

● - Partial support, not all command options are supported

× - Not supported

✓ - Supported

Support	Command	Description
✓	A1	ANSI Angularity computes the ANSI angularity between a best-fit feature and a specified datum axis or plane.
✓	A2	ANSI Parallelism computes the ANSI parallelism between a best-fit feature and a specified datum axis or plane.
✓	A3	ANSI Perpendicularity computes the ANSI perpendicularity between a best-fit feature and a specified datum axis or plane.
✓	A4	ANSI Runout computes the ANSI total runout between a best-fit feature and a specified datum axis.
●	A5	ANSI / ISO / DIN Positional Deviation uses the best-fit points to compute positional deviation of a point, circle, ellipse, sphere, line, cylinder and cone.
✓	A6	ANSI / ISO / DIN Concentricity / Coaxiality uses best-fit points to computer concentricity or coaxiality deviation of a point, circle, ellipse, sphere, cylinder, or cone
✓	A7	ANSI / ISO / DIN Circular Runout uses best-fit points to compute runout deviation for circles, ellipses, cylinders, planes, and cones.
✓	A8	ANSI / ISO / DIN Symmetry Deviation computes symmetry deviation for the feature in the Feature Register.
✓	AC	DCC Centerfind directs the CMM to automatically measure a circular feature.
×	AD	Disable Automatic Tracking
×	AF	Change Feature Number allows the feature number to change within a part program.
×	AH	DCC Calibrate Tip 0 directs the automatic or semi-automatic calibration of Tip 0.
✓	AI	Included Angle computes the obtuse or acute angle between two features, including cones, cylinders, slots and webs.
×	AK	Automatic Tracking lets you use tracking for part program-controlled operations.
✓	AL	Altitude specifies the probe tip height from a nominal center just before a DCC Centerfind measurement.
✓	AM	DCC Probe Move allows probe motion along the X, Y and Z axes.
✓	AN	Angularity computes the angle between lines and planes.
×	AP	Auto-sphere Measurement Point
×	AS	Automatic Scanning scans a surface from one point to the next with DCC control of probe movement.
×	AT	DCC Calibrate Additional Tips directs the automatic or semi-automatic measurement of a calibration sphere with a tip other than Tip 0.
×	AU	Auto Status determines the Auto or Manual status of the system as shown by the RCU.
✓	AW	Auto Mode Wait executes a programmed wait until the system is placed in the Auto mode.
×	B0	Disable Beep after DCC Touch turns off the normal MP-30 beeper response to a DCC touch probe deflection.
×	B1	Enable Beep after Touch turns on the normal MP-30 beeper response to a DCC touch probe deflection.

❶	B2	Best-fit 2D Line computes the best-fit position and attitude of a line from points in the selected summation array. The line computation projects the line on a plane parallel to the work plane.
✓	B3	Best-fit 3D Line computes the best-fit position and attitude of a line from points in the selected summation array. The line is computed in three-dimensional space.
✓	BA	DCC Bolt Circle measures and reports a bolt circle pattern under DCC control.
×	BB	Begin Block marks the beginning of a code block.
✓	BC	Best-fit Circle computes the best-fit to a circle from points in the specified summation array.
✓	BD	Best-fit Ellipse computes the best-fit location, orientation, and maximum and minimum radii for an ellipse. It uses points from the specified summation array to perform the calculations.
×	BF	Soft Probe Off deactivates the soft probe.
✓	BI	Best-fit Cylinder computes the best-fit to a cylinder from points in the selected summation array.
✓	BK	Best-fit Cone computes the best-fit location, orientation, and included angle for a cone. It uses points from the specified summation array to perform the calculations.
✓	BL	Bilateral Tolerancing specifies that the system uses bilateral tolerancing for evaluations.
❶	BM	Best-fit Summation sums the position of the specified feature into the specified summation array.
×	BN	Manual Bolt Circle measures and reports a bolt circle pattern under manual control.
✓	BO	Backoff Distance specifies the distance that the probe moves away after it contacts a surface.
❶	BP	Best-fit Plane computes the best-fit to a plane from points in a specified summation array.
×	BQ	Begin Skip marks the beginning of the coded block for a skip sequence.
×	BR	Soft Probe On activates the soft probe.
✓	BS	Best-fit Sphere computes the center point, diameter, and best-fit to a sphere from points in the specified summation array.
×	BT	Compute Best-fit Point
✓	BW	Compute Best-fit Slot / Web
×	BX	Compute Best-fit CparIn Feature computes the best-fit CparInf (Closed parallel lines - flat end) or CparInr (Closed parallel lines - round end) in the working plane to a previously accumulated set of
×	BZ	Beeper controls the beepers in the RCU and MP.
×	C1	CSV File On enables logging to the CSV file.
×	C6	Calibrate Changer calibrates a PH6A or PH9A probe head adapter using a probe changer sphere on the autochanger rack.
×	CA	Calibrate Using Best-fit Data calibrates probe tips from data in a summation array.
❶	CB	Clear Summation Array clears and initializes the summation array.
×	CC	Compute Circle Tangent to Two Lines
×	CD	Copy Scan Data to Best-fit Array

x	CE	Calibrate Extension calibrates a probe extension.
x	CF	Calibrate Fixture defines the type, location and size of a calibration fixture.
x	CH	Calibrate Tip 0 lets you calibrate Tip 0 manually.
✓	CL	Clearance specifies a distance from the nominal surface or circumference of a circle that the probe tip keeps to avoid contact before touches.
✓	CM	Probe Compensation specifies the probe compensation for round features.
✓	CN	Cone computes the location, orientation and included angle of a cone from five points in the stack.
x	CO	CSV File Off disables logging to the CSV file.
x	CP	Determine Probe Compensation corrects the computed feature results for probe radius after the feature is measured.
x	CQ	Circular Move
✓	CR	Circle computes a circle that is parallel to the measurement plane. The command uses three points in the stack.
x	CT	Calibrate Additional Tips calibrates multiple probe tips and identifies tip positions by measuring a calibration fixture.
x	CU	Clear Scan Buffer
✓	CV	Changing Sign or Orientation Vector
x	CW	Circular Wait Move
✓	CY	Cylinder computes a cylinder from five points in the stack.
x	D0	Define Tip 0 Offset Vector specifies tip 0's offset from end of probe shaft.
x	D9	Define PH9 Safe Position establishes a position where the PH9 can safely change probe tip attitudes prior to loading or unloading a station.
✓	DA	Axial Distance computes the three-dimensional distance between two points, two lines, two planes, a line and a plane, a point and a line, or a point and a plane. It also derives the axial components of the
✓	DF	Delete Feature deletes a feature from Feature Storage and frees that storage location.
x	DM	Display Mode returns the current status of the display update to variable S7.
x	DN	Display On turns the display update on.
x	DO	Display Off turns the display update off.
x	DP	MP Display displays alphanumeric information on the MP.
✓	DR	Delete Reference Frame
✓	DS	Distance computes the three-dimensional distance between two features.
❶	DT	Deviation/Tolerances computes the deviation and out-of-tolerances for a particular row in the Dimensional Array. It does not produce a printed report.
❶	DV	Set a Dimensional Array Value

x	DW	DCC Wait prevents execution of any further FLB commands in a part program until all previous commands are completed.
x	DX	Define Soft Probe
x	E0	Lower APC Rack on ProGage CMM
x	E1	Raise APC Rack on ProGage CMM
x	EI	Electronic Level Interface Reading for the ATLAS electronic levels.
✓	EL	Ellipse computes the location, orientation, and maximum and minimum radii of an ellipse parallel to the working plane from five points in the stack.
❶	EO	Establish Offset Angle establishes the offset angle based on a feature.
❶	EP	Establish Datum Plane establishes the primary datum plane or working plane based upon the feature in the Feature Register.
x	EQ	End Skip ends a block skip sequence.
x	ER	Error Handling selects a method of handling part program errors.
✓	ES	Establish Reference establishes the XYZ datum.
✓	EX	Establish X Reference establishes the X datum.
✓	EY	Establish Y Reference establishes the Y datum.
✓	EZ	Establish Z Reference establishes the Z datum.
x	F2	Disable Independent Axis Data
x	F3	Third Axis Scan Off deactivates data accumulation for the third axis.
x	FC	Form Calculation Method
x	FD	Display Format specifies the display format used on the MP.
x	FF	Fetch Form Feature Data
✓	FI	Feature Intersection computes the point of intersection of two circles, a circle and a line, or a cylinder and a line.
✓	FM	Define Format defines and stores an Inspection Report format.
x	FP	Define the Active Probe Tip Data Set
x	FT	Fetch returns the value of a parametric variable to a variable for examination.
x	G\$	Get Key allows the user to set up RCU-I keys as acceptable responses to a prompt.
x	GN	Get Number asks the user to enter a number on the RCU-I keypad.
❶	GS	Get Station loads the specified probe changer stations onto the probe adapter.
❶	GT	Select Tip selects the probe tips.

x	HF	Turn Standard Report Header Off
x	HL	High/Low Point Retrieval retrieves the high and low points determined when best-fit feature form is computed.
x	HO	Move To Home provides the capability to perform a DCC move to the home position of the probe.
x	I0	ANSI / ISO / DIN Form Reporting identifies and reports the form of the feature in the Feature Register.
✓	I1	ANSI / ISO / DIN Angularity Reporting computes angularity deviation as a width of a zone containing the feature in the Feature Register and prints a report showing this result.
✓	I2	ANSI / ISO / DIN Parallelism Reporting computes parallelism deviation as a width of a zone containing the feature in the Feature Register and prints a report showing this result.
✓	I3	ANSI / ISO / DIN Perpendicularity Reporting computes perpendicularity as a width of a zone containing the feature in the Feature Register and prints a report showing this result.
✓	I4	ANSI / ISO / DIN Total Runout Deviation Reporting computes total runout deviation between the best-fit feature in the Feature Register and a datum axis and prints a report showing the result.
❶	I5	ANSI / ISO / DIN Position Deviation Reporting computes and reports position deviation for the feature in the Feature Register.
✓	I6	ANSI / ISO / DIN Concentricity / Coaxiality Reporting computes and reports concentricity or coaxiality deviation for a feature.
✓	I7	ANSI / ISO / DIN Circular Runout Deviation Reporting computes and reports circular runout deviation for the feature in the Feature Register.
✓	I8	ANSI / ISO / DIN Symmetry Deviation Reporting computes and reports symmetry deviation for the feature in the Feature Register.
x	IC	Immediate Read of MEA Correction returns the current position based on the MEA correction data.
❶	ID	Identification Data outputs a literal string to the Inspection Report and/or Log.
x	II	Read CMM Axis Positions
x	IL	Initialize Library initializes the Measurement Library.
✓	IM	Read Probe Position
	IN	Inch sets measurement units to inches.
x	IO	IOSTAT allows you to sample the status of one of the input lines or change the status of one of the output lines.
x	IS	Initialize System initializes the complete CMM system.
❶	IT	Initiate Temperature Compensation causes all measurements to be corrected to appear as though both the machine and the part were at 20 degrees Celsius (68° F).
❶	JA	Projected Angularity projects two lines onto a selected plane and computes the angle between them.
✓	JD	Projected Distance projects two features onto a plane and computes the distance between them.
❶	JI	Projected Included Angle projects two features onto the selected plane and computes the included angle between them.
❶	JL	Projected Parallelism projects two lines onto the selected plane and computes the deviation from parallelism between them.
x	JP	Projected Perpendicularity projects two lines onto the selected plane and computes the deviation from perpendicularity between them.
✓	JX	Projected Axial Distance projects two features onto the selected plane before computing the distance between them. It also derives the axial components of the computed distance.

x	KA	Tracking Active Status
x	KD	Set Nominal Soft Probe Deflection.
①	KK	Cone Cross-section computes the circular cross-section of a cone.
x	KS	Set Tracking Speed
x	KT	Set Tracking Move Target Zone
x	L0	Logging Off prevents logging to the Inspection Log during the RP command.
x	L1	Logging On enables logging to the Inspection Log during the RP command.
✓	L2	2D Line computes the position and attitude of a line parallel to the working plane from two points in the stack.
✓	L3	3D Line computes the position and attitude of a line in three-dimensional space from two points in the stack.
x	LA	DCC Locate Calibration Sphere directs the automatic or semi-automatic measurement of a moved calibration sphere after an initial calibration at the sphere's MEA location.
x	LC	Locate Calibration Sphere locates the calibration sphere on the worktable for a manual measurement after an initial calibration at the sphere's MEA location.
x	LF	Logging Full sets the logging status to Full.
x	LK	Maintain a Part Axis Position
✓	LM	Limit Tolerancing specifies that the system uses limit tolerancing for evaluations.
x	LP	Logging Partial sets the logging status to Partial.
✓	LV	Level orients the working plane.
✓	M2	Manual Measure 2D Line constructs a line by recording points and computing a best-fit line. It projects the line onto a plane parallel to the work plane.
✓	M3	Manual Measure 3D Line constructs a best-fit line defined by a set of recorded points.
✓	M9	Mover PH9 rotates the PH9 probe in A or B axis or both.
x	MA	Auto Mode turns the Auto mode on. This is only supported on machines with special hardware.
✓	MB	Manual Measure Slot/Web lets you measure a slot or web.
✓	MC	Manual Measure Circle constructs a circle by recording points and computing a best-fit to a circle.
✓	MD	Manual Measure Ellipse constructs an ellipse by recording points and computing the best-fit of an ellipse to those points.
	ME	Metric sets measurement units to millimeters.
x	MF	Manual Measure Offset Plane lets you measure an offset plane.
✓	MI	Manual Measure Cylinder constructs a cylinder by recording points and computing the best-fit of a cylinder to those points.
x	MJ	Manual Measure Step Cylinder lets you measure a step cylinder.

x	MK	Manual Tracking controls probe movement with the RCU.
x	ML	Log Only directly logs inspection data according to the selected report format. This function does not generate a printed report, regardless of printer status.
✓	MM	Maximum Material Condition specifies that the system uses the principles of maximum material condition when computing true position.
✓	MN	Manual Mode switches the CMM into Manual mode.
✓	MO	Move Offset Angle modifies the offset angle for the current reference frame.
✓	MP	Manual Measure Plane computes the best-fit of a plane to the measured points.
✓	MQ	Manual Measure Cone constructs a cone by recording points and computing the best-fit of a cone to those points.
❶	MR	Move Reference moves a datum along one or more of the axes.
✓	MS	Manual Measure Sphere constructs a sphere by recording points and computing the best-fit of a sphere to those points.
x	MT	Monitor MP monitors the system variables displayed on the MP.
❶	MV	Move Point moves a feature in the Feature Register a specific point.
x	MW	Move W Reference moves the 0-degree angular reference of the rotary table.
✓	MX	Move X Reference moves a datum along the X-axis.
✓	MY	Move Y Reference moves a datum along the Y-axis.
✓	MZ	Move Z Reference moves a datum along the Z-axis.
x	N2	Enable Independent Axis Data
x	N3	Third Axis Scan On activates data accumulation for the third axis.
x	NEWCSV	New CSV closes and conditionally stores a CSV inspection record and then begins a new record with a new date and time stamp.
x	NEWLOG	New Log closes an open Inspection Log file, stores or deletes it (based on the input parameter) and then opens a new log file.
x	NEWRPT	New Report is used to close and print a report file.
✓	NL	Normal Line constructs a line using features in its function command string.
✓	NO	Cancel Level cancels leveling and aligns the part reference frame with the machine reference frame.
✓	NP	Normal Plane constructs a plane using features in its function command string.
x	NS	Next Segment processes measurements for multiple segments of a feature.
x	NT	Delete Tip deletes the calibration vectors for all probe tips except Tip 0.
x	NW	General Surface Sweep collects point data while sweeping a hard probe over a surface.
✓	OD	Overdrive Distance sets the distance the probe can move without making contact with the target after reaching the nominal position of the target.

✓	OL	Offset Line
✓	OP	Offset Plane computes the parameters from a plane described by three points. The points can exist in the stack or one of the summation arrays.
×	OS	Servo Off turns the servo power off.
×	OT	Off TempComp suppresses the reporting of TempComp messages.
✓	OW	Operator Wait prompts the user to press the footswitch or the appropriate key on the RCU.
×	P\$	Panel gives the part program access to the MP-30/35 front panel buttons.
✓	P0	Printer Off sets the printer status to Off.
✓	P1	Printer On sets the printer status to On.
×	PA	Parallelism computes the deviation from parallelism between two features.
×	PB	Probe Type identifies a probe's type (hard or touch) and status (deflected or not deflected since installation).
×	PD	Position Deviation computes the deviations and out-of-tolerances for the rectangular and polar coordinates of the part position. It does not produce a printed report.
×	PE	Perpendicularity computes the deviation from perpendicularity between two features.
×	PF	Polar Coordinates causes the MP to display polar part coordinates.
×	PI	Pallet ID reads the Pentrax pallet ID.
×	PK	DCC Park moves the probe to the end of travel of the X, Y and/or Z axes.
✓	PL	Parallel Line constructs a line using features in its function command string.
×	PM	Prompt displays a line of alphanumeric information on the CRT and/or RCU.
✓	PN	Plane computes the centroid and orientation of a plane from three points in the stack.
✓	PO	Pop Stack moves the features in the Feature Stack up one position. It puts the data from the first position of the Feature Stack into the Feature Register.
✓	PP	Parallel Plane constructs a plane using features in its function command string.
❶	PR	Probe Diameter sets or returns a probe's diameter.
×	PS	Preset Datum establishes the XYZ datum relative to the position of the probe.
❶	PT	Point constructs a point using features in its function command string.
✓	PU	Push Stack moves the features in the Feature stack down one position.
×	PW	Preset W-Axis establishes the 0-degree angular reference for the rotary table.
×	PX	Preset X Datum establishes a datum along the X axis relative to the position of the probe.
×	PY	Preset Y Datum establishes a datum along the Y axis relative to the position of the probe.

x	PZ	Preset Z Datum establishes a datum along the Z axis relative to the position of the probe.
x	QB	Query Best-fit Summation Status
❶	QP	Query CMM Probe Position
x	QS	Query Scan Buffer
✓	QT	Query Temperature returns the current temperature reading for a Temperature Compensation temperature sensor.
❶	QU	Measure Point prompts the operator to record a single point on a part's surface.
x	QV	Query Touch Point Surface Vector
x	QZ	Manual Single Point Measurement lets you select prompting at the RCU or the host computer.
x	R0	Remeasure Off turns the remeasure mode off.
x	R1	Remeasure On turns the remeasure mode on for non-DCC operations.
x	R3	Get Averaged Position Reading
x	RA	DCC Rectangular Pattern measures and reports a grid of circular features under DCC control.
❶	RB	Recall Best-fit Point loads the Feature Register with the specified point data from one of the summation arrays.
x	RC	Reference Frame Temporary Change
x	RD	Rectangular Coordinates causes the MP to display rectangular part coordinates.
x	RE	Read Point
✓	RF	Recall Feature moves the Feature Stack down and puts the data from the specified feature storage area into the Feature Register.
x	RI	Read Probe Data tells you a probe's offset and radius.
x	RL	Read Table determines the status of table calibration.
x	RM	Manual Rectangular Pattern measures and reports a grid of circular features under manual control.
x	RN	Return Scan Data
✓	RO	Read Offset Angle retrieves the offset angle of the current reference frame.
✓	RP	Report computes deviation and out-of-tolerance values in the Dimensional Array and prints a formatted report of the requested data.
✓	RR	Recall Reference Frame recalls a previously-saved reference frame.
✓	RS	Regardless of Feature Size
x	RT	Stored Reference Frame Status determines the status of reference frame storage locations.
x	RV	Firmware Version and MP Type

x	RW	Read W-Axis reads the current position of the rotary table.
x	RX	Reverse Axis for Mirror Imaging Part
x	RZ	Remove Station deletes all calibrated tips associated with a specified station.
x	S2	Independent Axis Scan Buffer Control
x	S3	Buffer Control 3 lets you designate a storage location for third axis data.
x	S6	DCC Calibration of SP600
①	SA	Starting Angle defines the starting angle and angular increment for a DCC measurement of a bore or boss. Used with the AC command.
x	SB	Scan Target transmits the targets in the scan buffer to the MP.
x	SC	Step Cylinder computes the location, orientation and radii of the step cylinder from six points. The six points can be in the stack or one of the summation arrays.
✓	SD	Probe Speed specifies the maximum probe velocity.
x	SE	Set Rotary Table Center Vector
✓	SF	Save Feature copies data from the Feature Register into Feature Storage.
x	SG	Segment sets internal flags for the measurement of segments of a feature.
x	SH	Sphere computes a sphere from four points in the stack.
x	SI	Station Information tells you if a station is loaded or unloaded. A station is loaded if the probe or probe extension from that station is currently mounted on the CMM probe shaft. Station Information also tells
✓	SK	DCC Seek Move moves the probe toward the target at the slower touch speed.
x	SL	Set Level specifies autolevel direction cosines for the working plane.
x	SM	Scale Machine scales machine coordinates for the X, Y and Z axes.
x	SN	Scan scans a surface from one point to the next.
x	SO	Set Offset Angle specifies offset angle.
x	SP	Scale Part scales part coordinates for the X, Y and Z axes.
x	SQ	Calibration Setup tells the measurement processor to use the measurements recorded on the calibration sphere to calibrate a probe tip.
✓	SR	Save Reference Frame saves the current reference frame.
✓	SS	Set Part Serial Number assigns a part serial number to identify the part being inspected.
①	ST	Set Point / Feature
✓	SU	DCC Summation Touch moves the probe at the slower touch speed and sums the point into a summation array.
x	SV	Servo Status determines whether the servo power is on or off.

x	SW	Table Speed specifies the maximum speed for table rotation.
x	SX	Save Home Position defines a safe position for a DCC CMM to move to allow unobstructed part loading and unloading.
x	SZ	Size Deviation/Tolerancing sets the mode of the size deviation calculation. This setting affects how the deviation calculation is performed when bilateral tolerancing is active.
x	TA	Touch Status determines whether the touch mode is on or off, indicated by the PH9/PH10 red light.
x	TB	Table sets angular compensation for manually controlled rotary tables.
✓	TC	DCC Touch Move moves the probe from its current position at the slower touch speed toward the specified target.
✓	TD	Touch Speed specifies the maximum speed for all programmed touches.
x	TF	Touch Mode Off prevents the system from sensing a deflected probe, whether the deflection is caused by a touch or vibration.
✓	TI	Tip Status tells you if a probe tip is calibrated.
x	TL	Tolerance Lights allows you to set a part status variable so the system can turn on a specified tolerance light.
x	TM	Tracking Move
x	TN	Touch Mode On allows the system to sense a deflected probe.
✓	TP	True Position computes the deviations and out-of-tolerances for the rectangular and polar coordinates of the part position. It does not produce a printed report.
x	TS	Set Table determines the center of rotation of the rotary table.
✓	TT	Target Tolerances sets the distance for the probe to begin its next DCC move before it completes its current move. Works in conjunction with high-speed commands such as AM.
✓	TU	Set Move Target Tolerance specifies the X, Y and Z target tolerances used to begin the next high-speed DCC move, and to determine when that move is complete.
✓	TV	Set Touch Target Tolerance specifies X, Y and Z target tolerances used to begin a DCC touch command, and to determine when that command is complete if no contact occurs. Works in
x	TW	Set Minimum Time sets a minimum time interval that is to elapse between the end of a high-speed move and a subsequent surface touch.
x	TZ	MEA Table Centerfind establishes the MEA table center of rotation and Tip 0 offset.
x	UA	Label User Array Rows allows a part program to label rows of the user array, and to define the type of processing to be performed on a row.
x	UK	Specify User Keys sets values to mark specific inspections in a Inspection Log for later retrieval and analysis.
x	UL	Shuttle allows you to start the shuttle sequence on Pentrax systems.
x	UM	Delete Point from Summation Array removes and unsums the point from the array.
x	US	Unstack moves the features in the Feature Stack up one position. It does not affect the Feature Register.
❶	VM	Vector Move Using Surface Vector
x	VP	Rectangular Conversion converts nominal polar radius and angle to their equivalent nominal rectangular coordinates.
x	VR	Polar Conversion converts nominal rectangular coordinates to their equivalent nominal polar radius and angle.

x	VS	DCC Vector Seek performs a seek from the current probe position toward a clearance point.
✓	VT	DCC Vector Touch performs a DCC touch along a specified vector.
x	W2	Sweep 2D Line records a sweep measurement of a line as projected into the working plane. It computes the best-fit position and attitude of the line.
x	W3	Sweep 3D Line records a sweep measurement of a line. It computes the best-fit position and attitude of the line in three-dimensional space.
x	WB	Construct Slot / Web computes the parameters of a slot or web in the active working plane.
x	WC	Sweep Circle records a sweep measurement of a circle. It computes the best-fit of a circle.
x	WI	Sweep Cylinder records a sweep measurement of a cylinder. It computes the best-fit to a cylinder.
①	WM	DCC Wait Move allows probe motion along the X, Y and Z axes. It is similar to the AM function except the system completes the move before processing the next command.
x	WN	Define Minimum Sweep Point
✓	WO	DCC Probe/PH9 Move provides the capability to perform a DCC move and select a new PH9 tip as the shaft moves. The probe tip can be swiveling to a new orientation as the arm moves.
x	WP	Sweep Plane records a sweep measurement of a plane. It computes the best-fit to a plane.
x	WS	Sweep Sphere records a sweep measurement of a sphere. It computes the best-fit to a sphere.
✓	WT	Define Thermistors for TempComp
x	XC	Exchange Feature exchanges the features in the Feature Register with the one in the first position of the Feature Stack.
x	XI	LOM Inch Increment / Decrement updates the MP30 transformations when the layout machine (LOM) is relocated along the machine base.
x	XM	LOM Metric Increment / Decrement updates the MP30 transformations when the layout machine (LOM) is relocated along the machine base.
✓	XY	XY Plane selects the XY plane as the working plane.
✓	YZ	YZ Plane selects the YZ plane as the working plane.
①	ZM	DCC Zero Switch Move commands a DCC machine to move to a location defined relative to the MEA zero switches. All three axes move immediately to the zero switches.
x	ZP	Set Soft Probe Zero Position
✓	ZX	ZX Plane selects the ZX plane as the working plane.
✓	ZZ	DCC Zero Switch Locate causes the DCC machine to perform a series of moves to locate the MEA zero switches. The axes move one after the other to avoid any contact in the measurement area.

① - Partial support, not all command options are supported

x - Not supported

✓ - Supported