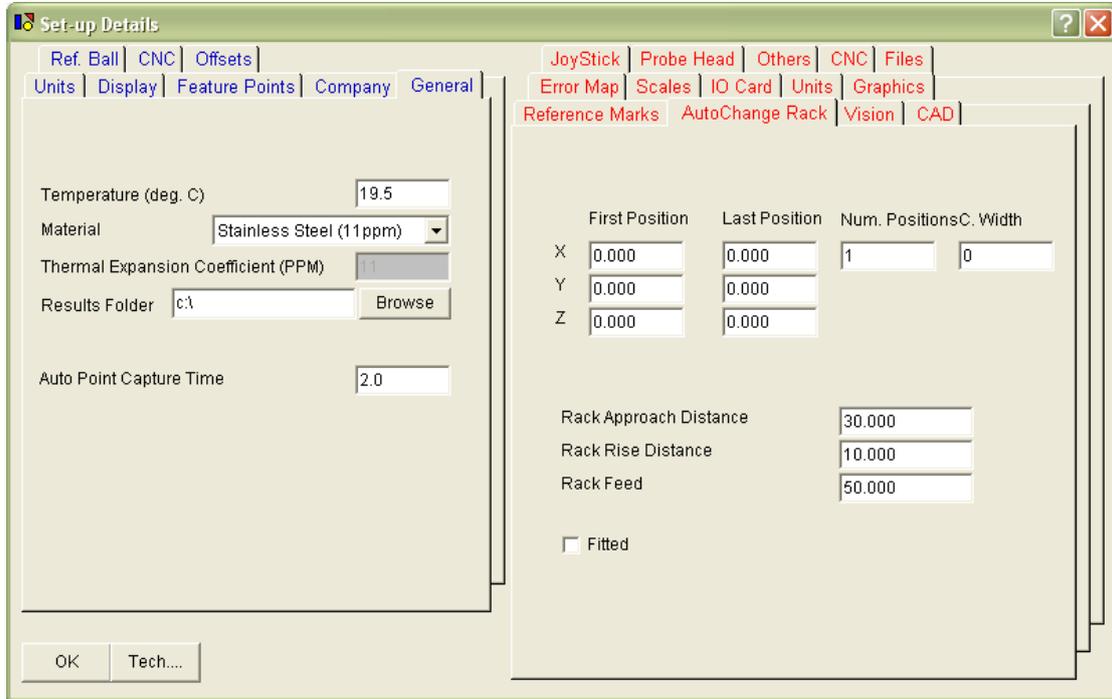


WI 017- Change rack setup	Date 27/07/15	Issue- 2	Author- Chris Walkley
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Auto-change Rack setup



To view the setup parameters, click on machine set up icon, then click on Tech.... and enter 2.718, then click on AutoChange Rack tab

First Position

This is the position of the first location (No 1) on the change rack.

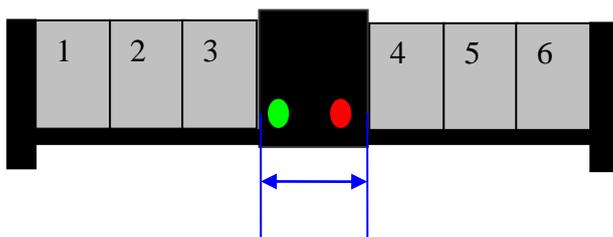
Last Position

This is the position of the last location (No 6) on the change rack.

Num. Positions

Enter the number of positions in the rack here. (MCR20 has 6).

C.width



On some change racks (like the SCR 20) there is a central area, this distance needs to be entered into



Rack

Approach Distance

This is the distance the probe will stand off from rack before starting the probe change routine.

Rack Rise

This is the distance the probe moves to disengage the module after it has docked with the rack, if this distance is too big the probe will miss the top covers.

Rack Feed

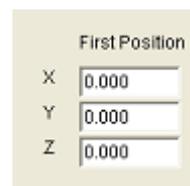
This is the speed at which the machine moves when swapping modules.

Setting up a Change rack

Place the rack on the table within the measurement volume of the machine. Best suited towards the back of machine if relatively short axes travel, or along the Y axis (half way) is long Y axis travel.

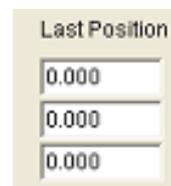
Open the auto-change rack tab and tick the fitted box by clicking on it.

Move the probe with the module still attached into the first position on the change rack (by hand or joystick), with the mouse double left click on any one of the first position boxes in the auto-change rack window this will record the X,Y,Z position of the first module.



First Position	
X	0.000
Y	0.000
Z	0.000

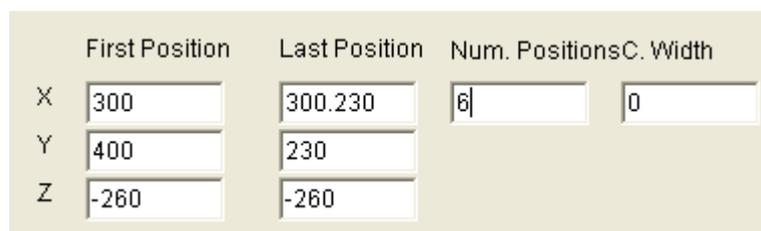
Repeat this for the last position on the change rack, clicking on one of the last position boxes (x,y or z) this will record the X,Y,Z position of the last module.



Last Position	
X	0.000
Y	0.000
Z	0.000

The remaining positions will be calculated automatically

Enter the number of modules the rack can hold in the number of positions box.



	First Position	Last Position	Num. Positions	C. Width
X	300	300.230	6	0
Y	400	230		
Z	-260	-260		

Close set-up window, and **restart** software.

Within probe status window

Click on rack drop down menu, you should have 6 options. To fill the rack fit a module to the probe and create an offset with 1 selected in the rack menu. Calibrate this probe. Then to add a module for port 2, at the top right of the window put the radio button into position 2 and click on swap. This will put current module away and go to the rack, once the probe comes out of port 2 (manually attach the probe). Calibrate this offset then continue with rest of ports if you have.

Do not build a probe offset using rack position 0, this option is for vision machines which have the camera and probe mounted together.

