

Procedure Name.

Part Probe and Tool Probe repeat tolerance adjustment.

Procedure Description.

As Above.

Supplementary Documentation.

None.

Procedure Details.

1. Exit machine control software. (CTRL F1).
2. Select PMAC and press enter.
3. Press ALT F then O (for Open).
4. Press TAB, select IPROB.PMC and press enter.
5. To change the Part Probe repeat value go to step 6, to change the Tool Probe repeat value got to step 9.
6. Cursor down to line 56, this contains the value of P872 for the part probe. (9 is the default value).
7. Change the value of P872 as required. (See Note below).
8. Go to step 11.
9. Cursor down to line 58, this contains the value of P872 for the tool probe. (3 is the default value).
10. Change the value of P872 as required. (See Note 1 below).
11. Press ALT-D to download the file to PMAC. (Follow on screen instructions).
12. Press ESCAPE to exit the editor.
13. Press Y to save the editor.
14. Type `i3=1` and press enter.
15. Type `SAVE` and press enter. (Wait for the cursor to move to the next line).
16. Press ESCAPE to exit PMAC, then press Y to confirm.

Note: The value of P872 is the repeatability of the probe in resolution counts. One count for the Optoform 50 is 10nm. One count for the Optoform 30 is 40nm. The new value of P872 should not exceed **100** in the case of the Optoform 50, and **25** in the case of the Optoform 30.