

# Secondary Alignment

In a nut shell, so to speak.

Once you've measured the 1st part of the program, put a CMM position in the last feature of the first part's strategy (if you're running off of features) to move the probe out of the way and then in the same feature, after the CMM position, put a programmable stop in to allow the operator to move or flip the part while program is stopped. You can put a message in the programmable stop to tell the operator what to do.

Create another set of features to align the part after it's moved (preferably ones that relate to the same alignment features of the original base alignment but, it doesn't have to be) and these features will be set to measure manually later.

Create your 2nd alignment:

Go to resources, utilities and select an additional alignment and it will be placed on the characteristics side. Go to it and Rename the alignment to something like "2nd side/section align" and then use your features you created to align the 2nd part of the program.

THEN, go to the measurement plan editor and select "Man CNC Mode" and select the 2nd side alignment features to be run on MAN mode so, the operator will take those points manually to tell the CMM where the part is.

Then each feature to be measured on the 2nd side (except the ones used for 2nd alignment) will use the new alignment you just created and be run automatically referencing the new position you created with the 2nd alignment. When you open a feature, there is a drop-down menu beside the alignment where the new 2nd alignment can be chosen. Make sure all the features on that 2nd side use that alignment but, again, not the features used for the 2nd alignment.

After the part is moved or flipped, the operator will select continue and the 2nd alignment will be measured manually and after they are measured, all the other 2nd side features will be run automatically, i.e. in CNC mode.

You will then have everything on one report, be sure to name all the back side features and characteristics accordingly for identification.