

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 re-create 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.**

