



M1 thru M4 are now functional.

Important: You need the at least UCCNC V1.2026 installed on your computer.

These macros are for use only with the Stepcraft system and the original Stepcraft attachments and tools, this will not work with homemade or third party sensors, be sure to use only the original Stepcraft parts.

The macros used and changed include the M31 and M6, so don't replace them!. For these macros to work as they should.

The macros contain pop-up windows that instruct you how to use them "on the fly".

M1

This macro allows you to change an endmill without losing the first endmill zero.

Usage: Move the gantry to any area and place the Tool Length sensor below the endmill, press the M1 button following the instructions press OK, after measuring the first endmill replace the endmill with the new one and press OK to measure the next endmill, the macro will adjust the zero for the new endmill.

M2

This macro provides the ability to change the 3D Probe for an endmill without losing the zero already probed by the 3D probe.

Usage: Move the gantry to any area and place the Tool Length sensor below the 3D sensor, mark the place of the Tool Length Sensor with a marker (you need these marks to place the sensor in the same position). Remove the Tool Length Sensor and press the M2 button. The 3D Probe will touch the surface twice and move up. Remove the 3D Probe, set up the spindle on place and place the Tool Length Sensor on the same position using the marks you previously made, this will place the sensor exactly below to the endmill, press ok to take the measure of the endmill, the macro will adjust the zero for the endmill.

M3

This macro allows you to change an ATC tool entering the tool number and loading the new offset tool in case it have it.

Usage: Press the M3 button and enter the tool number you want to change on the ATC, the macro will automatically change the ATC tool and load the tool offset.

M4

This macro automatically adjusts all the tools offsets on the ATC or can adjust only tool offset. Use this for the first time you set up the tools on the ATC. If you need to change the offset for a single tool it important that you already set up all the tools offsets first, this macro can't adjust the first tool offset because the first tool its zero, if you change the first tool, you need to run the adjustment for all the tools.

Usage: After setting up the ATC, ATC holder, and place all the tools in place be sure that if you have a tool on the ATC you need to have the empty place on the ATC holder corresponding to that tool number showing on UCCNC, if UCCNC show the tool number is 0 (zero) then the ATC must be empty and all the tools need to be positioned on the holder.

Move the gantry to a position where there will be free movement for it to grab the tools and measure them with the Tool length sensor (we recommend a front left position from the holder), place the Tool Length Sensor below the endmill and press the M4 button, following the instructions, enter how many tools you have on the holders, the macro will change the tool for tool #1, and start the measure for all the tools.

If you enter 1 on the how many tools question this instructs the macro to measure only one tool, the macro will ask you which tool you want to adjust, it will change the current tool for tool #1 measure it for reference then change the tool for the one you want to adjust and measure it and change the offset for that tool only.