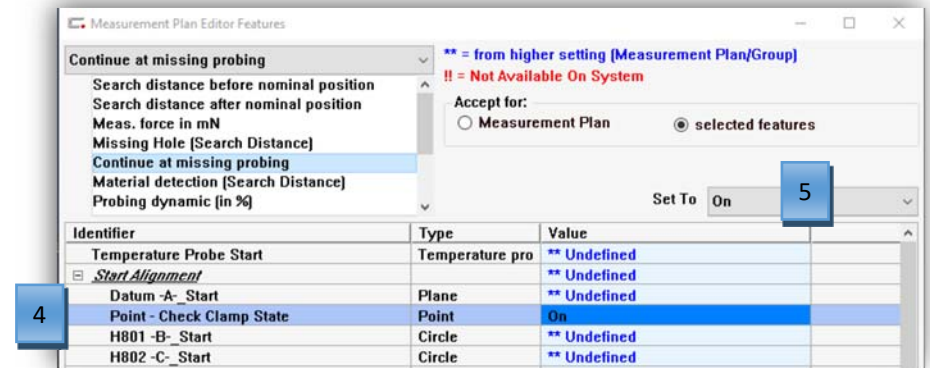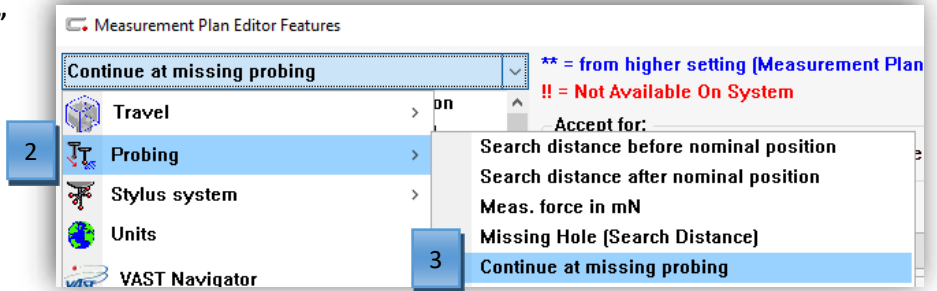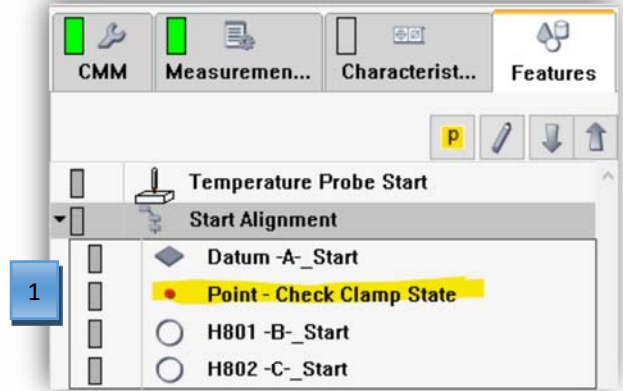# PCM to Abort Program if Part is not Clamped

1. Create a "X" point on the Clamp Handle
   (Rename it to "Point - Check Clamp State")

   Open "Measurement Plan Feature Editor"

2. Select "Probing" from the Dropdown list

3. Select "Continue at missing probing"

4. Select feature "Point - Check Clamp State"

5. Select "On" from "Set To" Dropdown

In this example, "Datum - A- _Start" is the Spatial Rotation within the Base Alignment (first feature measured in the program)

Place the code below in this feature's Presettings—It will force the clamp to be checked before everything else...

```
// Presettings of Plane  "Datum -A-_Start"  (First feature measured from Base Alignment)
// PCM Code for Failed Part Clamp

ClampFail = getActual("Point - Check Clamp State").x

 if ClampFail == 0  // This Boolean test is true, if "Point - Check Clamp State"  X Value has no value

  positionCMM(500,-10,-30)  // CMM moves to Safety Position

  message("Program was stopped because Part was not Clamped! ",cr(),cr()," Click OK, CMM will park in Safety Position, then Clamp Part and restart program")

  cncBreak()

endif
```


Message that is displayed when part is not clamped
Prior to moving to Safety Postion