

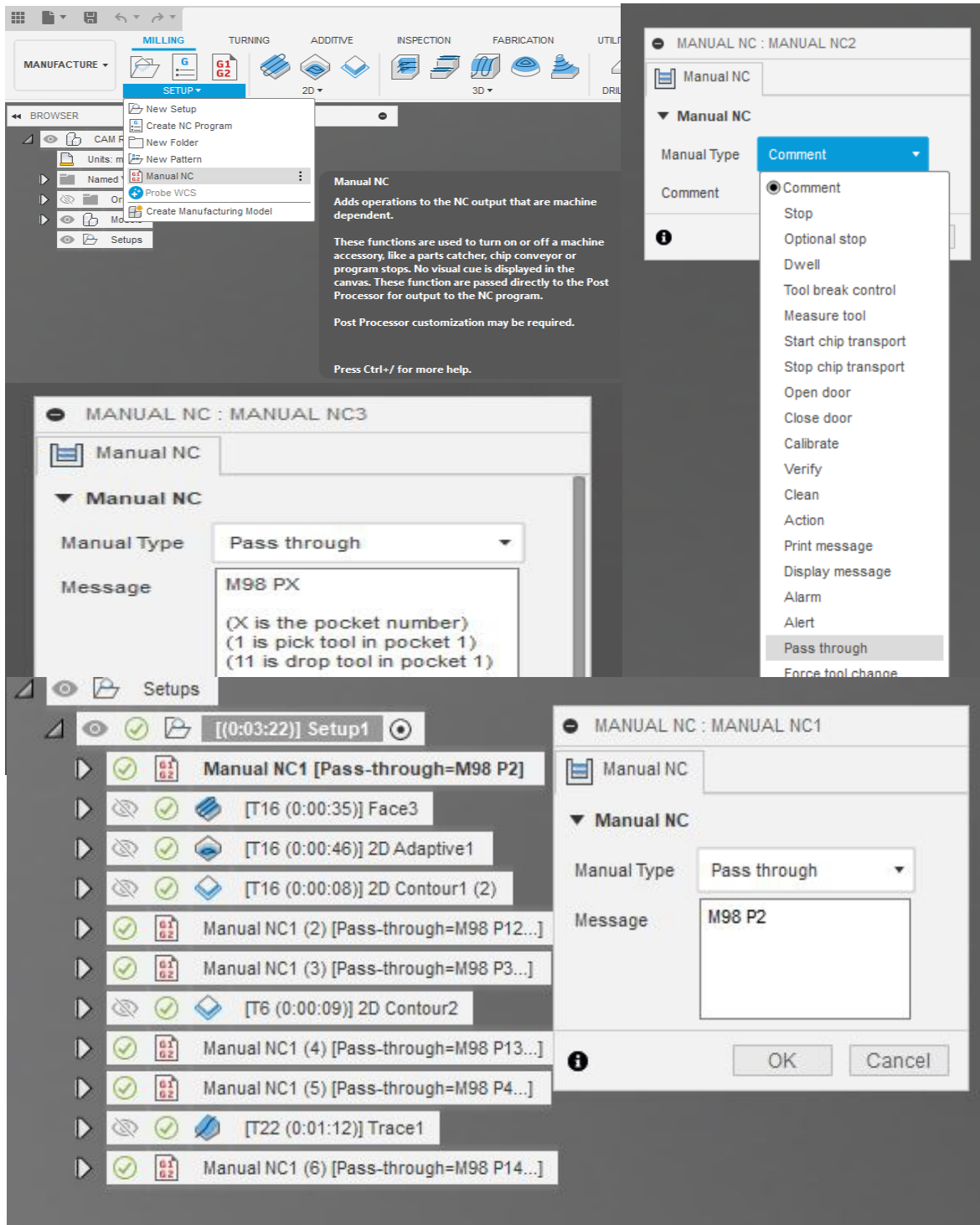
RapidChange ATC Setup on Masso cnc

* All examples assume the z home position is 0 at the highest position

Use Manual NC to call a tool

Use pass through m98 to pick and drop tools

All pick and drop codes (1 2 3 4 5 11 12 13 14 15 must be in the same masso folder as the gcode



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Add this line to close the cover using the esp32

`writeBlock(mFormat.format(64), "P" +(1)) // cover close atc`

```
893     if (insertToolCall) {
894         forceWorkPlane();
895
896         onCommand(COMMAND_STOP_SPINDLE);
897         setCoolant(COOLANT_OFF);
898
899         if (!isFirstSection() && getProperty("optionalStop")) {
900             onCommand(COMMAND_OPTIONAL_STOP);
901         }
902
903         if ((tool.number < 0) || (tool.number > 31)) {
904             warning(localize("Tool number should be between 0 and 31."));
905         }
906         writeBlock("T" + toolFormat.format(tool.number), mFormat.format(6));
907         writeBlock(mFormat.format(64), "P" +(1) ) // cover close atc
908         if (tool.comment) {
909             writeComment(tool.comment);
910         }
```

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