VMCsi Probe Part Option - Set Up Two Spindle Probes

Set up a VMCsi with two spindle probes so each probe keeps its own calibration data record.

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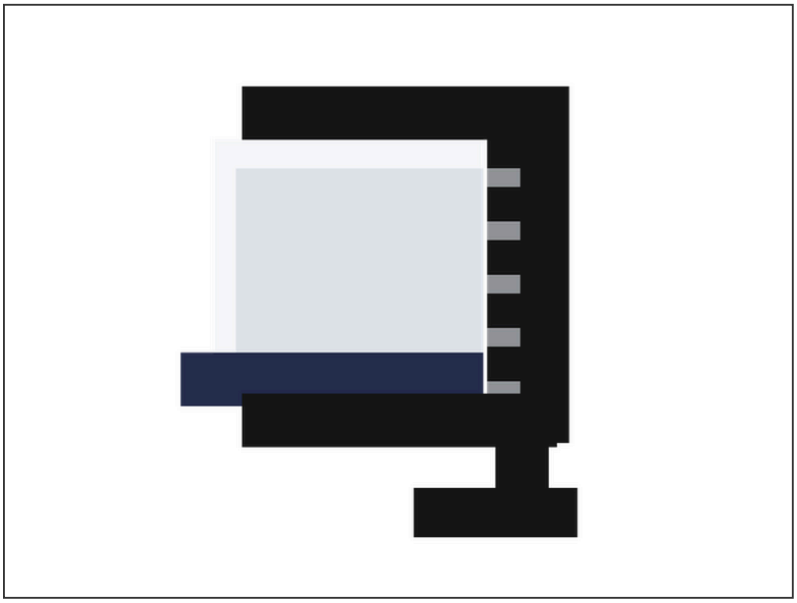


INTRODUCTION

Use this guide when a VMCsi has two spindle probes. Loading two probes in the tool changer is not enough: both probes share one data record, so calibrating or using one overwrites the other. One machine data change and two setting data changes give each probe its own record.

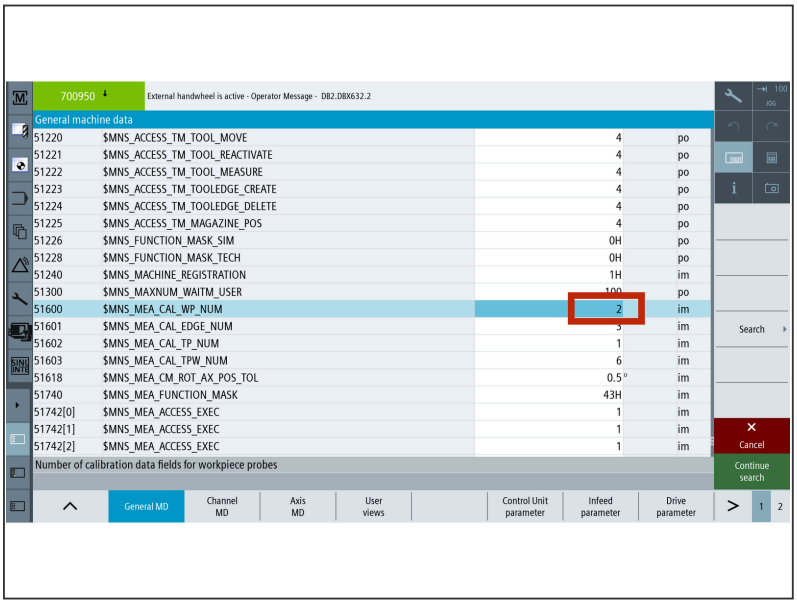
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Step 1 — Before You Start: Archive, Password and Tool Table



- Take an archive before changing any data. Archive Current System
- Set Manufacturer Password. Setting Manufacturer Password
- Set up both spindle probes in the tool table, each as its own tool in its own pocket.
  - ⓘ Example from the field: Probe 1 in pocket 40, Probe 2 in pocket 20.

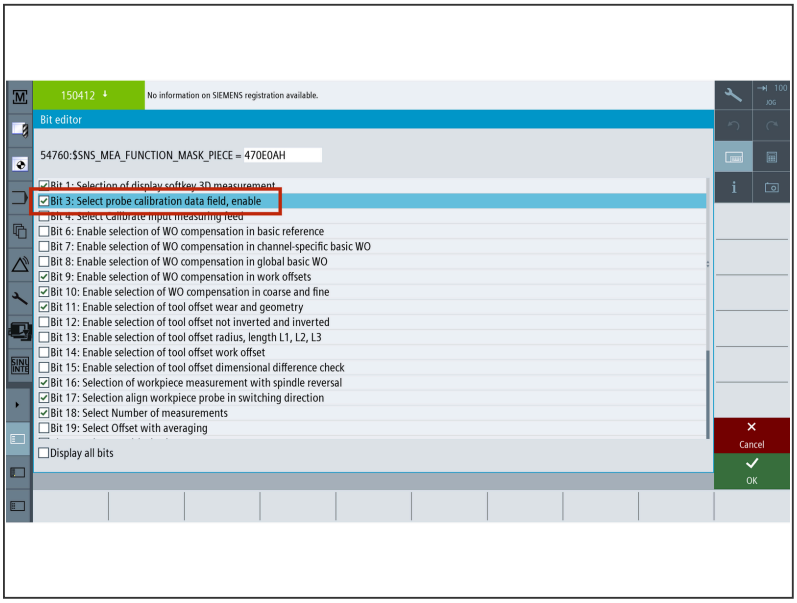
Step 2 — Set 51600 to 2



- Go to **[Setup]** → **[Mach. Data]** → **[General MD]**.
- Press **[Search]**, enter **51600**.
- Set the value to **2**.
- ⓘ 51600 sets the number of probe data records. 2 gives each probe its own record.
- ⓘ 51600 takes effect immediately (im). No reset is needed.

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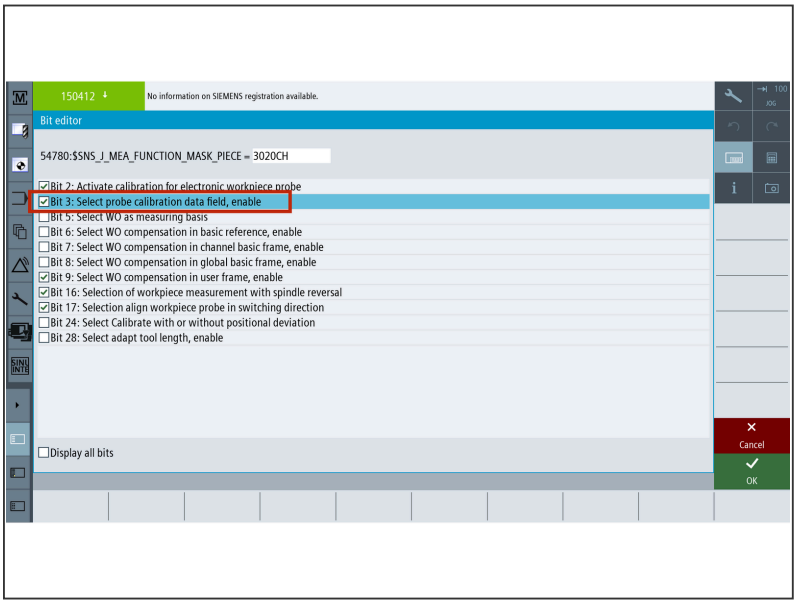
Step 3 — Enable Bit 3 in 54760



- Go to **[Setup]** → **[Mach. Data]** → **[Page 2]** → **[General SD]**.
- Press **[Search]**, enter **54760**.
- Set bit **3** to 1 (checked on). Leave the other bits as they are.

ⓘ 54760 takes effect immediately (im). No reset is needed.

Step 4 — Enable Bit 3 in 54780

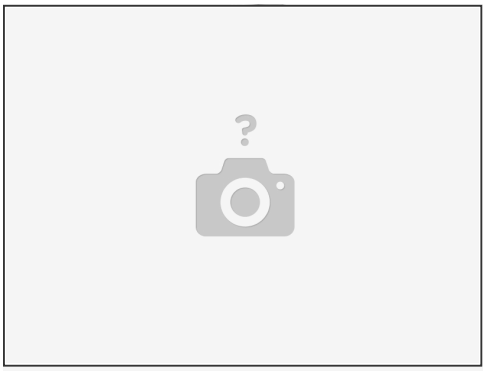


- Stay in **[General SD]**.
- Press **[Search]**, enter **54780**.
- Set bit **3** to 1 (checked on). Leave the other bits as they are.

ⓘ 54780 takes effect immediately (im). No reset is needed.

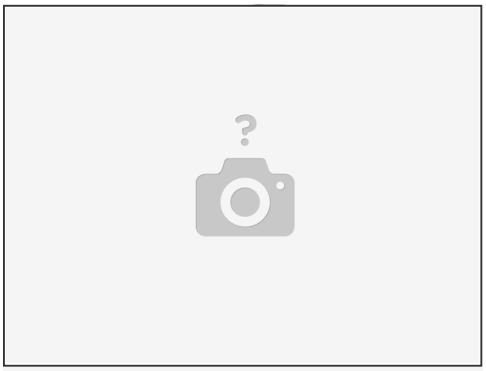
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Step 5 — Calibrate Each Probe Into Its Own Record



- Load Probe 1 into the spindle and calibrate it.
  - VMCsi Probe Part Option - Calibrate Spindle Probe
- Load Probe 2 into the spindle and calibrate it.

Step 6 — Verify Each Probe Keeps Its Own Data



- Test each probe on its own.
- Switch back and forth between the probes a few times.
- Confirm Probe 1's values still match after using Probe 2, and the other way around.

⚠ If one probe's values changed, the records are still shared. Do not use the probes. Recheck 51600 and bit 3 in 54760 and 54780.