

## Zeroing to the table bed with Ecabinets

If you are using Ecabinets along with the ShopBot Link, your part files will be automatically written with information that tells the ShopBot that you are zeroing the Z-axis to the top of the material. This document explains how to change this default so that your part files are zeroed at the table base instead. These changes will affect any .SBP files that you have on your computer that were created with Ecabinets. You do not need to recreate your old files.

Start by navigating to **C:\SBParts\Custom\MTC\MTC.sbp**. You are going to make some changes to this file. On or near line 29 you should see the following:

```
\&zero to bed = 1
```

Once you find this line, type an apostrophe right in front of it. This is called "commenting out the line" and turns the command into a comment, which effectively cancels it. You will see it change colors when you do this. Now it will look like this:

```
\&zero_to_bed = 1
```

There is another block of code that we will have to do this to, at or around line 370. It should currently read like this:

```
CHECK_MTL:
```

```
'IF &zshift = 0 THEN GOSUB MTL_ERROR &zshift = 0
'MSGBOX(Did you Zero to bed? ,YesNo,ZERO BIT?)
'If &msganswer = NO then &zero_to_bed = 0
'If &msganswer = YES then &zero_to_bed = 1
&z adjust = &zshift * &zero to bed
```

What you want to do to this block is activate the lines that are commented out (remove the apostrophe), and comment out the active lines (add an apostrophe)... with the exception of the last line. Leave that as is. This is what you'll end up with:

## CHECK\_MTL:

```
IF &zshift = 0 THEN GOSUB MTL_ERROR
'&zshift = 0
MSGBOX(Did you Zero to bed? ,YesNo,ZERO BIT?)
If &msganswer = NO then &zero_to_bed = 0
If &msganswer = YES then &zero_to_bed = 1
&z_adjust = &zshift * &zero_to_bed
```

When you are finished, you need to save this file. Click on File > Save (on the menu bar at the top of the window). If you are only working with ecabinets, you are now finished and can skip the next step.



If you are also creating part files on this computer with Partworks and Aspire, you may need to make some additional changes to keep everything working smoothly. If you are using the newest post-processor (Shopbot\_TC\_inch.pp), or any of the other posts that indicate toolchange capability, you will need to follow this next set of instructions. If you are using an older post without toolchange capability (shopbot\_arcs\_inch.pp or arcs\_mm.pp), you can disregard this step.

Open Partworks and/or Aspire, and click on **File > Open Application Data Folder > PostP > Shopbot\_TC\_inch.pp.** 

Create a new line in between "Start File" and Program moves. Enter the following code on the empty line:

## % = 0

And click File > Save. You are now finished making changes to your files.

```
ShopBot_TC_inch.pp - Notepad
File Edit Format View Help
                           Start of file
begin HEADER
   SHOPBOT ROUTER FILE IN INCHES"
GENERATED BY PARTWORKS"
  GENERATED BY PARTWorks"

'Minimum extent in X = [XMIN] Minimum extent in Y = [YMIN] Minimum extent in Z = [ZMIN]"

'Maximum extent in X = [XMAX] Maximum extent in Y = [YMAX] Maximum extent in Z = [ZMAX]"

'Length of material in X = [XLENGTH]"

'Depth of material in Z = [ZLENGTH]"

'Home Position Information = [XY\_ORIGIN], [Z\_ORIGIN] "

'Home X = [XH] Home Y = [YH] Home Z = [ZH]"

'UNITS:Inches"
  'UNITS:Inches
  IF %(25)=1 THEN GOTO UNIT_ERROR
                                                                'check to see software is set to standard"
                                                                'Set program to absolute coordinate mode
 'CN, 90"
TR,[S]"
                                   'Return tool to home in x and y"
 'PAUSE 2"
 'MS,[FC],[FP]"
 ˈjz,[zн]"
'j2,[xн],[үн]"
                         Program moves
begin RAPID_MOVE
"J3,[X],[Y],[Z]"
```