WI 050- Mark 4 setup	Date 02/02/2016	Issue- 3	Author- Chris Walkley

Use in conjunction with Mark 4 installation and setup document, this is tick list / order of events to setup Mark 4

Load errormap, convert to .nob file and load in deva, for all machines, store the file in the program data, Aberlink folder.

Set up probe head type

Ensure you have set the pos and neg limits in axis.cfg - No CNC function will occur if set to zero, this includes setting the ref ball, and indexing the RTP via the pole.

Set the measurement range. The measurement range is not the actual range of travel, it represents where the stylus tip can move to safely.

Axiom Too (600), if machine is longer add 100 to low value in Y

	Low	High
Measurement Range X	-750	100
Measurement Range Y	-700	100
Measurement Range Z	Temporarily set Z Low to -620	

Zenith Too (1000), if machine is longer add 100 to low value in Y

	Low	High
Measurement Range X	-1100	100
Measurement Range Y	-1100	100
Measurement Range Z	Temporarily set Z Low to -900	

Within probe setup, go to components, and remove any irrelevant quill plates, as there will be quill plates for each probe type, also check the quill has the correct length.

Build a probe, and set as current. Will have blue circle against it. Check the z offset is correct, top of quill plate to centre of ball.

Set the ref ball position

Datum the probe and measure a plane on the granite. Note the D value in the plane measure window. Add on 1mm and enter in the measurement range for Z Low. If measuring -619.5 for example, make the value -621 (don't worry about the value after the decimal point).

Setup RTP position if fitted. Generate the probes within the probe head setup window.

In CNC settings check blend radius is set to 0.000

In devacmm panel, joystick, check all settings are as below.
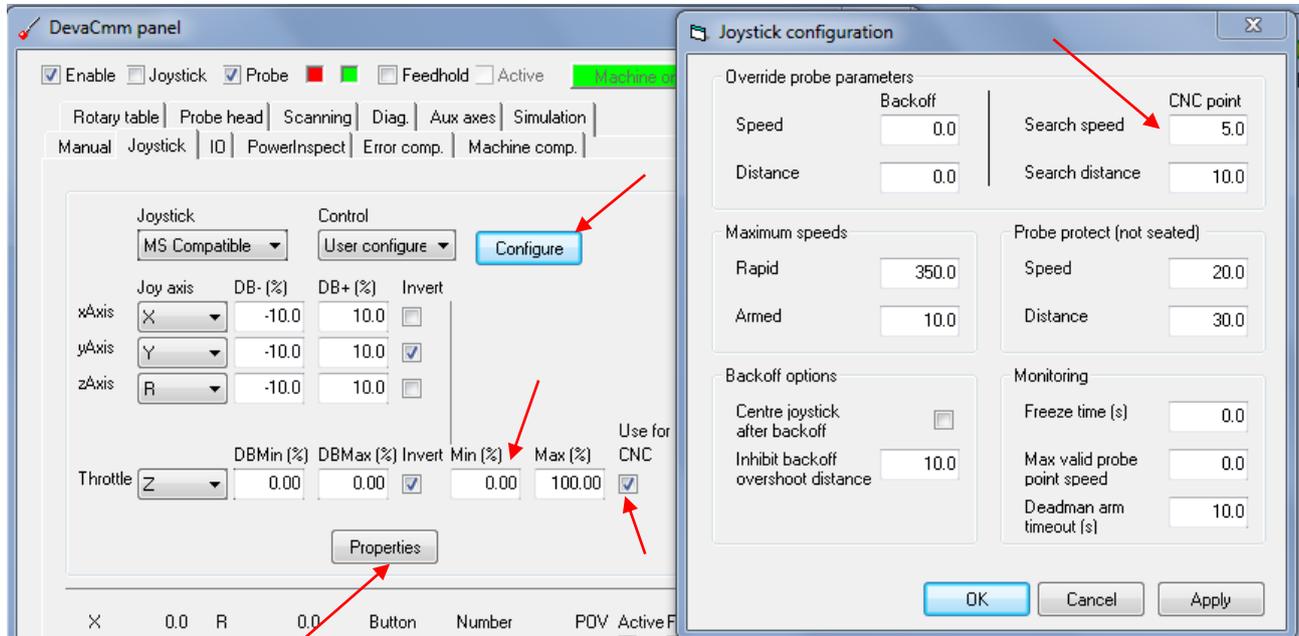
Set the values as below, just overwrite the numbers to enter them, click on Apply to make permanent. Make sure no ticks are in the shift boxes.