Setting Auto Measuring For Crysta Apex 7106







Step 08

File	Element	Machine Tolerance Probe Coor.sys. Output	Contour Calculate Program Graphic Window			
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	1.2	Clearan				
100.8.1	100.8 100	Move t height				
	List of re	Move				
11930		Move in one axis				
	-	Move in five axes	Axis			
	0000	Move circular				
	0000	Move manually to point				
	100	Measure point manually with pre-def				
	0000	Measure CNC point				
120	0000	Measure edge point with pre-probing				
100	-	Measure point on circular path				
	0000	Measure self centering point				
	0000	Autom. element measurement	>			
		Scan manually				
0	1	Scan CNC				
	Graphics	Scan by leading contour				
	E 😪 🛛	Scan by known contour	🍨 🕞 🚓			
		Scan on dual flanks	/ 3			
B		Scan thread				
TOT	• —	Scan with laser probe				
		Scan with external application				
- C		Scan on conical flank				
		Stop scanning				
0		Einish element section				
	-50	Finish element				
PERMIT						
		CNC on (off				
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		CNC parameter.				
		CNC parameters for UMAP				
	-100-	Stop				

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File	E	Machine	Tolerance	Probe	Coor.sys.	Output
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	List of re	Move				
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		Scan	manually			
0		Scan	CNC			
	Graphics	Scan	by leading o	contour		



1: Click on the CMM icon moving 3: Remember to notice the direction of the probe when it goes up

· Click on Machine/Click on CNC on/off



Step 11





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)



Calibrate automatically Probe selection No. of first probe 1 No. of last probe mine masterball position Manual point on top of sphere Calibration settings No. of masterball Diameter 19.9809 No. of executions Probe change dist. from 10.000 Determine probe factors umber of circles Number of points per cir Point on top of sphere 15.000 Zenith angle 1 90.000 Zenith angle 2 0.000 Z-Offset Inferred calibration Best guality

-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 3 of 5

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

Step 09

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2: Select the parameter for the probe to go up to a safe position when

Step 12







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

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)

(do the order from 1 to 3)







Step 17

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



kích thước mà ban đã cài.

Run the Installed Program:

Choose the Configuration File that you just installed the automatic measurement program in.

- Select the automatic measurement icon of CMM.





Exit single me

Save part

Ok

GEOPAK

Step 15

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Save part program Delete part program	
Save data for releam	
Dk 🛃 Cancel 🏆 Help	

-Save measured program: Select Save => Select OK.

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

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