Instruction Guide for Creating and Qualifying the Optical Sensor

THIS PROCEDURE IS ONLY APPLICABLE TO CALYPSO VERSIONS:

- 5.4.2400 or later
- 5.6.1200 or later
- 5.8.0000 or later

Required Equipment :



Stylus 3x50, glass mask with holder and ring gauge.

1. Create new stylus system "Camera" :

After creating the sensor "optic", default geometry data of the individual magnifications is automatically created. The camera is enabled for CNC processes. Manual measurements are not yet possible.

- 2. Tactile-optical adjustment
- 3. Start the plan "tactile_optical_adjustment_and_check_V1.x.xx" .

	Name tactile_optical_adjustment_and_check_V1.3_C5.4_Manta Comment Die Licht Einstellungen müssen je nach Maschine angepasst werden. The illumination need be set on different machine		
2			
Selection	Result	СММ	
Base Alignment	Multiple Printout	Order of run	
🔘 Start Alignment	default_PP1 🗸	From Characteristic List	
Manual Alignment 🛛 🗸			
	Plots 🗌 display 🗌 print	Use Clearance Plane	
 All Characteristics Current Selection Service 	Excel-printout Send results to printer PDF PostScript Clear existing results	Run Mode	
		Normal	
		Speed in mm/s	
	Results to file	200	
Printout becaler data	Table File		
User Information	Q-DAS		
Note	<u></u>	<u></u>	
All mounted styli must be qualifie (Necessary for navigation)	d.		
ОК	Cancel	Help	

Select "Manual Alignment" and "Service" in the CNC start window. The "Service" setting is necessary to secure the run and adjust the default values to the system.

Runtime 20 min.

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m 3	Comment		
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	Results to file	200	
Printout header data	Table File		
User Information	Q-DAS		
Note			
All mounted styli must be qualified. (Necessary for navigation)			
ОК	Cancel	Help	

 $Start\ the\ plan\ ``tactile_optical_adjustment_and_check_V1.x.xx''\ again\ .$

Select "tactile_optical_adjustment and check" and "Customer" In the CNC start window.

The accurate offset data is updated and entered into the geometry data.

→ Manual measurement with the camera is now possible.

Runtime 15 min

Qualify Camera :

1. -Start Plan "position_glasstemplate_xxx"

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In the CNC start window start system select "Manual alignment".

- ➔ Point X with Stylus 3x50
- → Point Y with Stylus 3x50
- ➔ Point Z with Stylus 3x50





Erstellt : Jürgen Keller Thomas Mehlhardt 2. After CNC run select the plan Circle 3, as shown in the picture

With button F9 or the right mouse button and Execute now , set the correct magnification. and move to the appropriate circle.





Instruction Guide for Creating and Qualifying the Optical Sensor

Light settings :



For all Optic's you must set the light manually to a black and white situation, as displayed in the image above.

3. Start "Qualify Camera"

Stylus system Sty	lus Management			
			(the second seco	
Stylus system	Mode	Parar	neter	
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Set Limit Values	s Qualify car	nera		
Stylus Reference sphere				
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R: 0.000 S: 0.000 X: 75.12	DO D3 D3	SNo Date R: S: X:	M8152 30.9.2013 12.4843 0.0001 224.1647	
R: 0.000 S: 0.000 X: 75.120		SNo Date R: S: X: Y:	M8152 30.9.2013 12.4843 0.0001 224.1647 -249.7337	
R: 0.000 S: 0.000 X: 75.120 Y: -0.514	DO D3 03 48	SNo Date R: S: X: Y: Z:	M8152 30.9.2013 12.4843 0.0001 224.1647 -249.7337 -157.6223	
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Position the circle from the live image in the illustrated blue circle. (4x)

Repeat the procedure from step 2 for all magnifications.

4. Start tactile optical adjustment

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ž	Name tactile ontical adjustment and check V1.3 C5.4 Manta		
	Comment		
	Die Licht Einstellungen müssen je nach Maschine angepasst werden. The illumination need be set on different machine		
	Result	СММ	
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tactile_optical_adjustment_an		Navigate-Feature To Feature	
	lots display print	Use Clearance Plane 🗸	
○ All Characteristics	Excel-printout	Run Mode	
Current Selection	PDF PostScrint	Normal	
💿 Customer 🗸	Clear existing results	Speed in mm/s	
	Results to file	200 🗸	
Printout header data	Table File		
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Runtime 15 min