

FLASHCUT CNC

CONTROL MADE SIMPLE

®

Tool Length Sensor



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1. Tool Length Sensing Kit

Thank you for purchasing the FlashCut CNC tool length sensor. This manual covers how to convert a FlashCut CNC touch probe into a tool length sensor.

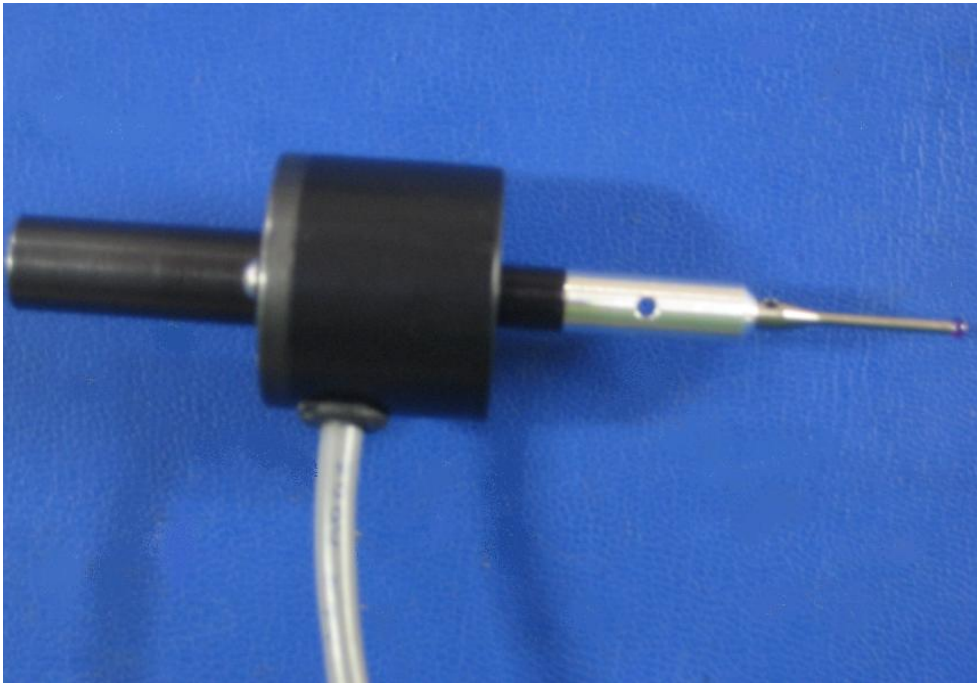
Kit Contents

The tool length sensing kit includes:

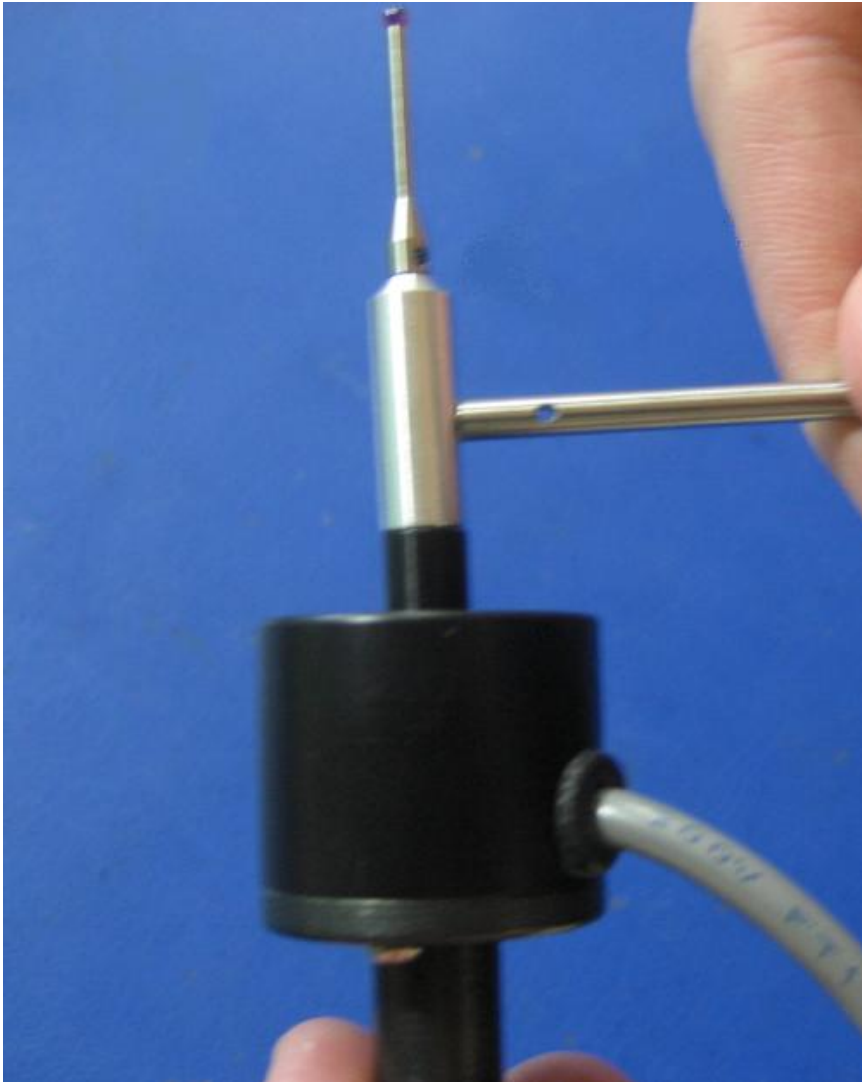
- (1) Circular touch-off plate
- (1) Mounting base
- (1) Touch probe body

Assembly

1. The first step is to disassemble the FlashCut CNC touch probe



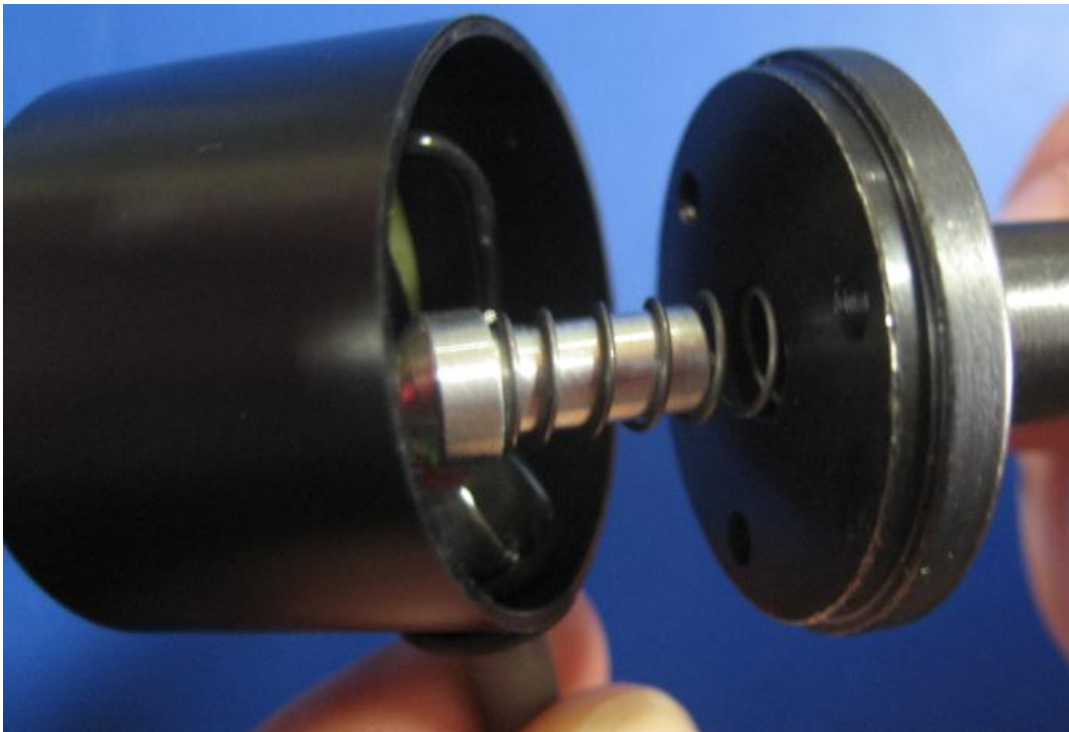
2. Unscrew the sensing tip of the touch probe. It is a standard right handed thread.



3. Next, on the shaft side of the touch probe remove the three screws holding the shaft on the touch probe.



4. Once the three screws are removed, remove the shaft from the touch probe being careful not to lose the spring inside the assembly.





5. Remove the spring and plunger from the shaft of the touch probe.



6. Place the spring and plunger assembly into the base of the tool length sensor



7. Place the base of the tool length sensor onto the body of the touch probe making sure not to damage the spring assembly.



8. Secure the tool length sensor base to the touch probe body using the 3 screws removed from the touch probe shaft.

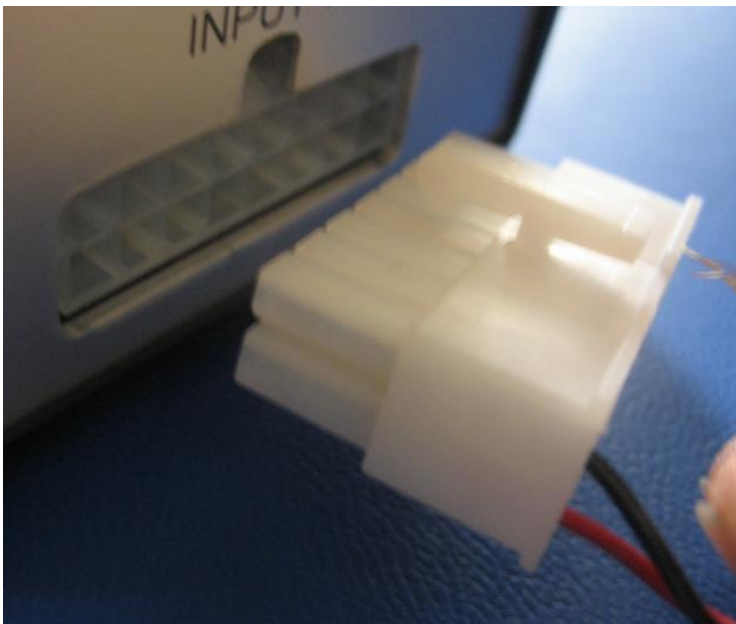


9. Screw the touch off plate to the top of the tool length sensor where the touch probe tip was removed.



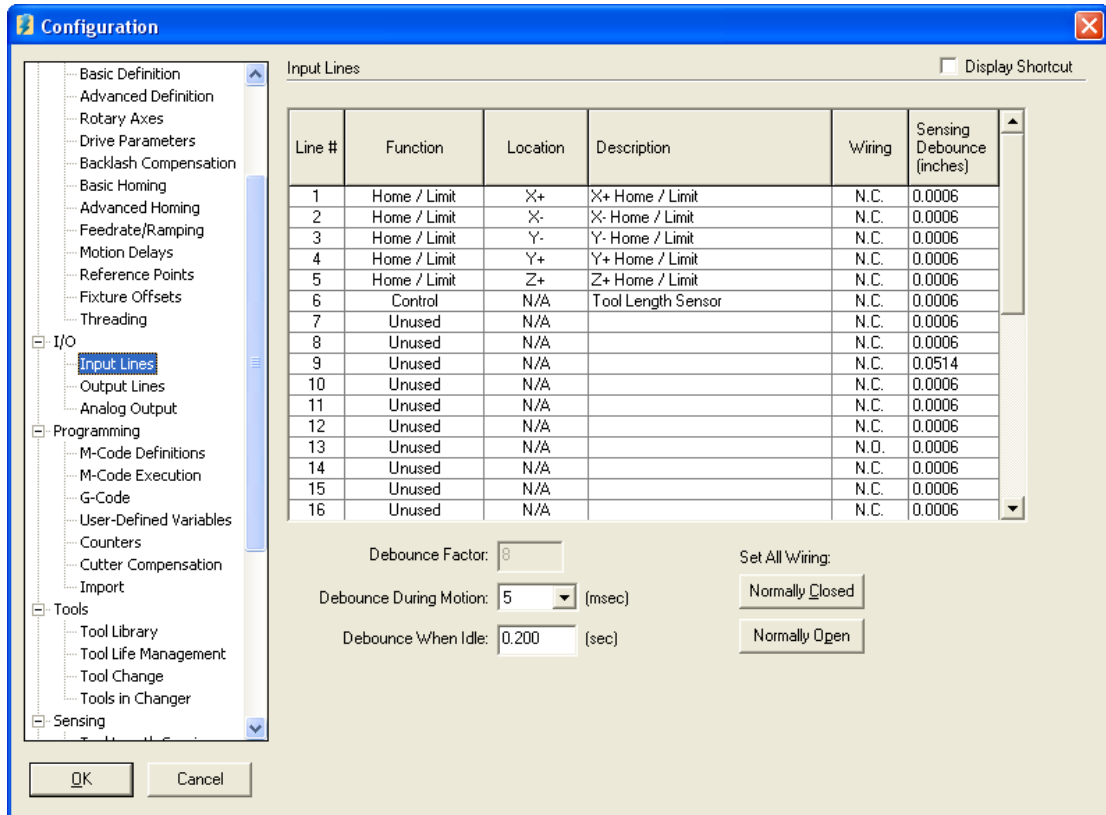
Wiring

Connect the tool length sensor to an available input line on the signal generator.

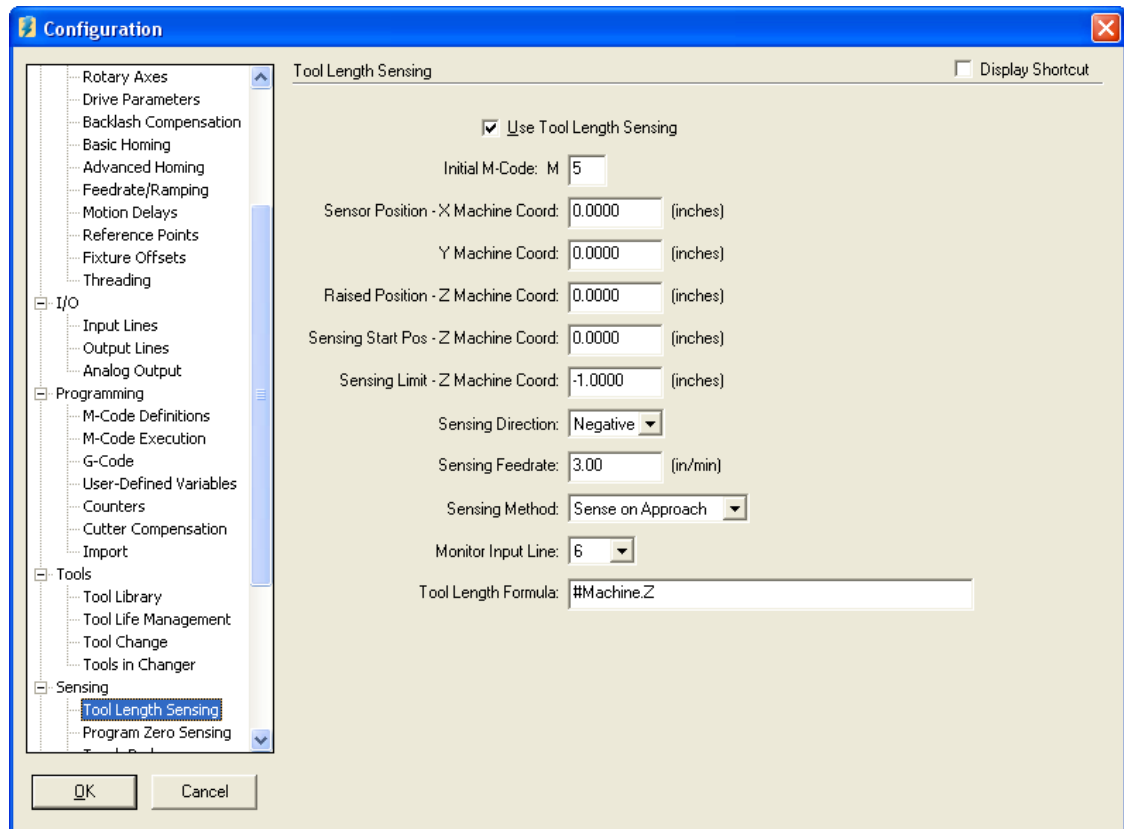


Software Configuration

In the FlashCut CNC software under input lines, define the input line, for which the tool length sensor has been connected, as the tool length sensor.



In the FlashCut CNC software under tool length sensing you must check the box that says to use tool length sensing, define an M code to perform the tool length sensing in the g-code, state which input line the tool length sensor is connected to and define a few more specifics of the tool sensing based on your application.



The tool length sensor has now been assembled and connected to FlashCut CNC. To use this feature simply load the tool as indicated in your tool library and select “length” in the tool box on the main screen.