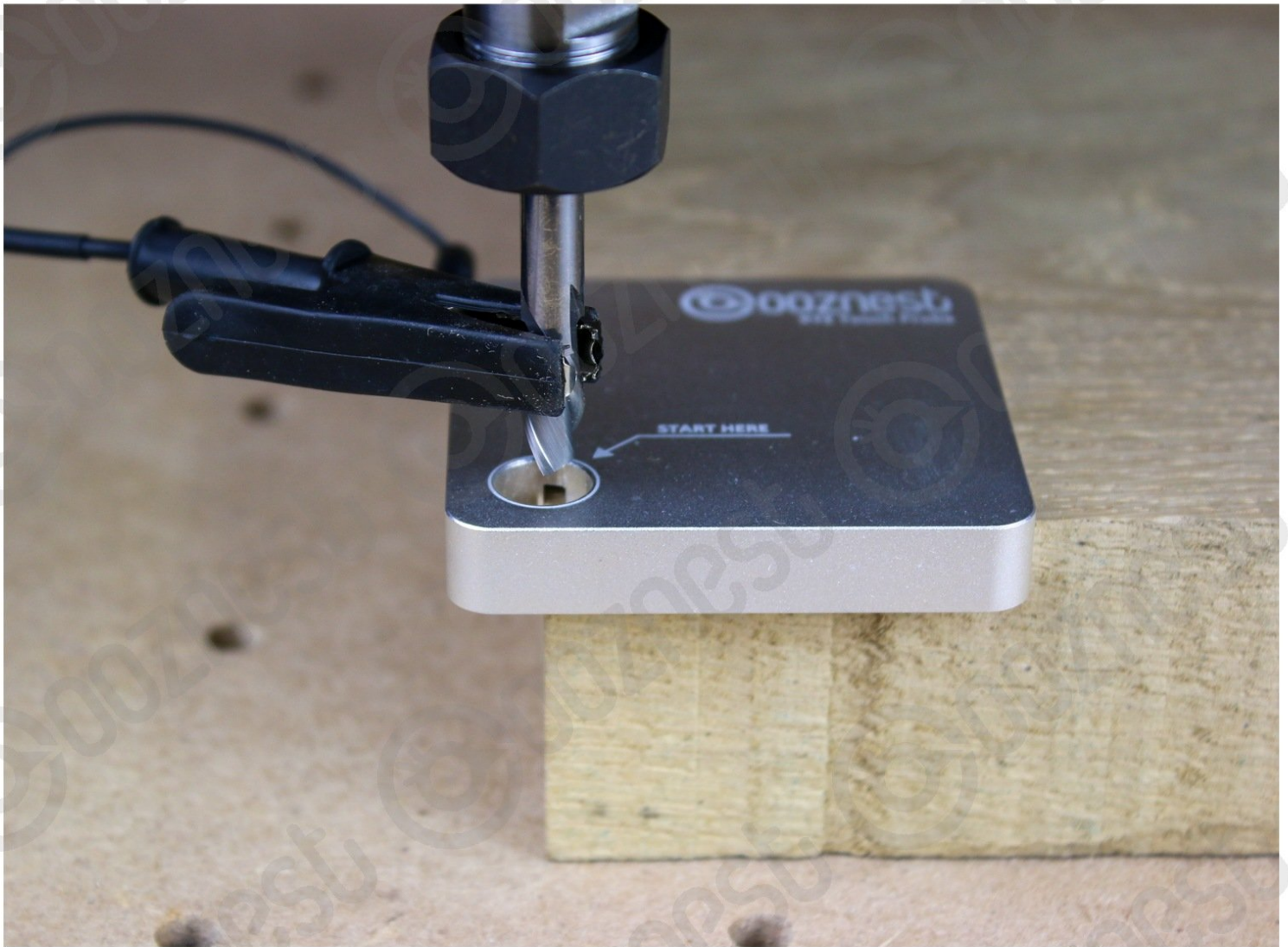


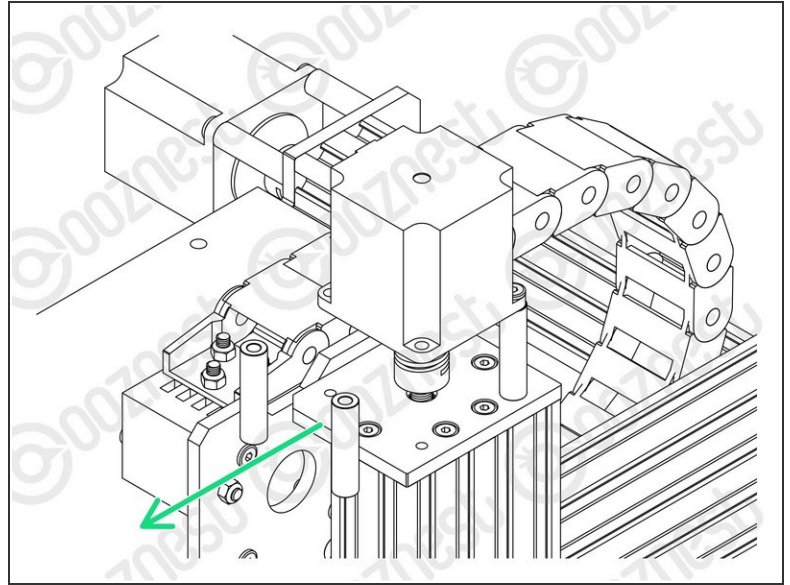
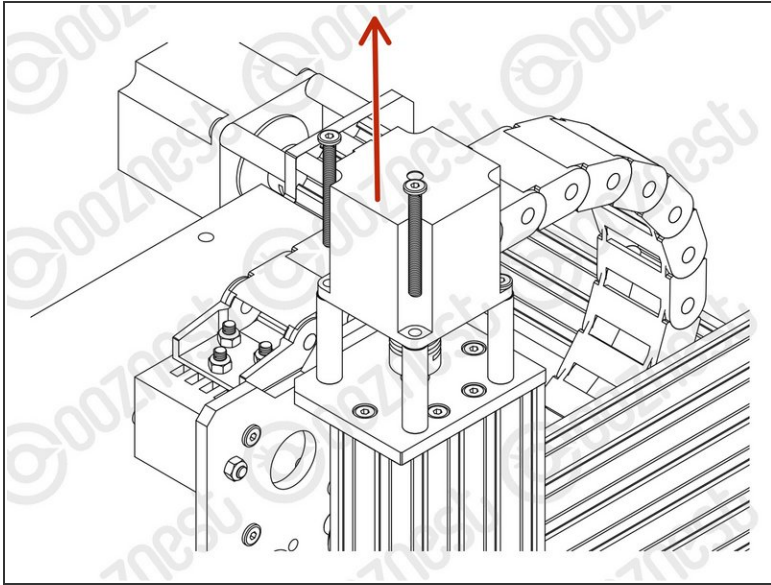


Assembling Your Original WorkBee XYZ Touch Probe

Written By: Ryan Christy



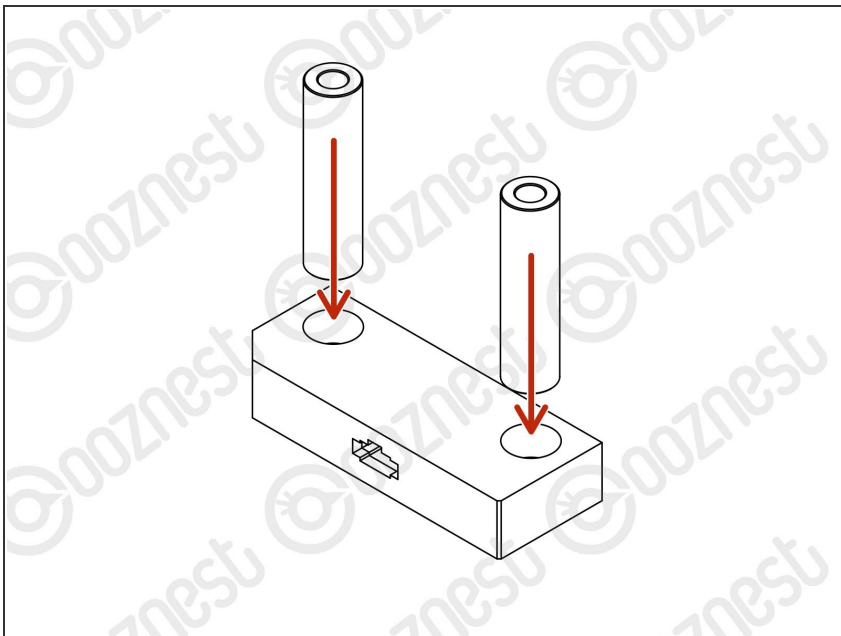
Step 1 — Removing Z-Axis Parts



i This step requires the removal of existing parts on the Z-Axis Stepper-Motor

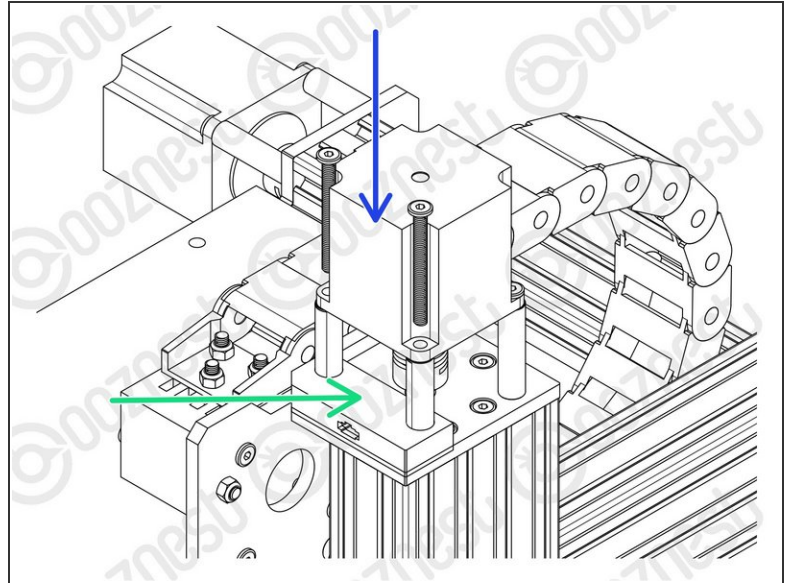
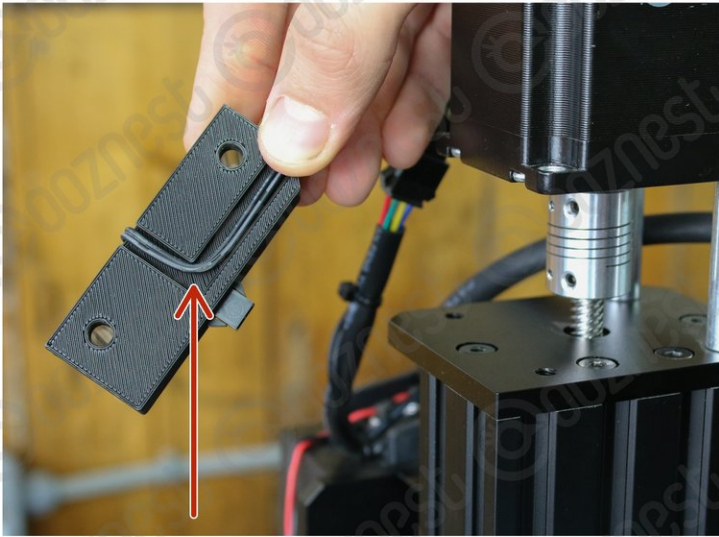
- Remove the left 2 x M5-Cap-Head-Bolt-50mm.
- Slide out the 2 x Aluminium-Spacer-40mms.

Step 2 — Touch Probe Mount - Part 1



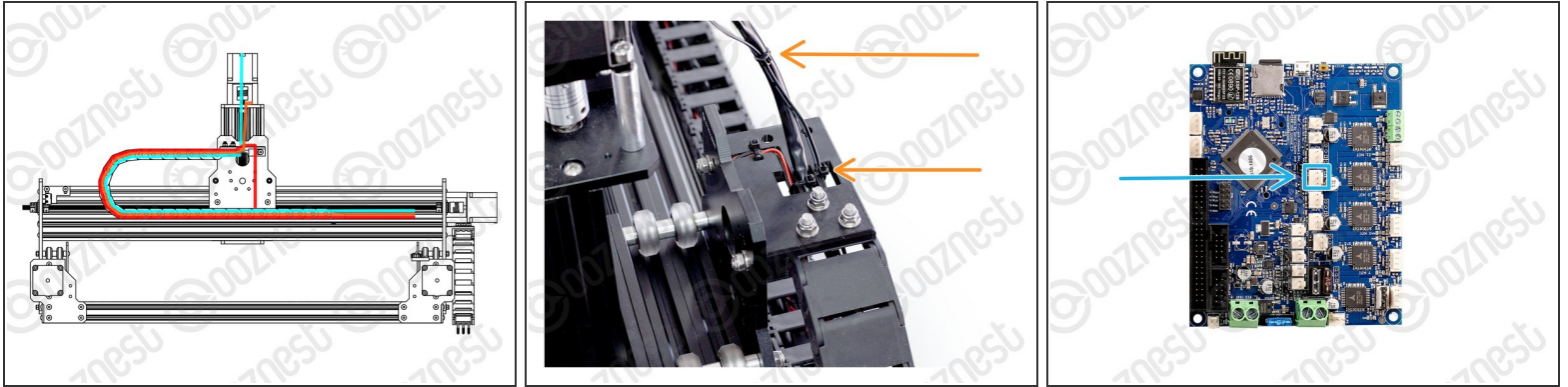
- Insert the 2 x Aluminium-Spacer-35mm into the Touch-Probe-Mount, pushing them in until they can go no further.

Step 3 — Assembling Components



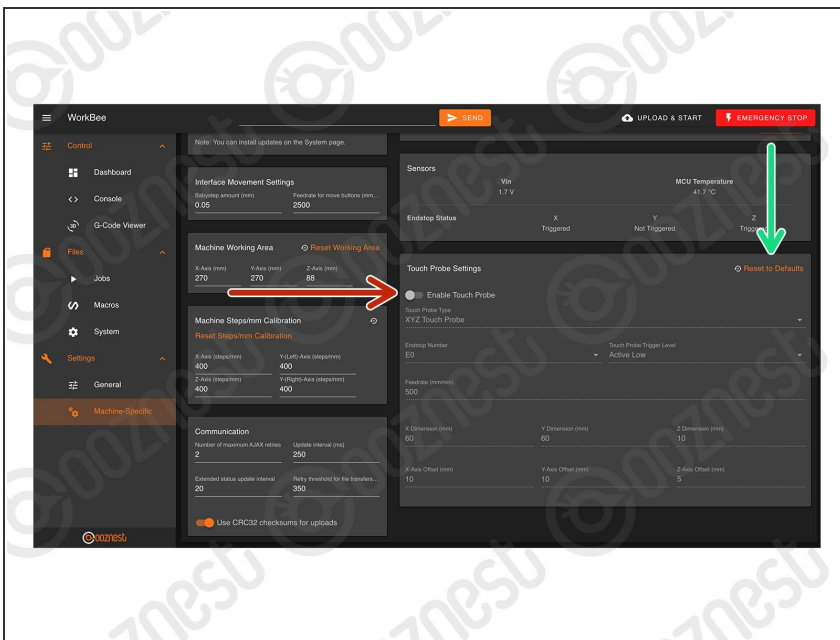
- Tuck the wire underneath the Touch-Probe-Mount as seen in Image 1.
- Place the Touch-Probe-Mount with the 2 x Aluminium-Spacer-35mm under the Z-Axis Stepper-Motor.
- Using the previously removed 2 x M5-Cap-Head-Bolt-50mm secure the Stepper-Motor.

Step 4 — Wire



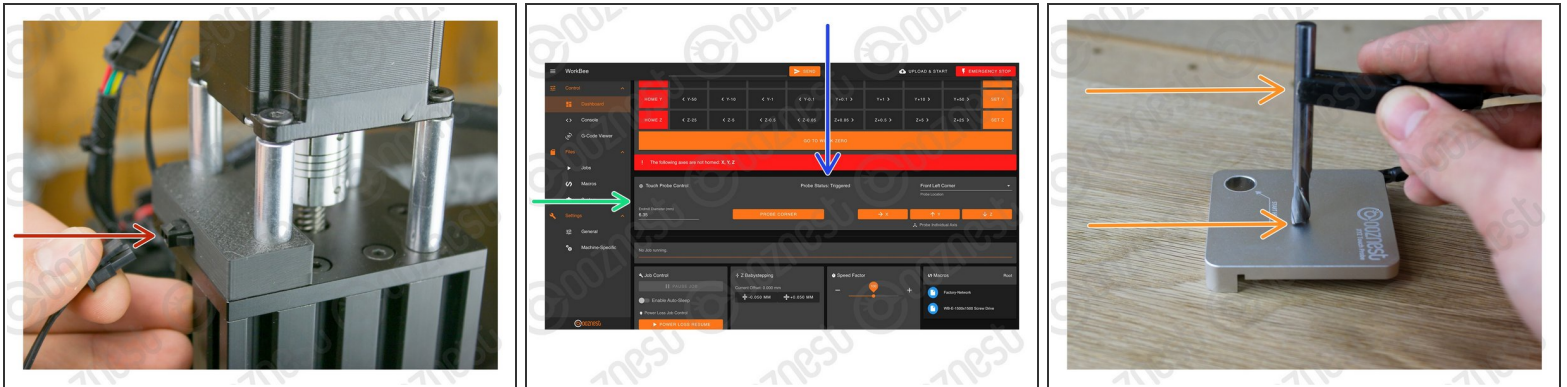
- Feed the Touch Probe Wire through the Drag-Chain-Mount and then through Drag-Chain-X so it comes out the Fixed End.
 - Secure the wire to the Drag-Chain-Mount using a small cable tie. Then secure it along Motor-Wire-6.
- i** The connector on the wire is keyed, so there is only one way which it can plug in.
- Plug in the Touch Probe Wire following Image 2.

Step 5 — Enable



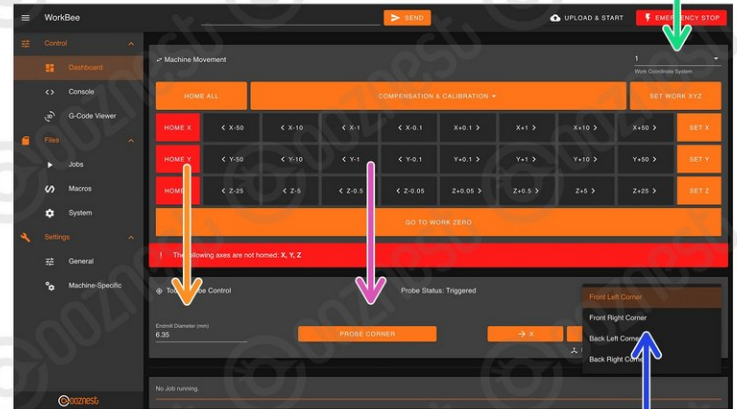
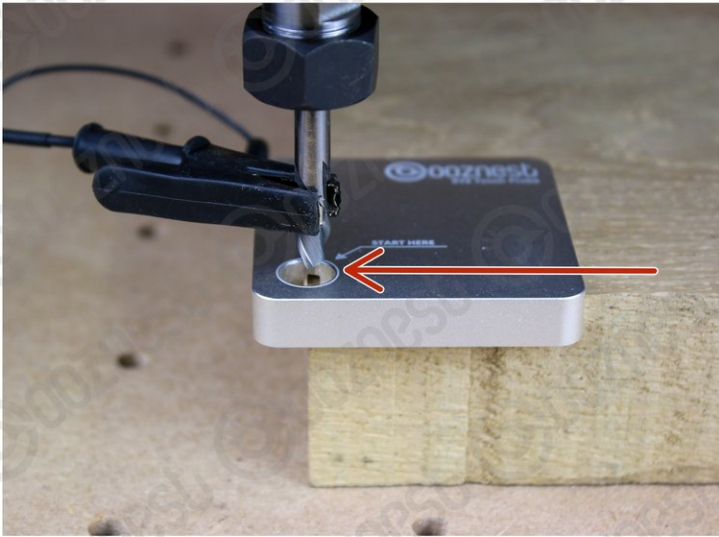
- Enable The Touch Probe.
- Press 'Reset to Defaults' to make sure we have the correct settings for the Original WorkBee XYZ Touch Probe.

Step 6 — Testing



- Plug your Touch Probe into the Touch Probe Mount Connector.
- In WorkBee Control go to Control > Dashboard.
 - You will now see the panel 'Touch Probe Control'
 - You can view the status of the Touch Probe.
- Clip the Crocodile Clip to an End mill not in the Router Head, and hold it touching the Touch Probe like Image 3
- The status of the Touch Probe should change to 'Triggered'
 - ⓘ If it does not, verify your wiring. Otherwise [Contact Us](#).

Step 7 — Corner Probing



- Locate your Touch Probe over the corner of the material. Jog the machine until it is within the 'START HERE' Hole, roughly level with the surface of the Touch Probe. Connect your End mill.
- Select the Work Coordinate system you would like to probe in.
- Select the Corner you have the Touch Probe on.
- Define the Endmill Diameter.
- Press Probe Corner to begin probing.
- Wait until the 'Probe Successful' confirmation.
- Unclip the Touch Probe from the End mill and Touch Probe Mount.
- Press 'Go to Work Zero'. Your machine should be perfectly aligned with the corner of the material.

Step 8 — Z Probing



⚠ Follow these Steps to Probe the **Z-Axis Only**.

- Connect your Touch Probe and End mill like previous.
- ① You can either have the Touch Probe on a corner with the End mill over the middle of the probe like Image 1.
- ① Or you can have the Touch Probe anywhere on your material, but upside down with the End mill over the inset portion like Image 2.
- This time just press the Probe Z button.

Thanks for following the guide. Any issues, please contact us!