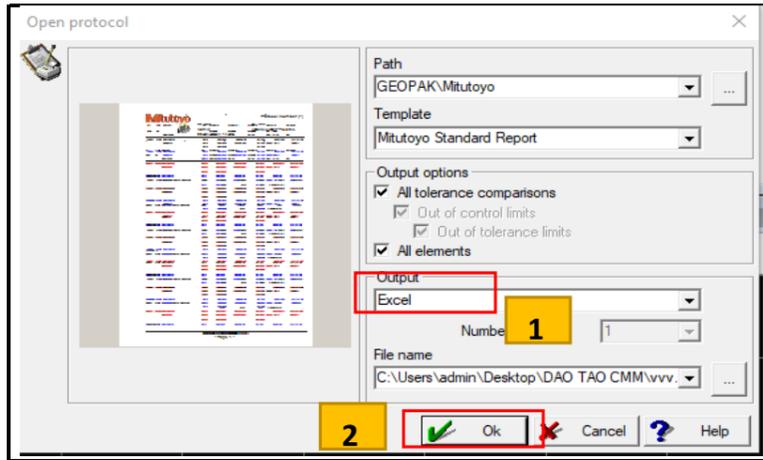


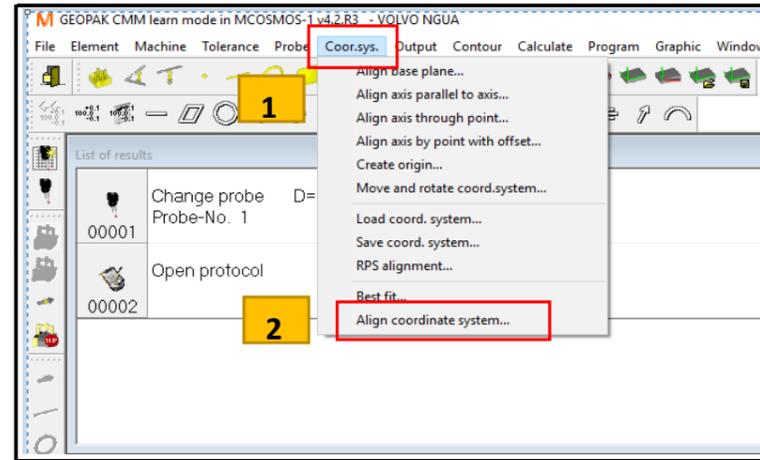
Setting Auto Measuring For Crysta Apex 7106

Step 01



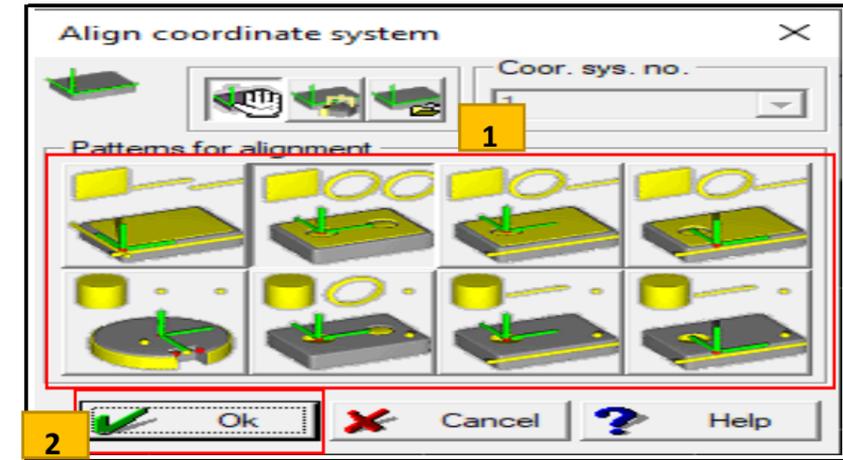
1. Choose the Output file
2: Click OK

Step 02



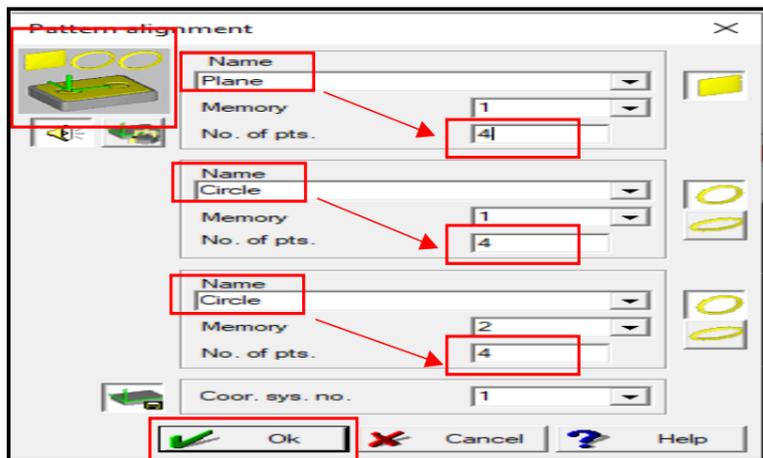
Choose Coor.sys then choose Align Coordinate System

Step 03



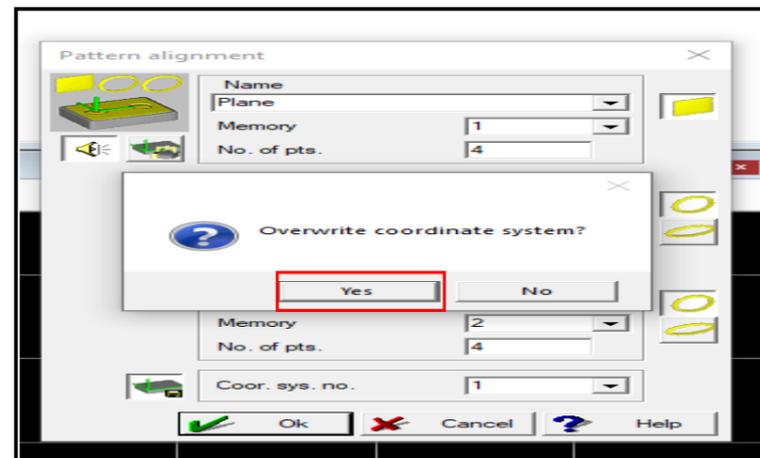
- Choose the coordinate that fit to the sample

Step 04



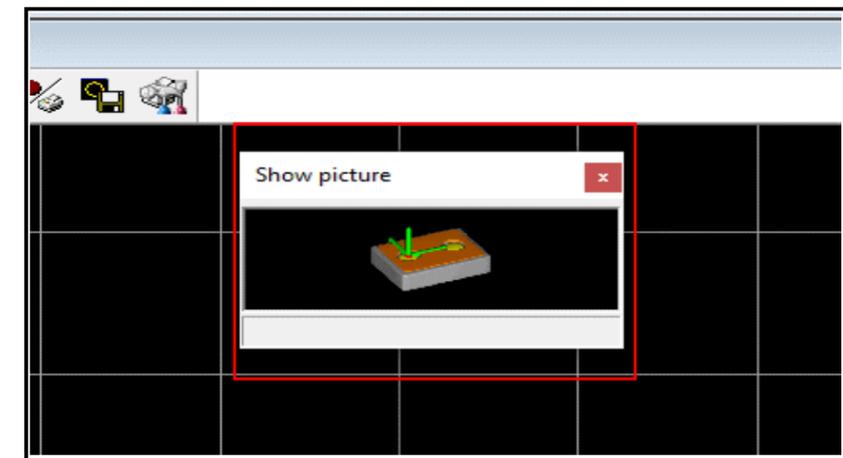
- NOTE: Insert the values on the box same as above picture.

Step 05



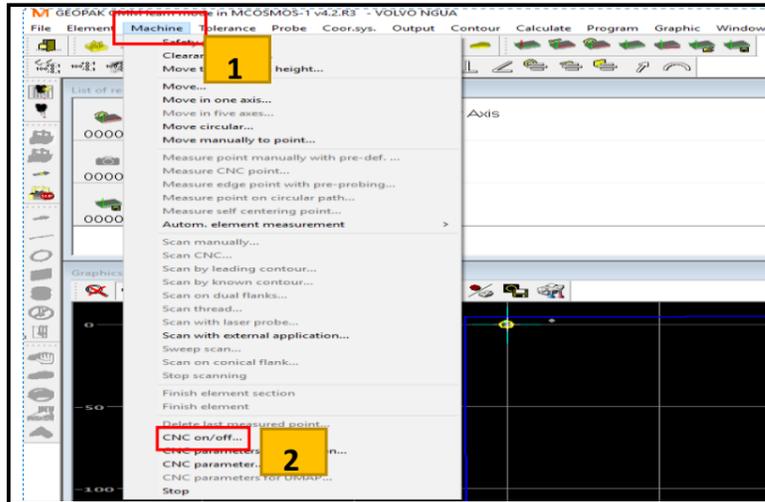
- Click yes

Step 06



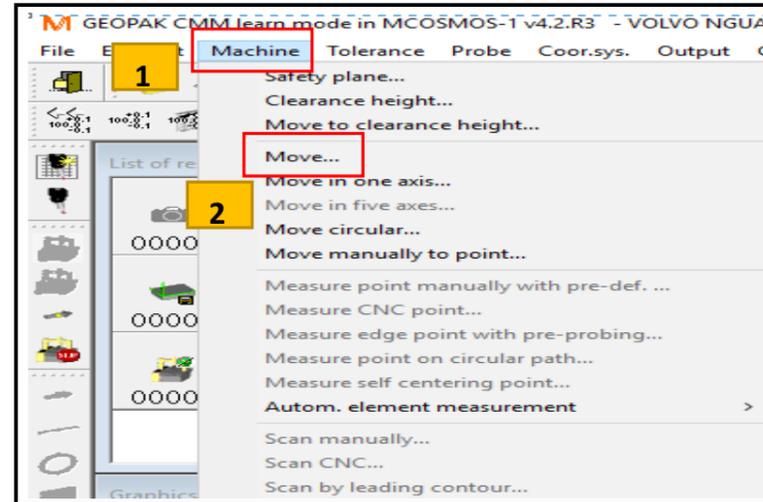
- Choose the flate of X, Y that is shown on the screen.

Step 07



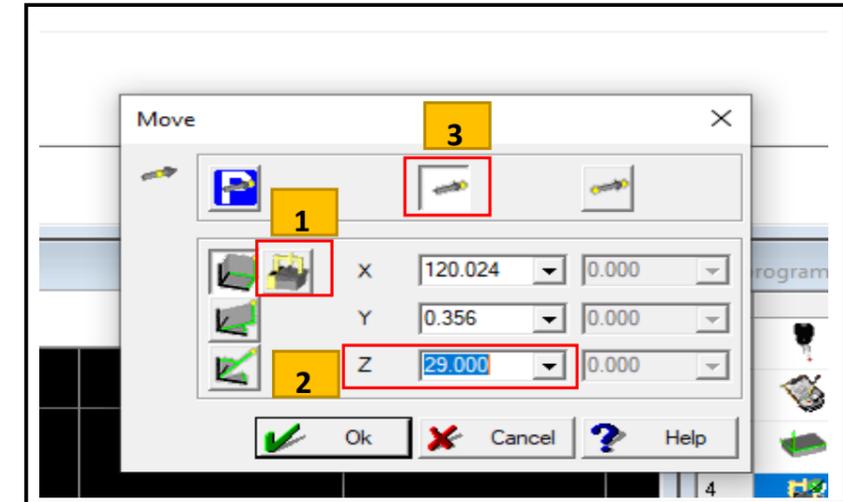
- Click on Machine/Click on CNC on/off

Step 08



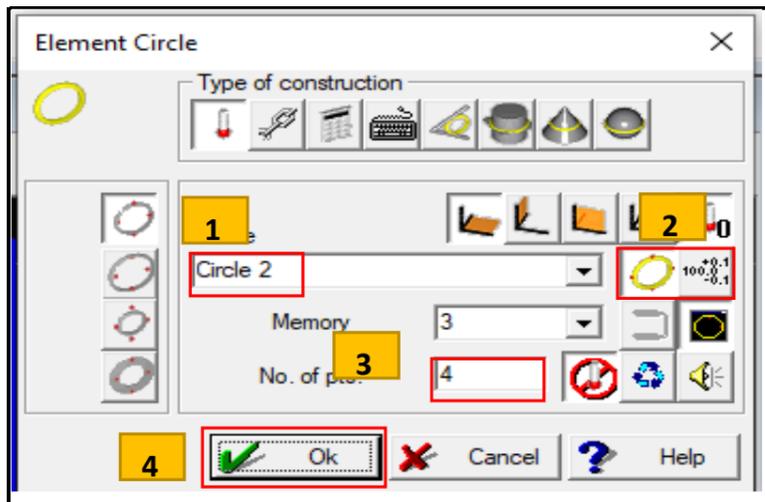
- Click on Machine/Move

Step 09



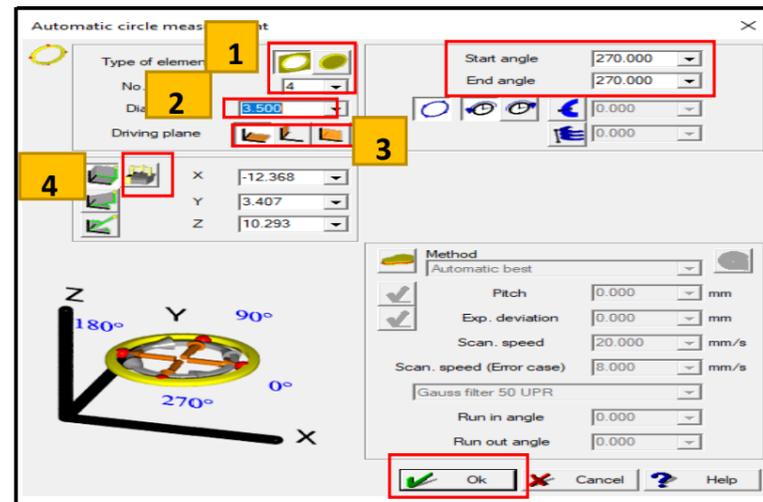
1: Click on the CMM icon
2: Select the parameter for the probe to go up to a safe position when moving
3: Remember to notice the direction of the probe when it goes up

Step 10



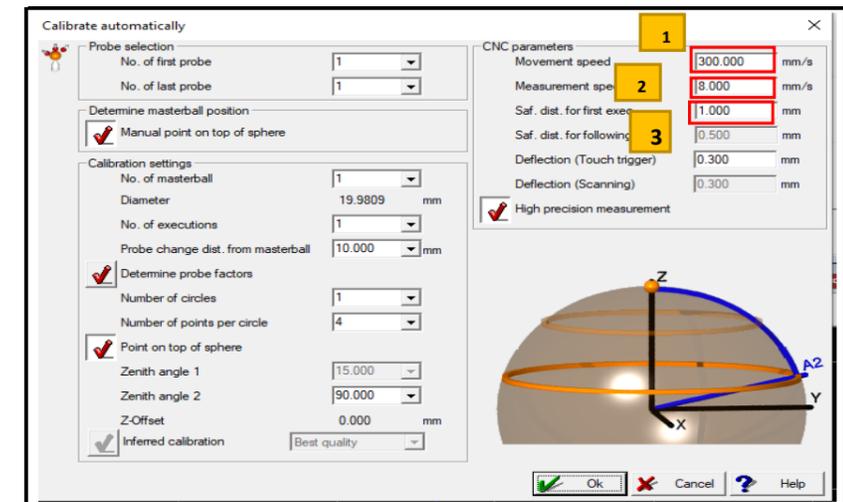
For example, measuring the circle
- Write the corresponding number in the drawing
- Click on Auto circle measurement mode and click on the icon to evaluate the result
- Choose how many points to measure that circle
- Select OK, (do the order from 1 to 4)

Step 11



- Select the mode to measure the inner circle or the outer circle.
To reset the parameter, we need to measure how many points the circle is.
- Install the movement of the probe (note: the inner circle must be smaller than the actual values, the outer circle must be larger than the actual values on the drawing).
- Select the reference face of the circle.
- Move the measuring head into the center of the circle => click on the CMM icon to CMM to determine where the probe is located (The parameters in X, Y and Z axis will change) => Select OK CMM will automatically measure that

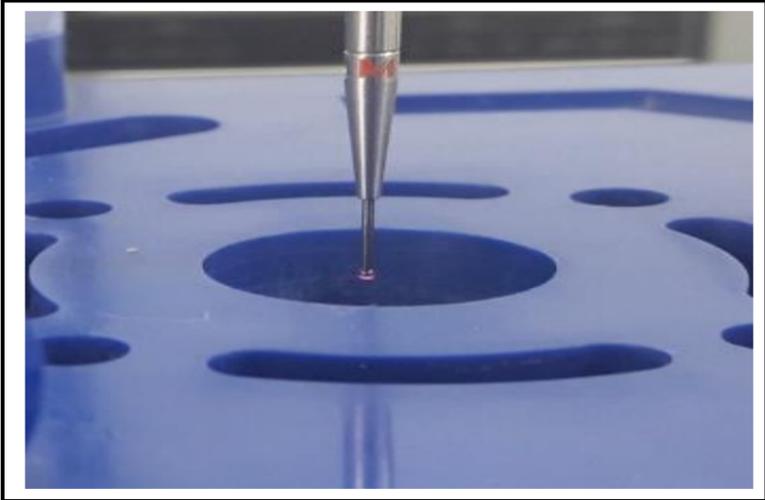
Step 12



- Note: not to change parameters 1 vs 2 arbitrarily
-1: Movement speed: 300,000 mm / s
-2: Measuring speed: 8,000 mm / s
-3: Safety of probe: 1.0 mm

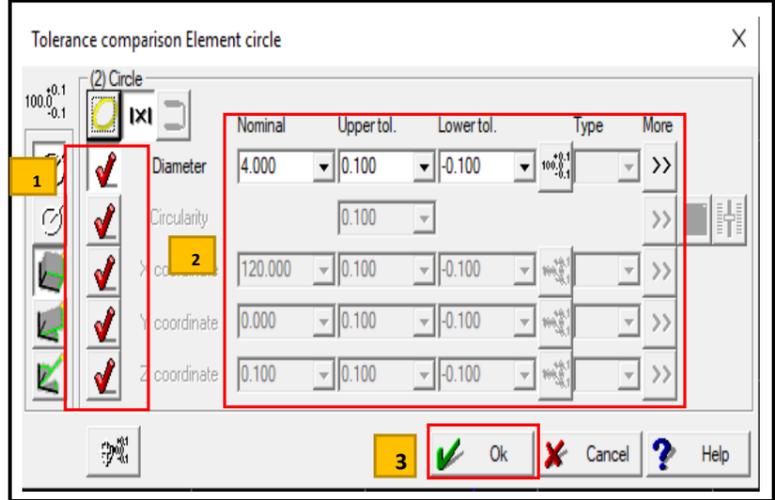
circle.

Step 13



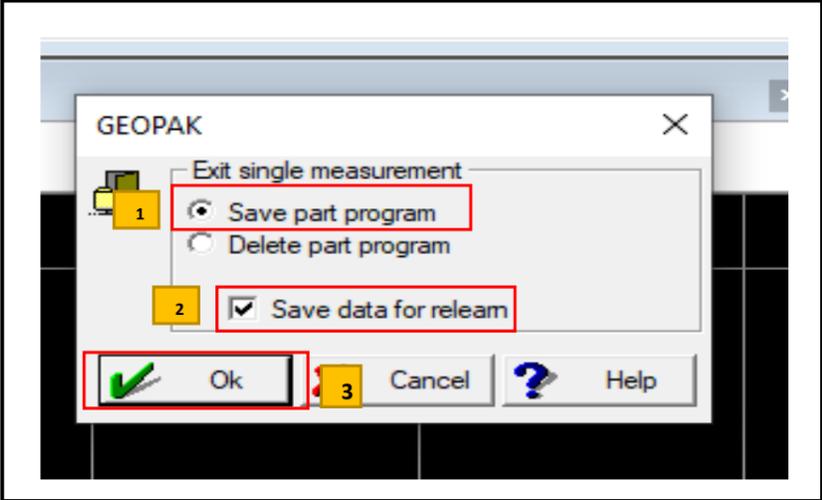
- The image of the probe is moved in the middle of the circle to wait for measurement.

Step 14



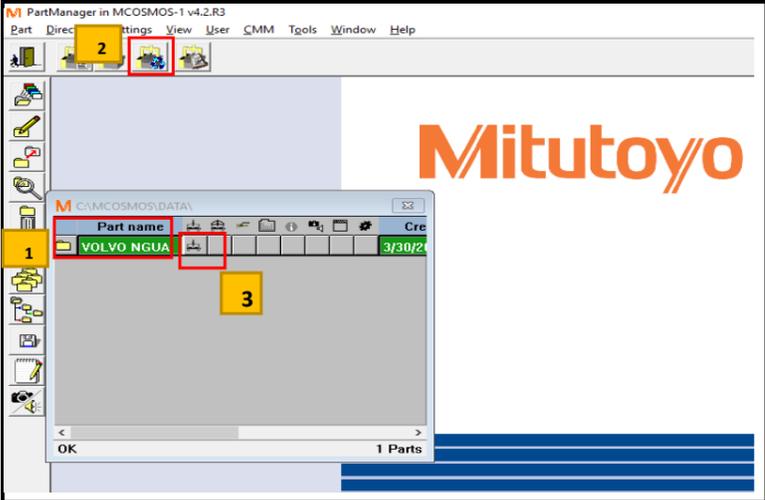
- Click V when you want to see the measurement results and edit data, tolerance according to drawings => Select OK.
(do the order from 1 to 3)

Step 15



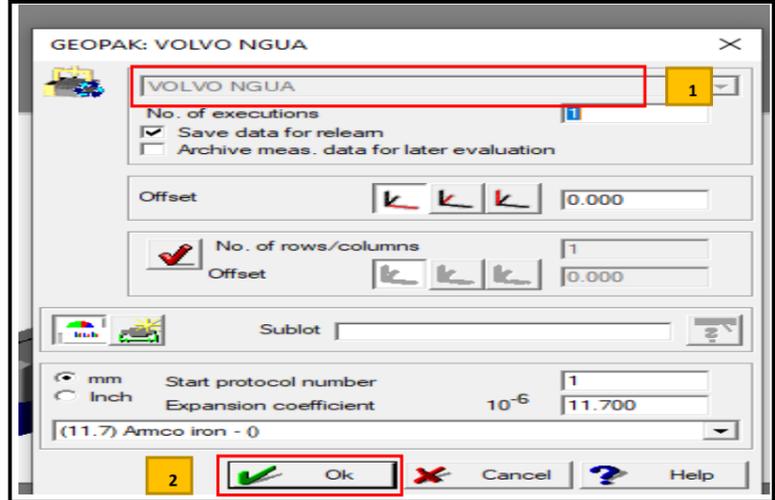
-Save measured program: Select Save ... => Select OK.
(do the order from 1 to 3)

Step 16



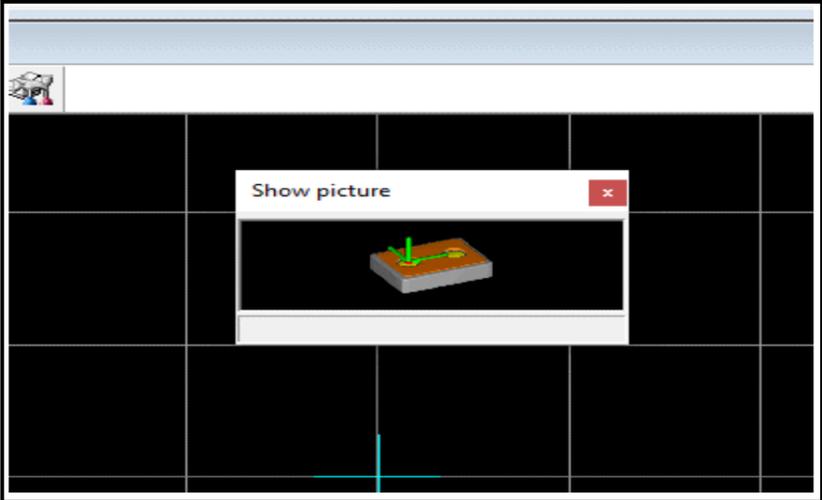
- Run the Installed Program:
- Choose the Configuration File that you just installed the automatic measurement program in.
- Select the automatic measurement icon of CMM.

Step 17



-Select the name of the program you just installed automatically => Select OK
(do the order from 1 to 2)

Step 18



-Bạn đo lại bằng tay hệ trục tọa độ : Mặt phẳng, trục X,Y (đo tuần tự theo chỉ thị theo hướng dẫn trên màn hình) => Sau đó CMM tự động đo các kích thước mà bạn đã cài.

(do the order from 1 to 2 or you can do the order from 1 to 3 also)