# P55D Tools Position Auto-calibrate

UPCNC3_2025.0219.1127.0 has added a new function of coordinate calculation, which can automatically calibrate the position of the tool magazine and solve the problem of malfunction caused by position deviation during tool change, the following is the operation guideline of this function:

I. Preparation:

1, the software will be updated to UPCNC3_2025.0219.1127.0 above version

2, machine firmware update to P55D (X6) O_V0731_H0000_202502191513_master version above

3, remove all tools in the machine (calibration bar should also be removed)

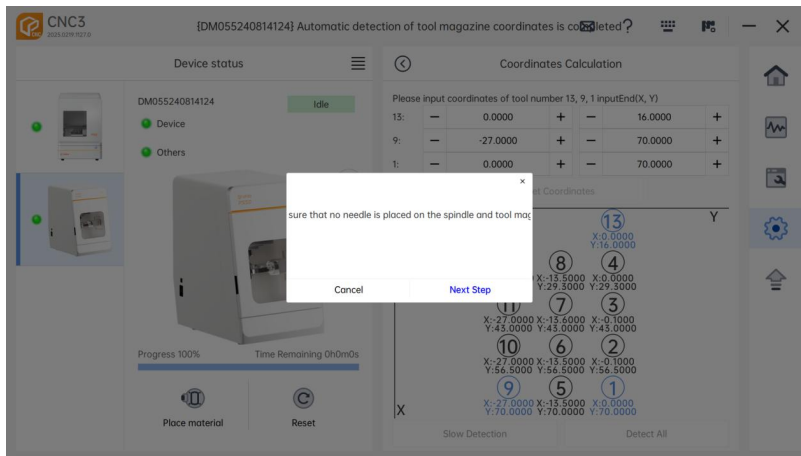II. open the CNC3 software and perform the tool calibration operation:

1, Enter the password, Enter device settings, click on the coordinate calculation to enter the tool position calibration interface.
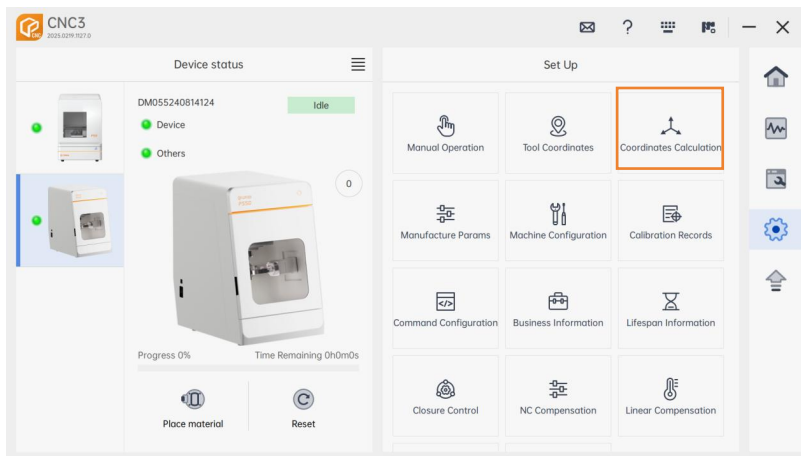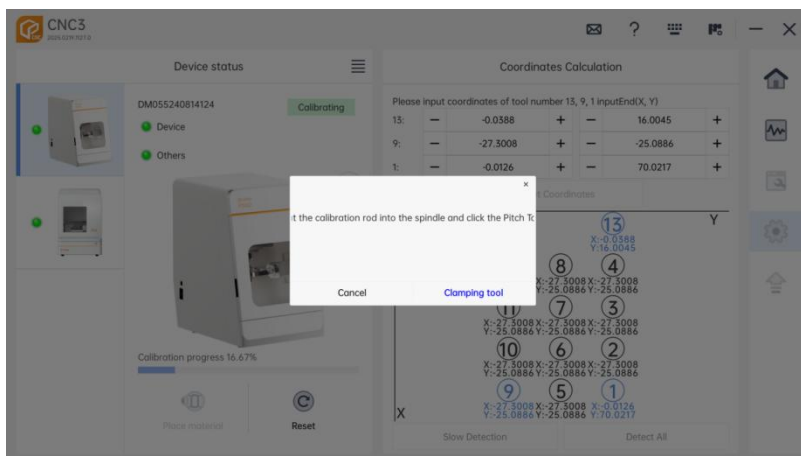

2, Click on Slow Detection.
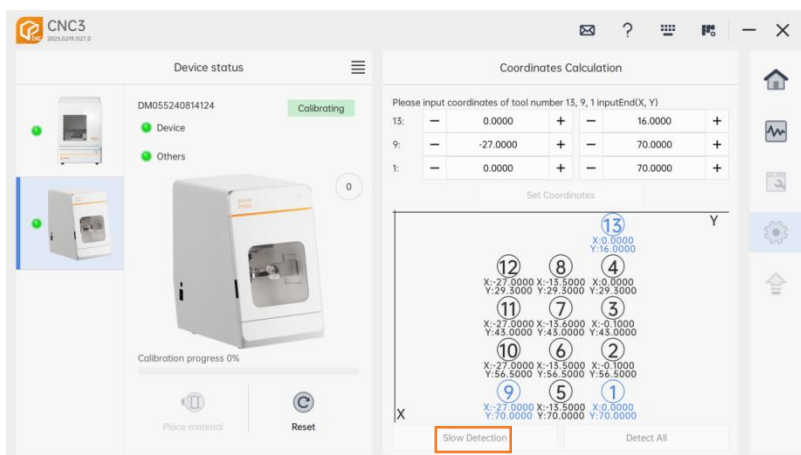
3, Make sure to remove all the knives in the machine (the calibration rods should also be removed), and then click Next.
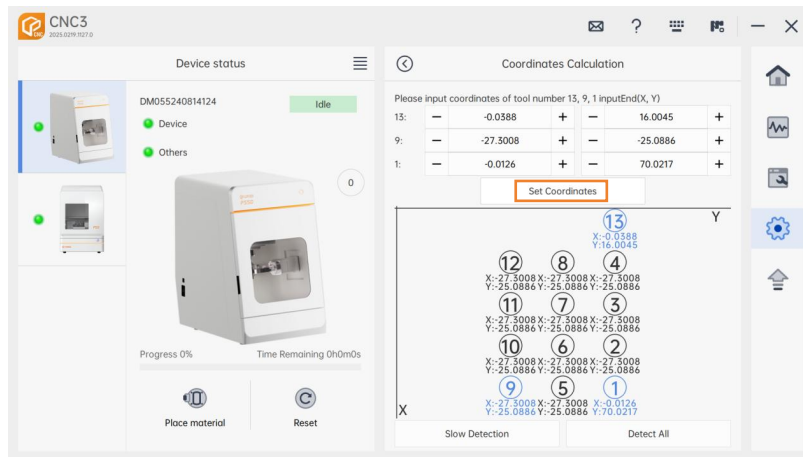

4, Place the calibration rod into the spindle chuck.

5,Click on *Clamping tool.*

6, Wait for the probe to finish, Click to set coordinates.

7, Enter the Tools control function to test the tool change.