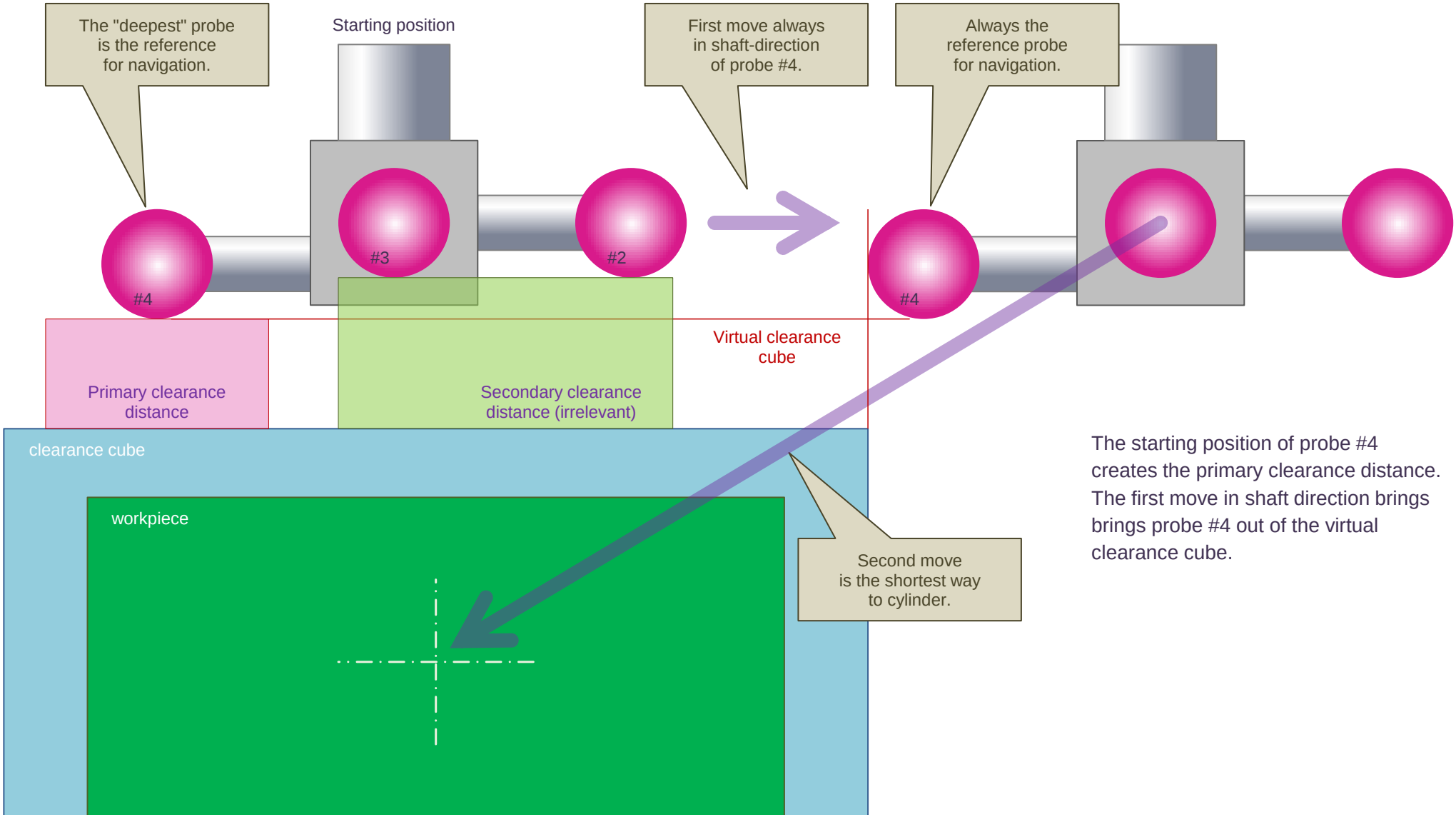
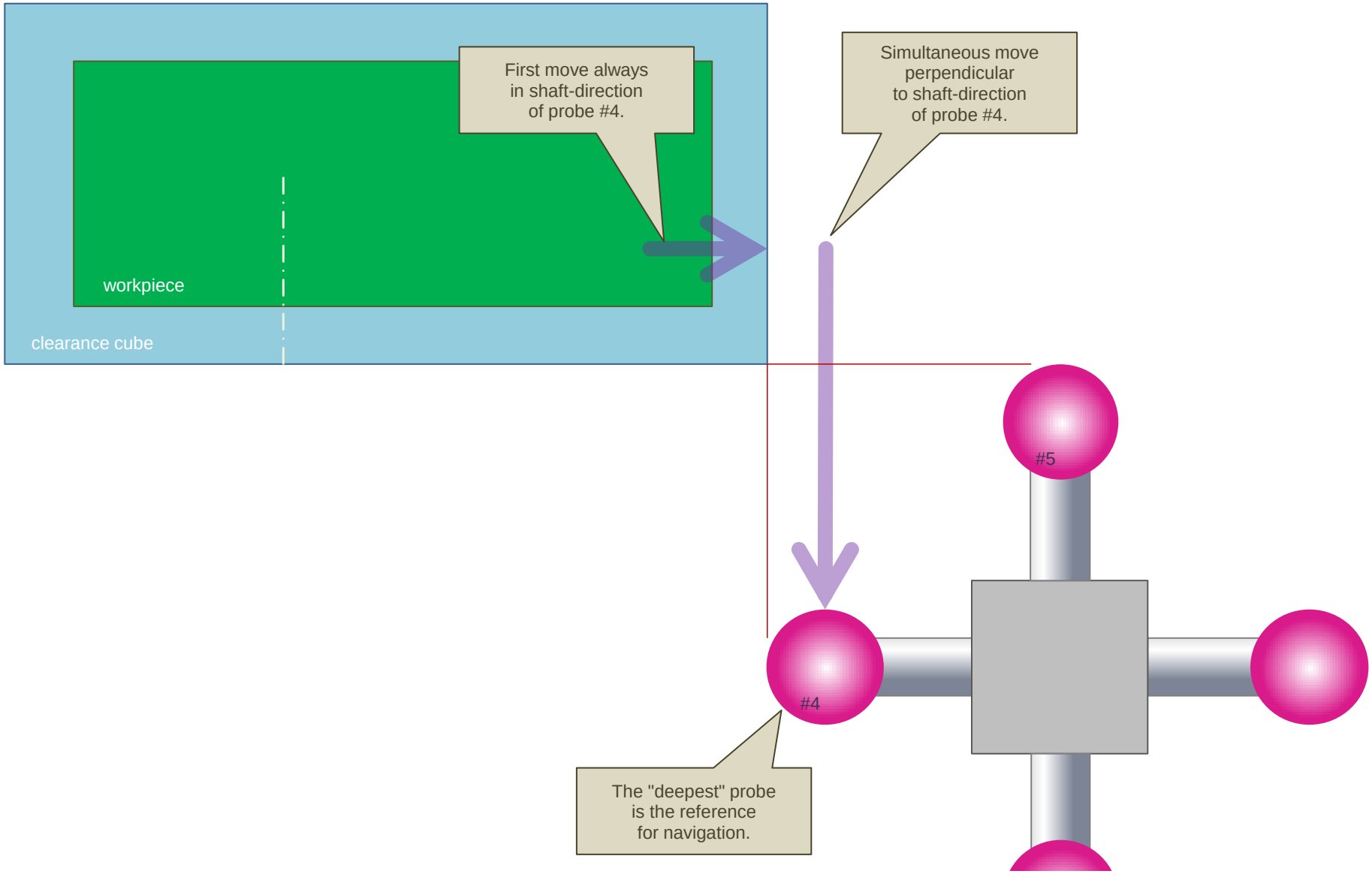
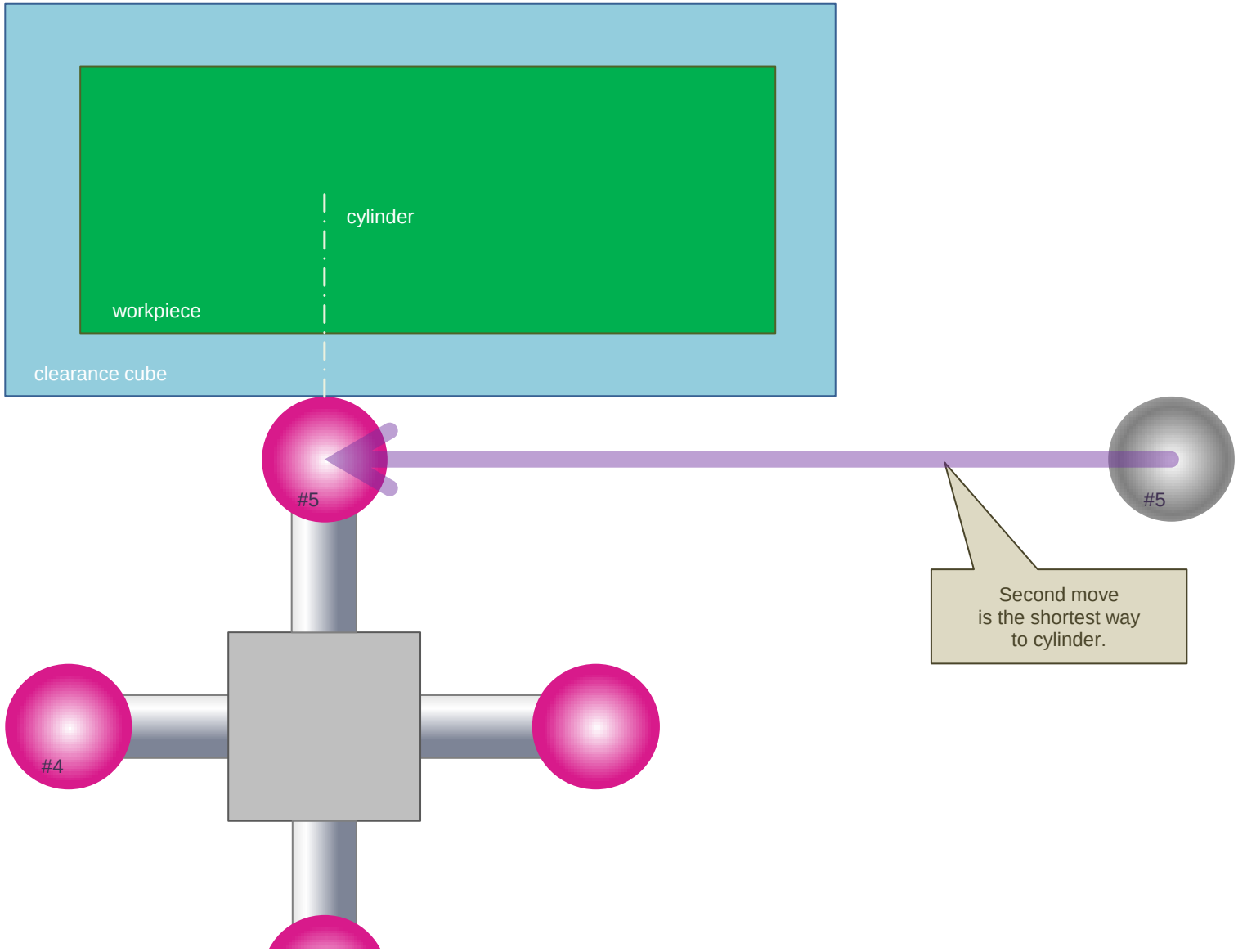


The starting position of probe #4 creates the primary clearance distance. The first move in shaft direction brings brings probe #4 out of the virtual clearance cube.


First move always
in shaft-direction
of probe #4.
Simultaneous move
perpendicular
to shaft-direction
of probe #4.
workpiece
clearance cube
#5
#4
The "deepest" probe
is the reference
for navigation.


cylinder
workpiece
clearance cube
#5
#5
#4
Second move
is the shortest way
to cylinder.