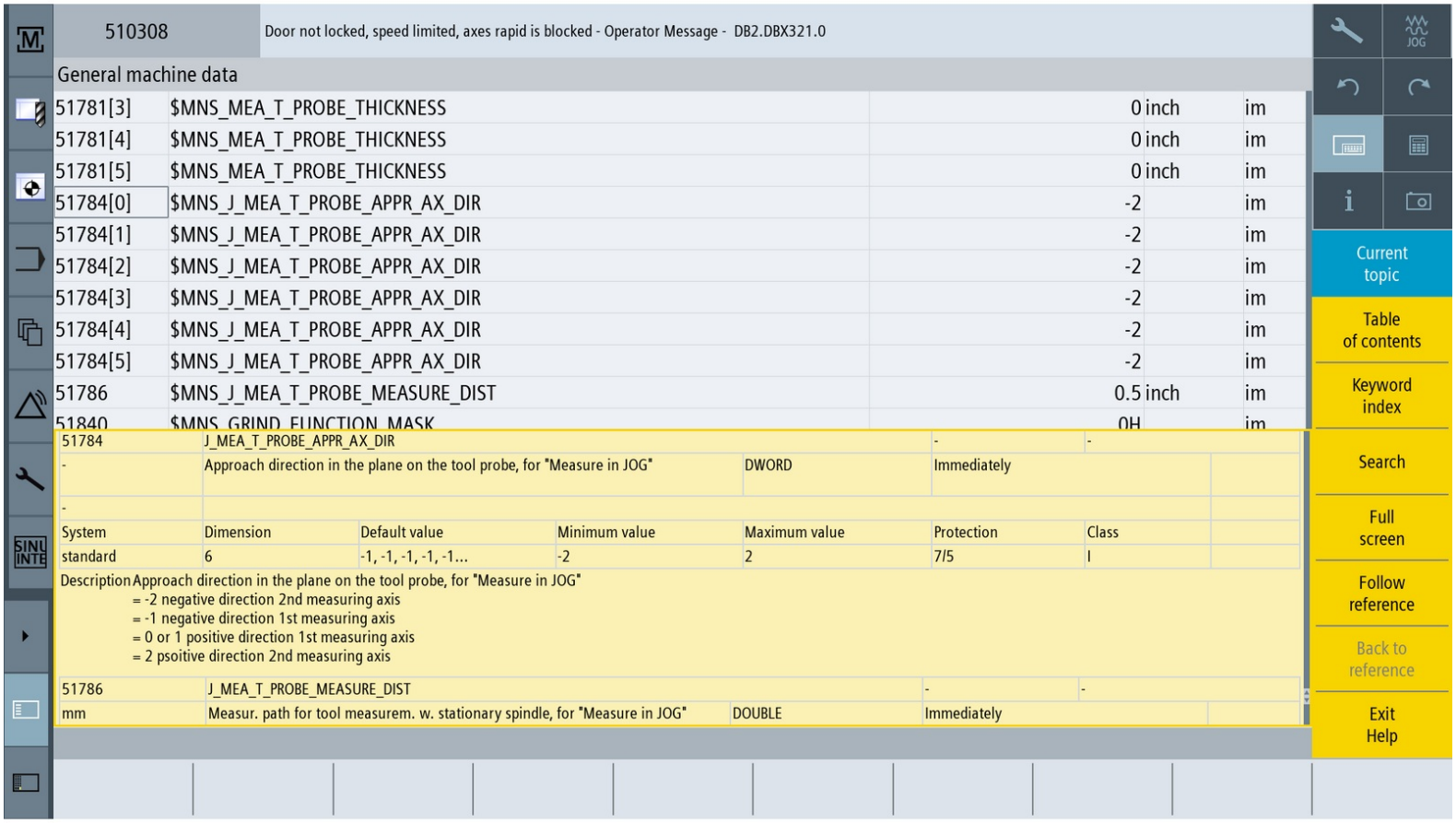
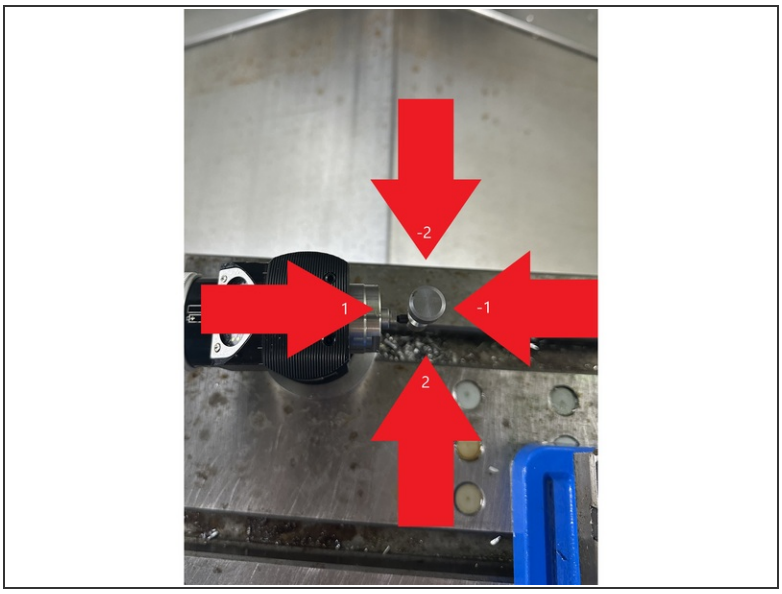
VMCsi - Changing Tool Probe Measuring Axis

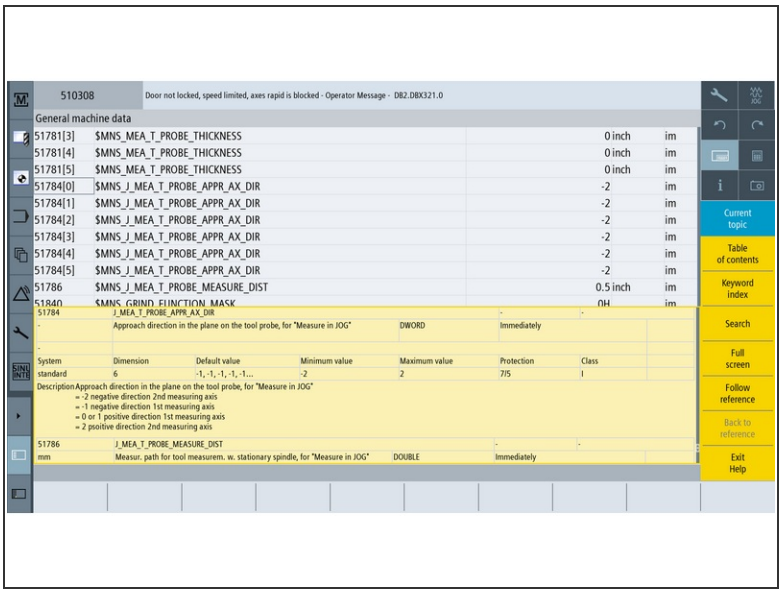
Parameter 51784 changes the axis used for tool diameter measurement.

Written By: Ryan Levrini



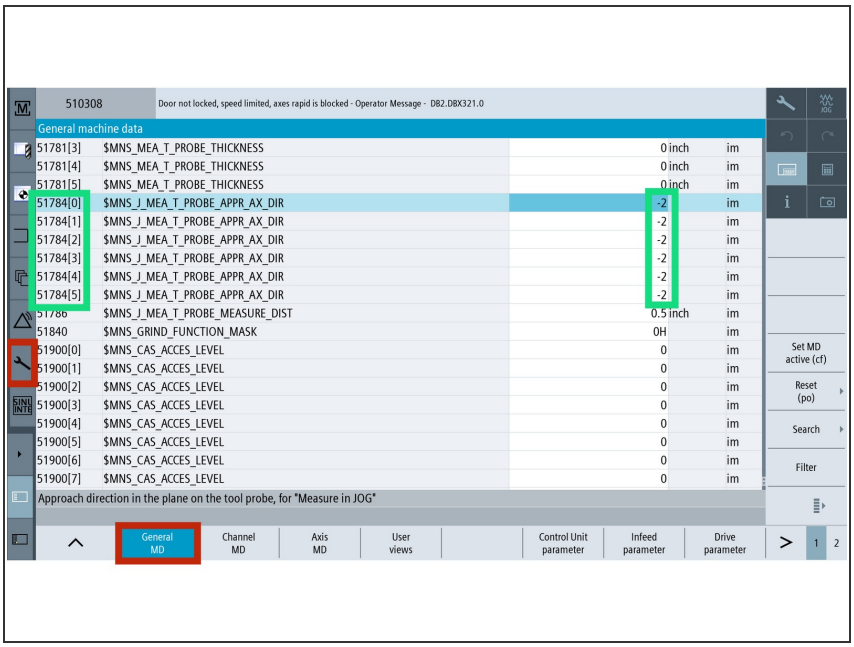
Step 1 — Understanding Parameter 51784





- Parameter 51784[0] through [5] controls the axis and direction used for tool diameter measurement. By default, it is set to -2, meaning the machine measures from the Y-axis in the negative direction (table forward).
- **-2** → Y-axis negative (table moves forward, probe hit from the back)
- **-1** → X-axis negative (probe hit from the right side)
- **1** → X-axis positive (probe hit from the left side) **Not recommended**, as large tools can damage the probe.
- **2** → Y-axis positive (table moves away, probe hit from the front)

Step 2 — Changing Parameter 51784[0] through [5]



- [Set Manufacture Password.]

- Go to **[Setup]** → **[Mach Data]** → **[General MD]** → **[Search]** → 51784

- Locate **51784[0] through [5]** and modify **all six** values to the desired setting from **Step 1**.

- The updated values take effect immediately and no resets or restarts are required.