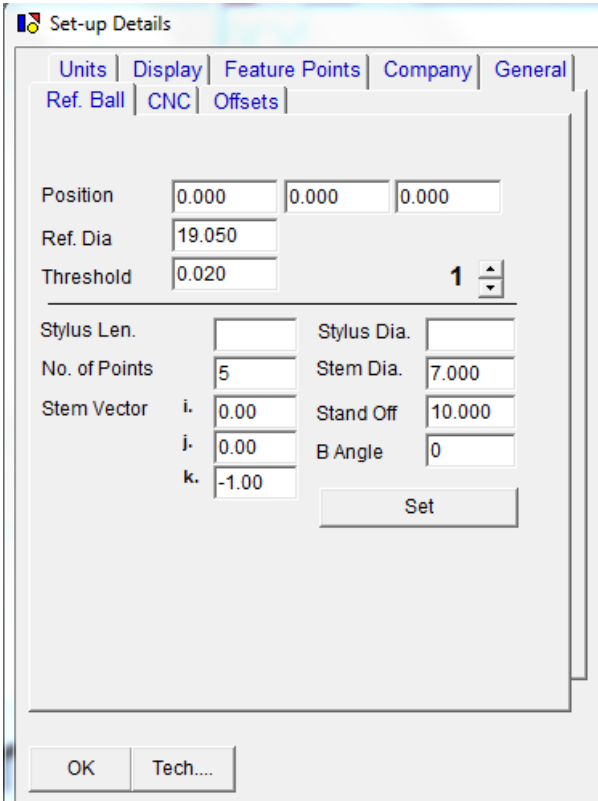


WI 048- Ref ball setup (mk3)	Date 27/07/15	Issue- 1	Author- Chris Walkley
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To set the reference ball position, click on setup icon, then choose the ref ball.

Firstly, delete any probe offsets from probe status window



Aberlink reference balls are 19.05mm

Threshold refers to the amount of acceptable error on fit for a probe calibration. Default is 0.020

Enter the stylus length, this would be the same value you would enter for a probe calibration, ie if using a 20mm stylus

PH10T	58mm
RTP20	20mm
MH20i	39mm
TP8	20mm

Enter stylus diameter (ruby ball dia)

No. of points defaults to 13, this determines number of points on probe calibration.

Stem dia, this is the diameter of the ball stem where it touches the ball, increase if you find

the stylus hits the stem during calibrations at A90 or A105

Stand Off is the amount of pre-travel the probe has before touching the sphere.

It is possible to have the stem in different directions other than vertical, the ijk vector needs to be changed along with the B Angle which is the angle offset from the horizon.

After entering the length and diameter, position the stylus 10mm above the centre of the reference ball and click on Set, the machine will take a point on top, then take points around the ball, if its an indexing head it will index to A90 B0. If using a RTP20 which is not yet set, the software will ask you to index head.

It is possible to have several ball positions, just index the offset number to 2, and repeat procedure.

