

Calypso 3.8 ~ Rotary Table Set-up

Prerequisites & RT information

On-line or page 4-59 of Calypso Manual.

Rotary Table ~ Position

Should be done for:

New installation.

If RT is moved.

1. Measure a cylinder using hole at center of RT.
2. Select: **Resources**→**RT Position**
Select feature & OK.

RT Axis Alignment, method 1. (canned program)

Canned program included with Calypso.

1. Open measurement plan: **inspections**→**inspections_rt_axis**→**RT-Axis**
2. Place Qualification Sphere on RT.
3. Use MasterProbe.
4. Place probe higher than Qualification Sphere.
5. Run with Manual Alignment.

RT Axis Alignment, method 2. (alignment to part)

For rotationally symmetrical parts.

1. Select RT icon in prerequisite window.
 - a. Check "RT activated for this Measurement plan."
 - b. OK to close.
2. Measure two circles on axis.
3. Recall Circle 1 & 2 into 3D line1.
4. Copy and paste both circles.
5. Using Feature Settings editor.
 - a. Select "RT Position". Edit RT angle (180 deg) for Circles 3 & 4.
 - b. Select "Base Alignment Rotation with RT" set to "off" for all circles.
6. Recall Circle 3 & 4 into 3D line2.
7. Create Symmetry from 3D lines.
8. Select RT icon in prerequisite window.
 - a. Check, Measure RT Axis.
 - b. Check, Rotationally Symmetrical Part.
 - c. Enter Symmetry into RT window.
9. Create Base Alignment using 3D line1.
10. Create Clearance Planes.