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https://carl-zeiss-industrial-metrology-llc.helpjuice.com/calypso/540011-continue-at-missing-bore-hole

CALYPSO: Continue at Missing Bore (Hole)

How Continue at Missing Bore works

As per the testing and the impression of what "Continue at Missing Probe" function does,

Recognizing a missing bore

Sometimes, bores provided in the drawing are missing in the workpiece. By setting CALYPSO accordingly, you can avoid faulty probings and collisions. The movement and the speed are adjusted so that damage is avoided. The missing bore is highlighted in color in the report as an error.

Activating the function

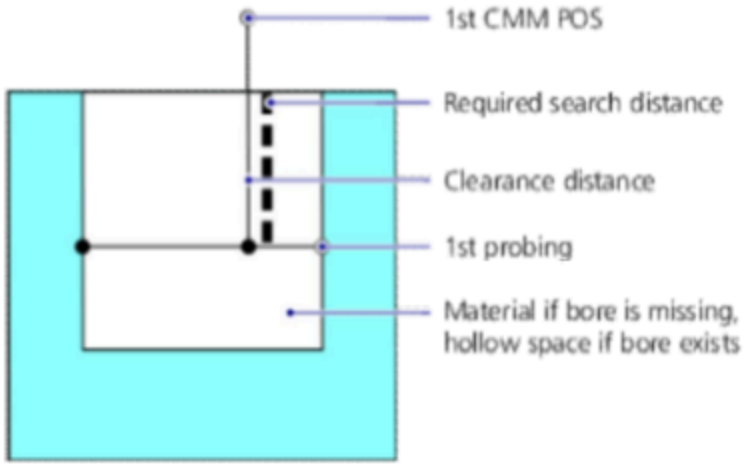
The "Bore Missing" function is set for each individual feature. You have two options:

- Activate the Bore Missing tab in the Relative Measurement window.
- Select Probing ▸ Missing Hole (Search Distance) in the Features Settings Editor.

Activate the function and set the Search Distance.

Use search distance to define the area in which the stylus is to move slowly in the search run to avoid any collision upon material contact, causing the run to be canceled. The CNC run is continued.

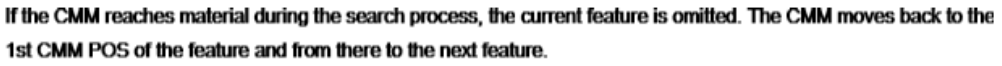
Enter the search distance large enough for the stylus to remain outside of any possible material at this location, taking into account the stylus radius, even if a bore is missing.



Movement if a bore is missing

If the "Bore Missing" function is active, the CMM will carry out a search run as soon as it reaches the search distance, i.e., it will move at reduced speed.

But if it doesn't find the bore or the hole here, it will **NOT** give a message or an error, instead it will go onto the next feature.



Only way to have the CMM to stop at missing bore or hole, is by using a PCM command in the pre-settings of the preceding feature that is to be measured.

PCM command as follows: