Z Probe operating instructions

Step 1: Connect the Z probe to the A5 pin of the control board, regardless of positive and negative.



Step 2: Measure the actual thickness of the Z probe, as shown in the figure is 14.19mm



Step 3: Probe commands filled in Grblcontrol (Candle):

Z14.19 is the thickness of the Z probe, you need to actually measure what you have and then modify this value Z25 is the height of the tool lifting, which can be configured as required.

Probe G code	After editing	Probe Tool height
G90G21G38.2Z-50F100	G90G21G38.2Z-50F100	
G92 Z14	G92 <mark>Z14.19</mark>	
G0 Z22	G0 <mark>Z25</mark>	

G-code progr	an				State Work coordia	hates.	
	6 Settings				2		
X: 0.000 . Y: 0.000 Z: 0.000 0.000 / 0.	Connection Sender Machine info Control User comma Heightmap Parser Visualizer Tool model Console	Connection Port: COM9 Sender Jenore error response Automatically set pre- Hachine information Status query period: Rapid speed: Spindle speed min. :	 • • • • • • • • • • • • • • • • • • •	Baud: 115200 fore sending from Units: Acceleration: max.:	selected line n 100 1000		G90G21G38.2Z-50F10 G92 Z14.19 G0 <mark>Z25</mark>
#	Panels Colors Font Set to defau	Laser power min.: Control Probe commands: G9062163 Safe position commands alts	0 8. 22–50F100 GS G21G90; GS	Rax. : P2214. 19 G0225 530020 OK	255	ectory	Fill the Commands here

🔝 Grblcontrol (Cano	dle)				
ile <u>S</u> ervice <u>H</u> elp	0				
C-code program [CC:C0 C54 C17 F/S: 0 / 0 X: 0.000 0 Y: 0.000 0 Z: 0.000 0 C: 0.000 0	7 G21 G90 G94 M5 M9 T0 F0 S100	0] .00	0:00:00 / 00:00:00 Buffer: 0 / 0 / 0 Vertices: 145 P: 63	State Vork coordinates: 0.000 0.000 0.000 Machine coordinates: 0.000 0.000 0.000 Status: Idle Control Co	Click the "Z-probe" button
	000			• ¥	
#	Command	State	Response	- Jog Console [CTRL+X] < Grbl 1.1f ['\$' for help] S1000 < ok	

Step 4: Click the "Z-probe" button, Z-axis automatic tool to zero.

Step 5: After the automatic tool setting is completed, you will see that the distance from the Z axis to the workpiece surface is 25mm. So the height of the workpiece surface has been defined as 0, no need to click the Zero Z button for the Grblcontrol(Candle).

Grbicontrol (Candi	e)			_ D X
<u>File</u> <u>Service</u> <u>H</u> elp				
G-code program				State
[GC:CO G54 G17 F/S: 0 / 0	G21 C90 C94 M5 M9 T0 F100 S1000	ĺ		Work coordinates: 0.000 0.000 25.000 Machine coordinates: 0.000 0.000 7.144 Status: Idle
X• 0.0000	000	00	.00.00 / 00.00.00	
Y: 0.000 0.00 Z: 0.000 0.00 0.000 0.000 0.000	000 000 0.000		Buffer: 0 / 0 / 0 Vertices: 145 FPS: 62	- Spindle Speed: 1000
#	Command	State	Response	•
				- Jos Console Cozz14.19 C0225 ok [C6:C0 C54 G17 C21 C90 C94 M5 M9 TO F100 S1000] ok
Check 🚺 Scrol	1 Open Reset	Send 🚽 Pau	ise Abort	40