

MACH3 surface scanning script

1. Copy the M650.m1s to your MACH3/macros/profile folder.
2. Edit the script and set correct output folder and file:

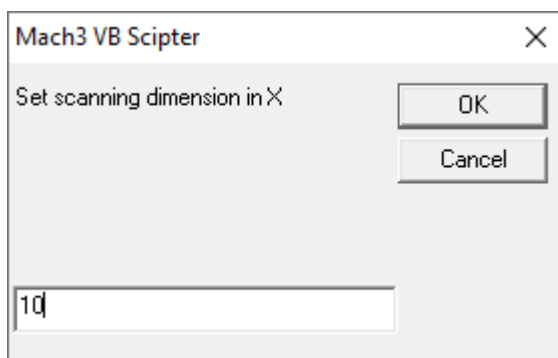
```
If(Xcnt<1 Or Ycnt<0) Then
  MsgBox "Wrong parameters. Script terminated!",0,Title
  Exit Sub
End If

If(MsgBox("Start surface scanning?",4,Title)<>6) Then
  MsgBox "Script terminated!",0,Title
  Exit Sub
End If

Open "C:\Mach3\SurfaceScanningOutput.txt" For Output As #iFileOutput

If(Xcnt>1) Then
  XStep=Xdim/(Xcnt-1)
Else
  Xstep=0
End If
```

3. Move a sensor to the start position. X and Y will be position of the first scanned point. Z has to be higher than any point in the scanned surface.
4. Run the script M650
5. Set the dimension of scanning in X and Y axis:

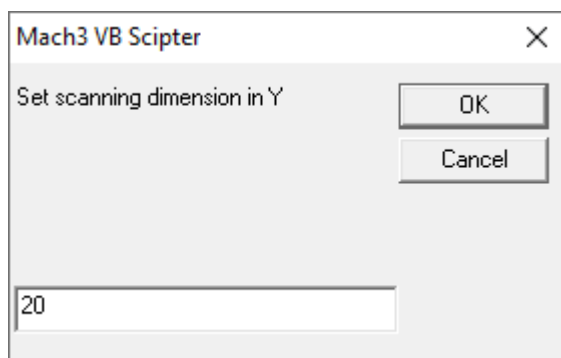


Mach3 VB Scriptor

Set scanning dimension in X

OK Cancel

10



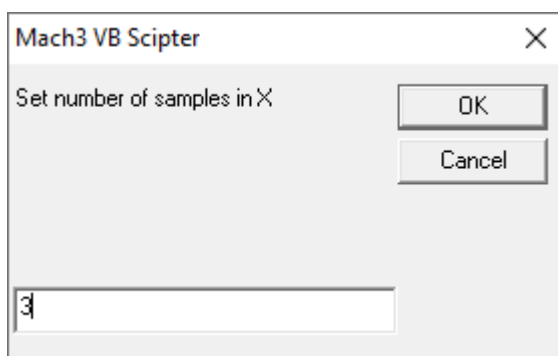
Mach3 VB Scriptor

Set scanning dimension in Y

OK Cancel

20

6. Set the number of the samples in X and Y axis. The number has to be ≥ 1

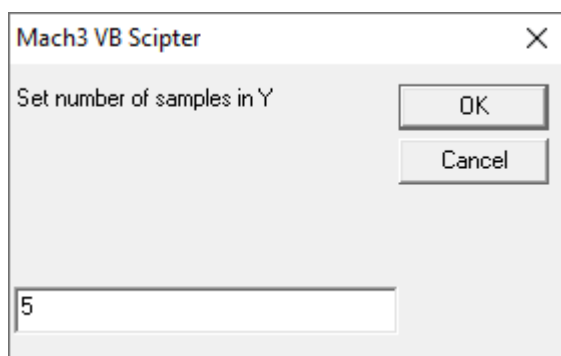


Mach3 VB Scriptor

Set number of samples in X

OK Cancel

3



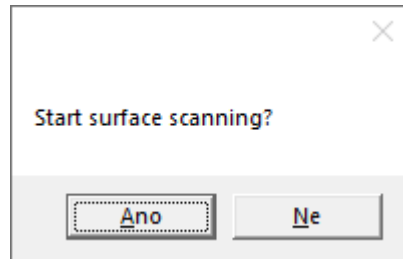
Mach3 VB Scriptor

Set number of samples in Y

OK Cancel

5

7. As soon as parameters are set and correct, start scanning by the dialog:



8. When scanning is finished, output file is stored in the defined folder.

Output format can be modified by the modifying of this code line:

```
Code"G91 G31 Z-20 F" &FeedMeas
Sleep(10)
While IsMoving()
Sleep(10)
Wend
Print #iFileOutput, "X" & roun(Xpos) & " Y" & roun(Ypos) & " Z" & roun(GetOEMDRO(802))
Next y
Code "G90 G0 Z" & Zstart & " F" & FeedMove
```