

```

1 'SETUP PROGRAM FOR TOOL CHANGER
2 'Move over to where the routing will be done. Remove any Tool Holder
3 'in the router. Place the zero plate under the collet chuck.
4 MS,2,0.75
5 &XOFFSET=0.0
6 &YOFFSET=0.0
7 FP,C:\MRTPROG\VARIABLES.SBP
8 INPUT "X Offset. ->" &XOFFSET
9 INPUT "Y Offset. ->" &YOFFSET
10 J2, &XOFFSET,&YOFFSET
11 'Place Zero Plate Under Router and Hit Any Key
12 PAUSE
13
14 ON INP(2,1) GOSUB STOPRETURN
15 &TEMP=1
16 SO,2,1
17 PAUSE .3
18 SO,2,0
19 PAUSE .3
20 SO,2,1
21 PAUSE .3
22 SO,2,0
23 MZ,-10.0
24 &TEMP=1
25 ON INP(2,1) GOSUB SETZZERO
26 &TEMP=1
27 MZ,-10.0
28 &TEMP=1
29
30 J2,&XZEROLOCATION+3,&YZEROLOCATION
31 JX,&XZEROLOCATION
32 &TEMP=1
33 ON INP(2,1) GOSUB STOPRETURN
34 &TEMP=1
35 SO,2,1
36 PAUSE .3
37 SO,2,0
38 PAUSE .3
39 SO,2,1
40 PAUSE .3
41 SO,2,0
42 MZ,-10.0
43 &TEMP=1
44 ON INP(2,1) GOSUB PLATFORMZERO
45 &TEMP=1
46 MZ,0
47 &TEMP=1
48 JZ,4.0
49 JX,&XZEROLOCATION+6.0
50
51 FP,C:\MRTPROG\VARIABLES.SBP
52
53 END
54 '-----
55
56 STOPRETURN:
57 ON INP(2,1)

```

```
58  &TEMP=1
59  JZ,%(3)+.25
60  &TEMP=1
61  MS,,0.125
62  RETURN
63
64  SETZZERO:
65  ON INP(2,1)
66  &TEMP=1
67  VA,,, &ZEROPLATETHICK
68  PAUSE .2
69  JZ,&DELTAZEROPLATES+.5
70  'REPLACE THE ZERO PLATE AND HIT ENTER
71  PAUSE
72  &TEMP=1
73  MS,,0.75
74  RETURN
75
76  PLATFORMZERO:
77  ON INP(2,1)
78  &TEMP=1
79  &ZEROPLATE=%(3)
80  RETURN
```