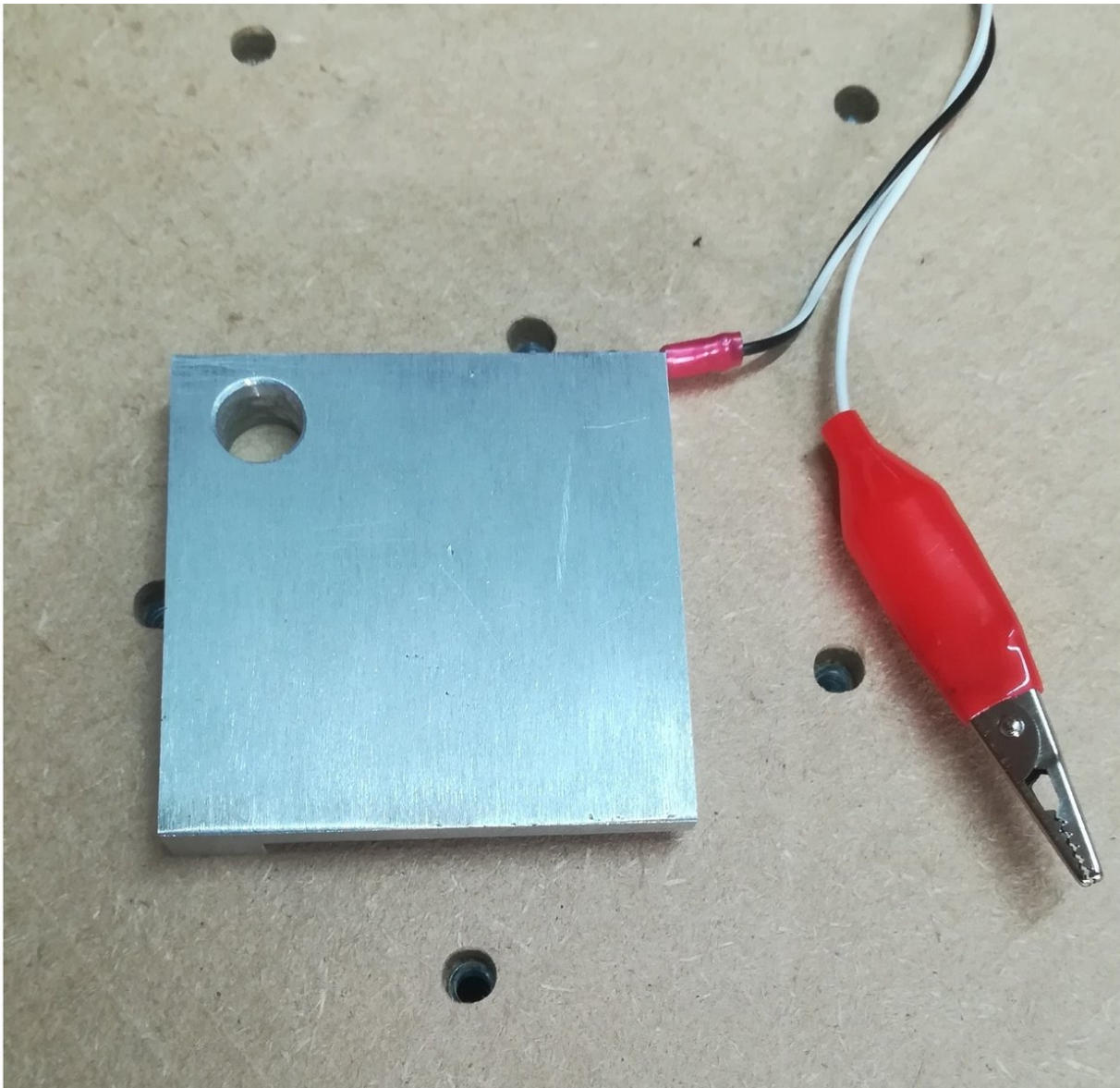




# Archive - Setup a XYZ Touch Probe with a CNC xPro

How to wiring and set-up a Touch Probe on the XPRO v3 controller.

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# INTRODUCTION

In this guide we will run through the steps to connect and configure a touch probe to your WorkBee or OX CNC running an XPRO controller.



## TOOLS:

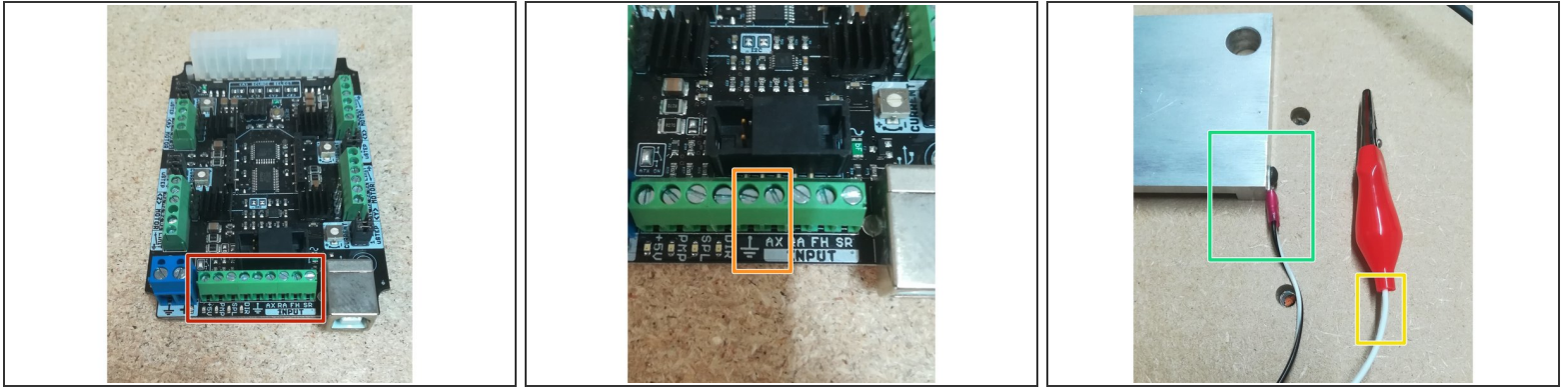
- [Small screw driver](#) (1)



## PARTS:

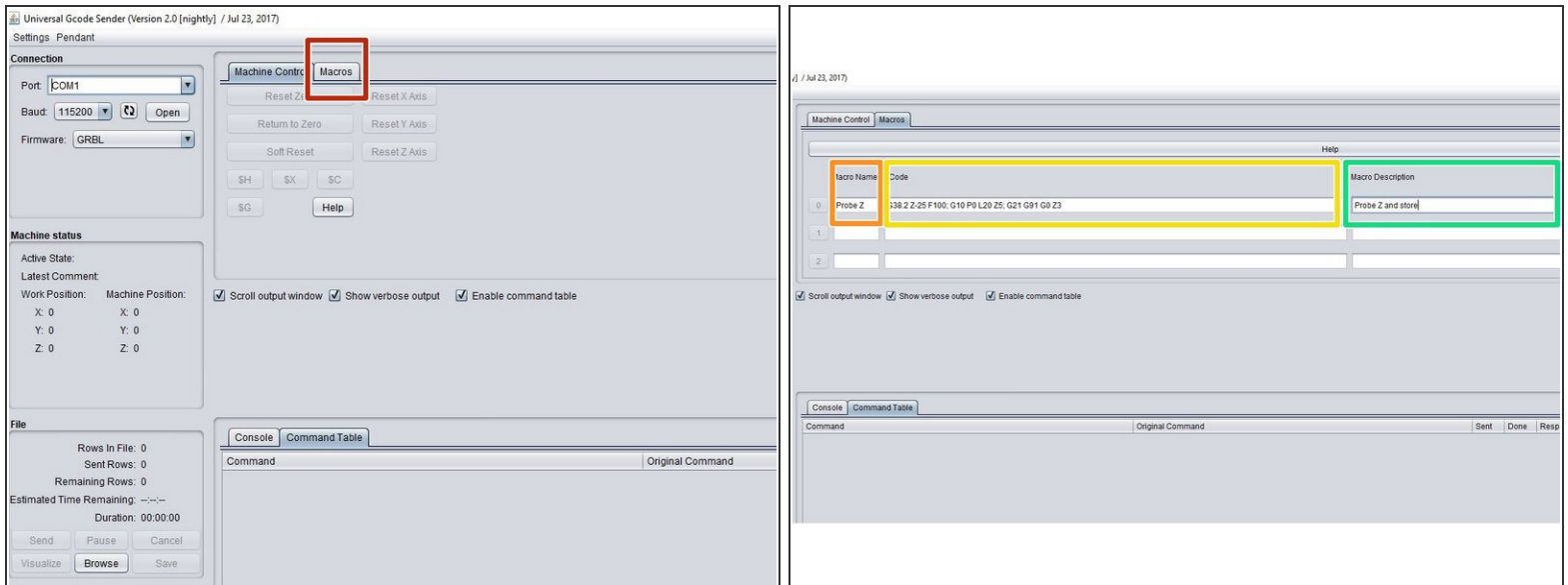
- [Touch probe](#) (1)
- [CNC-xPro](#) (1)

## Step 1 — Wiring the Touch Probe



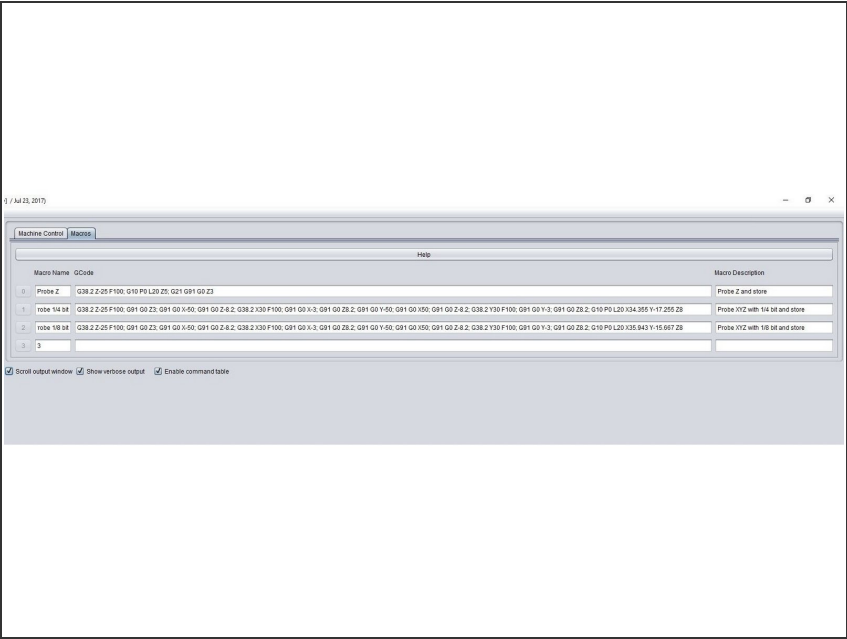
- Locate the Input screw terminals on the XPRO board.
- Identify the Ground and Touch Probe inputs.
- The wire attached to the crocodile clip, should be screwed into the ground terminal.
- The remaining wire (attached to the Probe) should be screwed into the probe terminal.

## Step 2 — Setting up the Macros



- Open up Universal G-code Sender (UGS) & connect to your WorkBee or OX CNC as normal.
- Locate and click on the Macros tab.
- ① On this tab we can set-up a number of macros to work with the Touch Probe.
- The first macro we will make is to probe the Z axis and store this value.
- In the Macro Name field, give your macro a name. In our case we will use "Probe Z".
- The next field is where we enter the GCode for our Macro. To probe and store the Z axis information we enter the GCode below. These commands are explained in the documents at the bottom of this guide.
- ① G38.2 Z-25 F100; G10 P0 L20 Z5; G21 G91 G0 Z3
- Lastly we can give our new macro a description such as "Probe Z and store"

### Step 3 — Adding more Macros



- To add more macros follow the steps above and use the PDF and spreadsheet documents at the bottom of this guide to configure your G-Code commands.

### Step 4 — Using your macros



- ① Now that you have set up your macros, for each size bit you want to use (1/4, 1/8, 1/16 etc) it's time

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to put them to action and find your zero point.

- Once you have set up your job, ensuring the work piece is clamped down securely, then home your machine.
- Place the touch probe on the bottom left corner of your work piece.
- Now use the jog axis commands to centre the bit within the probe. Then attach the crocodile clip to the bit in your router.
- You can then run your selected macro by pressing the correct macro number.
- ① In this example we ran the macro to probe X, Y and Z for a 1/4" bit. When the macro had finished we told the WorkBee CNC to return to the zero point.

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You are now set to use a touch probe and easily locate your work piece corners.