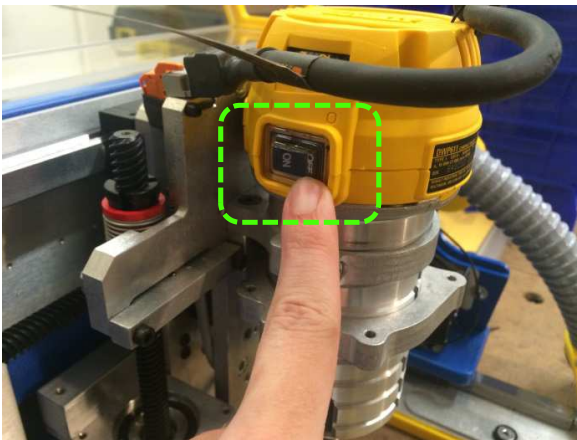


Setting Z Zero Plate Height

- 1 Your handibot comes with a built in Z Zeroing plate that is calibrated at the factory for your specific tool. From time to time it may be necessary to adjust the settings for this plate to get the most accurate Z Zeroing. Start by running the regular Z Zero routine as follows.



- 2 For safety, turn router power switch to "OFF"



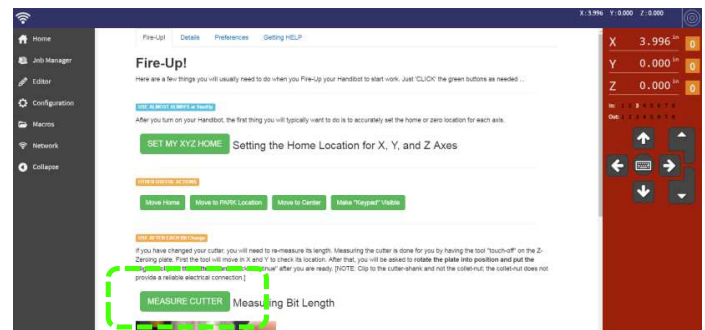
- 3 Remove vacuum foot by pulling it down from router bracket. Set vacuum foot out of the way, to the side.



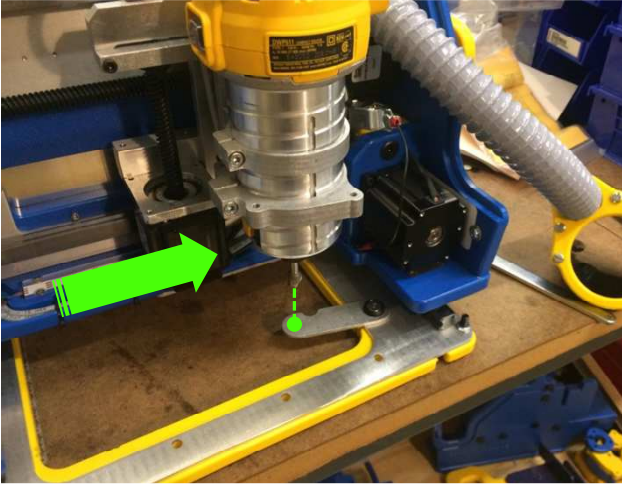
- 4 Flip Z-Zero plate out from right side of handibot base.



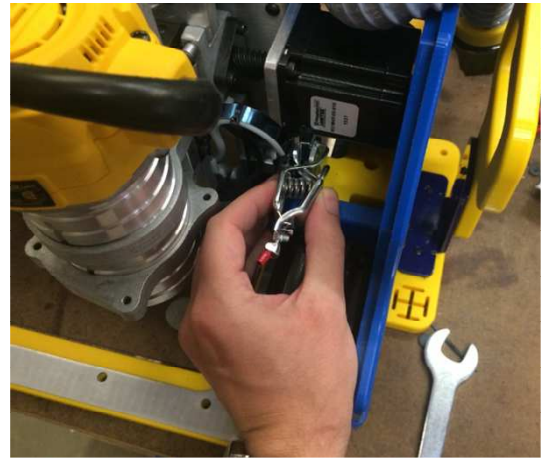
- 5 Open the "Fire-Up!" app from the FabMo dashboard and click the "MEASURE CUTTER" button.



- 6 The routine will move the bit into place over Z-Zero plate after homing all axes.



- 7 Remove bit clip from metal bracket on right side of tool.



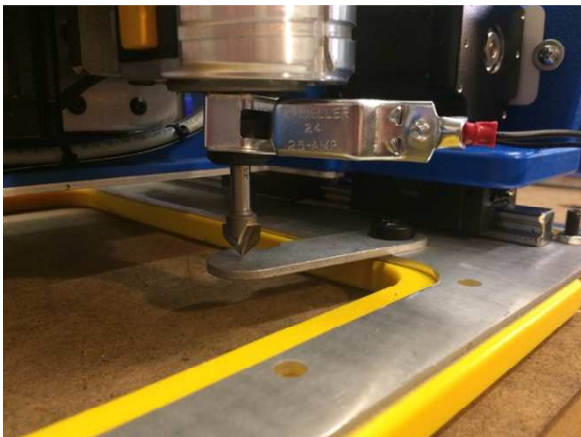
- 8 Attach clip to the shank of your bit.



- 9 For safety, get your hands clear of the tool before starting the zeroing process!



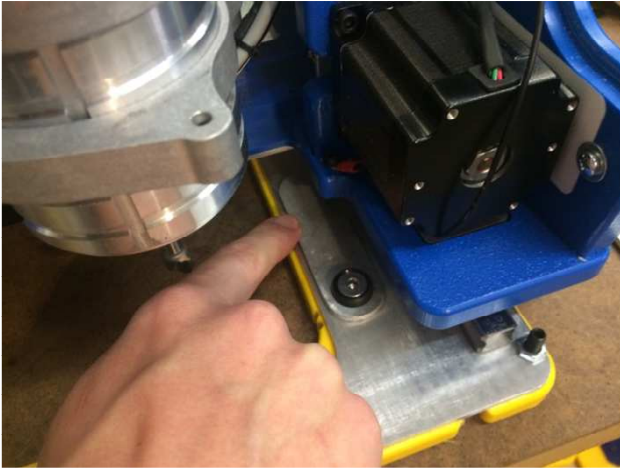
- 10 Tool will automatically touch off on Z-Zero plate and be offset based on the thickness of the handibot base.



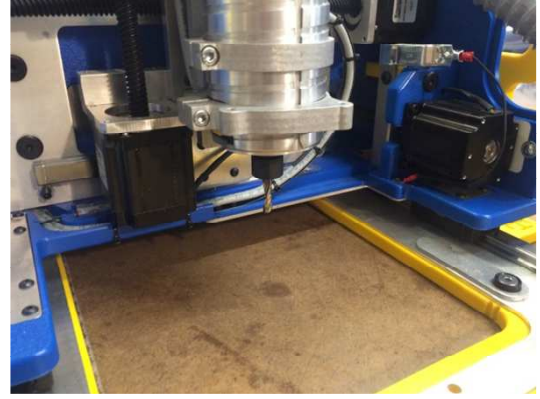
- 11 Be sure to put the clip back on the metal bracket on the right side of the tool.



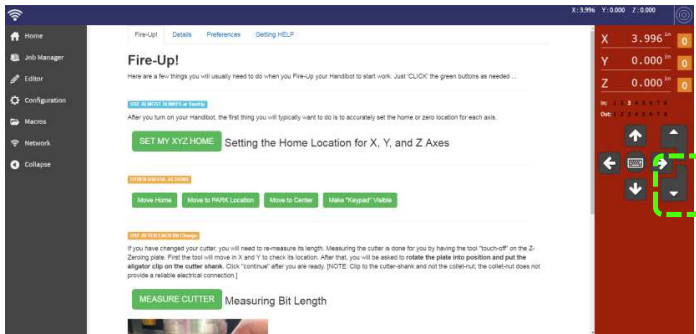
- 12** Flip Z Zero plate back into place on the tool base.



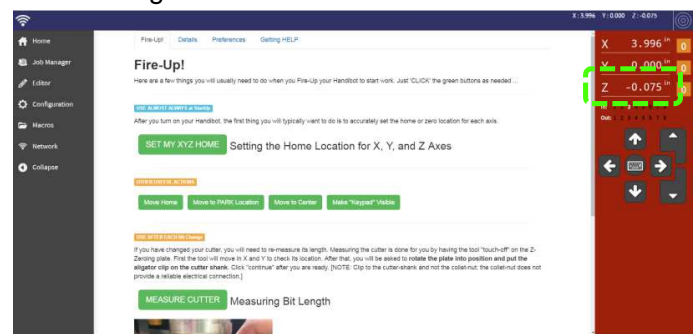
- 13** Now, manually drive to tool out to an area roughly in the middle of your material.



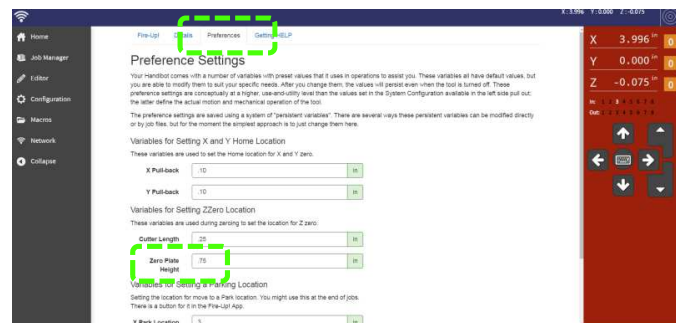
- 14** Manually step the bit down using the keypad on the right side of the FabMo interface. Quick taps will move the Z-axis in 0.005" increments. Continue until the bit just barely touches the material.



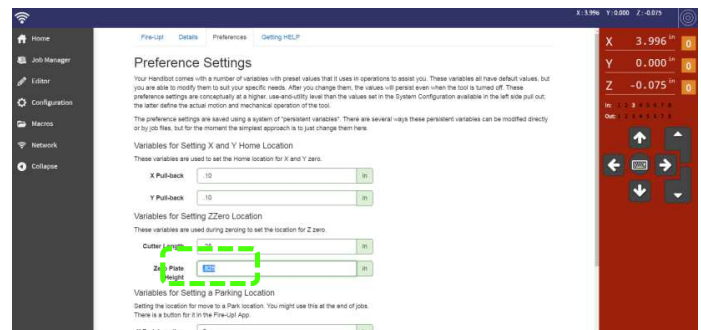
- 15** If your Z position is not exactly 0 then you will need to adjust the Z Zero Plate Height. Check the number in the digital read out; in this example we are 0.075" below where we thought "zero" was.



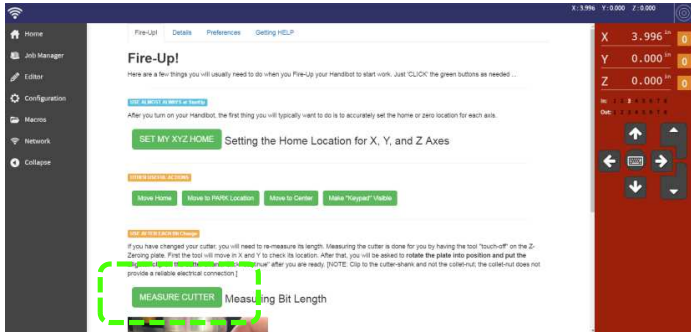
- 16** Click over to the "Preferences" tab in the fire-up app. Locate the setting for "Zero Plate Height" part way down the page.



- 17** To recalibrate your zero plate height, subtract the offset that we just found from the current plate height. In this example:
 $0.75 - (-0.075) = 0.75 + 0.075 = .825$



- 18** Click back to the “Fire-Up!” tab. The settings will automatically save. Re-run the “MEASURE CUTTER” function and re-check for correct bit height.



- 19** Clip vacuum foot back onto router bracket.



- 20** Turn router power switch back to “ON” to get ready to start cutting!

