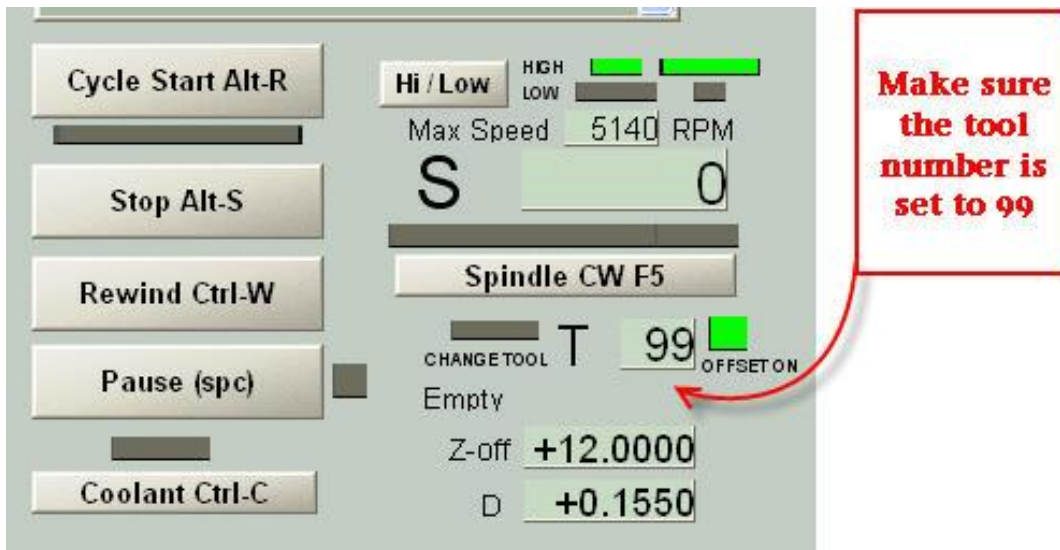


Image 1