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Probe open alarm: information for users of Fanuc controllers

The *92(Probe Open)* alarm occurs in Renishaw macro software when the probe stylus is already in contact with a surface at a time when a probing move is intended. (It may also occur if the probe is not active.)

As machine tool performance increases, Renishaw amends default values within the setting macros of our products. In particular, the 'back off factor' (#506) is changed to speed up probing.

In some cases this change may increase the likelihood of a probe open alarm occurring on large or older machines which are less able to stop quickly after the stylus first contacts the surface.

Action to take if a probe open alarm occurs

- Check that the probe is switched ON and functioning correctly
- When using longer styli, the probe may trigger due to machine vibration. A range of filter settings are available on all probes to overcome these false triggers. For information on these settings, please refer to the appropriate probe quick start guide, available from **www.renishaw.com**
- If the stylus remains in contact with the surface after a genuine measurement, i.e. the stylus has not backed off fully, the back off factor should be increased as follows:
  - Enter the CNC offset (#) setting page and edit #506. It is recommended that this value be increased in increments of 0.1 until your probing cycle runs without causing a probe open alarm (note the maximum value is #506 = 1.0)

Further details can be found in the programming manual supplied with each software kit.

Should you be unable to resolve the problem, please contact your machine tool supplier for further support.

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