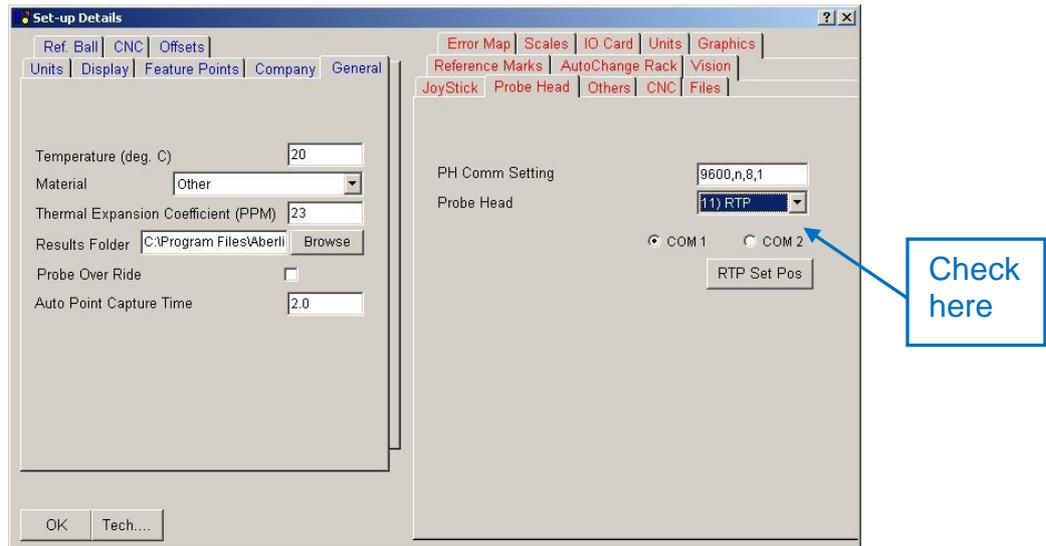


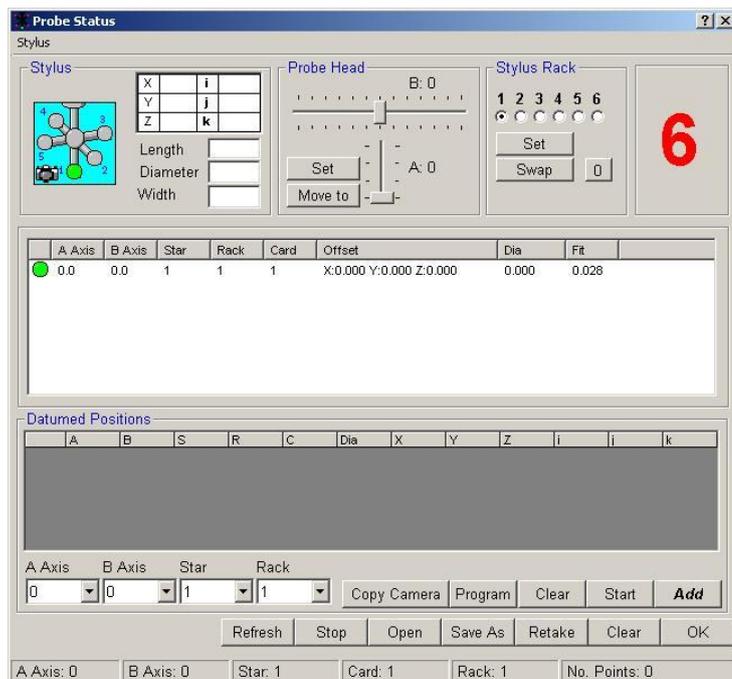
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SETTING THE POSITION OF THE RTP POLE

- Go into Machine Set Up, tech, 2.718 / Probe Head and make sure that the RTP option is selected: (re-start s/w if it was not previously selected)



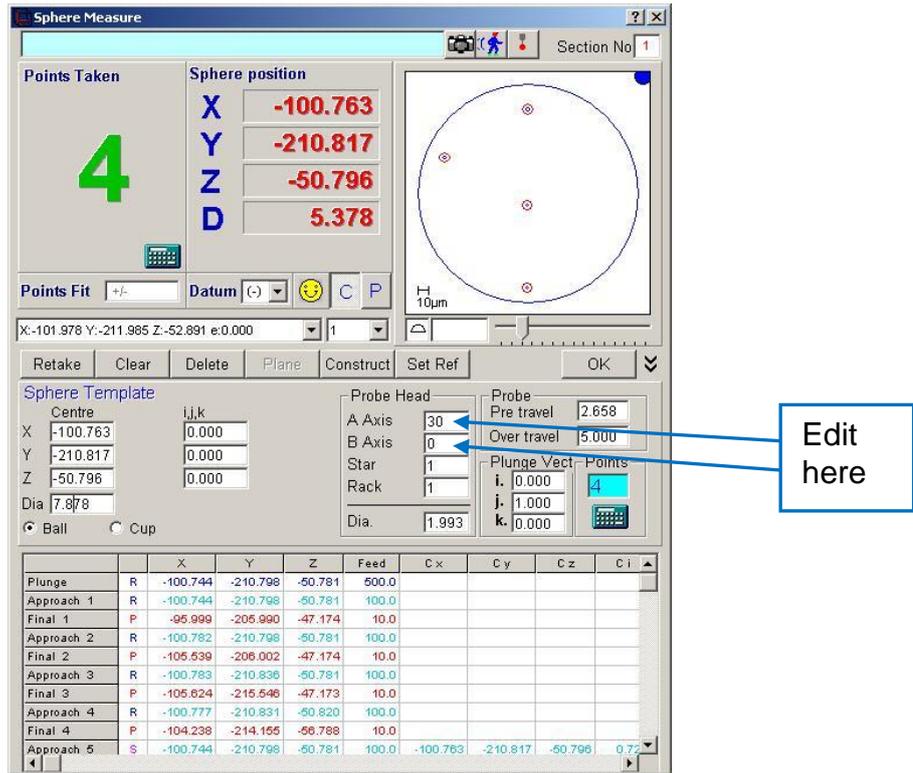
- Go into Probe Status Window right click on green dot and choose edit, change XYZ and Dia the stylus all to zero: Use a 10mm long stylus, ball diameter is not important.



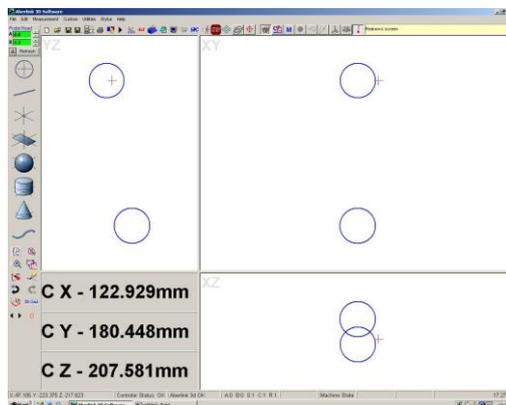
- Using a tape measure position the centre of the RTP base on the table of the CMM (400mm from the back edge of the granite, and 190mm from the left edge of the granite)

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- Open a Sphere measure window and measure the semi-spherical top of the pole – click OK
- Manually index the probe to A30 B0 and then call up another Sphere measure window and repeat measurement on top of pole. Before clicking OK you must manually edit the template to show probe position A30 B0 :



When you OK the Sphere window the Main Screen should look like this :



- Repeat this measurement with the probe in the following positions:

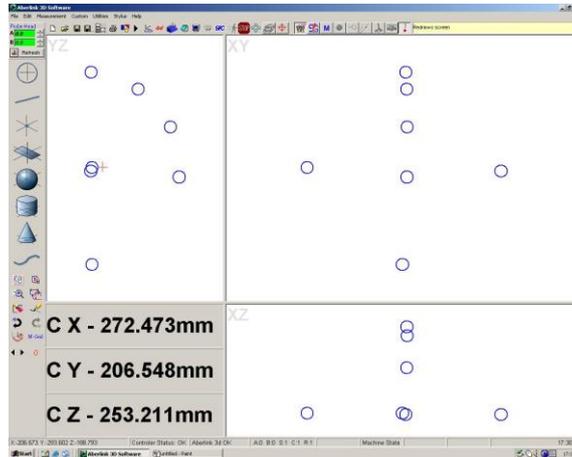
A60 B0 A90 B-90 A90 B180
A90 B90 A90 B0

Note, if there is not enough room, for one of the shown probe positions, then simply add another couple of positions, suggest A90 B135, and A90 B-135

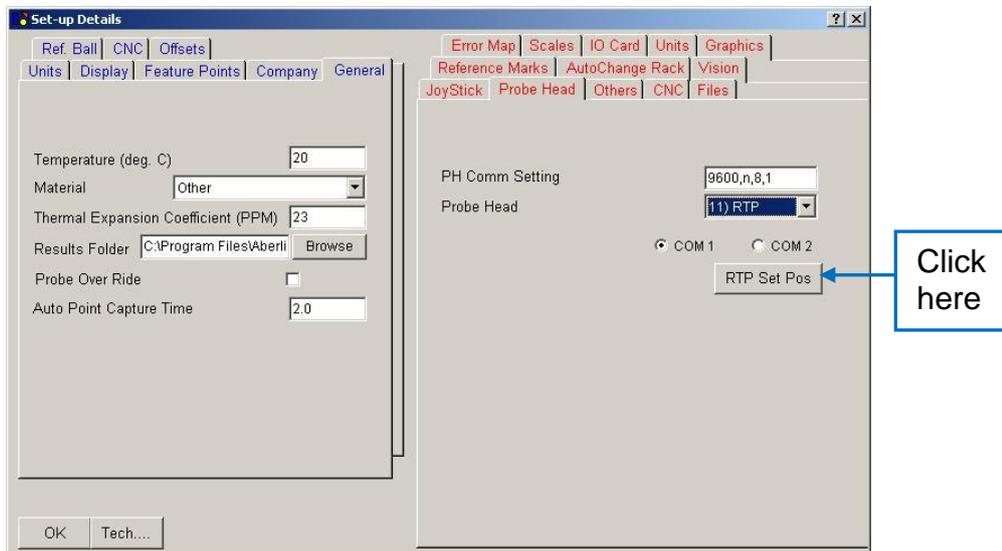
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Remember each time you must manually edit the probe position in the template section of the sphere window.

The main screen should now contain 7 spheres as follows:



7. Go back into Machine Set Up / 2.718 / Probe Head and click on RTP Set Pos button :



The Pole position is now set in s/w.

The above procedure, creates a file called RTP.hed, which is located in the Aberlink3d directory. This can actually be opened in notepad, and the position can be edited from here too, if the position needs a slight edit for example. It is also worth backing up this file.

If updating to mk4, you can use this file, copy it into Aberlink LLP settings folder, within Program Data.