
PC-DMIS Portable Manual

For Version 2018 R1



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Hexagon Manufacturing Intelligence

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PC-DMIS uses a free, open source package called lp_solve (or lpsolve) that is distributed under the GNU Lesser General Public License (LGPL).

```
lpsolve citation data
```

```
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```

```
Description: Open source (Mixed-Integer) Linear Programming  
system
```

```
Language: Multi-platform, pure ANSI C / POSIX source code,  
Lex/Yacc based parsing
```

```
Official name: lp_solve (alternatively lpsolve)
```

```
Release data: Version 5.1.0.0 dated 1 May 2004
```

```
Co-developers: Michel Berkelaar, Kjell Eikland, Peter  
Notebaert
```

```
Licence terms: GNU LGPL (Lesser General Public Licence)
```

```
Citation policy: General references as per LGPL
```

```
Module specific references as specified therein
```

```
You can get this package from:
```

```
http://groups.yahoo.com/group/lp\_solve/
```

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Arlington, MA

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PC-DMIS uses the Non-Negative Least Squares Algorithm for Eigen:

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It is available at <https://github.com/hmatuschek/eigen3-nnls>. It is subject to the terms of the Mozilla Public License v. 2.0. You can find the license at <http://mozilla.org/MPL/2.0/>.

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- computer icon
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Table Of Contents

Using PC-DMIS Portable	1
PC-DMIS Portable: Introduction	1
Launching PC-DMIS Portable	2
PC-DMIS Portable: User Interface	2
Using the Portable Toolbars.....	4
Edit Window	19
Quick Start Interface.....	20
Status Bar.....	21
Status Window	22
Probe Readouts.....	22
Configuring Portable Interfaces	23
Romer Arm Interface.....	24
Leica Tracker Interface.....	25
Faro Arm Interface	35
SMX Tracker Interface	37
Total Station Interface	44
Common Portable Functionality	50
Importing Nominal Data.....	51
Probe Compensation.....	51
Using Hard Probes.....	54
Probe Trigger Options	56
Converting Hits to Points.....	60

Edge Point Mode.....	61
Using a Romer Portable CMM	62
Romer Portable CMM: Introduction	63
Getting Started	63
Configuring a Perceptron Contour Sensor.....	67
Calibrating a Romer Hard Probe.....	72
Calibrating the Perceptron Sensor.....	72
Using Romer Arm Buttons	78
Using a Romer Laser Sensor.....	85
Using the RomerRDS Integrated Camera.....	87
Using a Leica Laser Tracker	89
Leica Laser Tracker: Introduction.....	90
Getting Started	90
Leica User Interface	95
Using Leica Utilities.....	113
Using Auto-Inspect Mode.....	118
Using Move Feature (Move To / Point To)	120
Using Leica Probes.....	124
Constructing Points for Hidden Point Devices	135
Using a Total Station.....	136
Getting Started with a Total Station.....	136
Total Station User Interface	137
Predefined Compensation	143

Table Of Contents

Using Move Feature (Move To / Point To)	146
Finding a Reflector.....	149
Creating Alignments	151
Quick Start Alignments	151
6 Point Alignment	154
Nominal Point Best Fit Alignment.....	155
Performing a Leapfrog Operation	157
Using Bundle Alignments.....	163
Measuring Features	175
Quick Start Interface for Trackers.....	176
A Note on Square Slots	177
A Note on Thickness Type: None	177
Creating "Single-Point" Measured Circle Features.....	177
Creating "Two-Point" Measured Slot Features.....	181
Portable Hard Probe Scanning	184
Rules for Manual Scans	184
Scanning for Auto Feature Sample Hits	186
Performing a Fixed Distance Manual Scan	187
Performing a Fixed Time / Distance Manual Scan	189
Performing a Fixed Time Manual Scan.....	190
Performing a Body Axis Manual Scan	192
Performing a Multisection Manual Scan	194
Performing a Manual Freeform Scan	197

Portable Laser Probe Scanning 198

AT403 and AT9x0 Continuous Scanning Modes201

Appendix A: Faro Portable Arm.....203

 Available Dialog Box Options204

 Faro Calibration Procedure205

Appendix B: SMX Tracker.....206

 Using the Closure Window208

 Performing Operational Checks.....208

Glossary..... 209

Index..... 211

Using PC-DMIS Portable

PC-DMIS Portable: Introduction

This documentation covers how to use PC-DMIS Portable with your portable measuring device to measure features on a part. Portable devices are manually-operated measuring machines that are relatively easy to move to new locations due to their size and design. These are sometimes called "manual machines" or "hard probe machines" because they cannot run in DCC mode, nor do they have a touch-trigger mechanism to record hits.

Supported Hardware Configurations

- [Romer arms](#) - Sigma Series, Flex Series, Omega Series, and Infinite series.
- [Leica Laser Trackers](#) - For supported Leica versions, see the "[Leica Laser Tracker: Introduction](#)" topic.
- [Faro arms](#)
- [SMX Trackers](#)

The main topics in this documentation include:

- [Launching PC-DMIS Portable](#)
- [PC-DMIS Portable: User Interface](#)
- [Configuring Portable Interfaces](#)
- [Common Portable Functionality](#)
- [Using a Romer Portable CMM](#)
- [Using a Leica Laser Tracker](#)
- [Using a Total Station](#)
- [Creating Alignments](#)
- [Measuring Features](#)
- [Portable Hard Probe Scanning](#)
- [Portable Laser Probe Scanning](#)

- [AT403 and AT9x0 Continuous Scanning Modes](#)

If you come across something in the software that isn't covered here, consult the PC-DMIS Core documentation.

Launching PC-DMIS Portable

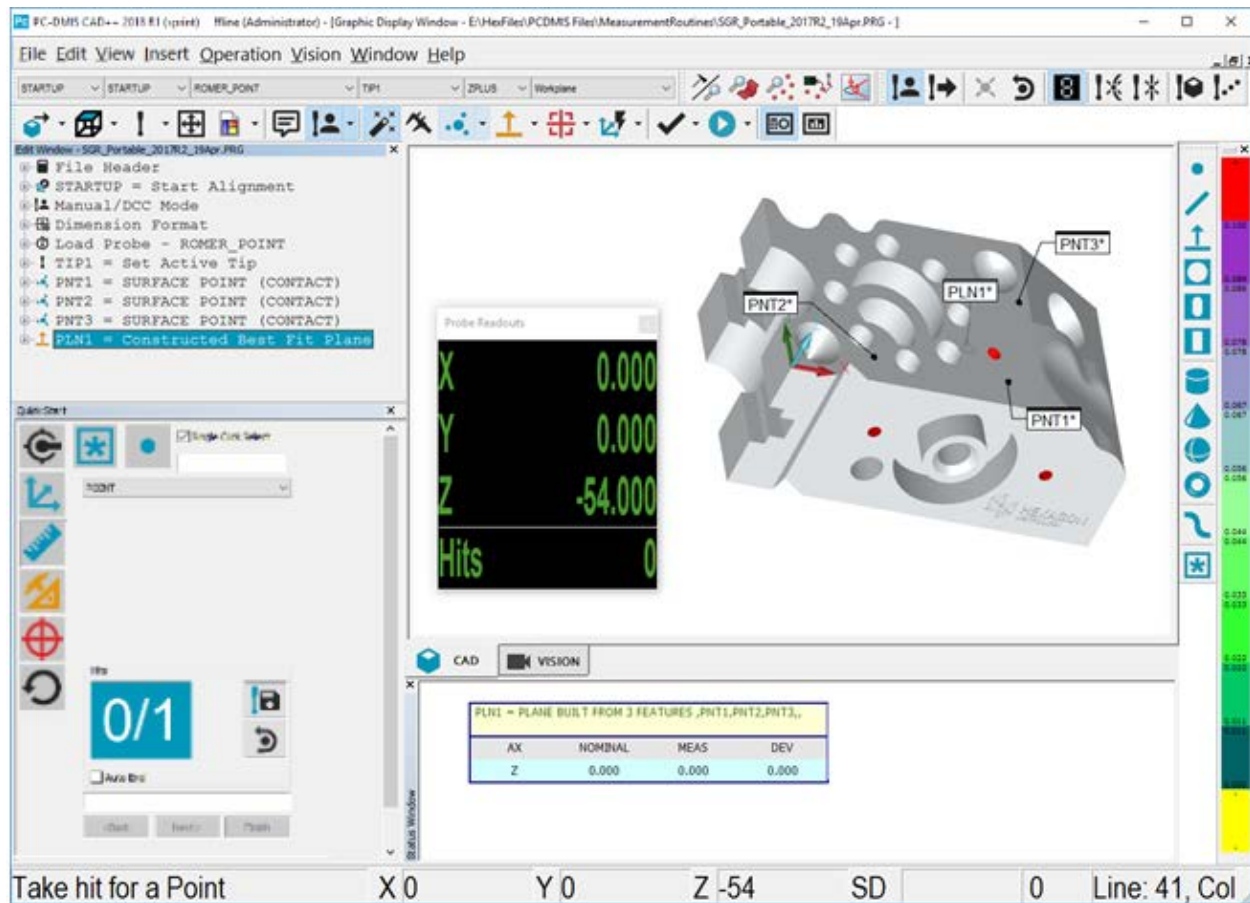
With PC-DMIS Portable, you can launch a slightly different user interface when you work with portable devices. A [Portable toolbar](#) appears with larger toolbar icons to improve visibility from a distance. In addition, menu items are larger than those used in a standard CMM-based configuration of PC-DMIS.

The portable interface becomes available if you are licensed to support a portable device.

You need to create one or more configuration files (XML files created from a configuration utility) that define the exact portable configurations you want to use. Next, using the **Configurations** list on the **Settings** toolbar of the PC-DMIS Portable user interface, choose the configuration to load. Once this is done, PC-DMIS restarts using the defined portable configuration. For example, you could define two different configuration files for the same Leica interface and switch between them as needed.

PC-DMIS Portable: User Interface

There are PC-DMIS user interface elements that are particularly useful when you use portable devices. The image below shows a sample Portable user interface.



Example of a Portable user interface

The following user interface elements are discussed in greater detail elsewhere in this documentation:

- [Using the Portable toolbars](#)
- [Edit window](#)
- [Quick Start interface](#)
- [Status bar](#)
- [Status window](#)
- [Probe Readouts](#)

In addition, the following user interface elements are discussed in greater detail in the PC-DMIS Core documentation:

- **Menu** bar - You can access all PC-DMIS functionality from the menu bar and the corresponding drop-down lists. For more information on the menu bar, see "The Menu Bar" in the "Navigating the User Interface" chapter in the PC-DMIS Core documentation.
- **Graphic View** toolbar - Allows you to easily change the view of the Graphic Display window. For more information on this toolbar, see "Graphic View Toolbar" in the "Using Toolbars" chapter in the PC-DMIS Core documentation.
- **Graphic Item** toolbar - Toggles the display of Graphic Display window labels. For more information on this toolbar, see "Graphic Items Toolbar" in the "Using Toolbars" chapter in the PC-DMIS Core documentation.
- **Graphic Display** window - Displays the geometric features that are being measured. For more information on this window, see "The Graphic Display Window" in the "Navigating the User Interface" chapter in the PC-DMIS Core documentation.
- **Dimensions Color** bar - Shows the colors for dimension tolerances and their associated scale values. For more information on this item, see "Using the Dimensions Colors Window (Dimensions Color Bar)" in the "Using Other Windows, Editors, and Tools" chapter in the PC-DMIS Core documentation.



If your license or portlock is programmed to support all interfaces, you need to run the PC-DMIS installation program with one of the following switches: /Interface:romer, /Interface:leica, /Interface:smxlaser, or /Interface:faro. You can add these case-sensitive switches by creating a shortcut to the PC-DMIS Setup.exe file and appending the needed switch to the **Target** box (for example: C:\Download\PC-DMIS\Setup.exe /Interface:romer). If you are installing with a license or portlock programmed for a specific interface, the correct interface should be installed automatically.

Using the Portable Toolbars

To decrease the time it takes to program your part, PC-DMIS Portable offers you a variety of toolbars composed of frequently-used commands. You can access these toolbars in two ways.

- Select the **View | Toolbars** submenu, and select a toolbar from the menu.
- Right-click on the PC-DMIS **Toolbar** area, and select a toolbar from the shortcut menu.

For a description of the standard PC-DMIS toolbars, see the "Using Toolbars" chapter in the PC-DMIS Core documentation.

The toolbars that are specific to Portable functionality are:

Build and Inspect Toolbar



Build and Inspect Toolbar

The **Build and Inspect Toolbar** has buttons to determine how the Build and Inspect modes are used in PC-DMIS Portable. The following options are available:



Inspect / Build mode - By default (Inspect mode), PC-DMIS displays the deviation (T) as *Difference = Actual - Nominal*.

- **Build Mode** - The general purpose is to provide real-time deviations between a real object and its nominal data or CAD model. This allows you to position your part as it relates to the CAD design data.
- Selecting this option displays the distance and direction that you need to move the measured point to reach the nominal position or *Difference = Nominal - Actual*.



When you are moving the part into position, there are just real-time deviations displayed without storing any data (taking hits). After the part is positioned within a reasonable deviation (e.g. 0.1mm), you would typically measure (hits are taken) the final position of the feature.

- **Inspect Mode** - In this mode, the position of an object (point, line of surface, etc.) is checked and compared with design data.



Surface Inspection - Applies the **Probe Readout** settings that are useful for inspecting surfaces/curves.



Point Inspection - Applies the **Probe Readout** settings that are useful to inspect points.

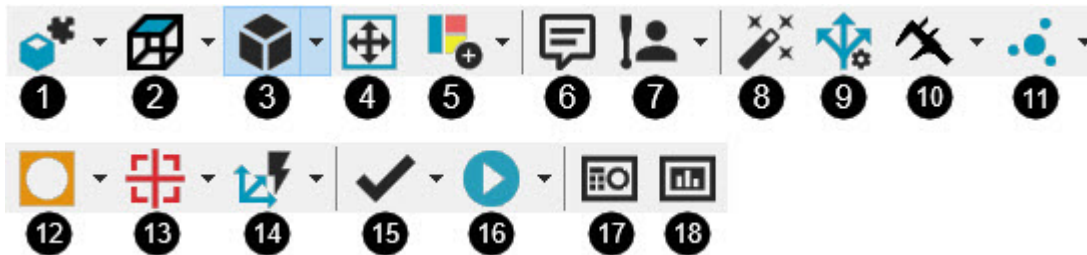


Distance to closest feature - When you enable this option, the distance to the closest feature displays in the **Probe Readout**.



Show Deviation Arrow - When you enable this option, arrows display in the Graphic Display window according to the inspect mode. The arrows are placed at the probe location in inspect mode (default) or at the measured point during build mode.

QuickMeasure Toolbar



QuickMeasure toolbar for Portable users

The Portable **QuickMeasure** toolbar models the typical flow of operation for Portable users. To access it, select **View | Toolbars | QuickMeasure**.

The toolbar provides drop-down functionality for many of the buttons. PC-DMIS stores the last-selected option for each button and displays it the next time the software shows the **QuickMeasure** toolbar.

You can add the drop-down buttons to any customizable toolbar from the **View | Toolbars | Customize** menu option. For details, see the "Customizing Toolbars" topic in the PC-DMIS Core documentation.

The following buttons are available:

1. **CAD Setup** button and drop-down arrow - Provides options to set up the CAD model.

Click the arrow to display the **CAD Setup** toolbar:



For details, see "CAD Setup Toolbar" in the "Using Toolbars" chapter in the PC-DMIS Core documentation.

2. **Graphic View** button and drop-down arrow - Resets the graphic in the Graphic Display window to the graphical view shown on the button.

Click the drop-down arrow to display the **Graphic View** toolbar:



For details, see "Graphic View Toolbar" in the "Using Toolbars" chapter in the PC-DMIS Core documentation.

3. **Graphic Items** button and drop-down arrow - Changes the graphic in the Graphic Display window to display or hide the graphical item properties shown on the button.

Click the drop-down arrow to display the **Graphic Items** toolbar:

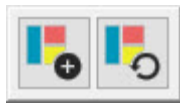


For details, see "Graphic Items Toolbar" in the "Using Toolbars" chapter in the PC-DMIS Core documentation.

4. **Scale to Fit** (Ctrl + Z) - Re-draws the part image to fit entirely within the Graphic Display window. This function is useful whenever the image becomes too large or small. You can also re-draw the image by pressing Ctrl + Z on your keyboard.

5. **Graphic Viewset** button and drop-down arrow - Depending on the button icon that is displayed, when clicked, the current Viewset can be saved, or an existing Viewset can be recalled.

Click the drop-down arrow to display the **Graphic Viewset** toolbar:



For details, see "Graphic Modes Toolbar" in the "Using Toolbars" chapter in the PC-DMIS Core documentation.

6. Opens the **Comment** dialog box so you can insert different comment types into the measurement routine. By default, the software selects the **Operator** option.

For details, see "Inserting Programmer Comments" in the "Inserting Report Commands" chapter in the PC-DMIS Core documentation.

7. **Probe Mode** button and drop-down arrow - Sets and adds the **Probe Mode** feature that is displayed on the button to the measurement routine.

Click the drop-down arrow to display the **Probe Mode** toolbar where you can select between **Manual Mode** and **DCC Mode**.



For details, see "Probe Mode Toolbar" in the "Using Toolbars" chapter in the PC-DMIS Core documentation.

8. **Quick Start** toggle button - Toggles the Quick Start functionality on and off. For details, see the "[Quick Start Interface](#)" topic in the "Using Other Windows, Editors, and Tools" chapter in the PC-DMIS Core documentation.

9. **Measurement Strategy Editor** button - Opens the **Measurement Strategy Editor** dialog box so that you can modify the settings for all auto features and store them as custom groups. For details, see the "Using the Measurement Strategy Editor" topic in the "Setting Your Preferences" chapter in the PC-DMIS Core documentation.

10. **Gage** button - Opens the **Gage** dialog box to add a Caliper command into the current measurement routine.

For details, see the topic "Caliper Overview" in the PC-DMIS Laser documentation.

11. **Auto Feature** button and drop-down arrow - Displays the **Auto Feature** dialog box that is related to the icon shown on the button. From the dialog box, you can select any of the available feature commands to insert into the measurement routine.

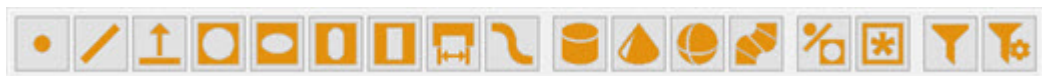
Click the drop-down arrow to display the **Auto Feature** toolbar:



For details, see "Inserting Auto Features" in the "Creating Auto Features" chapter in the PC-DMIS Core documentation.

12. **Constructed Feature** button and drop-down arrow - Displays the **Constructed Feature** dialog box that is related to the icon shown on the button. From the dialog box, you can select any of the available feature commands to insert into the measurement routine.

Click the drop-down arrow to display the **Constructed Feature** toolbar:



For details, see the "Constructing New Features from Existing Features" chapter in the PC-DMIS Core documentation.

13. **Dimension** button and drop-down arrow - Displays the **Dimension** dialog box that is related to the icon shown on the button. From the dialog box, you can select any of the available dimension commands to insert into the measurement routine.

Click the drop-down arrow to display the **Dimension** toolbar:



For details, see "Dimensioning Location" in the "Using Legacy Dimensions" chapter in the PC-DMIS Core documentation.

14. **Alignment** button and drop-down arrow - The alignment options are defined based on the types of features that you selected, the order in which you selected them, and the positions of the features relative to each other.

Click the drop-down arrow to display the **Alignment** toolbar:



For details, see the appropriate topic in the "Creating and Using Alignments" chapter in the PC-DMIS Core documentation.

15. **Mark** button and drop-down arrow - Depending on the selection you made on the drop-down toolbar, the button marks the currently selected feature, marks all features, or clears all marked features in the Edit window.

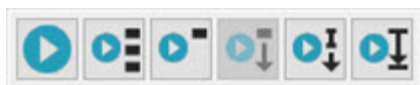
Click the drop-down arrow to display the **Mark** toolbar:



For details, see the appropriate topic in the "Edit Window Toolbar" chapter in the PC-DMIS Core documentation.

16. **Execute** button and drop-down arrow - Runs (or executes) the measurement process for any currently marked feature(s).

Click the drop-down arrow to display the **Execute** toolbar:



For details on executing your measurement routine, see "Executing Measurement Routines" in the "Using Advanced File Options" chapter in the PC-DMIS Core documentation.

17. **Status Window** - Displays the Status window. You can use this window to preview commands and features while you create them from the **Quick Start** toolbar, during feature execution, dimension creation or editing, and also by simply clicking on the item in the Edit window with the Status window open. For details on the Status window, see the "Using the Status Window" topic in the "Using Other Windows, Editors, and Tools" chapter in the PC-DMIS Core documentation.

18. **Report Window** - Displays the Report window. After execution of the measurement routine, this window displays your measurement results and automatically configures the output according to a default report template. For detailed information, see "About the Report Window" in the "Reporting Measurement Results" chapter in the PC-DMIS Core documentation.

Probe Mode Toolbar



The **Probe Mode** toolbar (**View | Toolbars | Probe Mode**) contains icons that you can use to enter the different modes used by the current probe or CMM:



Manual Mode - Use this icon to place PC-DMIS in Manual mode. Manual mode enables you to manually control your machine's movements and measurements. Manual mode is used on a manual CMM or during the manual alignment portion of a measurement routine that is run on an automatic CMM.


Selecting this icon inserts a [MODE / MANUAL](#) command into the Edit window at the cursor's location. Edit window commands that follow this command are executed in Manual mode.



DCC Mode - Use this icon to place PC-DMIS in DCC mode. DCC mode allows supported DCC machines to automatically take over the measurement of your measurement routine.

Selecting this icon inserts a [MODE / DCC](#) command into the Edit window at the cursor's location. Edit window commands that follow this command are executed in DCC mode.



 **Take Hit** - Automatically takes and records a measurement hit at the current cursor location in the Edit window.




 Erase Hit - Automatically deletes the last measurement taken.




 Probe Readouts - Shows or hides the Probe Readouts window.




 **Point Auto Trigger Mode** - Automatically takes a reading when the probe is close to the surface point. See the "[Point Auto Trigger](#)" topic.




 **Plane Auto Trigger Mode** - Automatically takes a reading when the probe is a close to an edge point. See the ["Plane Auto Trigger"](#) topic.

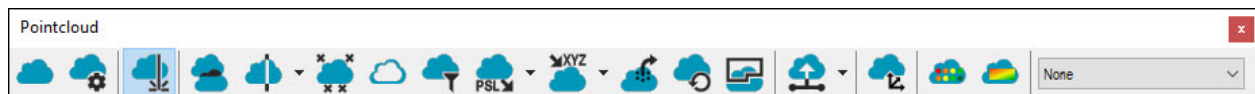


 **Find Nominals from CAD Mode** - Automatically finds the appropriate nominal from the CAD model when measuring on-line.



 **Point Only Mode** - Interprets all measurements as points only. The **Done** key is not required.

Pointcloud Toolbar

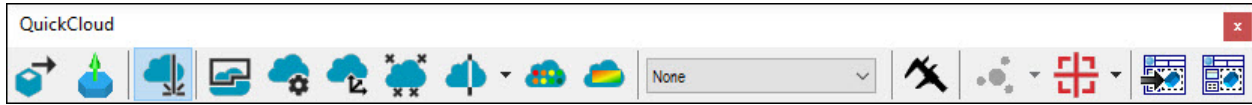


Pointcloud toolbar

The **Pointcloud** toolbar provides all pointcloud operations, features, and functions. You access it from the **View | Toolbars | Pointcloud** menu depending on your system's configuration.

For details on all **Pointcloud** toolbar functions, see the "Pointcloud Toolbar" topic in the PC-DMIS Laser documentation.

QuickCloud Toolbar



Portable QuickCloud toolbar

The **QuickCloud** toolbar is only available when PC-DMIS is licensed and configured as a Portable device. It provides the buttons to complete all the steps from beginning to end for working with COP.

The toolbar features drop-down button functionality for the **Auto Feature** and **Dimension** buttons. PC-DMIS stores the last-selected option for each button and displays it the next time the **QuickCloud** toolbar appears.

The drop-down buttons can be added to any toolbar capable of being customized in PC-DMIS from the **View | Toolbars | Customize** menu option.



For details on all **Pointcloud** toolbar buttons, see "Pointcloud Toolbar" in the PC-DMIS Laser documentation.

The following options are available:



Import from CAD file - Displays the **Open** dialog box, which you can use to navigate to and import any one of the supported part models from your library. Select the **Files of Type** drop-down list to view the available file types. For details, see "Importing a CAD File" in the "Using Advanced File Options" chapter in the PC-DMIS Core documentation.



CAD Vectors - Displays the **CAD Vectors** dialog box where you can view and manipulate surface vectors. For details, see "Editing CAD Vectors" in the "Editing the CAD Display" chapter in the PC-DMIS Core documentation.



Pointcloud Filtering Plane - Displays the **Laser Data Collection Settings** dialog box. Use it to define data filtering and an exclusion plane for your pointcloud data. For details, see "Laser Data Collection Settings" in the PC-DMIS Laser documentation.



Select Pointcloud - This pointcloud operator provides, by default, the Polygon selection method. Select the vertices of the polygon and then press the **End Key** to close it.



The **Select Pointcloud** option differs from the use of the pointcloud operator because it only applies the function and is not added as a command. To create the command, open the pointcloud operator and choose the **Select** method.



Pointcloud Operator - Displays the **Pointcloud Operator** dialog box. Use it to perform different operations on Cloud of Points (COP) commands and other Pointcloud operator commands. For details, see "Pointcloud Operators" in the PC-DMIS Laser documentation.



Pointcloud Alignment - Creates Pointcloud to CAD and COP to COP alignments. For details, see "Pointcloud/CAD Alignment Dialog Box Description" in the "Pointcloud Alignments" chapter in the PC-DMIS Laser documentation.

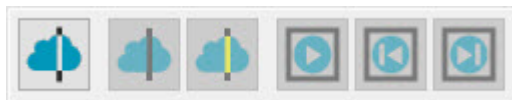


Clean Pointcloud - When clicked, the CLEAN operation immediately eliminates outlier COP points based on the default MAX DISTANCE of the points to the CAD. If the distance of a point is greater than the value of MAX DISTANCE, the point is considered an outlier or not belonging to the part. To use this operation, you must have at least a rough alignment established. For details on creating rough alignments, see "Creating a Pointcloud/CAD Alignment" in the PC-DMIS Laser documentation. For more details on the Clean Pointcloud operator, see "CLEAN" in the "Pointcloud Operators" chapter in the PC-MIS Laser documentation.



Cross Section - Opens the **Pointcloud Operator** dialog box with the CROSS SECTION option selected in the **Operator** drop-down list. For details on creating cross section features, see "CROSS SECTION" in the "Pointcloud Operators" chapter in the PC-DMIS Laser documentation.

Click the drop-down arrow to display the **Cross Section** toolbar:



For details on the buttons to show and hide cross section polylines, see "Show and Hide Cross Section Polyines" in the PC-DMIS Laser documentation.



Pointcloud Mesh - Displays the **Mesh Command** dialog box, which you can use to define a mesh command for pointclouds. For details, see "Creating a Mesh Feature" in the PC-DMIS Laser documentation.



Pointcloud Point Colormap - Opens the **Pointcloud Operator** dialog box with the POINT COLORMAP option selected in the **Operator** drop-down list. For details, see "POINT COLORMAP" in the "Pointcloud Operators" chapter in the PC-DMIS Laser documentation.



Pointcloud Surface Colormap - Displays the **Pointcloud Operator** dialog box with the Surface Colormap operator selected. The SURFACE COLORMAP operation applies a colored shading to the CAD model. The model is shaded based on the deviations of the cloud of points compared to CAD using the colors defined in the **Edit Dimension Color** dialog box (**Edit | Graphic Display Window | Dimension Color**) and the tolerance limits specified in the **Upper tolerance** and **Lower tolerance** boxes. For details on the Pointcloud Surface Colormap operator, see "SURFACE COLORMAP" in the "Pointcloud Operators" chapter in the PC-DMIS Laser documentation.

You can create multiple surface colormaps in a PC-DMIS measurement routine. Only one is active at a time, however. The last surface colormap that you applied and created, or the last one you executed, is always the currently-active colormap. You can also select which colormap is the active one by using the **FaceColormaps** list box. When a new colormap is activated, its associated scale with tolerance values and any annotations display in the Graphic Display window.

To do this, click the **FaceColormaps** list box and select the colormap from the list of defined Surface Colormap operators:

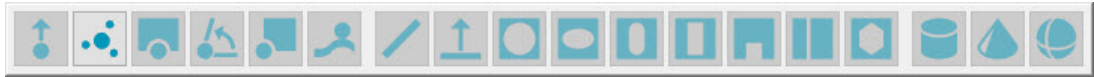


Caliper button - The **Caliper** is a quick-check tool that works similar to a physical caliper. It provides a local two point size check on the Pointcloud (COP), Mesh, or COPOPER (such as the COPSELECT, COPCLEAN, or COPFILTER) object. The Caliper shows the measured length along the selected axis or direction.



Auto Feature button and drop-down arrow - Displays the **Auto Feature** dialog box that is related to the icon shown on the button. From the dialog box, you can select any of the available feature commands to insert into the measurement routine.

To display the **Auto Feature** toolbar, click the drop-down arrow:



For information on Auto Features, see "Inserting Auto Features" in the "Creating Auto Features" chapter in the PC-DMIS Core documentation.



Dimension button and drop-down arrow - Displays the **Dimension** dialog box that is related to the icon shown on the button. From the dialog box, you can select any of the available dimension commands to insert into the measurement routine.

To display the **Dimension** toolbar, click the drop-down arrow:



For information on dimensions, see "Using Legacy Dimensions" and "Using Feature Control Frames" chapters in the PC-DMIS Core documentation.

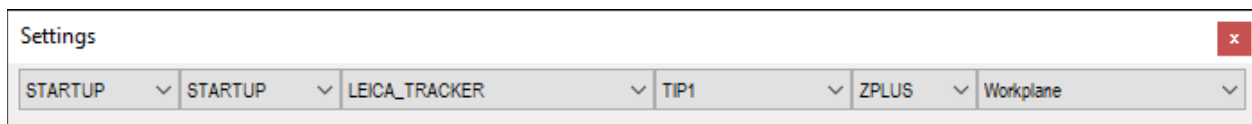


Edit Custom Report from other Measurement Routine - Creates a Custom Report from another measurement routine in your current measurement routine. For details, see "Creating Custom Reports" in the "Reporting Measurement Results" chapter in the PC-DMIS Core documentation.



Insert Custom Report - Inserts a custom report into your measurement routine as with the **Insert | Report Command | Custom Report** menu function. For details, see "Embedding Reports or Templates into a Measurement Routine" in the "Inserting Report Commands" chapter in the PC-DMIS Core documentation.

Settings Toolbar



The **Settings** toolbar allows you to recall and change these frequently-used settings:

- Saved views

- Alignments
- Probe files
- Probe tips
- System workplanes for 2D measurements and calculations
- Measured plane for reference for 2D measurements and calculations
- Defined machine and interface configurations

For details, see "Settings Toolbar" in the "Using Toolbars" chapter in the PC-DMIS Core documentation.

Tracker Toolbars

The default Leica tracker toolbars are shown below. These are available when you launch PC-DMIS Portable using a Leica tracker interface.



Tracker Operation toolbar (for AT-901 Trackers)

- [Tracker | Insert Tracker Command](#)
- [Tracker | Station Management](#)
- [Tracker | Initialize](#)
- [Tracker | Go Birdbath](#)
- [Tracker | Go 6DoF 0 Position](#)
- [Tracker | Find](#)
- [Tracker | Release Motors](#)
- [Tracker | Laser ON/OFF](#)
- [Tracker | Probe Comp. ON/OFF](#)
- [Tracker | Stable Probing ON/OFF](#)
- [Tracker | PowerLock ON/OFF](#)
- [View | Other Windows | Tracker Overview Cam](#)
- [Insert | Alignment | Bundle Alignment](#)
- [Tracker | Move Feature](#)



Tracker Operation toolbar (for AT-930/960 and AT-403 Trackers)

- [Tracker | Insert Tracker Command](#)
- [Tracker | Station Management](#)
- [Tracker | Initialize](#)
- [Tracker | Go 0 Position](#)
- [Tracker | Find](#)
- [Tracker | Change Face](#)
- [Tracker | Compensator On/Off](#)
- [Tracker | Probe Compensation](#)
- [Tracker | Stable Probing](#)
- [Tracker | PowerLock ON/OFF](#)
- [View | Other Windows | Tracker Overview Cam](#)
- [Tracker | Measurement Profile](#)
- [Tracker | Two Face Mode ON/OFF](#)
- [Insert | Alignment | Bundle](#)
- [Tracker | Move Feature](#)



Tracker Measure

- **Edit | Preferences | Machine Interface Setup**
- **Operation | Take Hit**
- **Operation | Start/Stop Continuous Mode**
- **Operation | End Feature**
- **Operation | Erase Hit**
- **Edit | Delete | Last Feature**



Tracker Nivel

- **Tracker | Nivel | Start 'Level to Gravity' Process**
- **Tracker | Nivel | Start Tilt Readout**
- **Tracker | Nivel | Start/Stop Monitoring**

For information on these options see "[Nivel Commands](#)" below.

Other PC-DMIS Windows and Toolbars

The PC-DMIS Core documentation provides the following information that is relevant for trackers:

Settings toolbar:

For information, see the "Settings Toolbar" topic in the "Using Toolbars" chapter in the PC-DMIS Core documentation.

The third drop-down box displays Reflector and T-Probe compensations from the emScon server (and any additional ones that are manually defined).

Probe Readouts window:

For information, see "Using the Probe Readouts Window" in the "Using Other Windows, Editors, and Tools" chapter in the PC-DMIS Core documentation.

Also, see the "[Customizing the Probe Readout](#)" topic for Leica-specific settings.

Edit window:

For information, see the "Using the Edit Window" chapter in the PC-DMIS Core documentation.

Quick Start interface:

For information, see "Using the Quick Start Interface" in the "Using Other Windows, Editors, and Tools" chapter in the PC-DMIS Core documentation.

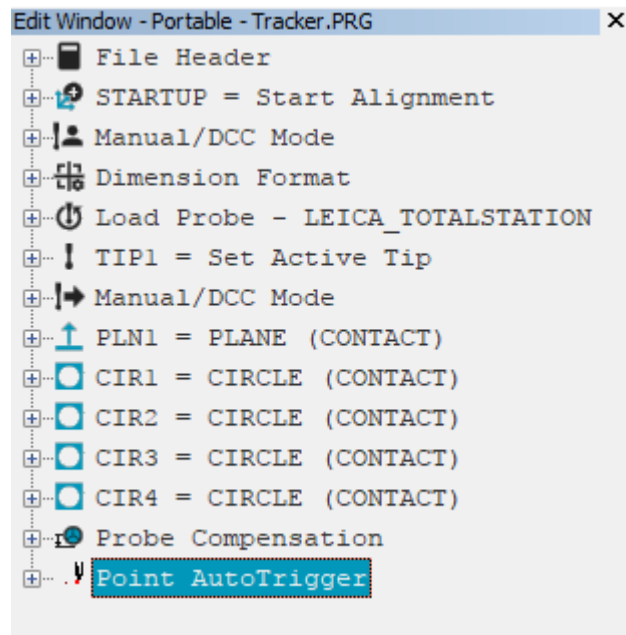
Status window:

For information, see "Using the Status Window" in the "Using Other Windows, Editors, and Tools" chapter in the PC-DMIS Core documentation.

Tracker status bar:

For information, see the "[Tracker Status Bar](#)" topic.

Edit Window



Edit window - Summary mode

The Edit window displays the commands for the measurement routine that you are creating.

The Edit window's Summary mode is a list of expandable and collapsible commands. You can right-click on commands or items in commands and choose **Edit** to modify items in the Edit window.

New measurement routine statements are added AFTER the highlighted line.

For more information on the Edit window, see the "Using the Edit Window" chapter in the PC-DMIS Core documentation.

Quick Start Interface



The Quick Start interface is the starting place for performing most of the functions when you work with portable devices. If it isn't already visible, select **View | Other Windows | Quick Start** to access it.

From this interface, you can:



Calibrate Probes



Create Alignments



Measure Features



Construct Features



Create Dimensions



Reset the window

For more information, see "Using the Quick Start Interface" in the "Using Other Windows, Editors, and Tools" chapter in the PC-DMIS Core documentation.

Status Bar

CAD element NOT selected! X 302.861 Y -164.846 Z 0 SD 0 1 Line: 13, Col: 001

The status bar provides PC-DMIS system information, such as:

- Help on buttons with mouse-over
- XYZ Counter
- StdDev of Feature Display
- Probing Point Counter (normal size only)
- Unit Display: MM or INCH (normal size only)
- Line / Column counter to show where the cursor is within the Edit window (normal size only)

To change the status bar to large size, select the **View | Status Bar | Large** menu option.

Status Window



The Status window displays user information as a measurement routine is being created, such as:

- Feature information as they are being measured
- Dimension reports as the dimension tolerances are being evaluated

For more information, see the "Using the Status Window" topic in the "Using Other Windows, Editors, and Tools" chapter in the PC-DMIS Core documentation.

Probe Readouts

Probe Readouts	
Linear	
X	0.000
Y	0.000
Z	0.000
DX	-999.000
DY	-999.000
DZ	-999.000
W	0.000
V	0.000
Hits	0

The Probe Readouts window primarily displays the XYZ probe location. You can toggle the display of the Probe Readouts window from the **Portable** toolbar. To toggle the display, press and hold the portable arm's left button for one or more seconds. If the Probe Readouts window is already open, the **T** value in the Probe Readouts window appears. The **T** value provides the distance to the CAD nominal.

When you work in the Build / Inspect mode, these Probe Readouts window colors indicate whether the current location is *in* or *out* of tolerance:

- Green - In tolerance
- Blue - Negative out of tolerance
- Red - Positive out of tolerance

For more information about the Probe Readouts window, see "Using the Probe Readouts Window" in the "Using Other Windows, Editors, and Tools" chapter in the PC-DMIS Core documentation.

Configuring Portable Interfaces

The **Edit | Preferences | Machine Interface Setup** menu option opens the **Machine Options** dialog box with the specific settings for your portable device. Machine options are only available when you work in online mode.



In most cases, you *shouldn't* change any of the values in this dialog box. Some items in this dialog box, such as the **Mechanical Offsets** area, permanently overwrite values stored for your machine on the controller's hard drive. For questions on how and when to use the **Machine Options** dialog box, you should contact your local service representative.

The parameters in the **Machine Options** dialog box are discussed for the following machine interfaces:

- [Romer arm](#)
- [Leica Tracker](#)
- [Faro arm](#)
- [SMX Tracker](#)
- [Total Station](#)

For information on the other machine interfaces that PC-DMIS supports, see the "Setting Up the Machine Interface" topic in the "Setting Your Preferences" chapter in the PC-DMIS Core documentation.

Romer Arm Interface

The Romer interface is used with a *Romer* arm machine. PC-DMIS v3.7 and above support USB arms.

Copy this file from Wilcox's ftp site:

<ftp://ftp.wilcoxassoc.com/Hardware/Portable/Romer/GDS/Romosoft V1Sr8.zip>

Unzip the file(s) and run setup.

Set the environment parameters so that PC-DMIS can access Romer's DLLs:

- Go to **Control panel**.
- Select **System**, click on the **Advanced** tab, and then click on the **Environment variables** button.
- In the system variables list box, edit the Path variable. Add a semicolon followed by the WinRDS installation directory. Normally this means adding ";C:\Program Files\cimcore\winrds" (without the quotation marks) to the end of the Path string.

Before you start PC-DMIS, rename the romer.dll to interfac.dll.

The **Machine Option** dialog box has five tabs for the Romer interface:

Debug tab

See the "Generating a Debug File" topic.

Tools tab

This tab provides a **Diagnostics** button. This button launches Romer software to configure and test your Romer arm. See the WinRDS User Guide, located in the WinRDS install directory, for more information. *The WinRDS User Guide is a PDF file that installs when you install WinRDS.*



The Machine Interface Installation Manual (MIIM) provides additional information for this interface.

You can access the MIIM.chm help file in the **en** subfolder where PC-DMIS is installed.

Romer Pulled Hit Feature

The Romer interface supports pulled hits. See "[Pulled Hits Method](#)" in the "[Probe Compensation](#)" documentation.

Leica Tracker Interface

The parameters that control how PC-DMIS interfaces with the Leica interface can be configured by selecting the **Edit | Preferences | Machine Interface Setup** menu item. This opens the **Machine Options** dialog box. The following tabs are available:

- [Options tab](#)
- [Reset tab](#)
- [Sensor Configuration tab](#)
- [Environmental Parameters tab](#)
- [Level To Gravity tab](#)
- **System Information** tab - Displays information for your configured Leica system. Included values are: IP Address, Tracker Type with Serial # (if available), Controller Type, T-CAM Type and Serial # (if available), emScon version, TP-Firmware version, Bootdriver version, and Nivel Type and Serial # (if available).
- **Debug** tab - For information, see the "Generating a Debug File" topic in the "Setting Your Preferences" chapter in the PC-DMIS Core documentation.



The Machine Interface Installation Manual (MIIM) provides additional information for this interface.

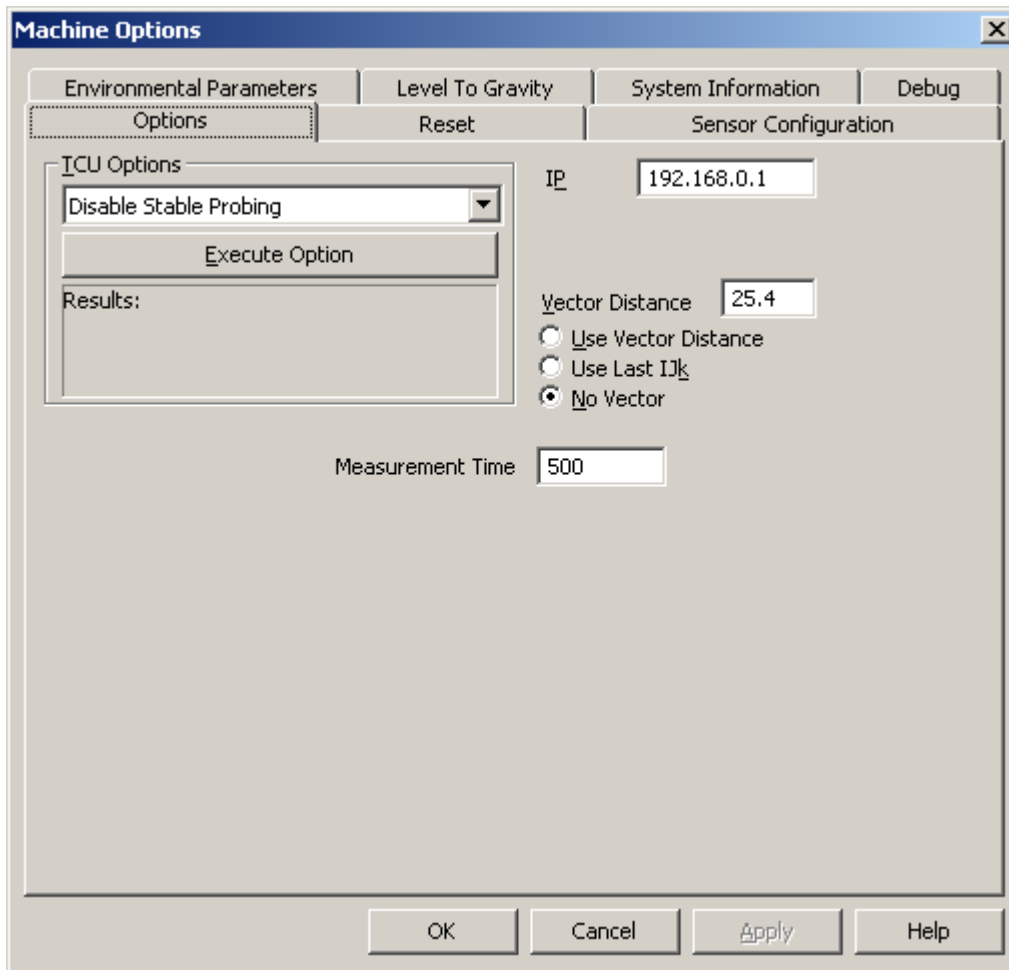
You can access the MIIM.chm help file in the **en** subfolder where PC-DMIS is installed.

Minimum continuous scanning time and distance settings enforced by PC-DMIS

Tracker	Minimum Time	Minimum Distance
Leica (AT403)	20ms (0.02)	-
Leica (AT901)	100ms (0.1)	-

LeicaLMF (AT9x0)	1ms (0.001) A performance hit occurs when setting a minimum time value less than 0.01 mm as Time Delta.	0.01 mm You need to set the 403 min / max settings for 10Hz (901 is 1000 Hz).
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Options tab



Machine Options dialog box - Options tab

The **Options** tab provides the means to execute various TCU (Tracker Control Unit) options and configure communication and other parameters. TCU options are also available as menu items.

TCU Options - This area allows you to execute the following options:

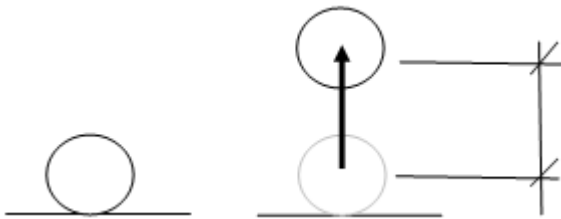
- **Disable Stable Probing** - Disables stable probing. See the **Stable Probing ON/OFF** menu item in the "[Tracker Menu](#)" topic for information.
- **Enable Stable Probing** - Enables stable probing. See the **Stable Probing ON/OFF** menu item in the "[Tracker Menu](#)" topic for information.
- **Go Birdbath** - See the **Go BirdBath** menu item in the "[Tracker Menu](#)" topic for information.
- **Initialize** - See the **Initialize** menu item in the "[Tracker Menu](#)" topic for information.
- **Level to Gravity** - See the **Initialize** menu item in the "[Nivel Commands](#)" topic for information.
- **Live Image** - Shows the laser cursor whether or not you are scanning.
- **Motors Off** - See the **Release Motors** menu item in the "[Tracker Menu](#)" topic for information.
- **Reset Nivel** - Makes a new reference measurement.
- **TScan** - Select this option when using the laser scanner for the tracker.
- **Zero Pos (6DoF)** - See the **Go 6DoF 0 Position** menu item in the "[Tracker Menu](#)" topic for information.



TCU Options are more readily available from the **Tracker** toolbar and menu.

IP Address - Specify the IP address of your Laser Tracker controller (the default is 192.168.0.1).

Vector Distance - Defines the distance that you need to move the T-Probe/Reflector from hit location before a "Pulled Hit" is taken.



Example that shows vector distance and movement

"Pulled Hit" - Changes the vector to that of the line between the location where you first depress the hit button (at the "Normal Hit" location) to the location where you release the hit button. This line must be longer than the **Use Vector Distance** to successfully register a "Pulled Hit".

"Normal Hit" - A "Normal Hit" is taken when you press and release the hit button in the same location.

Choose one of these vector options:

- **Use Vector Distance** - Allows you to establish the vector using a "Pulled Hit".
- **Use Last IJK** - Uses the same IJK vector values of the last measured point.
- **No vector** - Produces scan data when you press and hold a button on the T-Probe.

Measurement Time - This determines the time interval in milliseconds (ms). In the time interval, the data stream of measurements of the IFM is averaged to a single measurement value. A value of 500 means 500 measurements in 500 ms.

The data stream of measurements of the IFM is averaged, in this time interval, to a single measurement value. 500 ms = 500 measurements in 500 ms. This results in an XYZ coordinate with an RMS quality indication which is available on the DRO.



Measurement Time supports a value between 500 ms and 100000 ms (.5 to 100 seconds).

Reset tab

Machine Options

Environmental Parameters | Level To Gravity | System Information | Debug

Options | **Reset** | Sensor Configuration

MountPoint

Home

☒ Machine
☐ Part coord.

Aim

Add Delete

X 0 Y 0 Z 0

☐ Safety Position
☐ Go Birdbath
☒ Keep Last Position
☐ Go Point

Set Default Reset

Delay before positioning 5

Default Reset:

OK Cancel Apply Help

Machine Options dialog box - Reset tab

Home - Aims the laser to the BirdBath position.

Machine or **Part coord.** option - Select **Machine** if you are using machine coordinates, or **Part coord.** if you are using part coordinates.

Aim - Select a point from the Reset Point list, and click the **Aim** button to move the laser to the specified point.

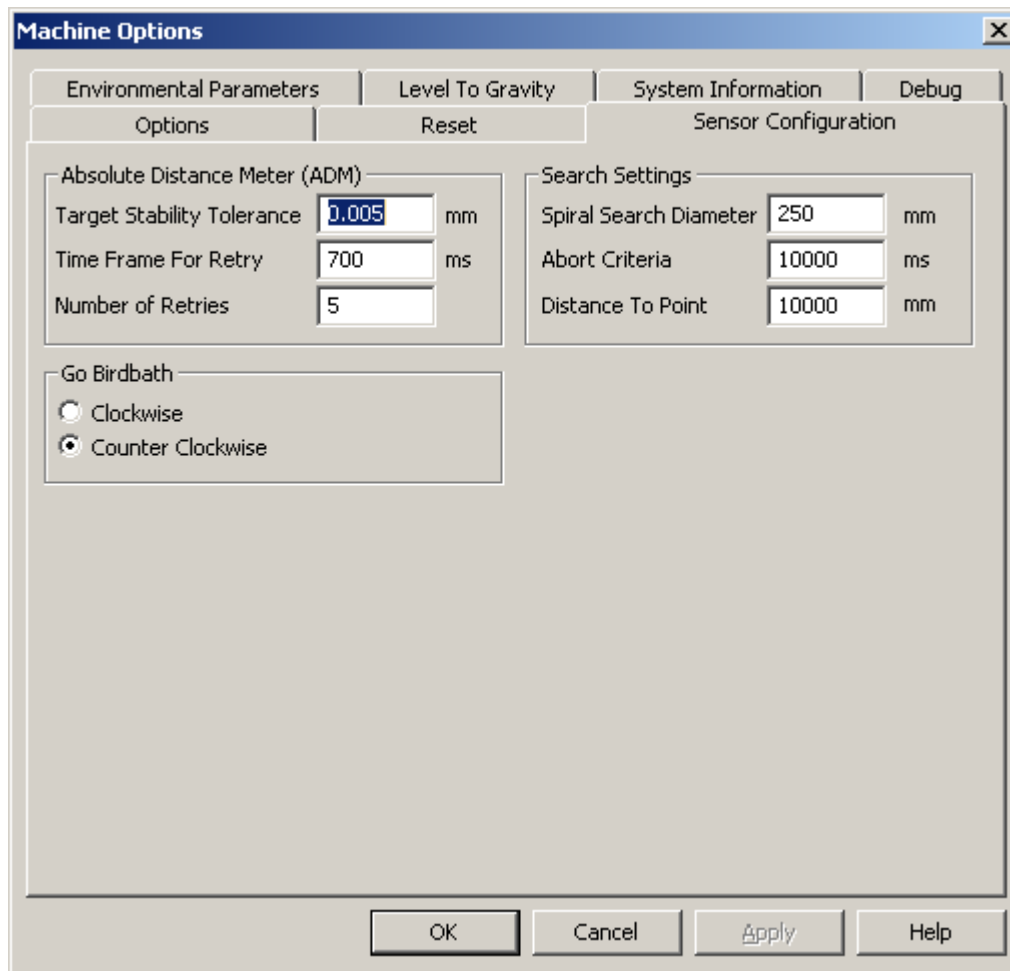
Add - Click the button to open the **Point** dialog box. Provide a **Title** and the **XYZ** values, and click **Create**. The new point is added to the Reset Point list above. For example, you might have attached reflectors to positions on a car door. You could then name these positions Door1, Door2, Door3, etc.

Delete - Select a point from the Reset Point list, and click **Delete**. The selected point is deleted.

Reset options - In case of a laser beam broken event, the following is done:

- **Safety Position** - The tracker points to the safe position, which is also called the park position.
- **Go Birdbath** - The tracker goes back to the birdbath position.
- **Keep Last Position** - The laser beam stays at its current positions and locks on accordingly, if possible.
- **Go Point** - Points to the Default Reset point.
- **Set Default Reset** - Select a point from the list above (to the left of the **Home** button), and click **Set Default Reset**. This is now the **Default Reset**. If the beam is broken with your reflector, the laser will point to the defined **Default Reset**.
- **Delay Before Positioning** - Provides the time in milliseconds before the laser tracker points to the next position.

Sensor Configuration tab



Machine Options dialog box - Sensor Configuration tab

Absolute Distance Meter (ADM)

- **Target Stability Tolerance** - This tolerance (between 0.005 and 0.1 mm) determines the maximum range of movement of a reflector target during ADM measurements. Values beyond this range will show an error message.
- **Time Frame For Retry** - Sets the period of time for determining target stability. If the target is stable, an ADM measurement is taken.
- **Number of Retries** - Sets the number of attempts for an ADM measurement before aborting, because the stability of the target has exceeded the given tolerance.

Search Settings - If any of these search criteria are not met, then the search process aborts.

- **Spiral Search Diameter** - Diameter in which to search for the target.

- **Abort Criteria** - Time in which the target should be found.
- **Distance To Point** - Distance at which to search for the target.

Go Birdbath - The Leica Tracker will rotate to the Birdbath position in the **Clockwise** or **Counter Clockwise** direction from its current position.

Environmental Parameters tab

Machine Options

Options Reset Sensor Configuration

Environmental Parameters Level To Gravity System Information Debug

Atmospheric Conditions

☐ Use Temperature Station

Air Temperature: C

Pressure: mBar

Humidity: %

Refraction Index

IFM	0.000000
ADM	0.000000

OK Cancel Apply Help

Machine Options dialog box - Environmental Parameters tab

Atmospheric Conditions

- **Use Temperature Station** - Determines whether the Leica Meteo Station is used. A Meteo Station collects data automatically and requires no manual interaction.

If no Meteo Station is connected, make sure that the correct values are entered manually.

This is also possible from the [Tracker Status bar](#).

- **Air Temperature** - Specifies the current temperature of the working environment in either Fahrenheit (**F**) or Celsius (**C**).
- **Pressure** - Specifies the air pressure of your working environment in terms of **mBar**, **HPascal**, **MmHg**, or **InHg**.
- **Humidity** - Specifies the percentage of humidity of your working environment.

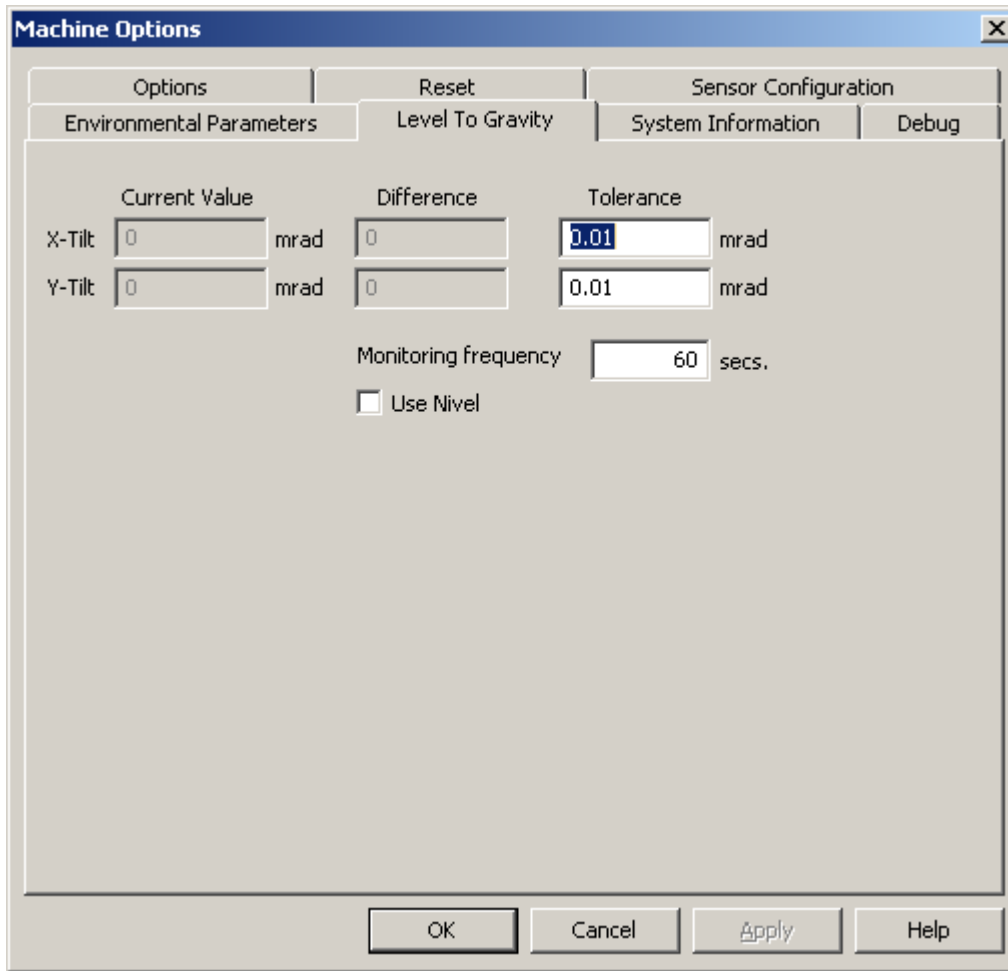


These Meteo parameters have a direct influence on the distance measurement. A change of 1 °C causes a measurement difference of 1 ppm. A change of 3.5 mbar causes a measurement difference of 1 ppm.

Refraction Index

- **IFM** - Displays the Interferometer refraction value.
- **ADM** - Displays the Absolute Distance Meter refraction value.

Level To Gravity tab



Machine Options dialog box - Level To Gravity tab

The **Level To Gravity** tab allows you to set up monitoring properties of the Nivel inclination device.

Current Value - Displays the current X-tilt and Y-tilt level values for the Nivel.

Difference - Displays the difference in milliradians between the actual reading of the current X-tilt and Y-tilt values from the current value.

Tolerance - Specifies the angle in milliradians that the Nivel level can change and still be considered in tolerance. Otherwise, you need to use the **Reset Nivel** option on the [Options tab](#).

Monitoring frequency - Defines how often (in seconds) a Nivel monitoring value is read.

Use Nivel - Defines whether a Nivel is used. This toggles the visibility of the [Nivel commands](#) and toolbars.

Faro Arm Interface

The Faro interface is used with a Faro arm machine. Software for your Faro arm is available on the Wilcox FTP server (<ftp://ftp.wilcoxassoc.com/Hardware/Portable/Faro/>).

Before you start PC-DMIS, rename the faro.dll file to interfac.dll.

The **Machine Options** dialog box (**Edit | Preferences | Machine Interface Setup**) has these tabs for the Faro interface:

Comm tab

For information, see the "Setting the Communication Protocol" topic in the "Setting Your Preferences" chapter in the PC-DMIS Core documentation. The default value is Comm Port **1**, **38400** Baud, **No** parity, **7** data bits, and **1** stop bit.

Axis tab

For information, see the "Assigning the Machine Axes" topic in the "Setting Your Preferences" chapter in the PC-DMIS Core documentation.

Debug tab

For information, see the "Generating a Debug File" topic in the "Setting Your Preferences" chapter in the PC-DMIS Core documentation.

Machine as Mouse tab

For information, see the "[Machine as Mouse Settings](#)" topic.

Tools tab

This tab provides a **Diagnostics** button and a **Hardware Config.** button. These buttons launch programs from Faro to test and configure your Faro arm.



The Machine Interface Installation Manual (MIIM) provides additional information for this interface.

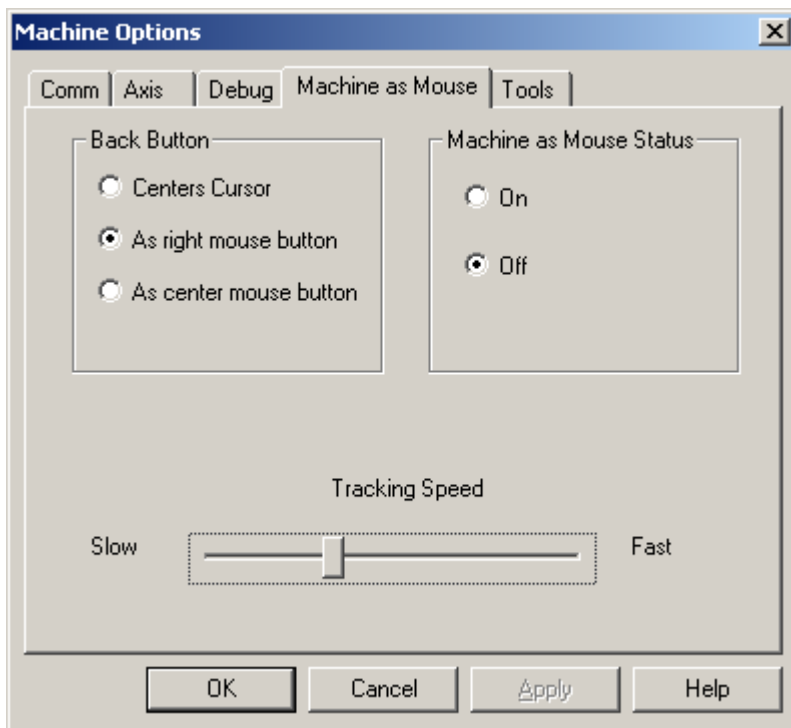
You can access the MIIM.chm help file in the **en** subfolder where PC-DMIS is installed.

Faro Pulled Hits Feature

The Faro interface supports pulled hits. See "[Pulled Hits Method](#)" in the "[Probe Compensation](#)" chapter.

See "[Appendix A: Faro Portable Arm](#)"

Machine as Mouse Settings



Machine Options dialog box - Machine as Mouse tab

The **Machine as Mouse** tab allows you to configure the capabilities of the Faro arm movement and button clicks to control the pointer movement and mouse button clicks.

Back button - You can set the **Back** button of the Faro arm:

- To center the cursor (moves the mouse pointer the center of the screen)
- As right mouse button
- As center mouse button

Machine as Mouse Status - Select whether Machine as Mouse mode is **On** or **Off**.

Tracking Speed - Controls how quickly the mouse moves relative to the Faro arm movement.

Enabling and Disabling Mouse Mode

- To enable mouse mode, press the front and back buttons together.
- To disable mouse mode, when the PC-DMIS screen is maximized (note that the window **MUST** be maximized), move the mouse cursor to the very top of the title bar (which is also the very top of the screen because PC-DMIS is maximized), and then click the button that simulates the left mouse button.

SMX Tracker Interface

You can configure the parameters that control how PC-DMIS interfaces with the Faro SMX Laser interface by selecting the **Edit | Preferences | Machine Interface Setup** menu item. This opens the **Machine Options** dialog box. The following tabs are available:

- [Options tab](#)
- [Reset tab](#)
- [Aiming tab](#)
- **Debug** tab: See the "Generating a Debug File" topic in the "Setting Your Preferences" chapter in the PC-DMIS Core documentation.



The Machine Interface Installation Manual (MIIM) provides additional information for this interface.

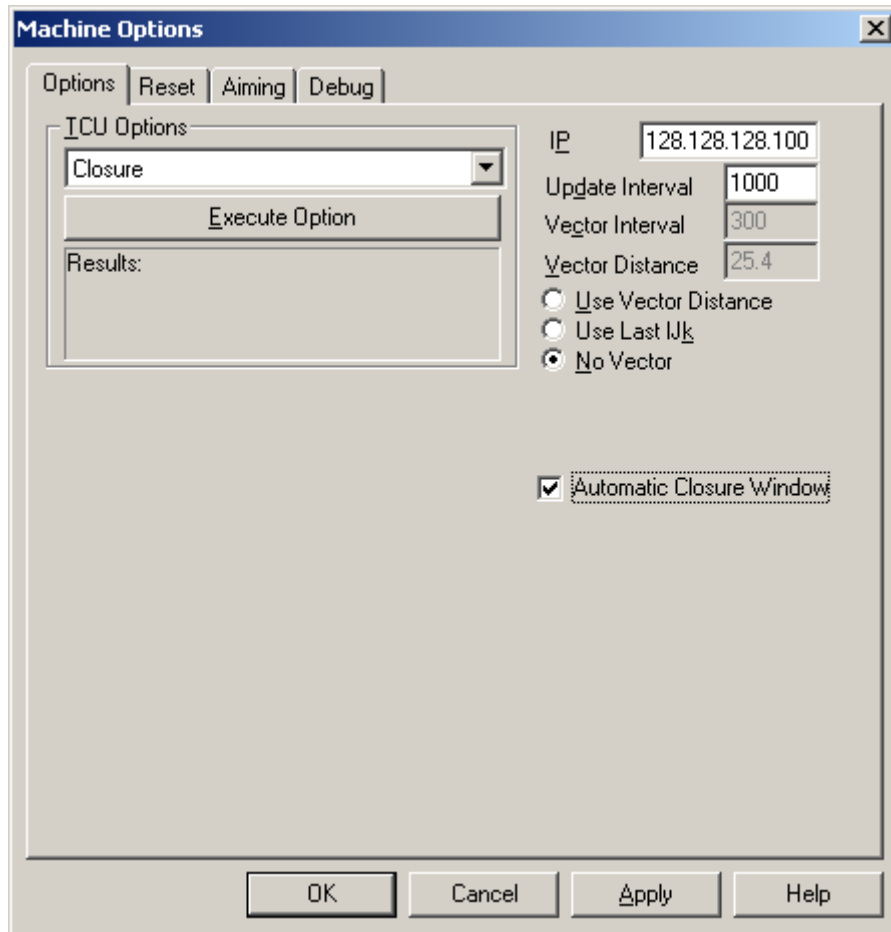
You can access the MIIM.chm help file in the **en** subfolder where PC-DMIS is installed.

Also review the documentation that came with your SMX Tracker.

Files used with the SMX Tracker are located here:

<ftp://ftp.wilcoxassoc.com/Hardware/Portable/Faro-SMXLaser/>

SMX Options tab



Machine Options dialog box - Options tab

The **Options** tab provides the means to execute various TCU (Tracker Control Unit) Options and configure communication and other parameters. TCU options are also available as menu items.

TCU Options - This area allows you to execute the following options:

- **Closure** - Opens the Closure window. See the "[Using the Closure Window](#)" topic.
- **Home** - Point your laser tracker to the home position.
- **Log Off** - Logs off the SMX Tracker.
- **Log On** - Logs on to the SMX Tracker.
- **Motors On** - Engages the horizontal and vertical tracker head motors in order to allow manual tracker head movement.

- **Motors Off** - Releases the horizontal and vertical tracker head motors in order to stop manual tracker head movement.
- **Operational Checks** - See "[Performing Operational Checks](#)".
- **TrackerPad** - Displays the **TrackerPad** dialog box to setup the Faro Laser Tracker. For details, see your Faro Tracker documentation.



- **Wake Up** - Allows you to set a time to turn the laser on.



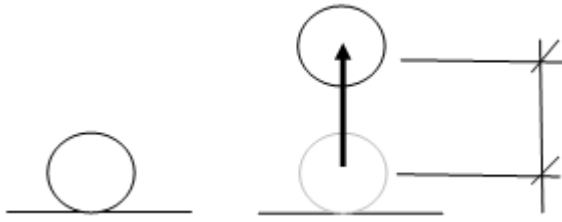
TCU Options are more readily available from the **Tracker** toolbar and menu.

IP Address - Specifies the IP address of your Laser Tracker controller (default 128.128.128.100).

Update Interval - Specifies the time in milliseconds the system checks the levels and makes any updates.

Vector Interval -

Vector Distance - This defines the distance that you need to move the T-Probe/Reflector from the hit location before the software takes a "Pulled Hit".



Example showing vector distance and movement

"Pulled Hit" - Changes the vector to that of the line between the location where you first depress the hit button (at the "Normal Hit" location) to the location where you release the hit button. This line must be longer than the **Use Vector Distance** to successfully register a "Pulled Hit".

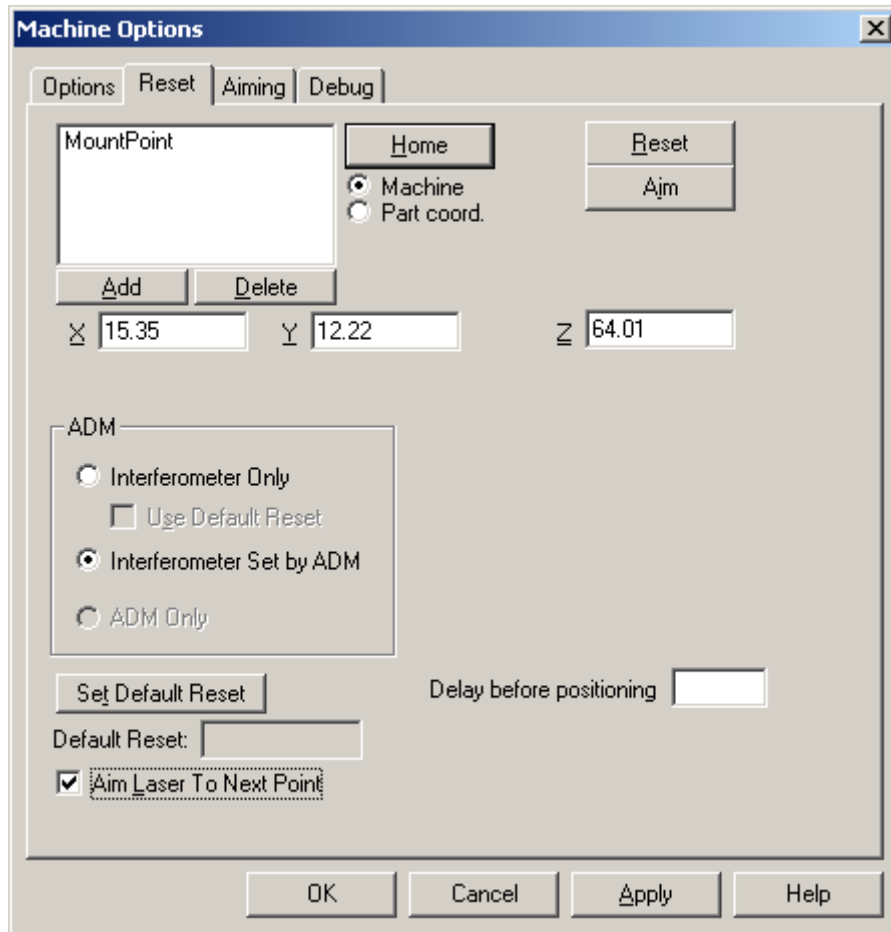
"Normal Hit" - A "Normal Hit" is taken when you press and release the hit button in the same location.

Vector Option - Choose one of these vector options:

- **Use Vector Distance** - Allows you to establish the vector using a "Pulled Hit".
- **Use Last IJK** - Uses the same IJK vector values of the last measured point.
- **No vector** - When this option is selected, you are able to produce scan data when you press and hold a button on the T-Probe.

Automatic Closure Window check box - When this check box is selected, the Closure window automatically opens when the reflector is very close to the home position (the nest).

SMX Reset tab



Machine Options dialog box - Reset tab

Home - Aims the laser to the BirdBath position.

Machine or **Part coord.** - Defines the coordinate system to use. Select **Machine** if you are using machine coordinates or **Part coord.** if you are using part coordinates.

Aim - Aims the laser to a point. Select a point from the **Reset Point** list, and click the **Aim** button to move the laser to the specified point.

Add - Opens the **Point** dialog box to add a point to the list above. From the **Point** dialog box, provide a **Title** and the **XYZ** values, and click **Create**. The new point is added to the list. For example, you might have attached reflectors to positions on a car door. You could then name these positions Door1, Door2, Door3, etc.

Delete - Removes a selected point from the list above.

ADM

Interferometer Only - Uses the interferometer laser for distance measurements. When starting or re-starting a measurement, it is typically initialized from the BirdBath.

Use Default Reset - Moves the Laser Tracker to the current Reset Point position.

Interferometer Set by ADM - Uses the interferometer laser for distance measurements. If the target gets lost by the Laser Tracker, the ADM laser find it. Once the ADM laser locates and sets the distance to the target, the interferometer laser calculates all distance measurements.

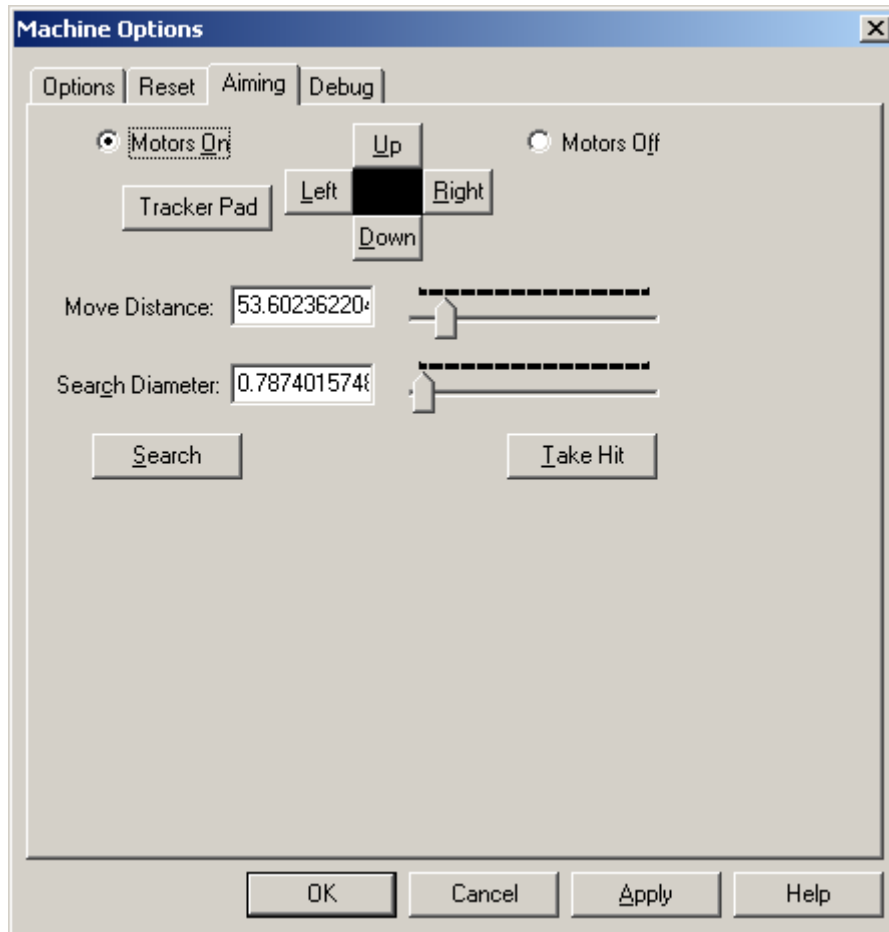
ADM Only - The software calculates all distance measurements with the ADM laser. If the target gets lost by the Laser Tracker, the ADM laser finds it.

Set Default Reset - Defines the selected point from the list as the default reset point. This is the point the laser points to if the beam is broken with your reflector.

Delay before positioning - Defines the time in milliseconds before the laser tracker points to the next position.

Aim Laser To Next Point - The laser tracker moves to the next point after completion of the previous point.

SMX Aiming tab



Machine Options dialog box - Aiming tab

Motors On - Engages the horizontal and vertical tracker head motors in order to allow manual tracker head movement.

Motors Off - Releases the horizontal and vertical tracker head motors in order to stop manual tracker head movement.

Tracker Pad -

Control buttons (Left, Up, Right, Down) - Moves the laser in the respective direction. When you click a control button once, the tracker slowly begins to move until you click **Stop**. Each successive click causes the tracker to move more quickly in that direction. The black box in the middle of these buttons flashes with a green indicator when the reflector settles.

Move Distance - Provides the approximate distance at which the laser will search for the reflector when you click **Search**. Moving the associated slider to the right increases the **Move Distance** value, and moving it to the left decreases the value.

Search Diameter - Provides the diameter for the search area at the approximate **Move Distance** when you click **Search**. Moving the associated slider to the right increases the **Search Diameter** value, and moving it to the left decreases the value.

Take Hit - Measures a stationary hit (same as Ctrl+H) at the current location of the reflector.

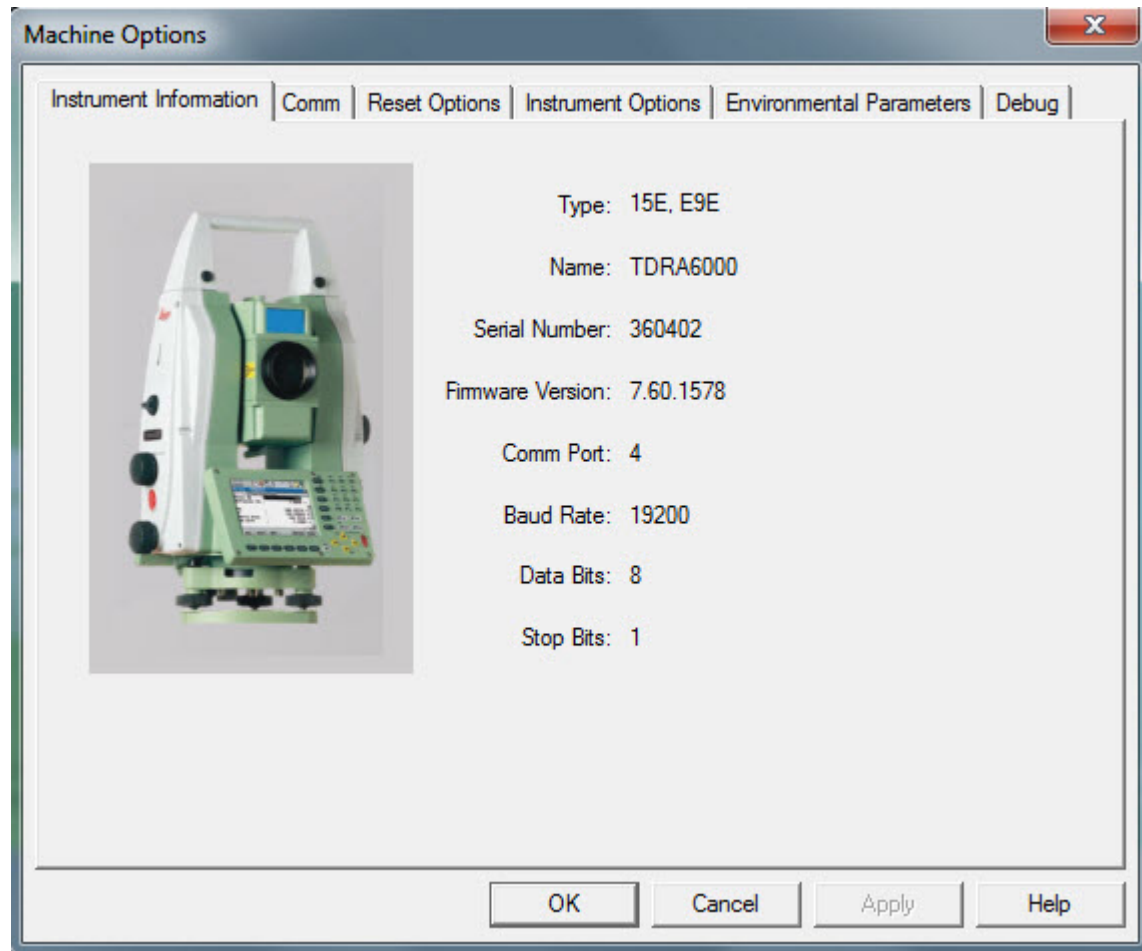
Total Station Interface

To configure the parameters that control how PC-DMIS interfaces with the Total Station interface, select the **Edit | Preferences | Machine Interface Setup** menu item. This opens the **Machine Options** dialog box. The following tabs are available:

- [Instrument Information tab](#)
- [Comm tab](#)
- [Reset Options tab](#)
- [Instrument Options tab](#)
- [Environmental Parameters tab](#)
- [Debug tab](#)

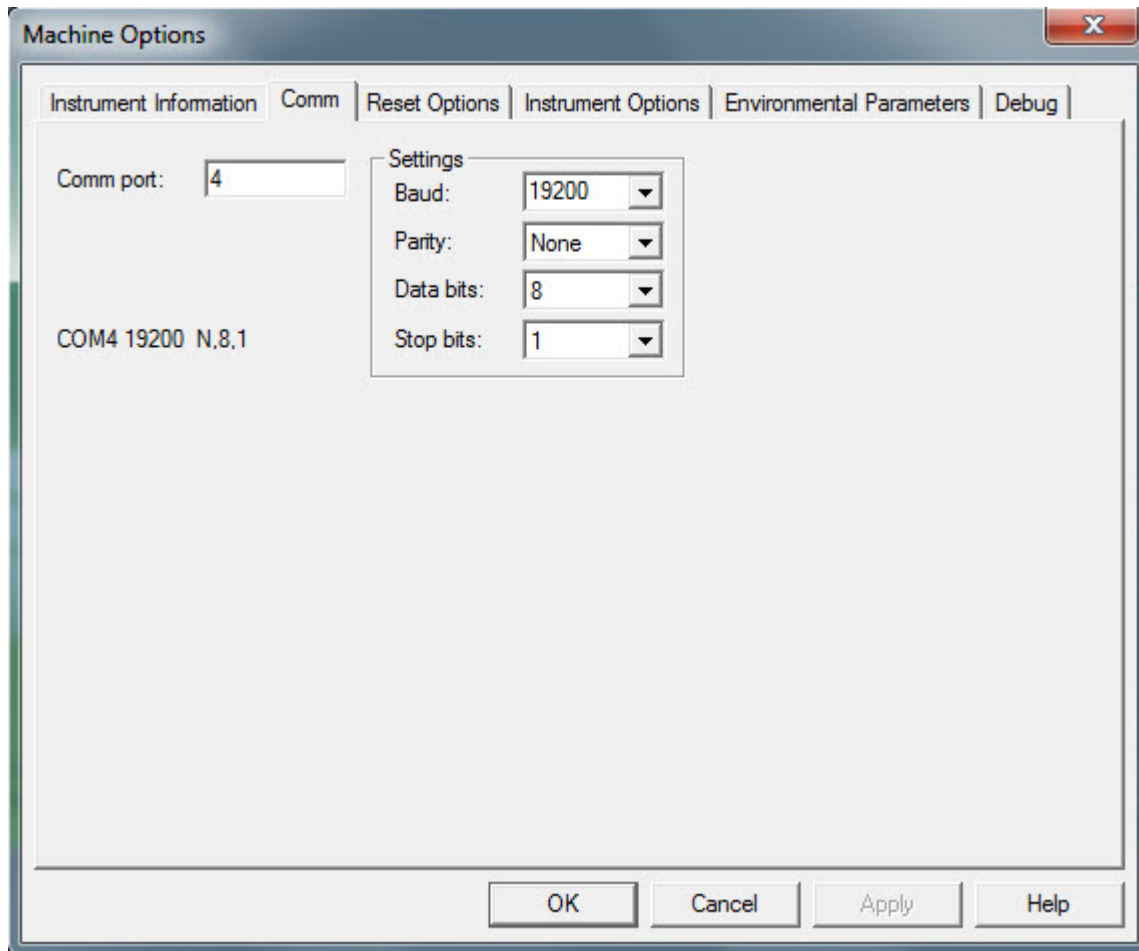
Please refer to the your machine interface documentation for details.

Instrument Information tab



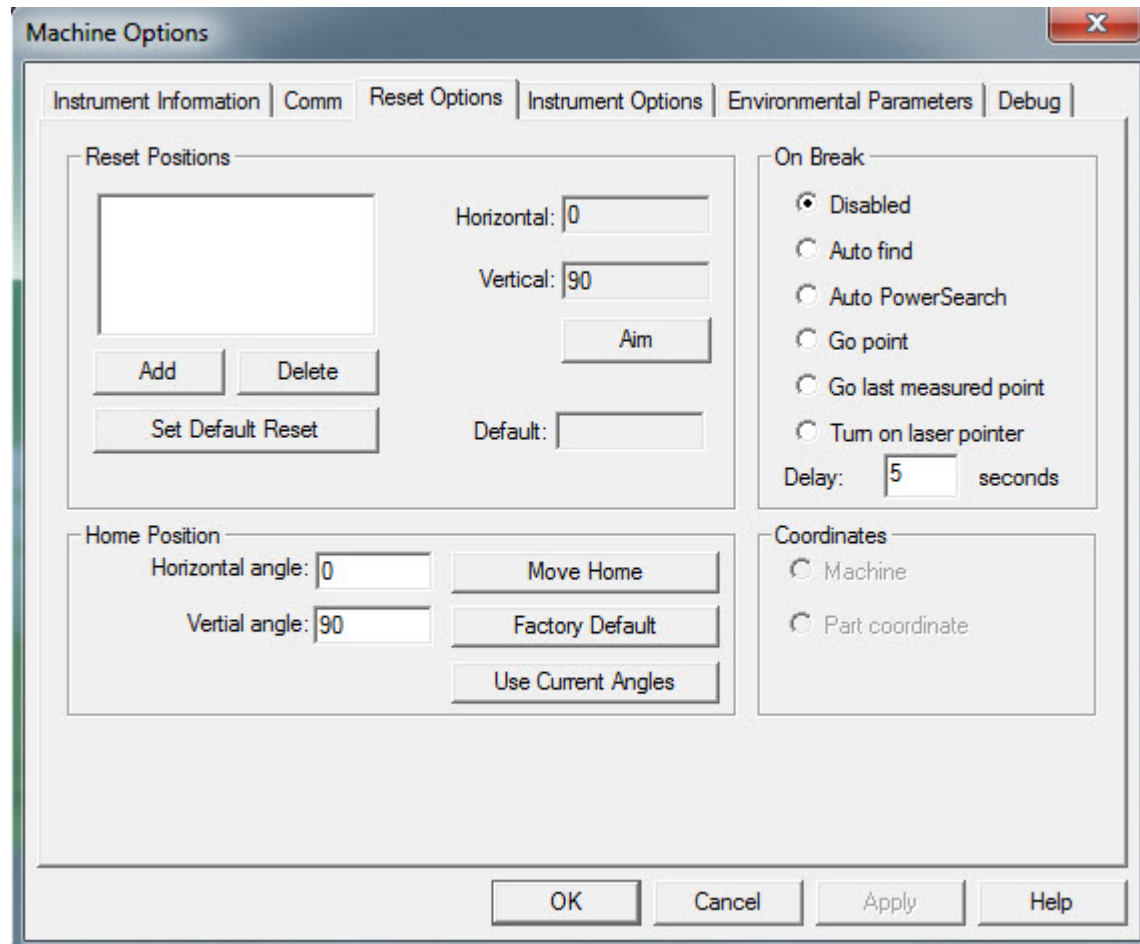
Measurement Options dialog box - Instrument Information tab

Comm tab



Measurement Options dialog box - Comm tab

Reset Options tab



Measurement Options dialog box - Reset Options tab

On Break

This area lets you determine what happens when the laser beam from the Total Station to the probe is broken.

- **Turn on laser pointer** - This option turns on the laser pointer. See the **Laser Pointer ON/OFF** menu item discussed in the "[Total Station Menu](#)" topic for more information on the laser pointer.

Instrument Options tab

The screenshot shows the 'Machine Options' dialog box with the 'Instrument Options' tab selected. The dialog has a title bar with a close button (X). The tabs are: Instrument Information, Comm, Reset Options, Instrument Options (selected), Environmental Parameters, and Debug.

Power Search window

Active Params
Center Hz: 268.46444500, Vt: 104.27867776
Range Hz: 30.00000000, Vt: 30.00000000

Update Window

Range Hz: 30 deg
Range Vt: 30 deg

Search settings

Spiral search diameter: 500 mm
Abort criteria: 5 seconds
Distance to point: 5 meters

Measurement Settings

EDM Mode
☒ Precise
☐ Standard
☐ Fast

Average Mode
Number of measurements: 5

2 Face Mode
☐ Force system back to Face 1 after measurement
☐ Measure distance only in Face 2

ID Creation
☐ From instrument
☒ From software

OK Cancel Apply Help

Measurement Options dialog box - Instrument Options tab

Environmental Parameters tab

The screenshot shows the 'Machine Options' dialog box with the 'Environmental Parameters' tab selected. The dialog has a title bar with a close button (X). The tabs are: Instrument Information, Comm, Reset Options, Instrument Options, Environmental Parameters, and Debug. The 'Environmental Parameters' tab contains two sections: 'Atmospheric conditions' and 'Refraction index'. In the 'Atmospheric conditions' section, there is a checkbox for 'Use temperature station' which is unchecked. To its right are input fields for 'Air temperature' (20.00) and a unit dropdown (C). Below these are 'Serial Port' (1), 'Update Interval' (300 seconds), 'Pressure' (1013 mBar), and 'Humidity' (20 %). There is an 'Update Temperature' button. The 'Refraction index' section shows 'Atmospheric PPM' as 7.7390513420105. At the bottom of the dialog are buttons for OK, Cancel, Apply, and Help.

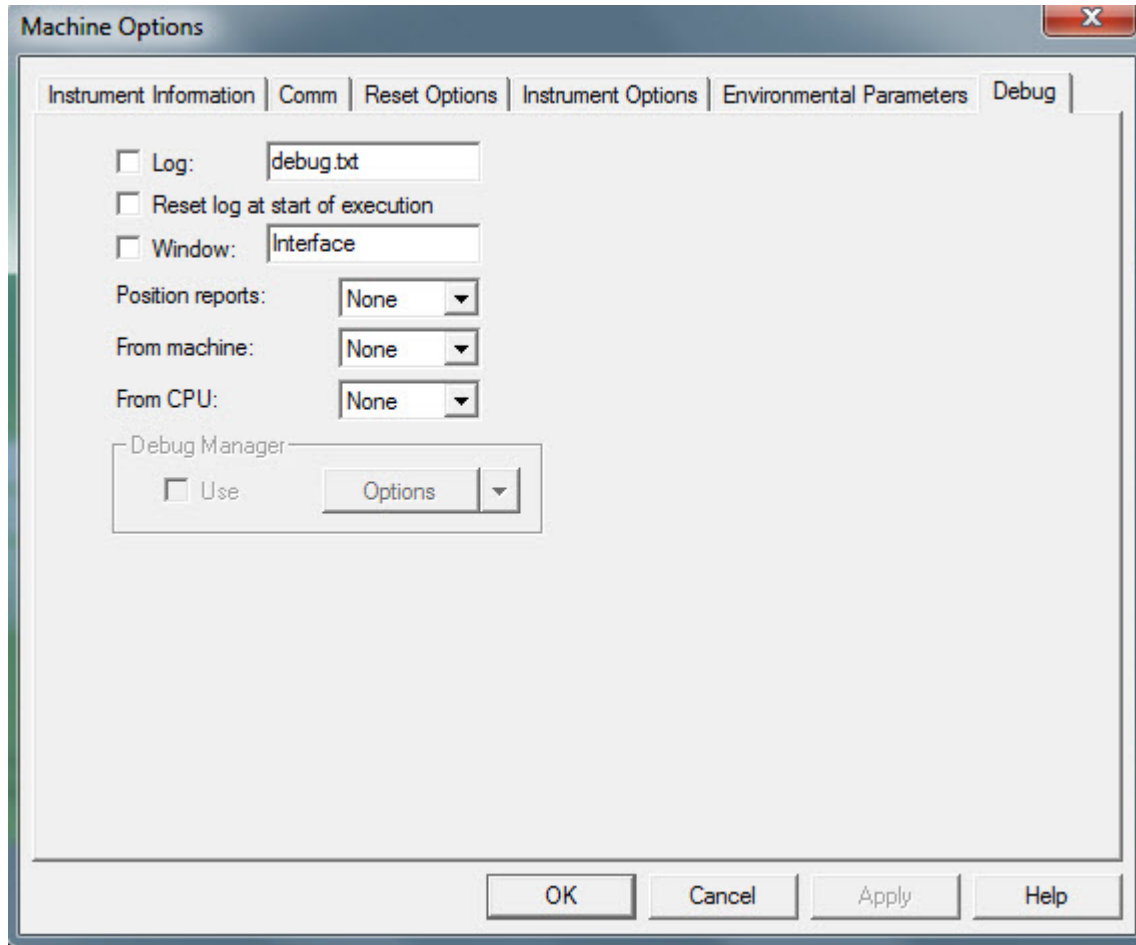
Atmospheric conditions	
<input type="checkbox"/> Use temperature station	Air temperature: 20.00 C
Serial Port: 1	Pressure: 1013 mBar
Update Interval: 300 seconds	Humidity: 20 %
Update Temperature	

Refraction index	
Atmospheric PPM:	7.7390513420105

OK Cancel Apply Help

Measurement Options dialog box - Environmental Parameters tab

Debug tab



Measurement Options dialog box - Debug tab

For information, see the "Generating a Debug File" topic in the "Setting Your Preferences" chapter in the PC-DMIS Core documentation.

Common Portable Functionality

Some PC-DMIS Portable capabilities are common among portable devices. This chapter provides information about this basic functionality. Common elements include:

- [Importing Nominal Data](#)
- [Probe Compensation](#)
- [Using Hard Probes](#)

- [Probe Trigger Options](#)
- [Converting Hits to Points](#)
- [Edge Point Mode](#)

Importing Nominal Data

PC-DMIS allows you to import nominal data of various types for the extraction of feature nominals.

Import the following CAD data types:

- **Standard Formats:** DXF, IGES, STEP, STL, VDAFS, XYZ
- **Optional:** Catia 4, Catia 5, Parasolid, Pro-engineer, NX
- **Direct CAD (DCI):** ACIS, CATIA V5, Pro-engineer, Solidworks, NX

For information on importing, see the "Importing CAD Data or Feature Data" topic in the "Using Advanced File Options" chapter in the PC-DMIS Core documentation.

If you have Inspection Planner programmed on your portlock, you may also use the Generic Parser to import ASCII files. For more information, see "Importing an ASCII File" in the "Using Advanced File Options" chapter in the PC-DMIS Core documentation.

Probe Compensation

To accurately measure hits, points are compensated from the center of the probe tip to the part surface. To turn probe compensation on or off, use the **Insert | Parameter Change | Probe | Probe Compensation** menu item.

There are a couple of things that you should understand when you measure with a portable device.

- The XYZ values of the DRO (Digital Readout) are the 3D location of the CENTER of the probe.
- When probing a single point on a part, PC-DMIS compensates for the probe radius by doing using one of two methods:
 - [Probe Shaft](#): Monitoring the angle of the probe shaft and compensating along the vector of the shaft to the point location on the surface.

- [Pulled Hit](#): Monitoring the direction of a "pulled hit" and compensating along the direction vector between where the hit button was pressed and subsequently released.

Normally, when measuring with portable CMMs with a hard probe, the probe's shank vector is used as the hit vector. However, due to the shape of a particular part, you may not be able to position the probe's shank to get a proper hit vector.

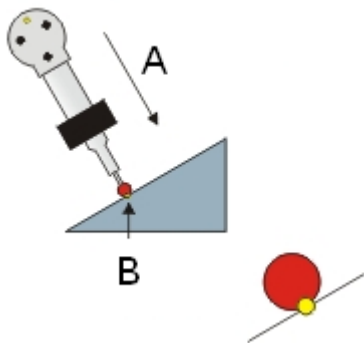


If you want to measure a small, deep hole, but the end of the arm is too large to fit into that hole, you need to take "pulled hits" to get each hit vector to properly point towards the center of the hole, thereby determining the proper in/out compensation. Pulled hits are hits whose vectors match the direction pulled away from the hit location, not the default shank vector of the probe.

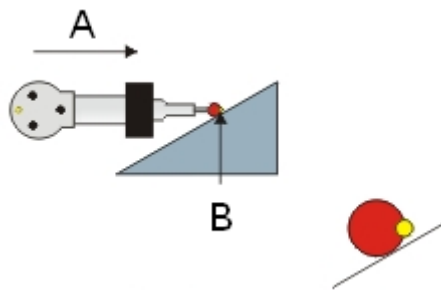
Probe Shaft Method

For a portable arm device, you would follow this procedure to measure a point on a top surface using the probe shaft for probe compensation:

1. Place the probe on the top surface with the probe shaft straight up (perpendicular to the surface) from the point location (B). The point will be compensated in the direction (A) of the probe shaft.



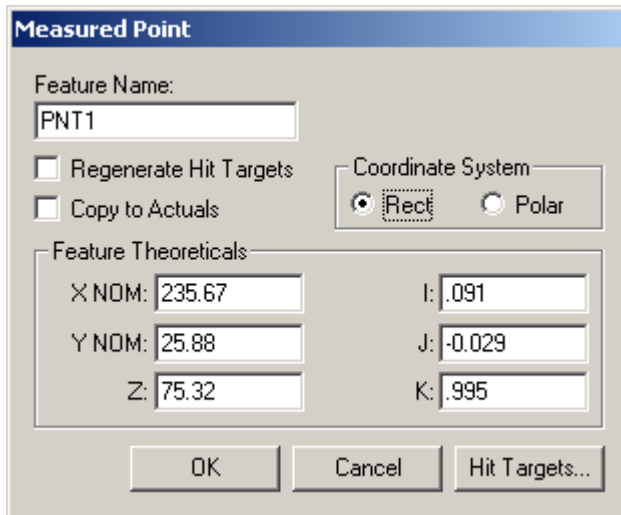
Correct Position



Incorrect Position

2. Press the **Hit** button.
3. Press the **Done** button. Notice that the measured point has been added to the Edit window.

- With the point high-lighted, press F9 to open the **Measured Point** dialog box.



Measured Point Example showing hit vector pointing up

- Notice that the IJK values in the example are generally pointing up (0,0,1). These values should generally coincide with the surface vector at the point's location.

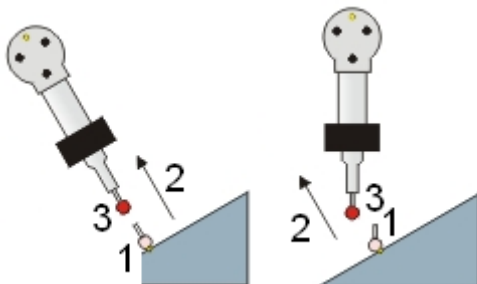


When you probe single points, be sure hold the probe normal to (perpendicular to) the surface.

Pulled Hits Method

For a portable arm device, follow this procedure to measure a point using a "pulled hit" for probe compensation:

- Place the probe on the surface at the point location (1). The probe shaft vector does not matter when you perform a pulled hit.



Either example will work for pulled hits

2. Press and hold the hit button long enough to get a pulled hit, but not so long that PC-DMIS starts scanning the part. To change the length of time to distinguish between “pulled hit” or “start scanning”, you can modify the `DelayToStartSendingScanPointsToManualHit` registry entry in PC-DMIS Settings Editor.
3. Move the tip in the direction of the vector (2) you want to send to PC-DMIS, away from the hit location. You must move it a distance equal to or greater than the defined vector distance (3). To define the minimum distance from the hit that you must move the probe for a pulled hit to be accepted, you can modify the `VectorToIMM` registry entry in PC-DMIS Settings Editor.
4. Release the button. You hear a different lower audible tone. Notice that the measured point has been added to the Edit window.
5. With the point highlighted, press F9 to open the **Measured Point** dialog box. Verify that the vector is following the PULL direction not the shaft direction.



For Auto Features, the last hit vector determines the compensation direction. For Measured Features, the first hit vector determines the compensation direction.

Supported Interfaces

The following interfaces support pulled hits:

- [Faro Interface](#)
- [Romer](#)
- [SMXLaser](#) (Faro tracker)
- [Leica](#)

Using Hard Probes

PC-DMIS Portable supports a variety of hard probes. The use and calibration of hard probes is similar to that of TTP probes.

If you selected a hard probe, PC-DMIS expects a probe that does not automatically trigger when it comes in contact with the part. DCC calibration cannot be done using a hard probe. Verify that you have selected the correct probe type.



When you measure with an arm machine, it is recommended to hold it such that the probe is between your fingers with the buttons accessible with your thumb.

When you measure geometric features (lines, circles, planes, and other features) the probe radius is compensated based on the resolved feature itself rather than the individually compensated points.



Suppose you measure a plane. You do not need to measure the individual hit points that comprise the plane feature with the probe shaft perpendicular to the surface of the feature.



PC-DMIS Portable monitors the probe shaft of the FIRST HIT when you measure a circle, cone, or cylinder to determine if you are measuring the inside diameter (ID) or the outside diameter (OD).



In most cases, you cannot physically orient the probe exactly normal to the surface of an ID circle without interference from the other side of the circle feature. The probe should be tipped as much as possible toward the center of the circle to register an inside diameter circle and away from the center to register an outside diameter circle.

After measurement of an ID or OD circle, you can verify that PC-DMIS has correctly determined the circle type by pressing F9 on the highlight feature in the Edit window. Check the **Circular Feature Type** option.

Probe Trigger Options

Probe trigger options allows you to trigger a hit when certain conditions are met while you use manual CMM machines.

The interfaces that support probe trigger options include Romer, Leica, Faro, Garda, and SMX Laser.

You can insert POINT AUTOTRIGGER, PLANE AUTOTRIGGER, and POINT MANUAL TRIGGER commands into your measurement routine from the **Probe Trigger Options** tab in the **Parameters** dialog box (**Edit | Preferences | Parameters** or F10) or from the **Probe Mode** toolbar.

These trigger commands function with the following features:

- Auto Features: Circle, Ellipse, Edge Point, Round Slot, Square Slot, Notch Slot, and Polygon
- Measured Features: Circle, Line, and Round Slot

The probe trigger options are:


- [Point AutoTrigger](#)
- [Plane AutoTrigger](#)
- [Point Manual Trigger](#)

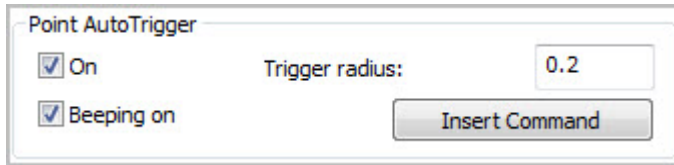
Point AutoTrigger

The **POINT AUTOTRIGGER** command tells PC-DMIS to automatically take a hit when the probe enters a tolerance zone at a specified distance from the original hit location. For example, if the tolerance zone, the Radius value, is set to 2 mm, a hit is taken when the probe is within 2 mm of the hit location.

You can use this option with manual machines; instead of pressing a button to take a hit, you can place **POINT AUTOTRIGGER** commands at any standard location in the Edit window.

You can add a **POINT AUTOTRIGGER** command from the **Insert Command** button on the **Point AutoTrigger** area of the **Probe Trigger Options** tab on the **Parameter Settings** dialog box (press F10 to access this dialog box). You can also do this with the **Point Auto Trigger**

Mode button () from the **Probe Mode** toolbar.



Point AutoTrigger area on the Probe Trigger Options tab



In addition to the standard supported features (as noted in the "[Probe Trigger Options](#)" topic), the **AUTOTRIGGER** command supports the Auto Vector Point feature and the Measured Point feature.

On: Selecting this check box activates the **POINT AUTOTRIGGER** command. Commands in the Edit window that follow the inserted **POINT AUTOTRIGGER** command will use the point auto trigger functionality as defined.

If you do not select this check box, and you click the **Insert Command** button, PC-DMIS inserts the command line into the Edit window but doesn't activate the command.

Beeping on: Selecting this check box activates a beeping sound associated with your **POINT AUTOTRIGGER** command. As you approach the target with the probe, the beeps become more frequent.

Trigger radius: This box allows you to type a tolerance zone value. When the probe moves into this tolerance zone, it automatically and immediately takes a hit.

Insert Command: Clicking the **Insert Command** button inserts the **POINT AUTOTRIGGER** command into the Edit window for the current measurement routine.

This command line reads:

```
POINT AUTOTRIGGER/ TOG1, TOG2, RAD
```

TOG1: This toggle field corresponds to the Point AutoTrigger **On** check box. It displays either ON or OFF.

TOG2: This toggle field corresponds to the **Beeping On** check box. It displays either ON or OFF.


RAD: The radius field contains the value for the tolerance zone, and it corresponds to the **Trigger radius** box. This value is the distance from the actual point that PC-DMIS takes the hit.

Plane AutoTrigger

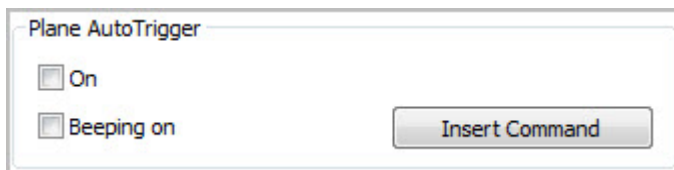
The **PLANE AUTOTRIGGER** command tells PC-DMIS to automatically take a hit when the probe passes the plane defined by the surface normal of a supported feature at the level of the defined depth. For auto features, this defined location is adjusted based on options such as sample hits or RMEAS features. As the probe center passes from one side of the plane to the other, the probe triggers and the hit is taken.

You can use this command with manual machines; instead of pressing a button to take a hit, you can place **PLANE AUTOTRIGGER** commands at any standard location within the Edit window.

You can add a **PLANE AUTOTRIGGER** command from the **Insert Command** button on the **Plane AutoTrigger** area of the **Probe Trigger Options** tab on the **Parameter Settings** dialog box (press F10 to access this dialog box). You can also do this with the **Plane Auto Trigger**

Mode button () from the **Probe Mode** toolbar.

This command only works in online mode. If you use the **AUTOTRIGGER** command, it takes precedence over the **PLANE AUTOTRIGGER** command.



Plane AutoTrigger area on the Probe Trigger Options tab



As defined above, PC-DMIS automatically takes a hit when the probe passes the plane. However, if you are using a Faro or Romer machine, the probe does not trigger again until you press the **Accept** button (or **Release** button). You must press this button after each registered hit to continue.

On: Selecting this check box activates the **PLANE AUTOTRIGGER** command. Commands in the Edit window that follow the inserted **PLANE AUTOTRIGGER** command use the plane auto trigger functionality as defined.

If you clear this check box, and you click the **Insert Command** button, PC-DMIS inserts the command line into the Edit window but doesn't activate the command. The **PLANE AUTOTRIGGER** command does not function until the option is turned on.

Beeping on: Selecting this check box activates a beeping sound associated with your [PLANE AUTOTRIGGER](#) command. As you approach the target with the probe, the beeps become more frequent.

Insert Command: Clicking the **Insert Command** button inserts the [PLANE AUTOTRIGGER](#) command into the Edit window for the current measurement routine.

This command line reads:

```
PLANE AUTOTRIGGER/ TOG1,TOG2
```

TOG1: This toggle field corresponds to the **On** check box. It displays either ON or OFF.

TOG2: This toggle field corresponds to the **Beeping On** check box. It displays either ON or OFF.

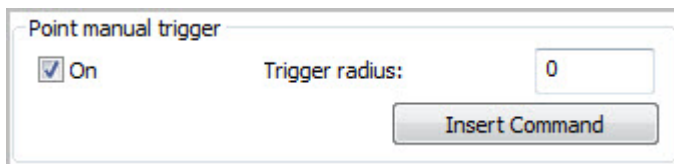
Point Manual Trigger

The [POINT MANUAL TRIGGER](#) command tells PC-DMIS to only accept a manual hit when it is within the specified tolerance zone.

You can add a [POINT MANUAL TRIGGER](#) command from the **Insert Command** button on the **Point Manual Trigger** area of the **Probe Trigger Options** tab on the **Parameter Settings** dialog box (press F10 to access this dialog box).

You can use this option with manual machines; when PC-DMIS prompts you to take a hit, trigger the probe as you wish. Each trigger is evaluated to see if it is within the cylindrical trigger tolerance zone. If it is not, an error appears in the **Machine Errors** list of the **Execution** dialog box. PC-DMIS then asks you to take the hit again. You can place [POINT MANUAL TRIGGER](#) commands at any standard location within the Edit window.

This option only works in online mode.



Point Manual Trigger area on the Probe Trigger Options tab

Use Trigger Tolerance: Selecting this check box activates the [POINT MANUAL TRIGGER](#) command. Commands in the Edit window that follow the inserted [POINT MANUAL TRIGGER](#) command use the point manual trigger functionality as defined.

If you do not select this check box, and you click the **Insert Command** button, PC-DMIS inserts the command line into the Edit window, but it doesn't activate the command. The trigger radius capability is disabled until the option is turned on.

Trigger radius: This box holds a tolerance radius value. When the probe is triggered, PC-DMIS checks to see if the probe is within this tolerance zone. If it is, the hit is accepted. If it is not, you are asked to take another hit.

Insert Command: Clicking the **Insert Command** button inserts the **POINT MANUAL TRIGGER** command into the Edit window for the current measurement routine with the following options.

This command line reads:

POINT MANUAL TRIGGER/ TOG1, RAD

TOG1: This toggle field corresponds to the **On** check box. It displays either ON or OFF.

RAD: The radius field contains the value for the tolerance zone, and it corresponds to the **Trigger Radius** box. This value is the distance from the actual point that PC-DMIS accepts the hit.


Converting Hits to Points

You can cause PC-DMIS to receive a stream of points from the interface. To do this, hold down the **Take Hit** button on your portable device. This lets you quickly scan over a surface and take several points in a very short amount of time.

Once PC-DMIS receives the stream of points, it can do one of two things with them:

- **Create Individual Point Features.** If you are in Point Only mode, or if you have the **Auto Vector Point** Auto Feature dialog box open, PC-DMIS creates individual point features from this stream of points.

To enter Point Only Mode, click **Point Only Mode** () from the **Probe Mode** toolbar.

To access the **Vector Point** dialog box, select **Vector Point** () from the **Auto Features** toolbar.

- **Guess the Feature.** If you are not in either mode, the points go onto the hits buffer, and you see the hit count increment on the status bar. When you finish measuring, the resulting feature depends on your settings and if you are using Guess mode.

Edge Point Mode

Edge Point Mode allows for walk-up measurement of sheet metal features without using the **Auto Feature** dialog box. The features generated using this mode are all Measured Features rather than Auto Features with two exceptions: If you are in point only mode, then PC-DMIS creates either an auto vector point or an auto edge point. PC-DMIS creates an auto edge point if you take your hit close to an edge and then slide it over the edge to complete the guiding.

For this mode to be enabled, you must do the following:

- Program the **Sheet Metal** option into your portlock.
- Import a CAD model with surfaces for the part you are measuring.
- Select the **Find Nominals** check box from the **General** tab of the **Setup Options** dialog box.
- Specify the needed tolerance distance for the `DistanceToClosestEdgeToleranceInMM` registry entry in the **Option** section in PC-DMIS Settings Editor. The default value is 5MM. Hits taken within this distance from the edge will initiate guided mode for completion of the edge point.

To measure points in Edge Point Mode:

1. Take measurements in Learn Mode within the tolerance (`DistanceToClosestEdgeToleranceInMM` registry entry) near the edge point location. PC-DMIS finds the nominals from the CAD model and checks to see if the hit is within tolerance. If the measurement is within tolerance, PC-DMIS goes into guided mode rather than storing the hit in the buffer.
2. In guided mode, slide the probe tip over the edge to complete the edge hit.
3. PC-DMIS places the completed edge hit into the buffer in learn mode. This allows for the guessing of features as you measure.
4. If you didn't want an edge hit, press the end button. PC-DMIS cancels guided mode and adds the previous hit to the buffer.



When you create certain features in Guess mode from edge hits, they become 3D features. These are circles, lines, and slots.

To eliminate internal borders between surfaces for determining edges, use the `AdjacentEdgeToleranceInMM` registry entry in the **Option** section in PC-DMIS Settings Editor. This is useful in situations where the CAD model has gaps between surfaces. If the gaps are large, you may need to increase the default value of 0.1MM.

Edge Point Mode also uses *half* of the thickness value from the **Auto Feature** dialog box to determine the depth. Normally, you only need to set this once to the part thickness and then close the **Auto Feature** dialog box. This value is written to the registry.



Edge Point Mode is designed for portable devices, but it works with any device with a hard probe.

Using a Romer Portable CMM

This section discusses the configuration and general usage of your Romer Portable CMM with PC-DMIS. Refer to documentation that Romer provided for detailed information on configuring and using your Romer arm.

- [Romer Portable CMM: Introduction](#)
- [Getting Started](#)
- [Configuring a Perceptron Contour Sensor](#)
- [Calibrating a Romer Hard Probe](#)
- [Calibrating the Perceptron Sensor](#)
- [Using Romer Arm Buttons](#)
- [Using a Romer Laser Sensor](#)
- [Using the RomerRDS Integrated Camera](#)

Romer Portable CMM: Introduction

Romer Portable CMMs are articulated arm machines that use either a hard probe or a Perceptron laser probe to measure parts.

PC-DMIS uses WinRDS to interface with your Romer arm. Refer to the WinRDS documentation for detailed information about configuring and using your portable arm. The latest WinRDS software is available from the Wilcox FTP site at

<ftp://ftp.wilcoxassoc.com/Hardware/Portable/Romer/>.



To use a Romer arm device with PC-DMIS, you must have your license or portlock programmed with the **Romer** interface option. If you are using a Perceptron probe on a Romer arm, you may also need to have the **Laser Probe** option with the "Perceptron" **Probe Type** programmed.

Also, the **Rotary Table** portlock option **MUST NOT** be selected when you are using a portable device. This can cause problems with your portable device.

The information provided in the topics in this chapter was written specifically for Romer arms, but it may apply to non-Romer arms.

Getting Started

You should take a few basic steps to verify that your system has been properly prepared before you begin the measurement process with your portable arm.

If you plan to use a Perceptron Contour sensor with your Infinite arm, then you will also need to follow the steps in the "[Configuring a Perceptron Contour Sensor](#)" topic.

This section contains supplemental material to the standard WinRDS documentation for your Romer Infinite arm. For additional setup information, consult the WinRDS documentation and Perceptron Contour sensor documentation.

To configure your Romer Infinite arm, follow these steps:

- [Step 1: Set Up the Romer Infinite Arm](#)
- [Step 2: Set WinRDS Environment Variables](#)
- [Step 3: Install PC-DMIS for Romer](#)

Step 1: Set Up the Romer Infinite Arm

1. Mount the fixturing base to a stable platform using the mounting screws or magnetic chucks.
2. Place the arm on the fixturing base by screwing the large threaded ring at the base of the arm to the fixturing base.
3. Once the arm is securely mounted, plug in the power to the arm and verify the power comes on. Turn off the arm until step 6.
4. Install WinRDS (version 2.3.5 or later) if it has not already been installed on the computer. WinRDS 3.1 is available via this link:
<ftp://ftp.wilcoxassoc.com/Hardware/Portable/Romer/RDS/>. Installing WinRDS will place two icons on your computer desktop; one is called **Cimcore Arm Utilities**, and the other one is called **Quick Check Tools**.



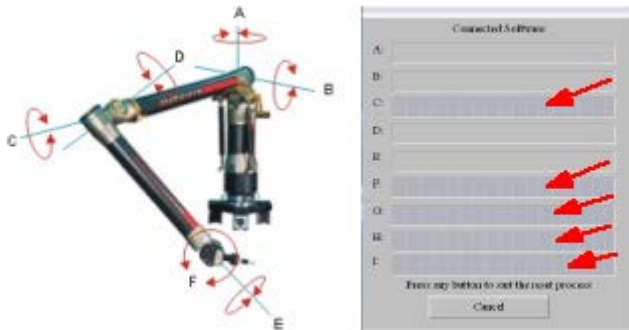
WinRDS versions earlier than 2.3.5 are not adequately supported for use with Perceptron Contour sensors.



There are two ways to communicate with the Infinite arm: via USB connection and via wireless connection if your computer has a wireless Network Interface Card (NIC). Because of the high communication speed that laser scanners require, it is preferred that you connect your computer to the Infinite arm via the USB port when you use a Perceptron Contour Sensor. This document does not cover wireless communication. If you want to connect via wireless communication, please see your **Infinite Setup Guide** and other documentation installed with the WinRDS installation.

5. Plug in the USB connector into one of the USB ports on your computer (or, verify Wi-Fi communication if you are not using a Perceptron Contour sensor).
6. Start up the arm by toggling the power switch. If you are using a computer running Windows, your computer detects the connection and asks you if you want to install the USB drivers for the arm. Go ahead and install the USB drivers.

7. Once the driver installation is complete, double click the **Cimcore Arm Utilities** icon on your desktop. This launches the **Arm Utilities** application. When the application starts up, it automatically tries to connect to the machine. If the machine is connected properly, it connects to the arm and asks you to reset the axes. If there are problems, consult the WinRDS and Cimcore documentation.
8. To reset the axes, move all of the joints on the arm until each joint is zeroed out. As each axis is zeroed out, the corresponding axes bar graphs fill as shown below. When all the axes are homed (zeroed out), the dialog box automatically closes.



At this point, the machine is connected and ready to work.

Step 2: Set WinRDS Environment Variables

There is one last step to work with PC-DMIS. If you are using a version of WinRDS prior to version 5.0, you need to set the WinRDS directory in the path of the computer. To do this, follow these steps:

1. Click the **Start** button and select **Control Panel** to open the Control Panel.
2. Double-click the **System** icon to open the **System Properties** dialog box.
3. Select the **Advanced** tab.
4. Select the **Environment Variables** button.
5. In the **System Variables** section of the **Environment Variables** dialog box, scroll down until you see *Path* on the left. Select *Path* from the list and select the **Edit** button.
6. Go to the end of the **Variable Value** line and add a semicolon (;) followed by the path of the WinRDS installation (i.e. c:\Program Files\CIMCORE\WinRDS)
7. Click **OK** on the **Edit System Variable** dialog box, click **OK** on the **Environment Variables** dialog box, and click **OK** on the **System Properties** dialog box.

At this point, you can launch PC-DMIS. You may get a message that says “Retrieving arm specs from the machine” depending on how you have configured WinRDS. You can change this setting through the Arm Utilities program.

Step 3: Install PC-DMIS for Romer

Once you have verified the connection of the PC to the arm, install PC-DMIS by doing the following:

NOT using a Perceptron Laser Sensor

1. Your portlock should have already been programmed with the **Romer** interface option before you install PC-DMIS.



If **All interfaces** is programmed in your license or portlock (such as a demo portlock), you need to manually rename Romer.dll to interfac.dll. Romer.dll is found in the PC-DMIS install directory.

2. Install PC-DMIS. PC-DMIS is now ready to use.

ARE using a Perceptron Laser Sensor

1. Your portlock should have already been programmed with the **Laser Probe**, **Perceptron**, and the **Romer** interface options before you install PC-DMIS. If you don't have **Laser** and **Perceptron** specified in the portlock, you will not have the necessary Perceptron files as indicated below. Additional files will be installed that are required by WinRDS when you install PC-DMIS.



If **All interfaces** is programmed in your license or portlock (such as a demo portlock), you need to manually rename Romer.dll to interfac.dll. Romer.dll is found in the PC-DMIS install directory.

2. Install PC-DMIS. Do not run PC-DMIS at this point.
3. Verify that the *probe.8* file has been installed in your ArmData directory (usually c:\Program Files\CIMCORE\WinRDS\ArmData). This file should be installed by PC-DMIS during the install process as long as your portlock is programmed correctly. The

probe.8 file is used by WinRDS as the identifier for the Perceptron Contour sensor. If you do not have a copy of this file, make sure that you contact your PC-DMIS distributor.

4. Continue to the "[Configuring a Perceptron Contour Sensor](#)" topic.



The **Rotary Table** license or portlock option **MUST NOT** be selected when you use a portable device. It can cause problems with your portable device.

Configuring a Perceptron Contour Sensor

This section discusses the configuration of your Perceptron Contour sensor once you have configured your Infinite arm as outlined in the "[Getting Started](#)" section.

To configure the Perceptron Contour sensor, follow these steps:

- [Step 1: Connect the Perceptron Sensor Controller Box](#)
- [Step 2: Configure the Network Card](#)
- [Step 3: Attach Your Contour Sensor](#)
- [Step 4: Complete the PC-DMIS Configuration](#)
- [Step 5: Verify Sensor Installation](#)

Step 1: Connect the Perceptron Sensor Controller Box

The connection to the Perceptron Sensor controller box requires a dedicated Network Interface Card (NIC). You need to use the integrated NIC on your computer or purchase an additional NIC because the Perceptron requires a dedicated NIC for communication with their Perceptron Sensor controller box.



A USB NIC is not sufficient for this connection. If you are using a desktop computer, you need an additional PCI NIC. If you are using a laptop, you need a PCMCIA NIC.

To connect your Perceptron Sensor controller box:

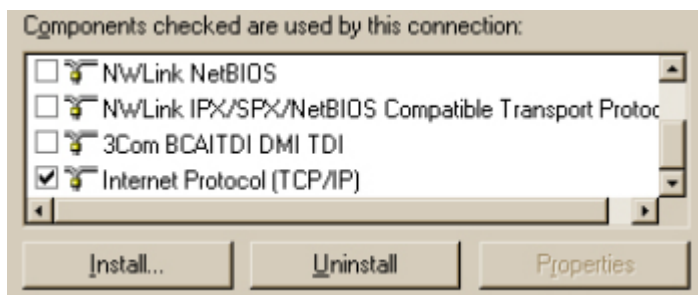
1. Remove the cap on the back of the Infinite arm labeled "SCANNER".

2. Take the sensor cable from the Perceptron box and plug it into the "Sensor" connector on the Perceptron controller box. Plug the other end into the "SCANNER" connection on the back of the arm.
3. There may be a small pigtail that comes off of the end plugged into the Perceptron controller box depending on what version of Perceptron controller you have. If you have a pigtail, plug the pigtail into the connector marked "Trigger".
4. On the other side of the Perceptron controller box, connect a crossover RJ45 cable. Connect the other end to the dedicated NIC on the computer.

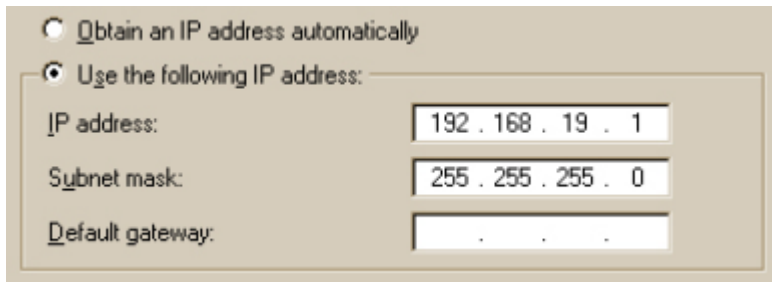
Step 2: Configure the Network Card

To communicate with the Perceptron controller box, you need to configure your dedicated NIC by following these steps:

1. Click the **Start** button and select **Control Panel** to open the Control Panel.
2. Double-click the **Network Connections** icon to view the current network connections.
3. From the list of **LAN or High Speed-Internet**, double-click on the name of the NIC connected to the Perceptron controller box.
4. Click **Properties** on the **General** tab.
5. Deselect all items except **Internet Protocol (TCP/IP)** by clicking in the check box next to any of the items that are currently checked. This should leave the list with only Internet Protocol checked.



6. Highlight **Internet Protocol** by selecting the text (not the check box). Select **Properties**.
7. On the **General** tab of the **Internet Protocol (TCP/IP) Properties** dialog box, select the option labeled **Use the following IP address**. Type the following values as shown in the image:



- **IP address:** 192.168.19.1
 - **Subnet mask:** 255.255.255.0
8. Click **Advanced** to open the **Advanced TCP/IP Setting** dialog box.
 9. From the **Advanced TCP/IP Settings** dialog box, select the **WINS** tab.
 10. Select the **Disable NetBIOS over TCP/IP** option in the **NetBIOS setting** area.
 11. Click **OK** on the **Advanced TCP/IP Settings** dialog box, click **OK** on the **Internet Protocol (TCP/IP) Properties** dialog box, and then click **OK** on the <dedicated NIC> **Properties** dialog box.

Step 3: Attach Your Contour Sensor

1. Mount the Contour sensor to the wrist. If you are using a seven axis infinite, you need to mount the sensor in the mount that is in the axis of the seventh joint.
2. Turn on the Perceptron Sensor controller box by pressing the power button located close to the power connector and the trigger connector. This is not to be confused with the sensor power rocker switch located on the same side of the controller box. The boot sequence for the controller box may take as long as two minutes. You will know when the boot cycle is complete because the green Ready LED will be lit.
3. When the boot cycle is complete, turn the sensor power rocker switch to the on position. This provides power to the sensor. You can verify that the sensor has power by looking at the three LED's on the side of the sensor head. The LEDs labeled +12V and +5V should be lit. If they are not on, check the power on the sensor controller box and the sensor cable. The LED marked LASER only comes on when scanning.
4. With the power on, browse to the Perceptron subdirectory inside the PC-DMIS install directory. Double-click on the WinSen application. This is a diagnostic application provided by Perceptron. When the application is launched, it tries to establish communication with the sensor. If it is successful, you should receive several messages

with Status=0x00000000 (All OK). You should also see a line indicating the sensor ID. If there is no sensor ID, there is no communication with the sensor.

5. Point the sensor at something and then select the **Image | Live Sensor Display** menu item. You should then be able to see (if you are within the camera's field of view) the live camera image of the part you are scanning. You should also see a red laser stripe projected onto the part.
6. Once you are satisfied that the system is working correctly, close WinSen.



The sensor cannot communicate with two different host applications at the same time. When you run PC-DMIS, you must make sure that WinSen, or any other application that communicates with the sensor controller, is off.

Step 4: Complete the PC-DMIS Configuration

You are now ready to start PC-DMIS. After you launch PC-DMIS, open a new measurement routine and follow these steps to complete the configuration:

1. Press F5 to open the **Setup Options** dialog box.
2. Select the **Laser** tab.
3. Type the path to the CSGMain.bin file in the **Sensor Binary File** box. This is normally installed with PC-DMIS into the Perceptron subdirectory of the main PC-DMIS installation. Alternatively, you can use the **Browse** button to locate this file.
4. Click **OK** on the **Setup Options** dialog box.

To verify that the sensor is working in PC-DMIS, close down PC-DMIS and restart. This ensures that all necessary information is written to the system registry.

Step 5: Verify Sensor Installation

1. Start PC-DMIS and open the original measurement routine created in the previous step. PC-DMIS should be able to identify the probe that is currently on the system. Once you have a probe in your measurement routine, the **Laser** tab in the Graphic Display window displays. It allows you to see real-time data that the sensor collected.

2. Switch to the **Laser** tab. It might take 10 or 20 seconds to initialize the sensor, so be patient. You should see a slightly skewed green trapezoid in the center of the window with a cross hair about two-thirds of the way to the top of the trapezoid. If you see anything else, PC-DMIS was unable to connect to the sensor and should give you an error message. If this happens, it usually means that the `contour.dll` file did not register correctly during installation. See the "[Contour.dll Registration](#)" topic.



Make sure there are no other copies of the `CSGMain.bin` file. Delete (or rename) any other `CSGMain.bin` files not in the current installation of PC-DMIS. If you do not have the correct version of `CSGMain.bin`, the sensor does not initialize.

3. Press the **Live View** button to start the scanner striping. The live image should update with the data that the scanner collected. You can now use your scanner in PC-DMIS.



If you still have problems, contact Hexagon Technical Support.

For additional information on how to use the scanner in PC-DMIS, consult the PC-DMIS Laser documentation.

For additional information on the Perceptron system, see the Perceptron documentation included with your PC-DMIS installation in the Perceptron subdirectory.

Contour.dll Registration

To manually register the `Contour.dll` file:

1. Check that the power on the Perceptron Sensor controller box is on as well as the power to the arm.
2. Open a Command Prompt window (DOS prompt), and change to the Perceptron directory. This is a subdirectory of the main PC-DMIS install directory.
3. Type the following on the command line: `regsvr32 contour.dll`. After a few seconds, you should get a message that says "Contour.dll registered successfully".
4. If the file does not register successfully, contact Hexagon Technical Support. Otherwise, restart PC-DMIS.

Calibrating a Romer Hard Probe

Accomplish the calibration of a Romer Infinite probe via the WinRDS software. PC-DMIS interfaces with WinRDS to acquire probe calibration data. Follow the steps found in the **Arm Utilities User Guide** document to calibrate your probe.

Use the PC-DMIS **Probe Utilities** dialog box to calibrate Perceptron Contour sensors. For information on how to calibrate Perceptron Contour sensors, see the "[Calibrating a Perceptron Contour Sensor](#)" topic.

Calibrating the Perceptron Sensor

Once you have configured your Perceptron sensor, complete the following steps to calibrate your laser probe:

Before You Begin

Exposure and Gray Sums During Calibration

Before you start to calibrate your laser probe, be aware that PC-DMIS automatically sets the exposure to the default calibration value of 300 and the gray sums to the default calibration values of 10 for the minimum and 300 for the maximum. These values work best for most calibration scenarios. Your original exposure and gray sums values are restored once the process finishes. While gray sums with values of 10, 300 are often appropriate for calibration, values of 30, 300 are typical for normal scanning.

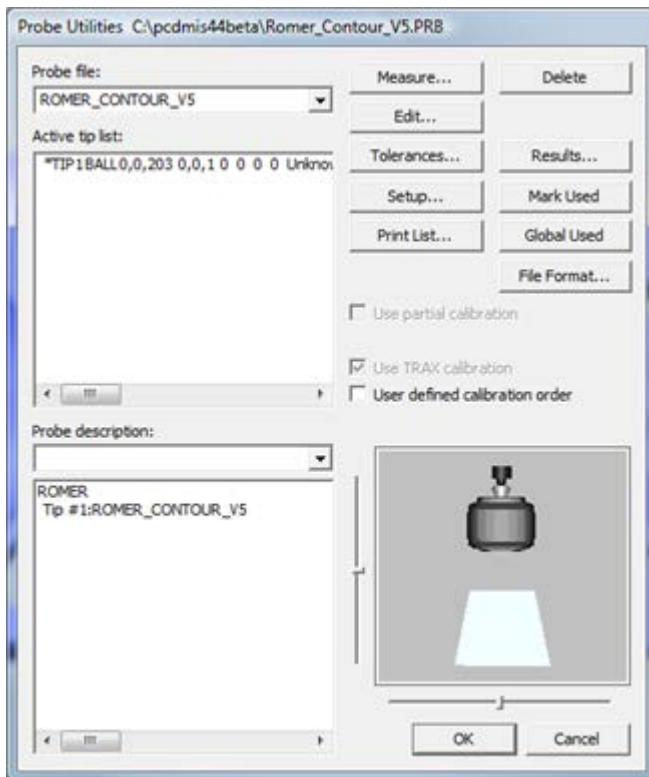
Exposure for Rare Lighting Conditions

An exposure value of 300 is sometimes not sufficient in rare lighting conditions, such as V4i in a sodium lighting environment. If, due to such lighting conditions, it appears that PC-DMIS has trouble accepting the laser arcs during the calibration process, you may need to lower the default calibration exposure to a value close to 200. To do this, use the PC-DMIS Settings Editor, and modify the `PerceptronDefaultCalibrationExposure` registry entry, located in the **NCSensorSettings** group, accordingly.

For information on exposure and gray sums, see the PC-DMIS Laser documentation.

Step 1: Define the Laser Probe

1. Open an existing measurement routine, or create a new one.
2. Select the **Insert | Hardware Definition | Probe** menu option to open the **Probe Utilities** dialog box (this dialog box automatically appears when you create a new measurement routine).



Probe Utilities dialog box

3. Define a probe configuration that uses the **CONTOUR** probe and the appropriate Romer arm inside the **Probe Utilities** dialog box. The type of Perceptron Contour probe is specified in the **Setup Options** dialog box.

Step 2: Calibrate the Laser Probe

The calibration process that this step describes varies depending on the type of measure laser probe options and the type of installed interface. For detailed information on calibration options, refer to the "Measure Laser Probe Options" topic in the PC-DMIS Laser documentation.

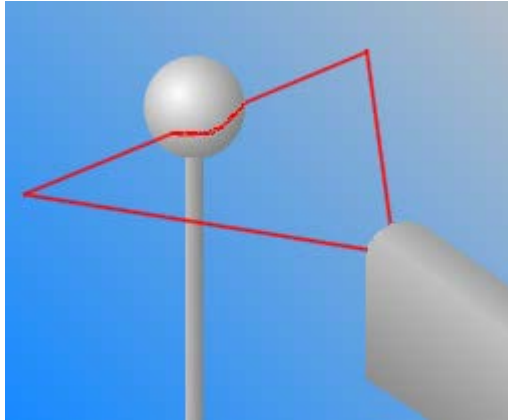
The following steps outline the procedure that would be used when you first calibrate your laser probe:

1. Once the tip is defined in [step 1](#), click **Measure** from the **Probe Utilities** dialog box. This opens the **Measure Laser Probe Options** dialog box.
2. Click **Measure** to begin the calibration procedure. If you are NOT using a Perceptron V5 sensor, skip to step 5. If you are using a Perceptron V5 sensor, you are first prompted to scan the entire range of the laser's Z depth on a flat target.
3. Measure the Z-depth of your V5 sensor by doing the following:
 - a. Place a white piece of paper on a flat surface where you will perform the flat target calibration.
 - b. Hold the V5 sensor close to the flat surface so the scan line is beyond the laser's projected grid box.
 - c. Press and hold the sensor's trigger while moving away to the full extent of the laser's range such that the laser line crosses the grid box to the other side.
 - d. Release the trigger. This completes the flat target calibration.
4. Follow any on-screen instructions and visual indicators from the **Laser** tab to complete the sensor calibration on the calibration sphere.
 - a. You are prompted to move the probe to 15 different locations on the calibration sphere (5 different positions around the sphere with 3 different fields at each position). The laser probe will continually be probing, but it only accepts a stripe of data when *certain criteria* are met. The system needs 5 stripes of data at each of the *15 different locations* to complete the calibration.

Graphical Depiction of the Different Probing Locations

- *5 Positions* around the sphere:

Position 1: The laser stripe should be horizontal along the side of the sphere as in the image below.



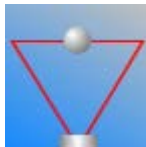
Position 2: Rotate the sensor 120 degrees around the sphere from Position 1.

Position 3: Rotate the sensor 120 degrees around the sphere from Position 2.

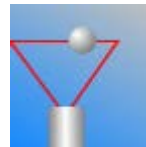
Position 4: Point the sensor straight down on the top of the sphere.

Position 5: Point the sensor straight down on the top of the sphere with the laser stripe located 90 degrees from Position 4.

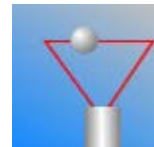
- 3 *Sensor Fields* (Far, Right, and Left) within the laser's range:



Field 1: Far

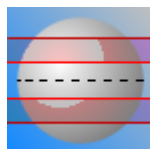


Field 2: Right



Field 3: Left

- 2 *Bands* on the sphere's surface. Hold the probe within either of these bands for five stripes.



Band 1: 20 Degrees *above* the equator (mid-line) of the sphere.

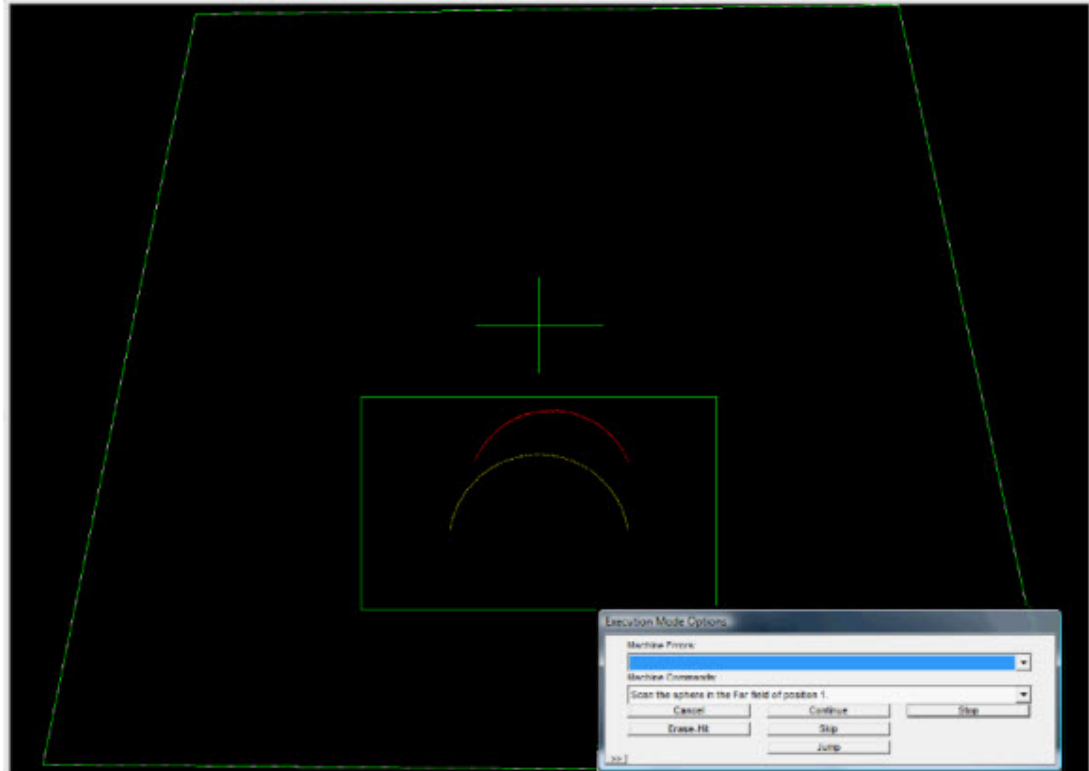
Band 2: 20 Degrees *below* the equator (mid-line) of the sphere.

Criteria for an Acceptable Stripe:

- The probe must not be against the hardstop of the arm.
- The stripe must be comprised of more than 100 points.
- In the **Laser View**, the laser's red arc must be inside the green rectangular area that bounds the yellow arc.
- The solved circle which is created by the laser's arc must have at least 100 degrees of arc angle, the difference between the starting vector and the ending vector of the arc.
- The laser must probe a diameter of .875 multiplied by the theoretical diameter of the calibration sphere. This means it should probe between 81.9% and 96.6% of the theoretical diameter.
- The probe must remain motionless. It should not move more than 1.5 mm over the last 5 probings.

When calibrating in the three fields (“far”, “left”, and “right”) for the 5 different positions, be sure to take a hit (laser stripe) at both of the tropics (indicated as "Band 1" and "Band 2"). Also, when probing at 0, 120, and 240 degrees around the equator, favor the lower part of the sphere by taking 2 stripes on the lower location and only 1 on the upper location. This is because additional data will be taken during sets 4 and 5 which occur on the top of the sphere.

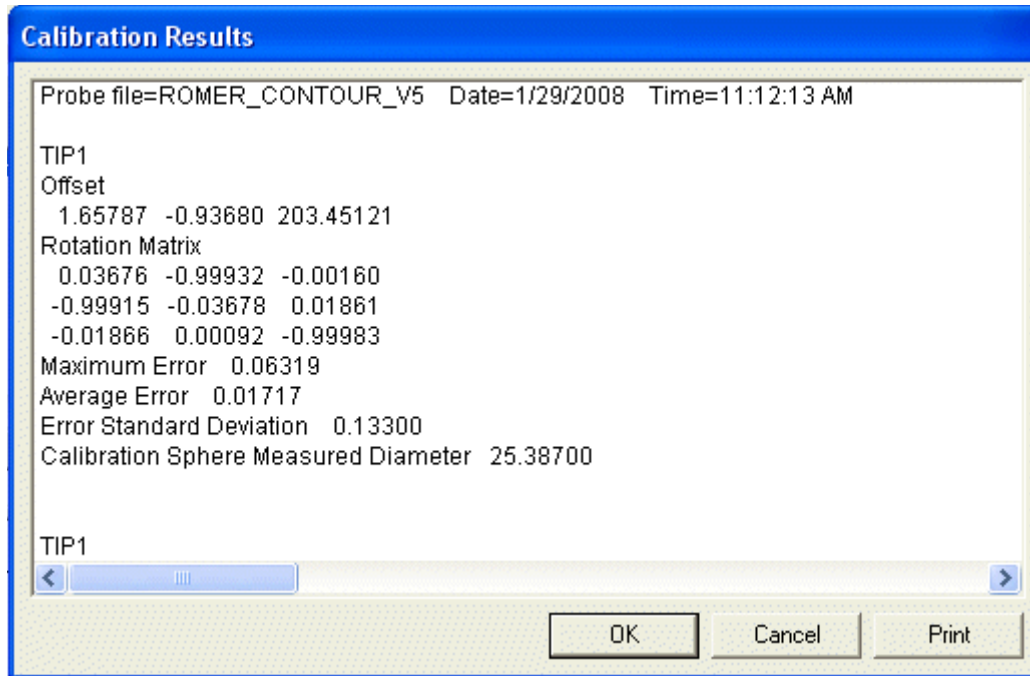
- b. For each hit (or laser stripe) of the calibration, use the **Laser** tab to align the red arc of the laser with the yellow arc (representing the sphere's theoretical arc) so the form and size match as close as possible.
- c. Move the laser's red arc so that it remains within the green rectangular box surrounding the yellow arc. As you position the laser's arc on top of the yellow arc, an audible beeping sound increases in frequency and pitch. This helps you know when you are approaching the desired location.



- d. Hold the laser probe motionless at the appropriate location until the various criteria are met. PC-DMIS automatically accepts the stripe and prompts you to probe at a new location.

Step 3: Check the Calibration Results

To open the **Calibration Results** dialog box, click the **Results** button.



Calibration Results

PC-DMIS records several things from the calibration in this dialog box. Take a look at the maximum, average, and standard deviation values. The **Average Error** should be around 0.05 mm. The **Maximum Error** should be around 0.15 mm.

If the results look correct, click the **OK** button to close the **Calibration Results** dialog box.

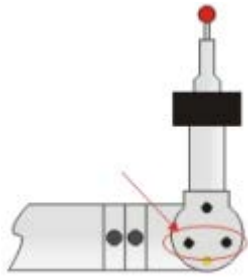
You are now done setting up and calibrating your laser probe. You should now have access to all laser-related functionality.



If the calibration exceeds the tolerance value defined for the `StandardDeviationLimit` registry entry in the **USER_Options** section of the PC-DMIS Settings Editor, PC-DMIS adds a line of text that says "Standard deviations for the probe calibration exceed limit" in the **Calibration Results** dialog box.

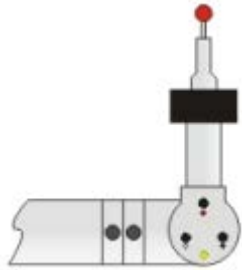
Using Romer Arm Buttons

Two types of button configurations exist:



Two Button Configuration:

Two buttons are programmed for use by PC-DMIS (even though three buttons exist). The two buttons indicated in the image at left perform the same function. See "[Two Button Configuration](#)".



Three Button Configuration:

Three buttons are programmed for use by PC-DMIS. The buttons have color-coded dots. See "[Three Button Configuration](#)".

Mouse Mode

PC-DMIS lets you place your portable device into "Mouse Mode". This special mode lets you perform standard mouse pointer actions (move the pointer, click, or right-click, etc.) inside PC-DMIS by moving the arm and probe head around and pressing buttons to perform mouse "clicks". PC-DMIS interprets the motion as if you were using a standard mouse. This allows you to remain with your portable device rather than continually switching between device and computer.

If PC-DMIS is in Mouse Mode, and you attempt to pick up and use your regular mouse, it behaves erratically. You should exit out of this mode prior to using your standard mouse functionality.

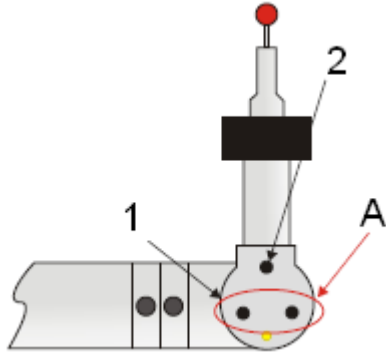
Mouse Mode functions outside of PC-DMIS but only if PC-DMIS remains running and minimized in the background.

For more information on how to use Mouse Mode, see the "[Two Button Configuration](#)" and "[Three Button Configuration](#)" topics.

Two Button Configuration

The two modes for a two-button configuration are discussed below:

Measure Mode



The following Measure Mode functions are available for the buttons indicated above:

1:DONE - Press < 1 second.

1:ERASE last hit - Hold > 1 second.

1:OPEN DRO - Hold > 1 second when there is no hit in the buffer.

1:TOGGLE DRO - Hold > 1 second when the DRO is already open. XYZ <-> XYZT. The "T" value is displayed.

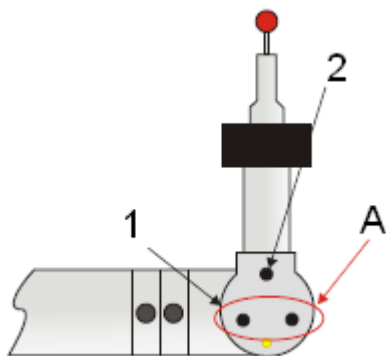
2:HIT POINT - Press < 1 second.

2:PULLED HIT - Press, pull back, release with 1 second. See "[Using Pulled Hits for Probe Compensation](#)"

2: SCAN - Press, hold > 1 second, drag.

A: Buttons indicated by a circle with a red arrow perform the same function.

Mouse Mode



The following Mouse Mode functions are available for the buttons indicated above:

1: Mouse **RIGHT** Button - Used for popup menus.

1: PAN - Press and hold on the CAD model.

2: Mouse **LEFT** Button - Used for screen selections.

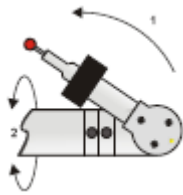
A: Buttons indicated by a circle with a red arrow perform the same function.

Switching Between Mouse Mode and Measure Mode

To switch to Mouse Mode: Press and hold the take hit button and then quickly press the done button (within the first second).

To switch to Measure Mode: Move the cursor to the top of the screen and press the middle button (left mouse button).

To toggle from either mode:

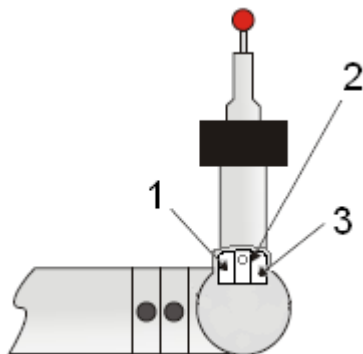


1. Turn the "F" axis to the limit, then
2. Turn the "E" axis 90 degrees.

Three Button Configuration

The two modes for a three-button configuration are discussed below:

Measure Mode



The following Measure Mode functions are available for the buttons indicated above:

1: DONE - Press < 1 second

1: ERASE last hit - Hold > 1 second

1: OPEN DRO - Hold > 1 second when there is no hit in the buffer.

1: TOGGLE DRO - Hold > 1 second when the DRO is already open. XYZ <-> XYZT.
The "T" value is displayed.

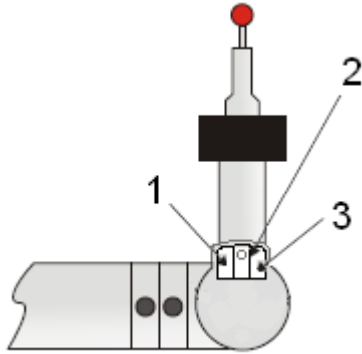
2: HIT POINT - Press < 1 second.

2: PULLED HIT - Press, pull back, release with 1 second. See "[Using Pulled Hits for Probe Compensation](#)".

2: SCAN - Press, hold > 1 second, drag.

3: TOGGLE Between Modes - Press < 1 second.

Mouse Mode



The following Mouse Mode functions are available for the buttons indicated above:

1: PAN - Press and hold the CAD model.

2: Mouse LEFT Button - Used for screen selections.

1+ 2: BOX ZOOM - Press and hold.

3: TOGGLE Between Modes - Press < 1 second.

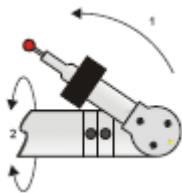
3: ROTATE - Press and hold the CAD model.

Optional Methods for Switching Between Mouse Mode and Measure Mode

To switch to Mouse Mode: Press and hold the take hit button and then quickly press the done button (within the first second).

To switch to Measure Mode: Move the cursor to the top of the screen and press the middle button (left mouse button).

To toggle from either mode:



1. Turn the "F" axis to the limit, then

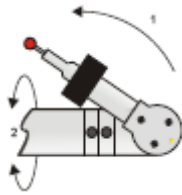
2. Turn the "E" axis 90 degrees.

Three Button Configuration for the RA7 Arm

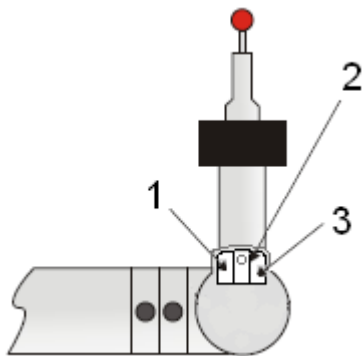
The two modes for a three-button configuration used on the RA7 arm are discussed below.

To switch between measure and mouse mode,

1. Turn the "F" axis to the limit, then
2. Turn the "E" axis 90 degrees.



Measure Mode

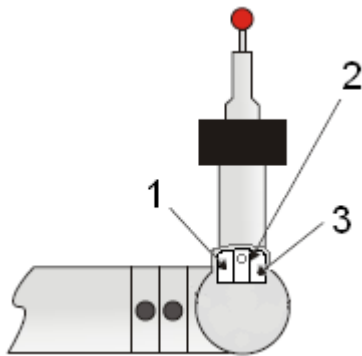


The following Measure Mode functions are available for the buttons indicated above:

Desired Action	Arm Procedure to Follow
Click Done , OK , Yes , Finish , Next , or Create on a dialog box	Press button 1 for less than 1 second.
Erase the last hit from the hit buffer.	Press and hold button 1 for more than 1 second.
Click Cancel , No , or Previous buttons on a dialog box	Press and hold button 1 for more than 1 second.

Bring up the Readout window (DRO)	Press and hold button 1 for more than 1 second when no hit is in the hit buffer.
Toggle the display of information in the readout window (DRO)	With the DRO already open, press button 1 for less than 1 second. The T value is displayed with the XYZ values in the DRO: XYZT
Take a point	Press button 2 for less than 1 second without moving the arm.
Take a "pulled hit"	Press and hold button 2 while pulling back on the arm, releasing it in before 1 second elapses. See " Using Pulled Hits for Probe Compensation ".
Scan	Press and hold button 2 for more than one second while dragging the probe along a part's surface.
Select features on the part using the arm	Position the probe near the feature, press and hold button 1 and then press button 2.

Mouse Mode



The following Mouse Mode functions are available for the buttons indicated above:

Desired Action	Arm Procedure to Follow
Use the left mouse button	Press button 1.
Use the right mouse button	Press button 2.
Use the middle mouse button	Press button 3.
Zoom out of the current	Press button 1 (left mouse click) above the imaginary center

CAD view	line of the current CAD view. The further above the center line the larger the zoom.
Zoom in on the current CAD view	Press button 1 (left mouse click) below the imaginary center line of the current CAD view. The further above the center line the larger the zoom.
Pan the view	Press and hold button 1 on the CAD model while dragging the arm.
Create a Point Info or Dimension Info box on the CAD view	Press button 1 twice (double click) on a feature label.
Rotate the CAD view	Press and hold button 3 while dragging.
Box Zoom	Press and hold button 1, press and hold button 2 and drag a box on the part model. Release the buttons to zoom in on the selected portion.

Using a Romer Laser Sensor

When you use a laser sensor on you Romer portable arm, you should use the information from this documentation in conjunction with the information provided in the PC-DMIS Laser documentation. That documentation provides greater detail on measuring with a laser device.

For information on manual scanning, see the "[Portable Laser Probe Scanning](#)" topic.

Using Sound Events

Sound events provide audible feedback in addition to the visual user interface. This allows you to perform measuring actions without needing to look at the PC screen. To access the **Sound Events** tab of the **Setup Options** dialog box, select the **Edit | Preferences | Setup** menu item.

Calibration Sound Events

When you calibrate a laser device, there are sound event options that are particularly useful. They are:

Laser Manual Calibration Bottom: The associated sound plays when calibration measurements for a given field should be taken in the upper region (location) of the sphere.

Laser Manual Calibration Field Counter: The associated sound plays to indicate in which field calibration measurements should be taken.

- 1 Beep - Measurement should be taken in the *Far* field.
- 2 Beeps - Measurement should be taken in the *Left* field.
- 3 Beeps - Measurement should be taken in the *Right* field.

Laser Manual Calibration Top: The associated sound plays when calibration measurements for a given field should be taken in the lower region (location) of the sphere.

Laser Probe Initialization End: The associated sound plays when at the end of the laser sensor initialization.

Laser Probe Initialization Start: The associated sound plays when at the beginning of the laser sensor initialization.

Laser Scan: The associated sound plays for each new step of the sensor calibration.

Sound Events for Laser Measurement

When you measure with a laser device, audible feedback is provided from the Romer speaker based on the calculated Z distance. This pitch varies according to the distance from the surface in relation to the optimal target distance.

- **Low pitched continuous sound** - Indicates that you are closer than the middle 50% of the laser range.
- **High pitched continuous sound** - Indicates that you are farther than the middle 50% of the laser range.
- **Series of beeps** - Indicates that you are in the middle 50% (25% below to 25% above) of the optimal target. This the desired range for optimal scanning.

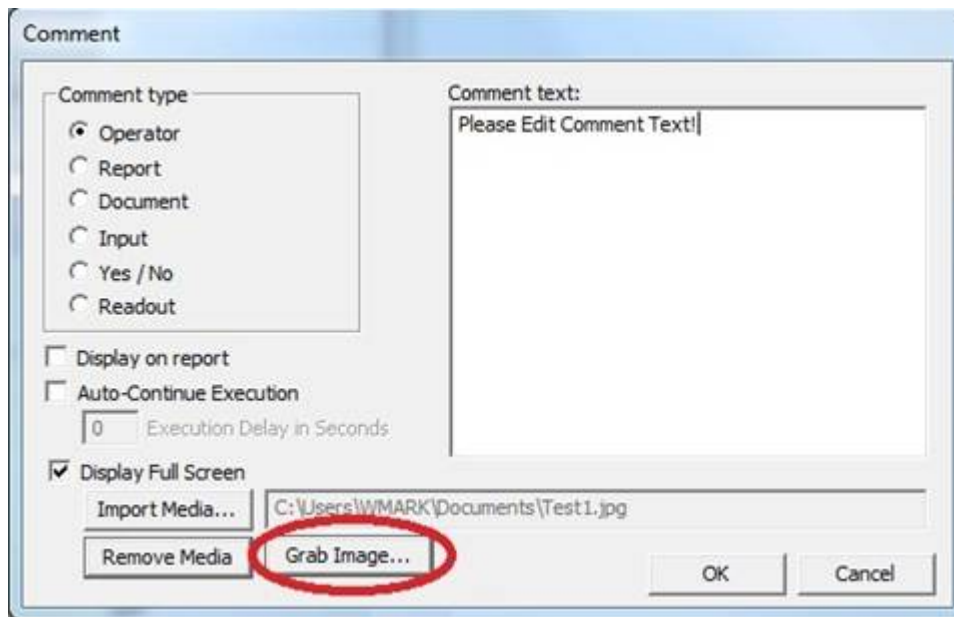


This functionality is probably best used on larger, flatter surfaces. When you use a V5 sensor, you may combine the sound events with the V5 projector option to ensure scanning at the optimal focal length. You can compare the V5 projector in relation to the audible cues to learn what the beeps mean.

Using the RomerRDS Integrated Camera

Prerequisites: RomerRDS Software Version 3.2 (drivers), Romer RDS arm with integrated camera.

If you meet the above prerequisites, you can use the RomerRDS integrated camera to take images of your part and add them into the supported PC-DMIS Comment commands. You can access this functionality from the **Comment** dialog box (**Insert | Report Command | Comment**).



Comment dialog box showing the Grab Image button

To capture a frame from the video stream as an image file:

1. Click **Grab Image**. PC-DMIS starts the RDS video capture sequence and displays the current video stream in an **RDS Video capture** output window.



RDS Video capture output window

2. Position the arm so that the feature of interest displays in the window.
3. Once the feature displays, press the middle "Hit" button on the arm to capture a frame from the video stream and display the **Save As** dialog box.
4. Type in a descriptive name for the image, and navigate to where you want the image saved. Press **OK** to save the captured frame as a .jpg file.



PC-DMIS comments only support the JPEG image format.

Modifying Image Properties

If needed, you can view and change image properties, such as image resolution, image format, and so on by using the RDS Control Panel software. You can also use this control panel to start or stop the integrated Romer head light as needed (if available).

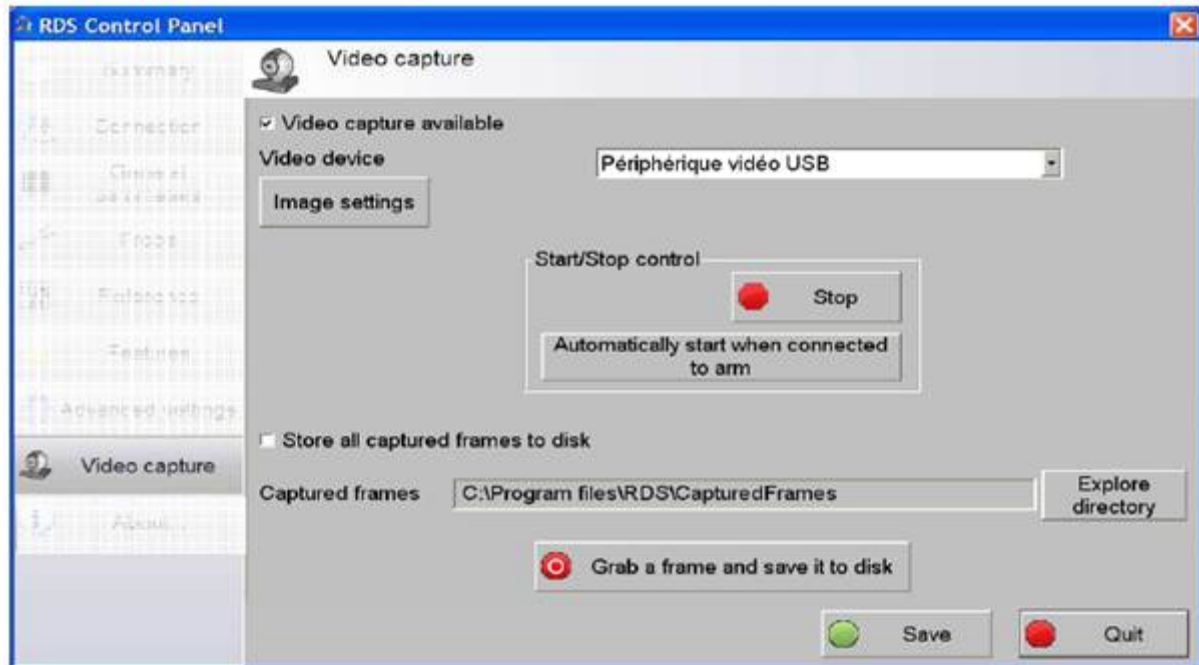
The RDS Control Panel comes bundled with the PC-DMIS installation.

To access this control panel, right click on the RDS icon in your system tray.



From the shortcut menu that appears, choose **RDS Control Panel**.

The RDS Control Panel opens.



RDS Control Panel software with Image and Video Capture settings

Click the **Image Settings** button on the control panel to view or change the settings. Consult the documentation that comes with the RDS Control Panel as needed.

Using a Leica Laser Tracker

This section discusses the configuration and general usage of your Leica device with PC-DMIS. Refer to documentation that Leica provides for detailed information on configuring and using your Leica Tracker.

The following topics discuss how to use your Leica device with PC-DMIS:

- [Leica Laser Tracker: Introduction](#)
- [Getting Started](#)
- [Leica User Interface](#)
- [Using Leica Utilities](#)
- [Using Auto-Inspect Mode](#)
- [Using Move Feature \(Move To / Point To\)](#)
- [Using Leica Probes](#)
- [Using Bundle Alignments](#)

- [Constructing Points for Hidden Point Devices](#)

Leica Laser Tracker: Introduction

Leica Trackers are laser tracker-based portable CMMs that you use to take measurements using the Leica T-Probe or reflector. The portable Leica Tracker is a line of sight sensor that can be moved around the part to access different features. The Leica Tracker provides a “Walk-Around” solution to measure even hidden points.

The Laser Tracker takes measurements of single points or scans to create any feature type, similar to a traditional CMM.



To use a Leica device with PC-DMIS, your license or portlock must be programmed with the **Leica** or **LeicaLMF** interface option.

In addition, your license or portlock must not have a **Rotary Table** portlock option enabled. This can cause problems with your portable device.

PC-DMIS supports the following Leica Laser Tracker Models:

Leica: LT500, LTD500, LT300, LT800, LTD800, LT700, LTD700, LT600, LTD600, LT640, LTD640, LTD706, LTD709, LTD840, AT901, AT401, AT402

LeicaLMF: AT930, AT960

PC-DMIS supports the following emScon version:

emScon version 2.4.666 or higher

PC-DMIS supports the following 6DoF systems:

T-ProbeII or T-ProbeI with FW 1.62 or higher (4 button support).

The information provided in the topics in this chapter was written specifically for Leica Laser trackers, but it may be relevant to non-Leica trackers.

Getting Started

There are a few basic steps that you should take to verify that your system has been properly prepared before you begin the measurement process with your laser tracker.

To get started, complete the following steps:

- [Step 1: Install PC-DMIS Portable for Leica](#)
- [Step 2: Connect the Leica Tracker](#)
- [Step 3: Launch PC-DMIS and Configure the Leica Interface](#)
- [Step 4: Customize the User Interface](#)

Step 1: Install PC-DMIS Portable for Leica

1. Connect your portlock (dongle) to your USB port. The portlock must be present during the PC-DMIS installation.
2. Execute setup.exe from the PC-DMIS Installation CD. Follow the on-screen instructions.

If **Leica/LeicaLMF** interface is programmed in your portlock, PC-DMIS loads and uses the Leica/LeicaLMF interface when you work online.

If **All interfaces** is programmed in your portlock (like a demo dongle), you may need to manually rename Leica.dll/LeicaLMF.dll to interfac.dll.
Leica.dll/LeicaLMF.dll is in the PC-DMIS install directory.

3. From the C:\ProgramData\Microsoft\Windows\Start Menu\Programs\<PC-DMIS Version> folder, make a copy the PC-DMIS Online shortcut, and modify its target as follows:

For 6dof Capable Trackers (AT901):

```
C:\<PC_DMIS_INSTALL_DIRECTORY>\PCDLRN.exe "  
/portable:LEICA
```

For 3D Trackers (AT401):

```
C:\<PC_DMIS_INSTALL_DIRECTORY>\PCDLRN.exe "  
/portable:LEICARIO
```

For LMF Trackers (AT930/960):

```
C:\<PC_DMIS_INSTALL_DIRECTORY>\PCDLRN.exe "  
/portable:LEICALMF
```

You will use this newly-created shortcut to launch PC-DMIS and open PC-DMIS with the additional interface items. Do not launch PC-DMIS at this time.

Step 2: Connect the Leica Tracker

Procedure for 6dof Capable Trackers - AT901

Communication with this Leica Tracker is accomplished using the TCP/IP protocol via a cross-over cable that is connected directly to the Leica Tracker Controller (LTC plus/base). This is the preferred method for connection, but you may also connect over your local area network (LAN). For detailed information about setting up your Leica Tracker hardware, see the Laser Tracker Hardware Guide that came with your tracker.

To connect to your Leica Tracker:

1. Secure your tracker in the position from which you will first take measurements.
2. Connect your tracker to the LT controller's "Sensors" and "Motors" ports.
3. Mount the T-Cam (if you are using one) to the top of the tracker and connect T-Cam cable from the tracker to the LT controller.
4. Attach the Meteo station to the serial port on the LT controller if you have one. The Meteo station is used to report environmental data to the LT controller.
5. Directly connect your LT Controller to the computer where PC-DMIS is installed via a cross-over cable with RJ45 connectors. You may also connect the LT controller to the network (LAN) via a twisted-pair Ethernet cable.
6. Turn on the power to the LT controller which provides power to the Leica Tracker as well.
7. Check the status display on the back of the LT controller. This provides information about the IP address (typically 192.168.0.1/255.255.255.0), name, emScon firmware version, and current operation. If your LT controller has a different IP address than the standard 192.168.0.1, do one of the following:
 - Change the IP Address from the "[Options tab](#)" of the **Machine Options** dialog box to the new IP Address of the controller.
 - Use the PC-DMIS Settings Editor and change the TrackerIPAddress entry to the new IP Address of the controller. For information on editing registry settings, see the "Editing PC-DMIS Registry Entries" section of the PC-DMIS Settings Editor documentation.
8. Make sure that the IP address for the PC-DMIS computer is in the same subnet as the controller. For example, if the LT controller has an address of 192.168.0.1, then you

would need to assign an address between 192.168.0.2 and 192.168.0.254. You must avoid IP Address conflicts with other devices on the same network.

9. Type **PING 192.168.0.1** (or a different address of your controller) from the command prompt on the PC-DMIS computer to verify communication to the LT controller.

Procedure for 3D Trackers - AT401

Communication with this Leica Tracker is accomplished using the TCP/IP protocol via a cross-over cable that is connected directly to the Leica AT Controller 400. This is the preferred method for connection, but you may also connect over your local area network (LAN). For detailed information about setting up your Leica Tracker hardware, see the Laser Tracker Hardware Guide that came with your tracker.

To connect to your Leica Tracker:

1. Secure your tracker in the position from which you will first take measurements.
2. Install batteries in the tracker and the tracker controller. The tracker must have a battery in the bay in order to measure however, the battery in the AT Controller 400 is optional.
3. Connect your tracker to the AT controller's "Sensors" port.
4. Optionally connect the power input to the power port on the AT controller. Note, if there is a battery installed in the AT controller and the external power is connected, the battery will NOT be charged. This is due to the amount of heat generated by lithium-ion batteries while they charge.
5. Directly connect your AT Controller 400 to the computer where PC-DMIS is installed via a cross-over cable with RJ45 connectors. You may also connect the AT controller to the network (LAN) via a twisted-pair Ethernet cable.
6. Turn on the power to the AT controller which provides power to the Leica Tracker as well.
7. Check the status display on the face of the AT controller. You will be prompted to level the device first since the Nivel is integrated into the AT 400 unlike the add-on with the LT controllers. The display on the top face of the AT controller also provides you with the ATC400 firmware version, system status, graphical connection information, and weather information. To access the different views press the down arrow button.

8. Make sure that the IP address for the PC-DMIS computer is in the same subnet as the controller. For example, if the AT controller has an address of 192.168.0.1, then you would need to assign an address between 192.168.0.2 and 192.168.0.254. You must avoid IP Address conflicts with other devices on the same network.
9. Type **PING 192.168.0.1** (or a different address of your controller) from the command prompt on the PC-DMIS computer to verify communication to the LT controller.



The needed power-up time depends on the type of tracker. For newer trackers, the first time you power on the device it should remain turned on for *at least two hours* to ensure the most accurate results. Thereafter, the warm-up time when turning on the tracker is between five to seven minutes. If you are not going to be using the laser for a while, you should turn it off to conserve the laser's life-span.

Step 3: Launch PC-DMIS and Configure the Leica Interface

Once you have correctly [installed](#) PC-DMIS and [connected](#) your Leica tracker, you are ready to launch PC-DMIS.

1. Use the shortcut you created in [step 1](#) to start PC-DMIS. The Leica Tracker initializes upon PC-DMIS startup. Initialization causes the tracker to go through a series of movements to ensure proper functionality. If there are other issues that cause the Leica Tracker to not initialize correctly, the LT controller sends messages to PC-DMIS for display.
2. For 6dof systems, PC-DMIS warns you *if* the laser is still warming up. Warming up the laser takes about 20 minutes.
3. Select the needed probe file from the **Select Probe File** dialog box.
4. Use the **Machine Options** dialog box (**Edit | Machine Interface Setup**) to [configure the Leica Interface](#).

Step 4: Customize the User Interface

You can fully customize the colors, fonts, toolbars, and status bars of the PC-DMIS user interface to work optimally with your Leica Laser Tracker. Changing the following interface elements may prove helpful when you measure features at a distance from your computer monitor.

- **Fonts:** Select the **Edit | Preferences | Fonts** menu item to change the fonts and font sizes for PC-DMIS.
- **Background:** Select the **Edit | Graphic Display Window | Screen Color** menu item to alter the background color of the Graphic Display window.
- **Menus:** Select the **View | Toolbars | Customize** menu item, and select the **Use Large Menus** option from the **Menu** tab for large menus.
- **Toolbars:** Select the **View | Toolbars | Customize** menu item, and select the **Use Large Toolbars** option from the **Menu** tab for large toolbars.
- **Status Bar:** Select the **View | Status Bar | Large** menu item for the large status bar.
- **Tracker Status Bar:** Select the **View | Status Bar | Tracker** menu item to toggle the display of the Tracker status bar.



The above settings are preconfigured and installed for the tracker interface.

Creating Customized Toolbars

You can customize and exchange toolbars between PC-DMIS installations. The toolbar.dat file is in the <PC-DMIS Install Directory>/<user name> directory. Copy the toolbar.dat file to the other PC-DMIS installation to make the custom toolbars available. The "[Tracker Toolbars](#)" topic discusses the default toolbars for Leica trackers.

Customizing OpenGL Settings

Adapt the Open GL settings for the solid view mode as required by the installed video card. To do this, select the **Edit | Preferences | OpenGL** menu item. Then make adjustments as explained in the "Changing OpenGL Options" topic in the "Setting Your Preferences" chapter in the PC-DMIS Core documentation.

Leica User Interface

When you configure PC-DMIS to use the Leica interface, additional menu options and status information become available in PC-DMIS.

PC-DMIS provides specific menu options as well as standard menu options that are available when you use the Leica interface. Primarily, there is a new [Tracker Menu](#) that has functions that

are specific to Leica. Additionally, there is a submenu with [Nivel Commands](#) to control the leveling and monitoring processes of the Nivel.

Also unique to the Leica interface are the [Tracker status bar](#), [special Leica controls](#), and [Tracker Overview Cam](#).

There are also [other PC-DMIS menu items](#) and [other PC-DMIS windows and toolbars](#) that are common to PC-DMIS and useful for Leica devices.

This section discusses only a few of the menu items that you would use with the Leica interface. For general information on using PC-DMIS, refer to the PC-DMIS Core documentation.

Tracker Menu

Tracker Menu for 6dof Trackers

Station Management - Brings up the tracker **Station Manager** dialog box. For details, see the "[Adding and Removing Stations](#)" topic.

Initialize - This command initializes encoders and internal components of the laser tracker. This command is automatically called when PC-DMIS first connects to the Laser Tracker (emScon) controller once the tracker is warmed up. The tracker goes through a series of movements to verify the functionality.

Go Birdbath - The Leica Tracker points the laser to the BirdBath position. The beam is "attached" to the reflector in the BirdBath, and the interferometer distance is set to the known BirdBath distance. This command is especially important for LT series trackers without integrated ADM. For such trackers, there is no other way to set the interferometer distance.

With the laser pointed at the BirdBath position, this provides a known and convenient location at which you can recapture the beam. This may be necessary if the beam to the Reflector has been broken.

Go 6DoF 0 Position - The Leica Tracker points the laser in the opposite direction of the BirdBath position to the 6DoF 0 position. This provides a known and convenient location at which you can recapture the beam with the T-Probe.

Find - Searches for a reflector or T-Probe at the current laser position. The find function is performed based upon the **Search Settings** provided in the "[Sensor Configuration tab](#)".

Release Motors - Releases the horizontal and vertical tracker head motors in order to allow manual tracker head movement.

Laser ON/OFF - Toggles the laser to be on or off.



Turning the laser on again requires about 20 minutes for it to stabilize.

Nivel - See "[Nivel Commands](#)".

Probe Comp ON/OFF - When the probe compensation is "ON", PC-DMIS compensates by the radius of the T-Probe tip or the reflector sphere. During bundle alignment creation, PC-DMIS automatically activates or deactivates probe compensation as needed when it measures points.

Stable Probing ON/OFF - When stable probing is "ON", PC-DMIS automatically triggers a hit if you leave a reflector in a position for a specified time. This allows for hits to be taken, without using a remote control or interacting directly with the computer.

PowerLock ON/OFF - This turns the PowerLock functionality on or off. When turned on, the tracker's laser beam can very quickly re-lock on the device without needing you to catch the beam manually. If you break the laser beam, simply point the reflector or other supported T-product measuring device at the tracker, and the tracker immediately catches the beam for you. This is usually very helpful while you are relatively close to the tracker. If you are working far away from the tracker, you may want to turn off PowerLock because the field of view is so large that the laser always locks on even if that isn't what you want. In addition, multiple reflectors in the field of view could confuse the tracker and cause problems. This icon will be disabled for trackers that do not support the PowerLock functionality.

Insert Tracker Command - Determines whether or not PC-DMIS inserts a command into the Edit window when you select to perform a Tracker operation from the **Tracker** menu or **Tracker Operations** toolbar. If you enable this menu item, a check mark appears next to it. You can also toggle this on or off through the **Insert a tracker command** icon on the **Tracker Operations** toolbar.

Move Feature - See the "[Move Feature \(Move To / Point To\)](#)" topic.

Tracker Menu for 3D Trackers

Station Management - Brings up the tracker **Station Manager** dialog box. For details, see the "[Adding and Removing Stations](#)" topic.

Tracker Pilot - See the "[Tracker Pilot Commands](#)" topic.

Measurement Profile - See the "[Tracker Measurement Profile Commands](#)" topic.

Initialize - This command initializes encoders and internal components of the laser tracker. This command is automatically called when PC-DMIS first connects to the Laser Tracker controller once the tracker is warmed up. The tracker goes through a series of movements to verify functionality.

Go 0 Position - This moves the tracker to the zero position. This is a user-defined setting in the [Machine Options](#) dialog box (**Edit | Preferences | Machine Interface**).

Find - Searches for a reflector or T-Probe at the current laser position. The find function is performed based upon the **Search Settings** provided in the "[Sensor Configuration tab](#)".

Change Face - This rotates the tracker head and camera by 180 degrees. The final target position will be the same as it was before the command was issued, except that now the optics are inverted.

Compensator On/Off - This turns the compensator on or off. The compensator adjusts the measurements taken by the device in order to level them to the gravity vector calculated on the machine. This can be helpful when all measurements need to be referenced off of the level of the ground.

Release Motors - Releases the horizontal and vertical tracker head motors in order to allow manual tracker head movement.

Probe Comp ON/OFF - When the probe compensation is "on", PC-DMIS will compensate by the radius of the T-Probe tip or the reflector sphere. During bundle alignment creation, PC-DMIS will automatically activate or deactivate probe compensation as needed when measuring points.

Stable Probing ON/OFF - When stable probing is "on", PC-DMIS will automatically trigger a hit if you leave a reflector in a position for a specified time. This is set from the **Probing** tab on the **Parameter Settings** dialog box (F10). It is only available if you are running as a tracker. This allows for hits to be taken, without using a remote control or interacting directly with the computer.

PowerLock ON/OFF - This turns the PowerLock functionality on or off. When turned on, the tracker's laser beam can very quickly re-lock on the device without needing you to catch the beam manually. If you break the laser beam, simply point the reflector or other supported T-product measuring device at the tracker, and the tracker immediately catches the beam for you. This is usually very helpful while you are relatively close to the tracker. If you are working far away from the tracker, you may want to turn off PowerLock because the field of view is so large that the laser always locks on even if that isn't what you want. In addition, multiple reflectors in

the field of view could confuse the tracker and cause problems. This icon will be disabled for trackers that do not support the PowerLock functionality.

Two Face Mode ON/OFF - If “Insert Tracker Command” is active in the tracker menu, PC-DMIS inserts a tracker command into the measurement routine that is associated with the current Two Face mode On/Off state. The Two Face setting on the sensor is also updated according to the active setting in the measurement routine.

Insert Tracker Command - Determines whether or not PC-DMIS inserts a command into the Edit window when you select to perform a Tracker operation from the **Tracker** menu or **Tracker Operations** toolbar. If you enable this menu item, a check mark appears next to it. You can also toggle this on or off through the **Insert a tracker command** icon on the **Tracker Operations** toolbar.

Move Feature - See the "[Move Feature \(Move To / Point To\)](#)" topic.

Tracker Pilot Commands

The **Tracker | Tracker Pilot** submenu appears for 3D trackers.

The order of these menu options may differ somewhat based on your Tracker Pilot model:

Two Face Check

Scale Bar Check

Tip Check

ADM Check

Angle Check

Probe Check

Angle Compensation

ADM Compensation

Tip Compensation

Each of these menu items starts the Tracker Pilot in wizard mode for the selected check or compensation mode. Because the functionality of these options varies with the installed Tracker Pilot version and model, the documentation is not included here. Refer to your specific Tracker Pilot reference manual for information on these items.

Tracker Measurement Profile Commands

The **Measurement Profile** submenu is found by clicking the **Tracker | Measurement Profile** menu item.

The options are:



Standard: Useful in controlled environments to provide relatively high measurement accuracies.



Fast: Useful for handheld applications when you need measurements as fast as possible.



Precise: Provides the highest measurement accuracies but requires longer measurement periods.



Outdoor: Useful for almost any kind of outdoor measurement application (not available for LeicaLMF trackers).



Continuous Distance: Useful for contact scans which have a fixed distance between hits. The Distance delta value is set from the **Probing** tab of the **Parameter Settings** dialog box (**Edit | Preferences | Parameters**).



Continuous Time: Useful for contact scans which have a fixed time between hits. The Time delta value is set from the **Probing** tab of the **Parameter Settings** dialog box (**Edit | Preferences | Parameters**).

You can set these commands from the **Tracker Operation** toolbar (**View | Toolbars**).

The currently active measurement profile displays in the tracker status bar. The toolbar button is implemented to display a submenu with the available measurement profiles depending on the tracker you are using.

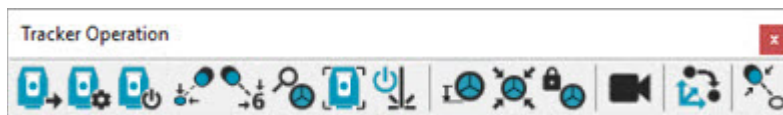
If **Insert Tracker Command** is turned ON in the **Tracker** menu, PC-DMIS inserts the tracker command into the measurement routine that is associated with the current measurement profile. The active measurement profile on the sensor is then updated according to the active measurement profile command in the measurement routine.



If the tracker provides measurement profile settings, the Measurement time setting in the Tracker **Machine Interface Setup** dialog box will not be available as the tracker internally determines the optimal measurement time.

Tracker Toolbars

The default Leica tracker toolbars are shown below. These are available when you launch PC-DMIS Portable using a Leica tracker interface.



Tracker Operation toolbar (for AT-901 Trackers)

- [Tracker | Insert Tracker Command](#)
- [Tracker | Station Management](#)
- [Tracker | Initialize](#)
- [Tracker | Go Birdbath](#)
- [Tracker | Go 6DoF 0 Position](#)
- [Tracker | Find](#)
- [Tracker | Release Motors](#)
- [Tracker | Laser ON/OFF](#)
- [Tracker | Probe Comp. ON/OFF](#)
- [Tracker | Stable Probing ON/OFF](#)
- [Tracker | PowerLock ON/OFF](#)
- [View | Other Windows | Tracker Overview Cam](#)
- [Insert | Alignment | Bundle Alignment](#)
- [Tracker | Move Feature](#)



Tracker Operation toolbar (for AT-930/960 and AT-403 Trackers)

- [Tracker | Insert Tracker Command](#)
- [Tracker | Station Management](#)
- [Tracker | Initialize](#)
- [Tracker | Go 0 Position](#)
- [Tracker | Find](#)
- [Tracker | Change Face](#)
- [Tracker | Compensator On/Off](#)
- [Tracker | Probe Compensation](#)
- [Tracker | Stable Probing](#)
- [Tracker | PowerLock ON/OFF](#)
- [View | Other Windows | Tracker Overview Cam](#)
- [Tracker | Measurement Profile](#)
- [Tracker | Two Face Mode ON/OFF](#)
- [Insert | Alignment | Bundle](#)
- [Tracker | Move Feature](#)



Tracker Measure

- **Edit | Preferences | Machine Interface Setup**
- **Operation | Take Hit**
- **Operation | Start/Stop Continuous Mode**
- **Operation | End Feature**
- **Operation | Erase Hit**
- **Edit | Delete | Last Feature**



Tracker Nivel

- **Tracker | Nivel | Start 'Level to Gravity' Process**
- **Tracker | Nivel | Start Tilt Readout**
- **Tracker | Nivel | Start/Stop Monitoring**

For information on these options see "[Nivel Commands](#)" below.

Nivel Commands

The **Tracker | Nivel** menu has these commands. You can also find these commands on the **Tracker Nivel** toolbar:



Start Orient to Gravity Process: PC-DMIS uses the Nivel 20/230 device to create a gravity plane and then automatically create a coordinate system based on the gravity plane information. Once it completes the process, the monitoring process starts automatically.



Start Tilt Readout: Starts an X, Y tilt readout to bring the tracker into the working range of the Nivel by adjusting the Tracker base foot screws.



Start/Stop Monitoring: Starts or stops monitoring independent from the Orient to Gravity process.

See: "[Orienting the Tracker to Gravity](#)"

Tracker Status Bar

You can use the **View | Statusbar | Tracker** menu item to toggle the visibility of the Tracker status bar.

Status bar for 6dof Machines:





1. **System Laser Status Indicator:** This indicates the status of the Laser Tracker system.
 - **Green** (Ready): The system is ready to measure.
 - **Yellow** (Busy): The system is currently measuring.
 - **Red** (Not ready): The system is not ready to measure. This may be due to a broken beam or a T-Probe reflector mismatch.
 - **Blue** (6dof error): The camera cannot see enough LEDs on the device (usually a T-Probe) to accurately calculate the orientation of the probe.
2. **Active Station Indicator:** Indicates which station is currently active. Double-click onto the station indicator to open the [Station Manager](#) dialog box.
 - **Red** (Not oriented): The station position has not been computed yet.
 - **Green** (Oriented) The station position has been computed.
3. **Environmental Parameter Display:** Shows the active environmental parameters of temperature, pressure, and humidity. If no weather station is connected, you can double-click on the boxes to change their values.


Status Bar for 3D Machines:



1. **System Laser Status Indicator:** This indicates the status of the Laser Tracker system.
 - **Green** (Ready): The system is ready to measure.
 - **Yellow** (Busy): The system is currently measuring.
 - **Red** (Not ready): The system is not ready to measure. This may be due to a broken beam or a T-Probe reflector mismatch.
 - **Blue** (6dof error): The camera cannot see enough LEDs on the device (usually T-Probe) to accurately calculate the orientation of the probe.
2. **Active Probe Name:** This displays the currently-active reflector or probe.

3. **Active Probe Diameter:** Current reflector or probe diameter.
4. **Probe Compensation Indicator:** Displays the current state of probe compensation.
5. **Active Station Indicator:** Indicates which station is currently active. Double-click on the station indicator to open the [Station Manager](#) dialog box.
 - **Red** (Not oriented): The station position has not been computed yet.
 - **Green** (Oriented) The station position has been computed.
6. **Environmental Parameter Display:** Shows the active environmental parameters of temperature, pressure, and humidity. If no weather station is connected, you can double-click on the boxes to change their values.
7. **Battery Indicators:** There are two indicators, one for the device and one for the controller. If the batteries are active, the status indicators display the percent power left in each individual battery. If the battery has more than 25% power, the background of the text is green. If the power level is between 10% & 25%, the color is yellow. If the power drops below 10%, the color changes to red. If the external power is active, the color of the fields changes to gray and there are no numbers in the fields. Also, the battery icons change to display small external power chords.
 - Device Icons: 
 - Controller Icons: 
8. **Tracker Measurement Profile Mode:** Only shown with firmware v2.0 or higher. It displays the current measurement profile mode of the tracker.



For some reason, if PC-DMIS fails to determine the measurement profile mode, the toolbar button icon and the status bar icon for the measurement profile display the status unknown symbol (). If this happens, select the measurement profile from the toolbar button or the tracker menu.

Special Leica Controls

Tracker Head Movements: You can use the Alt + left arrow, right arrow, up arrow, and down arrow keyboard keys to control the direction that the laser is pointing. Use Alt + Space to stop the movement of the laser. The tracker motors must be engaged for these controls to work (**Tracker | Release Motors** - Alt-F12).

These options appear on the shortcut menu that appears when you right-click on a feature in the Edit window:

Point To: This points to the feature's nominal position (Laser Pointer).

Move To: This moves to the features nominal position (Go Position).

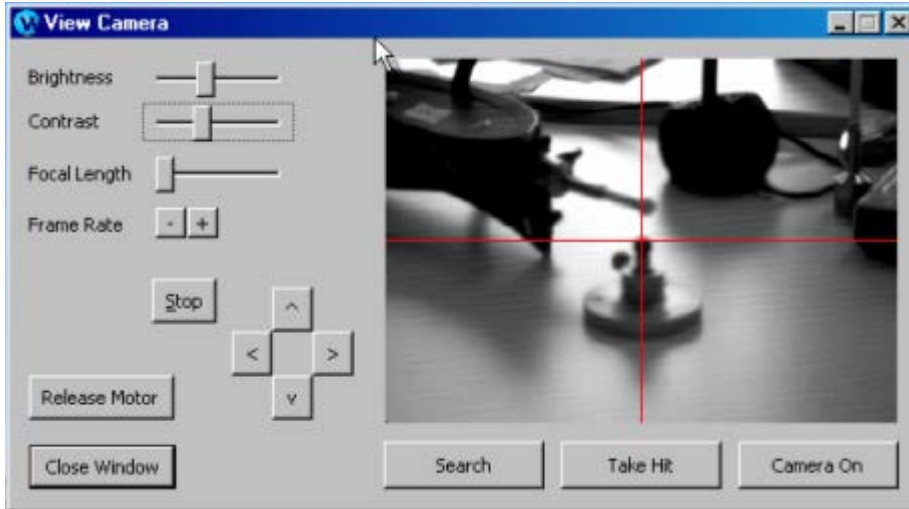
Using the Tracker Overview Cam

The Leica T-Cam mounts to the top of your Leica Tracker and provides true depiction and calculation of the Target Device's spatial position with respect to the T-Cam/Tracker. The tracker provides the horizontal movement for the T-Cam.

This displays the view from the Overview Camera (T-Cam), which allows you to move the tracker head and find reflective targets.

To use the T-Cam to find a measured target:

1. Mount the T-Cam to the top of the Leica Tracker according to the "T-Cam Hardware Guide" provided by Leica.
2. Select the **View | Other Windows | Tracker Overview Cam** menu item to open the **View Camera** dialog box.



View Camera dialog box that shows a view of a reflector

3. Click **Release Motor** and approximately aim the camera at the target by moving the laser tracker head. The Overview Cam will move in relation to the movements that are made with the tracker head. When the camera/tracker laser is pointing at the target, click **Release Motor** again to re-engage the tracker motors.
4. Adjust the **Brightness**, **Contrast**, **Focal Length**, and **Frame Rate** as needed to clearly see the target.
5. Use the arrow keys to more precisely aim the laser at the intended target. Click **Stop** to stop any movement initiated by the arrow keys when the laser points to the target. You may also use the "[Special Leica Controls](#)" to aim the laser.
6. Click **Search** to run the procedure that automatically finds the center of the target and locks the laser onto that position.
7. Click **Take Hit** to measure the target's location. If you are unable to take a hit, you may need to redo some or all of the previous steps to ensure that the laser can measure from the intended reflector.
8. Use the **Camera On** button to toggle the display of the camera image.

Other PC-DMIS Menu Items

Operation Menu

End Feature (END) - Tells PC-DMIS that the number of hits for the feature has been reached and it can calculate the feature.

Erase Hit (Alt + -) - Deletes the last-measured hit.

Take Hit (Ctrl + H) - Measures a stationary T-Probe or Reflector position based on the measuring profile specified on the [Sensor Configuration tab](#) of the **Machine Options** dialog box or on the **Tracker Operations** toolbar, respectively.

Move To - Opens the **Move Point** dialog box, which enables you to insert a [MOVE / POINT](#) command into the measurement routine. See the "Inserting a Move Point Command" topic in the "Inserting Move Commands" chapter in the PC-DMIS Core documentation for more information.

Start/Stop Continuous Mode (Ctrl + I) - Starts or stops a scan, based on the basic scan settings on the **Probing** tab of the **Parameter Settings** dialog box (**Edit | Preferences | Parameters**). The default value for **Distance delta** provides a continuous distance separation of 2mm.



The AT401 does not support the Start/Stop Continuous Mode.

Other PC-DMIS Windows and Toolbars

The PC-DMIS Core documentation provides the following information that is relevant for trackers:

Settings toolbar:

For information, see the "Settings Toolbar" topic in the "Using Toolbars" chapter in the PC-DMIS Core documentation.

The third drop-down box displays Reflector and T-Probe compensations from the emScon server (and any additional ones that are manually defined).

Probe Readouts window:

For information, see "Using the Probe Readouts Window" in the "Using Other Windows, Editors, and Tools" chapter in the PC-DMIS Core documentation.

Also, see the ["Customizing the Probe Readout"](#) topic for Leica-specific settings.

Edit window:

For information, see the "Using the Edit Window" chapter in the PC-DMIS Core documentation.

Quick Start interface:

For information, see "Using the Quick Start Interface" in the "Using Other Windows, Editors, and Tools" chapter in the PC-DMIS Core documentation.

Status window:

For information, see "Using the Status Window" in the "Using Other Windows, Editors, and Tools" chapter in the PC-DMIS Core documentation.

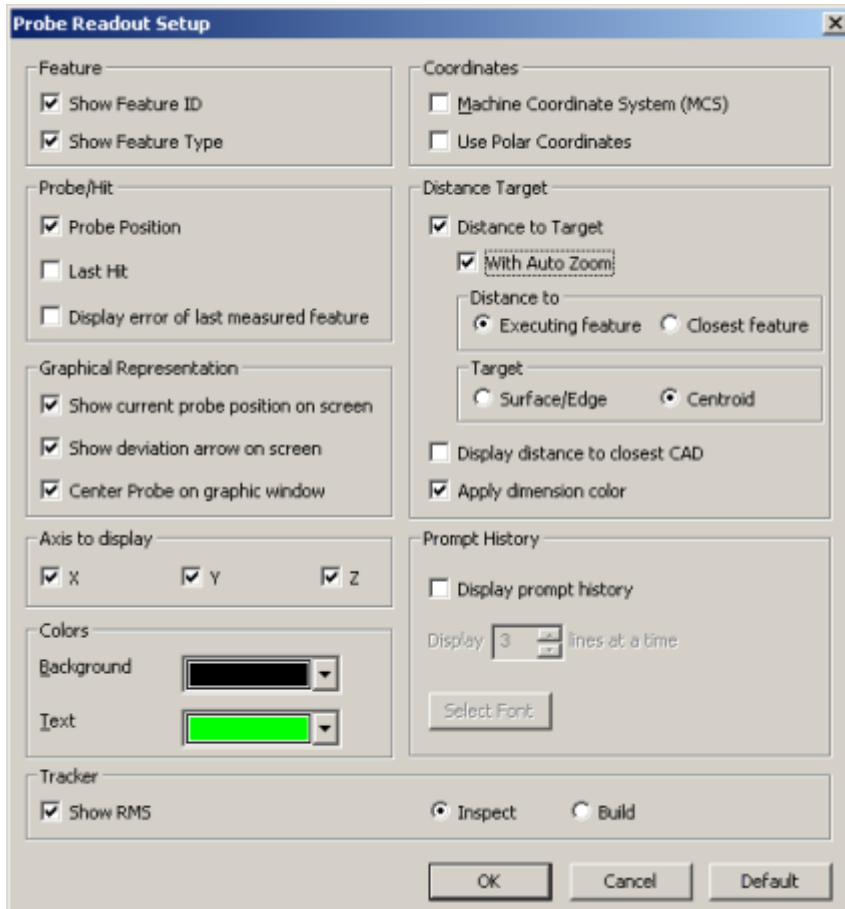
Tracker status bar:

For information, see the "[Tracker Status Bar](#)" topic.

Customizing the Probe Readout

The **Probe Readout Setup** dialog box has various options that you can use to work with Leica trackers. This topic discusses a few key options that relate to Leica tracker usage.

To access the **Probe Readout Setup** dialog box, select the **Edit | Preferences | Probe Readout Setup** menu item. To access this dialog box directly from the Probe Readouts window, right-click and select **Setup**. (For more information on the **Probe Readout Setup** dialog box, see "Setting Up the Probe Readouts Window" in the "Setting Your Preferences" chapter in the PC-DMIS Core documentation.)



Probe Readout Setup dialog box

Show Feature ID: Displays the Feature ID for the feature being executed, or the closest feature depending on the **Display distance to closest CAD** option.

Show Feature Type: Displays the type of feature that corresponds to the feature being executed.

Show current probe position on screen: Displays a 3D representation of the current position in the Graphic Display window.

Show deviation arrow on screen: Displays a 3D arrow in the Graphic Display window that indicates the direction of deviation. The tail of the arrow is always drawn to the probe location in inspect mode and the measured point in build mode.

Center Probe on graphic window: The graphical representation of the current probe always appears in the center of the Graphic Display window.

Distance to Target: This is an execute-only option. In execute mode, it shows the distance from the probe to the feature being executed or the closest feature depending on the **Display distance to closest CAD** option.

Distance to... Executing Feature or Closest Feature: This option allows you to display the currently executing feature ID or the feature ID for the closest feature to your current probe location. The distance to that feature updates according to the feature selected (executing or closest).

Target: Selecting **Centroid** calculates the distance to the centroid of the feature. Selecting **Surface/Edge point** calculates the distance to the point, which is on the feature or CAD element and closest to the centroid.

Display Distance to closest CAD: Shows the distance from probe to the closest CAD element.

Apply dimension color: This check box changes the colors of the deviation values (Distance to Target values) to match the out-of-tolerance dimension colors.

Show RMS: Displays the RMS value as you take hits.

Inspect / Build mode: By default (**Inspect** mode), PC-DMIS displays the deviation (T) as *Difference = Actual - Nominal*.

- **Build Mode:** The general purpose is to provide real-time deviations between a real object and its nominal data or CAD model. This allows you to position your part as it relates to the CAD design data.

This option displays the distance and direction that you need to move the measured point to reach the nominal position or *Difference = Nominal - Actual*



When you move the part into position, PC-DMIS just displays real-time deviations without storing any data (taking hits). After the part is positioned within a reasonable deviation (such as 0.1 mm), you would typically take hits to measure the final position of the feature.

- **Inspect Mode:** In this mode, the position of an object (point, line of surface, etc.) is checked and compared with design data.

Useful Keyboard Shortcuts for Trackers

When you use a Leica tracker, the following keyboard shortcuts are useful for remote control usage:

Function	Supported Devices	Shortcut
Go Birdbath	6dof only	Alt + F8
Go 6DoF 0 Position	6dof only	Alt + F9
Go 0 Position	3D only	Alt + F9
Find		Alt + F6
Release Motors	6dof only	Alt + F12
Probe Compensation ON/OFF		Alt + F2
Stable Probing ON/OFF		Alt + F7
Measure stationary point		Ctrl + H
Start/Stop continuous measurement	6dof only	Ctrl + I
End Feature		End
Erase Hit		Alt + -

Leica Feature Parameters in Offline Mode

When you use a Leica Tracker in online mode to generate feature commands, PC-DMIS automatically inserts the following information into the Edit window inside those feature commands:

- **RMS** - Root Mean Squared value of each hit.
- **Probe Type** - The type of probe used to measure the feature.
- **Time Stamp** - The time the feature was executed or learned. PC-DMIS updates this only when it actually measures a feature in online mode.
- **Environmental Conditions** - Information such as temperature, pressure, and humidity.

In offline mode, PC-DMIS behaves differently. These Leica Tracker items only appear after you select the **Show tracker parameters in offline** check box on the **General** tab of the **Setup**

Options dialog box. These parameters only appear for new feature commands that you insert into the measurement routine after you select this option. Previously-measured features remain unaffected except for a permanent structure change adding in an empty Tracker Parameter group into each feature command.



If you select this check box, it permanently changes your measurement routine structure for inserted feature commands regardless of if you later clear this check box. For example, if you clear this check box after you've already used it for some features, newly-inserted features still contain a Tracker Parameter group, but that group does not contain any group items.

Using Leica Utilities

The Leica interface provides new utilities that are specific to the Leica interface. The following topics discuss this functionality:

- [Initializing the Leica Tracker](#)
- [Orienting the Tracker to Gravity](#) (6dof devices only)
- [Defining Environmental Parameters](#)
- [Toggling the Laser and Probe Compensation](#) (toggling the laser is only valid for 6dof devices)
- [Resetting the Tracker Beam](#) (6dof devices only)
- [Releasing Tracker Motors](#) (6dof devices only)
- [Finding a Reflector](#)

Initializing the Leica Tracker

When you start PC-DMIS, the Leica Tracker starts the initialization process. The Leica Tracker performs a series of self-checks to verify that everything works correctly. You can also select the **Tracker | Initialize** menu item to initialize the Leica tracker.

When you move the tracker to a new station for a [bundle alignment](#), it is necessary to re-initialize the tracker. When you turn the laser back on, you must also initialize the tracker.



It is strongly recommended that you initialize the encoders and internal components of your tracker two to three times a day. This is important due to thermal expansion of the tracker hardware, which has a direct influence on the measurement accuracy.

Orienting the Tracker to Gravity (6dof devices only)

The NIVEL inclination sensor is designed for use with the Leica Geosystems Laser Tracker series. The NIVEL mounts on the top of the sensor unit or on the top of the Overview Camera / T-CAM to establish the parameters for the Orientation to Gravity. It then mounts on a bracket to monitor the stability of the Laser Tracker.

For detailed information on the configuration and use of the Nivel sensor, see the "Nivel 230 Hardware Guide" provided with your Nivel sensor. Leveling to gravity is not required, but it does improve the Leica Tracker measurement results.

To level to gravity and monitor the Leica Tracker:

1. Mount the Nivel sensor to the top of the Leica Tracker or the top of the T-Cam (if it is already mounted to the tracker). See the "Nivel 230 Hardware Guide".
2. Connect the LEMO cable to the Nivel.
3. Select the **Tracker | Nivel | Start Tilt Readout** menu item to display the Tilt Readouts window. The Tilt Readouts window helps by reading the Nivel measurement three times per second. You can maximize the values on the whole screen if you need to.



Using the Tilt Readouts window to roughly level the tracker

4. Use the Tilt Readouts window to level the Leica Tracker base and the Nivel according to the steps in the "Nivel 230 Hardware Guide".
5. When the tracker is roughly leveled and brought into an acceptable working range, select the **Tracker | Nivel | Start Orient to Gravity Process** menu item. The laser tracker then

performs Nivel measurements in all four Quadrants of the laser tracker and creates a generic plane feature and a leveled sensor coordinate system based on this plane.



Any additional new alignment commands can use the gravity information if required.

6. Once you complete the procedure, PC-DMIS prompts you to move the Nivel to the monitoring position.



7. Mount the Nivel to the monitoring position according to the steps in the "Nivel 230 Hardware Guide".
8. Select the **Tracker | Nivel | Start Monitoring** menu item. This begins to monitor the status of the Leica Tracker. The [Level To Gravity tab](#) of the **Machine Options** dialog box provides information about the leveled status. Every 60 seconds, a reference Nivel measurement is made and compared with the original orientation.



The monitoring process makes sure that nobody moves or hits the tracker. You can start it explicitly if no Gravity plane is needed. In this case, you should monitor only the stability of the system.

Defining Environmental Parameters

Temperature, pressure, and humidity affect the measurement values that your Leica tracker acquires. Compensation is provided for measurements based on the changes in these values, which calculate the refraction index of IFM / ADM.

You can use a Meteo Station to provide these values, or you can manually enter these values if you do not have a Meteo Station. When the Meteo station is enabled, the refraction is calculated every 30 seconds. For changes that are greater than 5 ppm, the parameters are updated accordingly.

To manually alter these values, do one of the following:

- From the **Machine Options** dialog box (**Edit | Preferences | Machine Interface Setup**), edit the Leica environmental parameters. If you have a Meteo station but would like to manually edit the values, deselect the **Use Temperature Station** option.
- From the Leica status bar (**View | Status Bar | Tracker**), edit the environmental values by clicking on the value and typing the new value.

Toggling the Laser and Probe Compensation

Laser Toggle (6dof devices only)

To toggle the laser on and off, use the **Tracker | Laser ON/OFF** menu item or toolbar icon. This allows you to preserve the laser's life-span (lasers last about 20,000 hours). There also may be time that you just don't want or need to have the laser on. The laser requires about 20 minutes to warm up before you begin to use it.



Once you turn the laser off, you must wait for 20 minutes when you turn it back on. You also need to [reinitialize](#) the Leica Tracker.

Probe Comp Toggle

To determine whether probe compensation is applied for a measured point, use the **Tracker | Probe Comp. ON/OFF** menu item or toolbar icon. When this is "on", PC-DMIS compensates by the radius of the T-Probe tip or the reflector sphere. During bundle alignment creation, PC-DMIS automatically activates or deactivates probe compensation as needed when it measures points.

Resetting the Tracker Beam (6dof devices only)

If the laser beam from the Leica Tracker is broken and the tracker is unsuccessful in following the reflector or T-Probe location, it might be necessary to reset the position to which the laser is pointing. This allows you to recapture the beam at a known location.

This is mainly used for LT trackers, which do not have an integrated ADM.

You can reset the laser to point to one of two positions:

- **Birdbath:** Select **Tracker | Go Birdbath** to reset the laser to point to the Birdbath position. Use this when you work with reflectors.
- **6DoF:** Select **Tracker | Go 6DoF 0 Position** to reset the laser position by pointing to the predefined T-Probe 0 position. This enables you to catch the beam at that location. Use this when you work with a T-Probe.

Use these options to catch the reflector again and bring the reflector or T-Probe to a stable position. This will re-establish a distance via ADM and enables you to continue.

Releasing Tracker Motors (6dof devices only)

You can release the Tracker Motors to allow you to manually move the Leica tracker to the desired location. To do this, press the green "Motors" button on the LT controller or select the **Tracker | Release Motors** menu item.

You can also release motors through the [View Camera](#) dialog box or press Alt-F12.

Finding a Reflector

The Find function allows you to search in a spiral pattern to find the actual location of a reflector or T-Probe (6dof system only) with your Leica Tracker or Total Station device.

Finding a Reflector Location Using a Leica Tracker Device

1. Point the Tracker laser approximately to the location of the desired reflector. You can do this in these ways:
 - "[Releasing Tracker Motors](#)" (6dof system only) and manually moving the laser to the location.



You do not need to release the motors on the 3D systems.

- Use the control buttons on the **ADM** tab of the **Machine Options** dialog box (**Edit | Preferences | Machine Interface Setup**).
- Use the [Overview camera](#).

- Use the Alt + left arrow, right arrow, up arrow, and down arrow keyboard keys to move the tracker head. Use Alt + Space to stop movement of the laser.
2. Select the **Tracker | Find** menu item. The tracker device searches in a spiral pattern and take readings until the reflector sends the signal back to the device. This locates the position.

Finding a Reflector Location Using a Total Station Device

1. Point the Total Station laser approximately to the location of the desired reflector. You can do this in these ways:
 - Manually move the laser to the location.
 - Use the Alt + left arrow, right arrow, up arrow, and down arrow keyboard keys to move the tracker head. Use Alt + Space to stop movement of the laser.
2. Select the **Total Station | Find** menu item. The total station device searches in a spiral pattern and takes readings until the reflector sends the signal back to the device. This locates the position.



You can only execute this function from the [View Camera](#) dialog box.

Using Auto-Inspect Mode

Auto-Inspect mode provides automated inspection of a sequence of points using a Leica tracker. This process is essentially the same as the typical point inspection process, except that the process may run unattended as the tracker automatically moves from one position to the next one.

This process is often used for deformation measurements or repeated stability studies over a long time range. Each of the positions that are going to be auto inspected are typically equipped with a separate reflector.

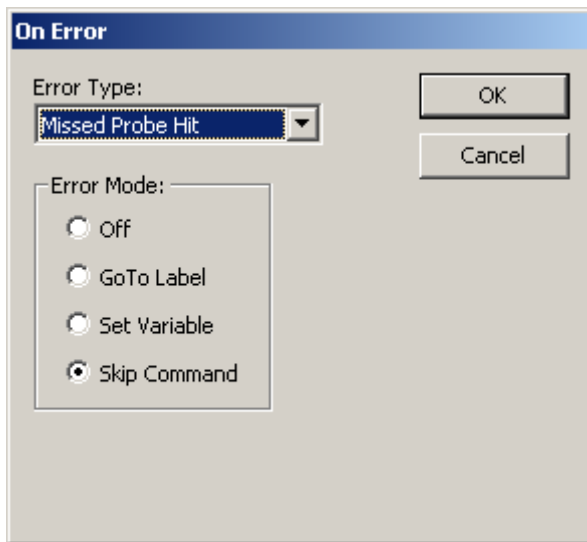
For example, some typical cases for Auto-Inspect might include:

- Inspecting four points distributed over the full working range of the laser tracker. Those four points could be inspected automatically at the beginning and end of a measurement routine to verify that the tracker position has not moved during the measurement process.

- Checking the repeatability of 10 reflector positions mounted to a large structure. For example, you could measure these 10 points every 15 minutes over a time span of 24 hours.

To use Auto-Inspect mode:

1. Open or create a measurement routine.
2. Insert a Manual/DCC mode command, and set it to DCC.
3. Select the **Insert | Flow Control Command | On Error** menu item to insert an **On Error** command.



On Error dialog box

4. Select the 'Missed Probe Hit' **Error Type** and the **Skip Command** option.
5. Insert points for each mounted reflector. To insert each point into your measurement routine:
 - a. Aim the tracker at the reflector.
 - b. Press Ctrl+H to take a hit.
 - c. Press the End key on your keyboard.
6. Execute the measurement routine.

In execution mode, PC-DMIS automatically measures each of these points as follows:

1. The Leica tracker points to the first point (position).


2. The laser locks onto the positions if possible. If no reflector is there, or no reflector has been found with the current search settings, PC-DMIS continues to the next feature.
3. If the laser locks onto the reflector, it measures the point.
4. The process is repeated (steps 1 through 3) until PC-DMIS has measured or skipped all points.

For any points that were skipped, error message "Reflector not Found" displays to alert you to the problem or problems. You can then take corrective action for skipped points. The error contains a message that there was an error, the feature ID for the error, and the coordinate location of the feature. The report also contains a message for any points that were skipped.

Using Move Feature (Move To / Point To)

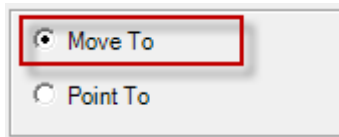
The screenshot shows the "Move Feature" dialog box. It has a title bar "Move Feature". Inside, there are two main sections. The left section contains radio buttons for "Cartesian" (selected), "Polar", "Theo" (selected), and "Meas". Below these are input fields for X, Y, and Z coordinates, all set to "0.0000". At the bottom of this section are radio buttons for "Move To" (selected) and "Point To". The right section is a list box containing a tree structure of features: "PLN1" (with a plus icon), "CIR1" (with a plus icon), "CIR1" (with a minus icon), "CIR1" (with a minus icon), "CIR1" (with a minus icon), and "CIR1" (with a plus icon). To the right of the list box are two buttons: "Create" (highlighted with a blue border) and "Close".

Move Feature dialog box

The **Move Feature** dialog box is available when you use either a Leica Tracker or a Leica Total Station device. It appears when you select the **Move Feature** toolbar icon  from the **Tracker Operation** or **Total Station Operation** toolbar. You can also select the **Tracker | Move Feature** or **Total Station | Move Feature** menu item.

The **Move Feature** dialog box contains the **Move To** and **Point To** options. These commands are used only with the Leica Total Station or Leica Tracker devices. In addition to the standard move ability of other DCC systems, the **Point To** command exploits the unique capabilities of these tracker-type systems by using the device as a laser pointer to identify, directly on the part, the location of out-of-tolerance points.

Move To



This option moves the device to a specific location where it then tries to find a reflector.

To move to a point, select the **Move To** option and then define where it should move to. There are three ways to specify the location to which it should move.

- **Method 1:** Type the values into the **X**, **Y**, and **Z** boxes (or **R**, **A**, and **Z** if you use the **Polar** option).
- **Method 2:** Select the feature that you are going to move to out of the **Feature** list. When you select the feature, PC-DMIS fills in the **X**, **Y**, and **Z** values based on the centroid of the feature.
- **Method 3:** Expand the feature by selecting the + symbol next to it to display the hits on the feature. While "hits" is something of a misnomer, it means the point measured by the laser device. Select one of the hits from the list. PC-DMIS fills in the **X**, **Y**, and **Z** values for that hit.

To move to the measured or theoretical value for the point, choose either the **Theo** or **Meas** option.

Once you have set up the command correctly, click **Create** to insert the command into the Edit window.

```
MVF1          =MOVE FEATURE/MOVE TO,CARTESIAN,THEO,<-
36.3574,33.3898,-10.8127>,
```

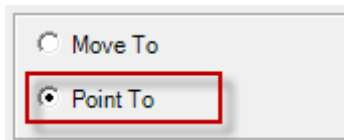
```

FILTER/NA,N WORST/1,
POINT TO METHOD/NA,DELAY IN SEC/0.0000,
REF/PNT1,

```

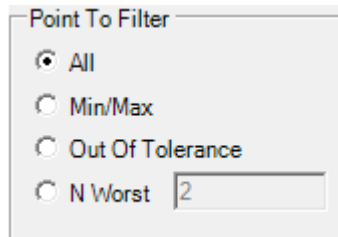
When PC-DMIS executes this command, the device automatically moves to the position indicated and attempts to find a reflector. If no reflector is found, an error displays that says "AUT_FineAdjust - Request timed out". To get past this error, if there is a nearby reflector, use the **Execution Options** dialog box and stop the execution, adjust the location to point nearer the reflector, and then click **Continue**. If a reflector is not close by, click **Skip** to move onto the next point.

Point To



To point to different hits, the procedure is the same as the "Move To" information above, but there are some additional options. With **Point To** you can also select from available dimensions in the measurement routine. If you select a dimension, PC-DMIS displays the **Point To Filter** and **Point To Method** areas. You do not need to select individual hits in the expanded dimension. All of the hits visible in the dimension will be pointed to, although you can use the **Point to Filter** area to filter hits.

Point To Filter



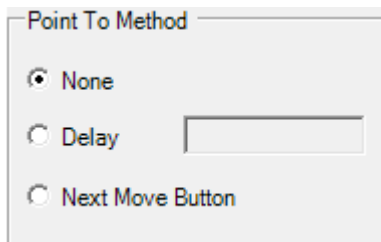
The **Point To Filter** area displays options that control which hits are pointed to. The options include:

- **All** - PC-DMIS points to each point in the dimension.
- **Min/Max** - PC-DMIS identifies and points to only the Min and Max points.
- **Out Of Tolerance** - PC-DMIS points to only the out-of-tolerance points.

- **N Worst** - PC-DMIS points to a number of "worst points". These points may or may not be in tolerance. This sorts the data based on the proximity to the theoretical values.

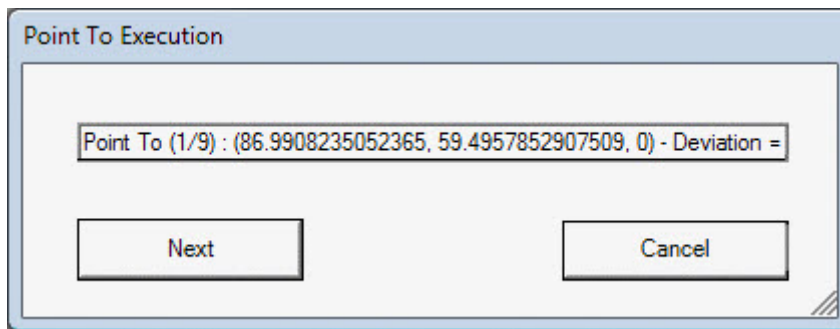
When you choose one of the options in the **Point To Filter** area, PC-DMIS updates the list of hits for the selected dimension in the dialog box to reflect the points to which PC-DMIS points the laser beam. For example, if you select **Min/Max**, the list of hits in the selected dimension updates with only two hits in the list, which represent the min and the max points for that dimension. If you choose **All**, the list updates and displays all of the input hits of that dimension.

Point To Method



The **Point To Method** area lets you indicate how the device cycles through the list of points. The options include:

- **None** - No delay or user input is needed to move to the next point. It points to each of the points without delay just as soon as the device can physically proceed to the next point.
- **Delay** - This delays the cycle time by a specified number of seconds. When executed, the device points to the first point in the list, turns on the laser, and waits the specified amount of time. When the time expires, the laser turns off, and the device moves to the next point and repeats this process until all of the points in the list have been pointed to.
- **Next Move Button** - During execution, a **Point To Execution** dialog box appears and shows the index of the point in the list and its location.



The dialog box has **Next** and **Cancel** buttons, which allow the operator control over when

to point to the next hit in the list. The device moves to the first point, turns on the laser, and then waits until the operator clicks **Next**. It then moves to the next point in the list.

You can use the Edit window's Command mode to edit the command. Or, you can select the command in the Edit window and press F9 on the keyboard to edit the command.

Using Leica Probes

Once PC-DMIS connects to the emScon server, all necessary probe files (*.prb) are automatically created from the available compensated probes in the emScon database (Reflectors and T-Probes). All created *.prb files are in the PC-DMIS installation directory.

In rare situations, it might be necessary to create additional, customized probe files. This is possible with the **Probe Utilities** dialog box. This provides full flexibility when you need it. For information, see "Defining Probes" in the "Defining Hardware" chapter in the PC-DMIS Core documentation.

Review the following topics for information on using T-Probes or reflectors:

- [Measuring with a T-Probe](#)
- [Measuring with a B-Probe](#)
- [LAS Scanning Workflow Example](#)
- [Scanning with Reflectors](#)
- [Measuring Circle Features and Slots with Reflectors](#)
- [Tracker Feature Parameters](#)

Measuring with a T-Probe

The T-Probe represents a free and movable target device to measure with the Laser Tracker and the T-Cam simultaneously. The reflector in the center of the T-Probe is responsible for providing the initial distance measurement of the Absolute Distance Meter (ADM) and the tracking measurement of the Interferometer (IFM). It also receives system command and control signals from the tracker.



See the documentation that came with your T-Probe for detailed information.

Ten (10) IR LEDs with unique IDs are distributed on the T-Probe to provide real-time feedback for measurement procedures. The T-Probe is working in either measurement mode or communication mode. Measurement mode provides that when the laser beam is locked on the reflector that measurements can be taken. Communication mode uses strobing sequences from the LEDs to communicate information back to the LT controller.

Before measurement can take place, the T-Probe battery indicator must be solid green (when it is connected to the tracker with a cable) or flashing green (using a battery without a cable). The status indicator must also be green.



PC-DMIS automatically recognizes the T-Probe, unlike reflectors. PC-DMIS marks the currently-active T-Probe in the **Probes** list of the **Settings Toolbar** in a **bold** font face. If you select a different probe from the list that isn't the physically active T-Probe and then take a hit, PC-DMIS displays a warning message. It is recommended to always use the probe settings of the physically active probe; otherwise, your hit data might not be properly corrected for the ball diameter and offset.

To measure points:

1. Attach the needed stylus to the T-Probe.
2. Switch on the power to the T-Probe.
3. Capture the laser beam in the T-Probe reflector. PC-DMIS automatically detects the Leica T-Probe. The serial number of the T-Probe, the stylus assembly, and the respective mount are visualized on the **Settings** toolbar and in the Graphic Display window.



Detected T-Probe Serial Number 252, Stylus Assembly 506, Mount 1

4. Move to the location of the point to measure while you maintain the laser beam visibility.
5. Record a hit or execute a scan according to the "[T-Probe Button Assignments](#)" topic.



If the RMS value for a hit is out-of-tolerance as defined by the `RMSToleranceInMM` registry entry, the action specified by the `RMSOutTolAction` registry entry is executed. The available actions are: 0=Accept hit, 1=Reject hit, 2=Prompt to accept or reject hit. These two registry entries are in the **USER_Option** section of the PC-DMIS Settings Editor.

T-Probe Button Assignments



T-Probe Buttons

1. **Button 1 (A)** - Stationary Points

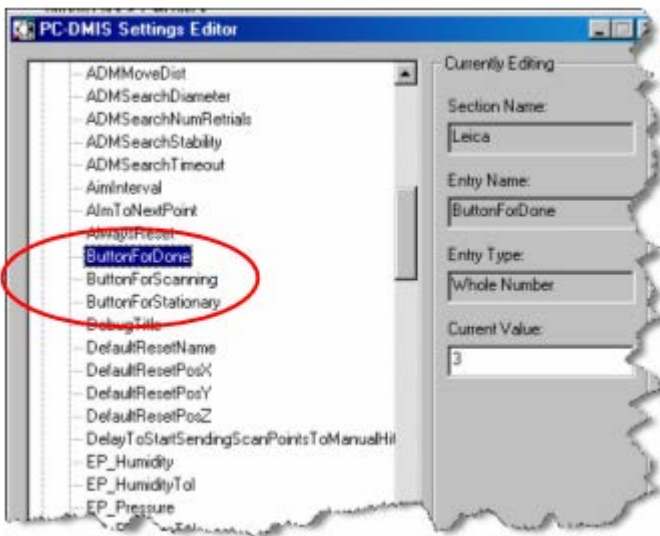
- **Click for less than 1 second** - Measures a regular stationary point (duration as defined on the "[Options tab](#)"). The shank of the stylus determines the probing direction.
- **Click for greater than 1 second** - Measures a regular stationary point as a "Pulled Hit". To change the vector for the measured point, you can press this button and hold it while moving to a location that defines the vector. The vector is established by the representative line between the measured point and the release point

location. For information about the parameters that affect the way that vectors are recorded, see the "[Options tab](#)" topic.

2. **Button 2 (C)** - Currently has no functionality
3. **Button 3 (B)** - Done/End
 - **Click for less than 1 second** - Ends Feature
 - **Click for greater than 1 second** - Displays Read out window or enables real-time 3D Distance to CAD. Deletes the last hit.
4. **Button 4 (D)** - Scanning Button - Pressing this button starts continuous measurement. Releasing it stops the measurement.

Changing Button Assignments

You can change the standard button assignments of the T-Probe in the PC-DMIS Settings Editor if required. To do this, change the number for each of the Leica button entries to the number of the desired T-Probe button.



Also, see the "Modifying Registry Entries: Introduction" chapter in the Settings Editor documentation for more information about how to edit registry values.

IJK Behavior on T-Probe Points

If aligned to the part, PC-DMIS always stores IJK values perpendicular to one of the active coordinate system axes, except if using Point Only mode.

Measuring with a B-Probe

The B-Probe represents a free, movable target device to measure with the AT402 Tracker similar to the T-Probe device used with the AT901. Unlike the T-Probe, the B-Probe is a passive 6DoF device and needs to be activated like a reflector.

Prior to using the B-Probe with the AT402 Tracker, make sure the firmware version on both devices are the same. The minimum Emscon version needs to be 3.8.500.



To activate and use the B-Probe, see the documentation that came with your Tracker Pilot software.

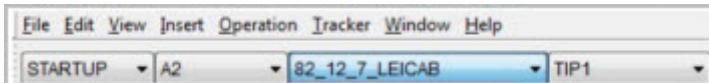
Before measurement can take place, the B-Probe status indicator LED's must be solid green. When the LED's are orange or blinking orange, you need to replace the batteries.



B-Probes, like reflectors, are not automatically recognized by PC-DMIS. You need to select B-probes from the probe combo boxes. PC-DMIS marks the currently-active B-Probe in the **Probes** list of the **Settings Toolbar** in a **bold** font face. Ensure that the selected probe in PC-DMIS is the same as the physically active probe.

To take hits:

1. Attach the needed stylus to the B-Probe.
2. Switch the B-Probe on by clicking one of the buttons on the front side or on top of the probe (when the probe is turned on, it automatically triggers a hit). For B-Probe button assignments, see "[B-Probe Button Assignments](#)" topic.
3. Capture the laser beam in the B-Probe reflector, and press one of the buttons to initiate a measurement.



Detected B-Probe - Serial Number: 82, Ball Diameter: 12.7 mm

4. Move to the location of the point to measure while you maintain the laser beam visibility.

5. Click one of the buttons on the probe to record a hit (scanning is not supported with this probe).



If the RMS value for a hit is out-of-tolerance as defined by the `RMS Tolerance In MM` registry entry, the action specified by the `RMS Out Tol Action` registry entry is executed. The available actions are: 0=Accept hit, 1=Reject hit, 2=Prompt to accept or reject hit. These two registry entries are found in the "USER_Option" section of the PC-DMIS Settings Editor.

To turn the probe off:

1. Press and hold the front measure button for two seconds and then release.
2. Press either one of the buttons immediately after, and the probe shuts off.

B-Probe Button Assignments



B-Probe Buttons

Button 1 - Button 1 functions are:

- Click and hold to turn on.
- Once the probe turns on, use the button to take measurements.

Button 2 - Button 2 functions are:

- Click and hold to turn on.
- Once the probe turns on, use the button to take measurements.
- Click and hold to turn the probe off.

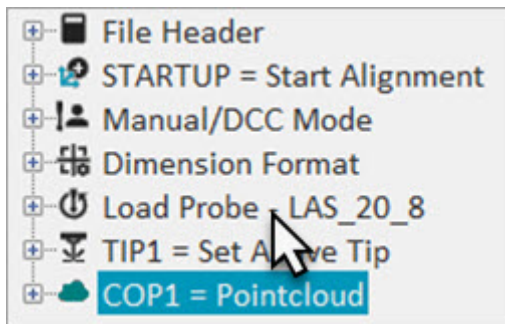
IJK Behavior on B-Probe Points

If aligned to the part, PC-DMIS always stores IJK values perpendicular to one of the active coordinate system axes, except if you use Point Only mode.

LAS Scanning Workflow Example


The workflow for scanning with the Leica LAS-20-8 sensor is:

1. In PC-DMIS, lock onto the LAS-20-8 scanner. (It is automatically set as the active probe in the Edit window.) When the RDS Scanning window appears, you are ready to begin scanning.

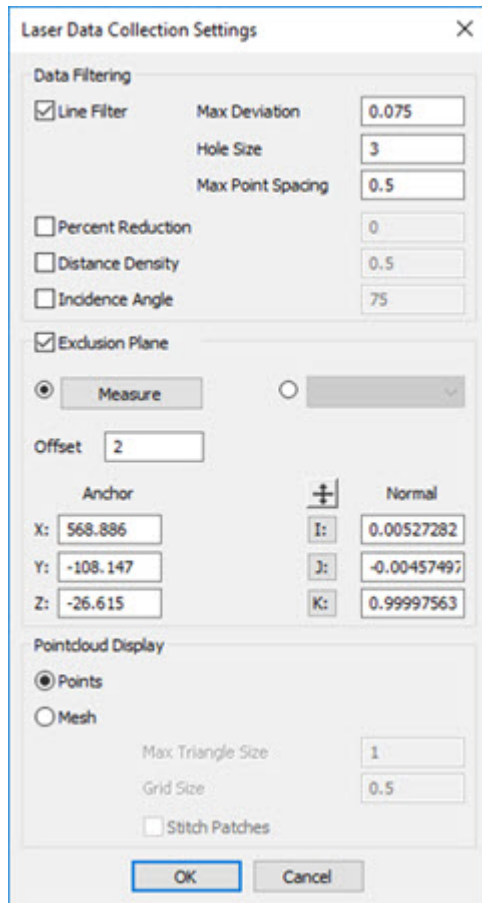


2. From the RDS Control Panel, enter the LAS scanner settings. You can also double-click the LAS scanner button to advance to the next RDS scanning profile.

Optional:

- a. Select the **Pointcloud Data Collection Parameters** button  from the **Pointcloud** or **QuickCloud** toolbar (**View | Toolbars**).

For details on the Portable toolbars, see "[Using the Portable Toolbars](#)".



For details on the **Laser Data Collection Settings** dialog box, see "Laser Data Collection Settings" in the PC-DMIS Laser documentation.

- b. From the **Exclusion Plane** area, click the **Measure** button.
 - c. Scan the table surface and then click the appropriate button on the scanner when done.
 - d. In the exclusion plane **Offset** field, enter the offset value (for example: 1 for 1mm) and then click the check box to enable.
 - e. Click **OK** to close the **Pointcloud Data Collection Parameters** dialog box.
3. Press and hold down the LAS scanner button and scan the part.
 - If a COP feature exists, the pointcloud data is added to the COP.
 - If a COP feature does not exist, a new COP is created (COP1) and populated with the pointcloud data.
 4. If the scan beam is accidentally broken (for example, when changing faces), you can lock back onto the LAS and continue scanning.

5. When you complete the scan, you can lock onto a different probe (for example, a reflector or T-probe) to reconnect to the tracker. There is a 10-second delay when you disconnect from the scanner.
6. You can add pointcloud data to the COP at any time by locking onto the LAS and starting to scan.




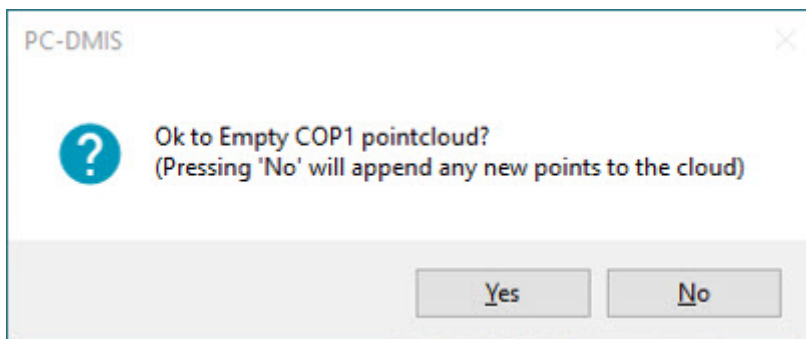
All pointcloud functions (for example: Pointcloud Alignments, Colormaps, etc.) are available when using the LAS scanner.

For details on the pointcloud operators, see the "Pointcloud Operators " chapter in the Laser documentation.

Re-executing the Scan (Ctrl + Q)

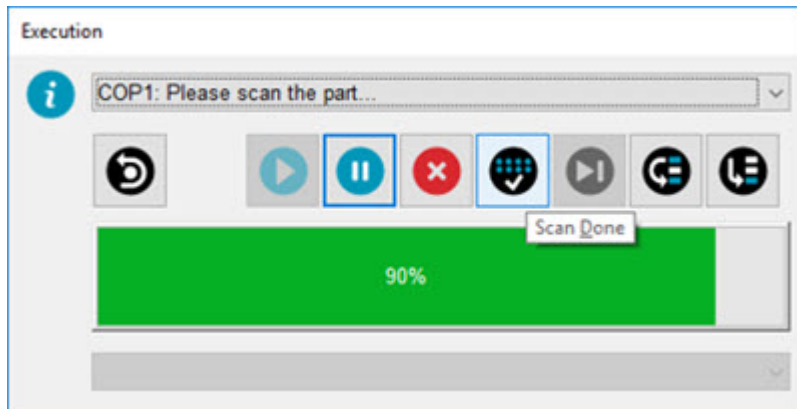
To re-execute the measurement routine:

1. Click the PC-DMIS **Execute** button  to re-execute the measurement routine.
2. PC-DMIS displays a prompt to empty the COP. Click **Yes** to empty the COP and populate it with the newly scanned data. Click **No** to add the newly scanned data to the existing data.



PC-DMIS prompt to empty COP and add new data, or append new data

3. The software displays the **Execution** dialog box. When you've completed the data collection, click the **Scan Done** button.



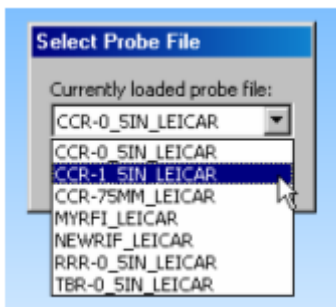
Execution dialog box when hovering over the Scan Done button

4. If the measurement routine contains laser auto features, the software extracts the features if enough data exists. If PC-DMIS determines it needs more pointcloud data for the feature extraction, a prompt appears in the **Execution** dialog box. The software highlights the features that need more data in red in the Graphic Display window. Re-scan the areas as needed to get more data and extract the features.

Scanning with Reflectors

Reflector definitions together with the surface offsets are automatically received from the emScon server and are all available from the **Settings** toolbar. There is no need to define any new probes once the standard reflectors are being used.

Once the Tracker system detects a reflector, the **Select Probe File** dialog box appears. This enables you to select the appropriate reflector.



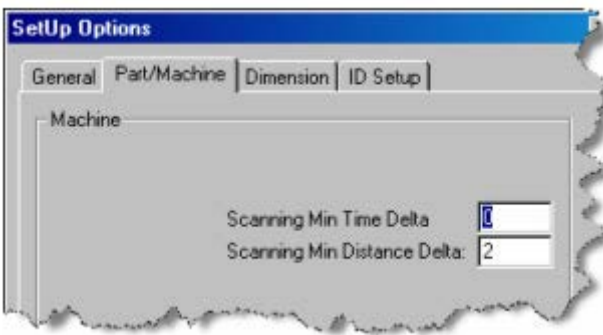
Probe compensation and offset direction

Quick Scanning

To scan a surface or feature using a reflector, you need to be in scan mode. To do this, select the **Operation | Start/Stop Continuous Mode** menu item to start continuous mode.

Continuous mode allows you to take incremental points for the reflector location. To execute scanning, press Ctrl-I when you use a reflector. To stop continuous scanning, press Ctrl-I again.

You can set the **Scanning Minimum Time Delta** and **Scanning Minimum Distance Delta** from the **Part/Machine** tab of the **Setup Options** dialog box (**Edit | Preferences | Setup**). The default value for point distance separation is 2mm.



Advanced Scanning

There are many advanced scans possible like sections, multi-sections, etc. Create scans from the **Insert | Scan** menu. For information, see the "Advanced Scans" subtopic in the "Scanning Your Part: Introduction" topic in the "Scanning Your Part" chapter in the PC-DMIS Core documentation.

Measuring Circle and Slot Features with Reflectors

The official Leica name is Reflector Holder. These are tools that measure a feature, like a circle, that is smaller than the diameter of a corner cube reflector. The top is magnetic, and it sticks to a 1.5" Corner Cube Reflector (CCR).



Leica Reflector Holder

You make measurements by placing the pin nest probe into the circle and then taking hits with the pin following the inside diameter (ID) of the circle.

When you measure a hole or an internal slot with a reflector attached to a pin nest probe, be sure to lift the probe away from the center of the internal feature when you finish creating or measuring the feature. This way, PC-DMIS properly calculates the vectors. Otherwise, the feature's vector may be reversed.

Tracker Feature Parameters

When you measure features with a tracker, PC-DMIS adds additional parameters to the feature command in the Edit window. The parameters found in the "Tracker Parameters" section include:

- Time Stamp
- Probe Name
- Temp (temperature)
- Press (pressure)
- Humid (humidity)
- RMS value (for each hit)

These values are also reflected in the report with a new tracker label.

Constructing Points for Hidden Point Devices

PC-DMIS supports the use of "hidden point adapters" from Leica. This is accomplished by constructing a point from two point inputs and an offset distance. The two points are measured via two reflectors that are mounted along the adapter at specific locations.

After you measure two points, you can construct a point at a specified distance (offset) from the second point along the vector that is created between the two input points.

To construct this point:

1. Access the **Construct Point** dialog box (**Insert | Feature | Constructed | Point**).
2. Select the **>Vector Distance** option from the list of options.
3. Select the first feature.
4. Select the second feature.

5. Specify a distance in the **Distance** box. You can type a negative value to construct the point between the two input features.
6. Click the **Create** button. PC-DMIS constructs a point at the specified distance from the second input feature along the line from the two features.

Using a Total Station

This section discusses the configuration and general usage of your Total Station device with PC-DMIS. To configure and use the Total Station device, refer to the documentation provided with your Total Station for detailed information.

The following topics discuss using the Total Station device with PC-DMIS:

- [Getting Started with a Total Station](#)
- [Total Station User Interface](#)
- [Predefined Compensation](#)
- [Move Feature \(Move To / Point To\)](#)
- [Finding a Reflector](#)

Getting Started with a Total Station

There are a few basic steps that you should take to verify that your system has been properly prepared before you begin the measurement process with your Total Station.

To get started, complete the following steps:

- [Step 1: Install PC-DMIS Portable for Total Station](#)
- [Step 2: Connect the Total Station](#)
- [Step 3: Launch PC-DMIS](#)

Step 1: Install PC-DMIS Portable for Total Station

To install PC-DMIS Portable for the Leica Total Station, if using a portlock dongle, insert it into your computer and run the PC-DMIS setup program. Your license or portlock must be configured to use the Total Station interface. Once you have run the setup program, run PC-DMIS. You are ready to start measuring.



If you are an AE and you have your license or portlock programmed for all interfaces, you can run the PC-DMIS setup program with the following startup option to get an install of PC-DMIS as if your license or portlock was programmed specifically for the Total Station. *The word "Interface" is case sensitive.*

`/Interface:leicatps`

This adds `/portable:leicatps` switches onto the offline and online shortcuts as well as copies the custom layouts associated with the Total Station.

Step 2: Connect the Total Station

Follow the instructions that came with your Total Station hardware for information on how to connect the Total Station to your computer.

Step 3: Launch PC-DMIS

To launch PC-DMIS, double-click the **PC-DMIS Online** icon in your PC-DMIS program group. The lower left corner of the screen should display “Machine OK” once PC-DMIS has established communication with the Total Station device.

Total Station User Interface

When you configure PC-DMIS to use the Total Station interface, additional menu options and status information become available in PC-DMIS.

PC-DMIS provides specific menu options as well as standard menu options that are available when you use the Total Station interface. Primarily, there is a [Total Station menu](#) that has functions specific to the Total Station.

Also unique to the Total Station interface are the [Total Station toolbar](#) and [Total Station status bar](#).

There are also [other PC-DMIS menu items](#) and [other PC-DMIS windows and toolbars](#) that are common to PC-DMIS that may be useful for Total Station devices.

This section discusses only a few of the menu items that you would use with the Total Station interface. For general information on how to use PC-DMIS, refer to the PC-DMIS Core documentation.

Total Station Menu

The Total Station menu contains these items:

Station Management - Displays the **Station Manager** dialog box for the Total Station. For details, see the "[Adding and Removing Stations](#)" topic.

Go 0 Position - Moves the **Total Station** to the zero position.

Change Face - Rotates the Total Station head and camera by 180 degrees. The final target position is the same as it was before the command was issued, except that now the optics are inverted.

Find - Locates a target within the field of view of the Total Station camera if possible. This does not work with tape targets.

Power Search - This attempts to locate a target either within a user-defined window if Power Search Window is enabled or a 360-degree search if it is not.

Probe Modes - The items in this submenu control how measurements are taken with the Total Station. There are four different modes:

- **Single** - This mode takes a single measurement from a single head orientation.
 - **Average** - This mode takes multiple measurements from a single head orientation and reports the average of the total measurements. Configure the number of measurements to take on the **Instrument Options** tab of the [Machine Options](#) dialog box (**Edit | Preferences | Machine Interface Setup**).
 - **Two Face** - This mode takes one measurement, rotates the head and camera by 180 degrees, and then takes a second measurement. The result of the measurement is the average of the two measurements. Note that this does the averaging in cylindrical coordinates even though PC-DMIS reports them in Cartesian coordinates. This is set on the **Instrument Options** tab of the [Machine Options](#) dialog box.
 - **Stable Probing** - This mode is used when tracking a target. It takes a measurement when the target has been stationary for a specified period.
-

The various ON/OFF items below are different modes that you can activate when you measure with a Total Station device. Some of these modes are available with all target types, and others

are only available with specific target types. A description of each mode and its availability follows:

Compensator ON/OFF - This turns the compensator on or off. The compensator adjusts the measurements taken by the device to level them to the gravity vector calculated on the machine. This can be helpful when all measurements need to be referenced off of the level of the ground.

Availability - All target types.

Laser Pointer ON/OFF - This turns the laser pointer on or off. The laser pointer makes it easier to locate where the Total Station is pointing. It allows you to position the total station close enough to a target that you can issue a Find command to locate and lock-on to the target if lock-in (see "Lock-in ON/OFF" below) is supported for that target type. It can also be used in conjunction with the Point To command to locate points that are identified by a filter applied to the measurement results (see "Move To Point To" above).

Availability - All target types.

ATR ON/OFF - This stands for Automatic Target Recognition. When turned on, the Total Station locates the center of mass of the target closest to the center of the optics and makes a fine adjustment to the position of the Total Station to take more accurate measurements.

Availability - Reflector type measurements only.

Lock-in ON/OFF - When active, the Total Station tracks the movement of the target. This allows the operator to find the target and then pick it up and move it from one measurement location to another without having to go back to the Total Station to complete the next measurement. This is used in conjunction with ATR mode. If Lock-in is turned on, PC-DMIS automatically sets ATR to on as well. This works well with the stable probing measurement mode (see the "Stable Probing" item above).

Availability - Prism target types only.

Power Search Window ON/OFF - The total station can recognize targets within the field-of-view of its optics. This is called Power Search. The Power Search window is a user-specified window or region that defines where the Total Station should search for a target. The window's boundaries can be set using the [Machine Options](#) dialog box. If the Power Search window is off, it defaults to a 360-degree search and stops at the first target found.

Availability - Prism target types only.

Target Illumination ON/OFF - This enables or disables the flashing target illumination light. This light is used to help locate a target while looking through the telescope. The light flashes alternately between red and yellow. When looking through the telescope, you can easily see the targets because of the light reflected to the telescope. If the Total Station is locked on a prism

and loses that lock, the default action of the machine is to perform a power search to try and relocate the prism, and if one is not found, to turn on the Target Illumination light.

Availability - All target types.

Probe Compensation ON/OFF - The enables or disables the probe compensation. When the probe compensation is "on", PC-DMIS will compensate by the radius of the probe tip or the reflector sphere. During bundle alignment creation, PC-DMIS will automatically activate or deactivate probe compensation as needed when measuring points. See "[Total Station Probe Compensation](#)" for more information on probe compensation.

Live Readout ON/OFF - This enables or disables a continual update of the target location on the DRO. Since the Total Station does not send back position updates to PC-DMIS on a regular basis, the standard DRO does not update as do most other devices. This is due to the nature of the communication with the Total Station and the desire to have a responsive interface. However, the Live Readout mode is included if you want to track the location of the target in real time. This is used in conjunction with Lock-in, and PC-DMIS automatically enables the Lock-in mode if it is not already enabled. If you take a measurement while Live Readout mode is enabled, you will notice that the readout update on the DRO pauses. This happens because the measurement mode is momentarily changed to get a precise measurement and then switches back to Live Readout mode.

Availability - Prism target types only.

Insert Total Station Command - When enabled, this mode lets you insert selected Total Station menu items or toolbar items as executable commands into the measurement routine at the cursor's location in the Edit window. This lets you automate repetitive measurements or processes.

Move Feature - This points the total station at a specified feature or at a hit or hits within a feature. Certain dimensions can also be used as inputs to this command. See the "[Move Feature \(Move To / Point To\)](#)" topic for additional information.

Total Station Toolbars

PC-DMIS displays the following two toolbars when you start PC-DMIS with the Total Station interface.

For convenience, the **Total Station Operation**, **Total Station Probe Modes**, and **Total Station Measure** toolbars, described below, provide the same functions that exist on the **Total Station** menu.

Total Station Operation Toolbar



Total Station Operation Toolbar

For a description of the items on this toolbar, consult the "[Total Station Menu](#)" topic.



- Insert Total Station Command



- Probe Compensation On/Off



- Power Search On/Off



- ATR On/Off



- Gravity Compensation On/Off



- Station Management



- Home Position (Go to 0 Position)



- Change Face



- Power Search



- Illumination Light On/Off



- Laser Pointer On/Off



- Find Target



- Lock-in On/Off



- Live Readouts On/Off



- Single Probing Mode



- Average Probing Mode



- Two Face Probing Mode



- Stable Probing Mode



- Bundle Alignment

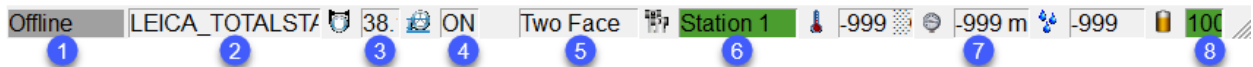


- Move Feature

For the measure options that used to be on the old **Total Station Measure** toolbar, see the [Tracker Measure](#) toolbar.

Total Station Status Bar

The Total Station status bar automatically appears when you launch PC-DMIS Portable with the Total Station interface:



Total Station Status Bar

By using the **View | Status Bar** menu item, you can change the status bar's size and visibility.

1. **System Laser Status Indicator:** This field indicates the status of the system. When online, the status changes depending on the current settings and operations that you are performing.
2. **Probe Name:** This lists the name of the active probe.
3. **Probe Diameter:** This displays the probe's diameter.

4. **Probe Compensation:** This indicates whether probe compensation is turned ON or OFF.
5. **Probe Mode:** The probe mode pane updates the icon and text to reflect the probing mode that is currently active. The probe mode icons are the same ones that are used in the [menu](#) and on the [toolbar](#).
6. **Active Station Indicator:** Indicates which station is currently active. Double-click on the station indicator to open the [Station Manager](#) dialog box.
 - **Red** (Not oriented): The station position is not computed yet.
 - **Green** (Oriented) The station position has been computed.
7. **Environmental Parameter Display:** Shows the active environmental parameters: temperature, pressure, and humidity. If no weather station is connected, you can double-click on the editable boxes to change their values.
8. **Battery Level:** This static icon and the text next to it reflect the current amount of power left in the battery. If the power level is between 25% and 100%, it displays a green background. If the power level is between 10% and 25%, it displays a yellow background. For anything 10% or less, it displays a red background.

Predefined Compensation

For a Total Station device, PC-DMIS retrieves the compensation direction information from the following:

- For point features, the compensation direction comes from a reference plane or work plane.
- For hole type features, the compensation direction comes from the feature information.
- For line and plane features, the compensation direction comes from the Total Station position that is defined when you use the [Quick Start](#) dialog box to measure a feature.

The options inside the **Compensation** area of the **Quick Start** dialog box change depending on the type of measured feature you are measuring. However, they all perform the same function of changing the direction of the compensation.

Also, depending on the system configuration, the **Compensation** area of the **Quick Start** dialog box may change to include different options, or it may be unavailable.

Following are three possible scenarios, followed by a more detailed explanation of the Quick Start **Compensation** area. For information on the **Compensation** area, see "[Compensation Area](#)" below.

Scenario 1 - No Compensation area for an AT901 with a T-Probe

For this device, the **Compensation** area is not available in the Quick Start interface because PC-DMIS configures this using information provided from the tracker and T-Probe.

Scenario 2 - Compensation area for an AT901 with a Reflector

For this device, the **Compensation** area appears in the Quick Start interface.

It has a **Predefined** check box and **In** and **Out** options. You can then select the **Predefined** check box along with the associated **In** and **Out** options discussed in "[Compensation Area](#)" below.

Scenario 3 - Compensation area for a Total Station

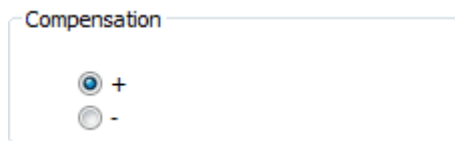
For this device, the **Compensation** area shows a **Predefined** check box and **In** and **Out** options.

You cannot clear the **Predefined** check box in the **Compensation** area. It remains selected.

You can then select the associated **In** and **Out** options discussed in "[Compensation Area](#)" below.

Compensation Area

For Points (+ or -)



The image shows a rectangular box with the title "Compensation" in the top left corner. Inside the box, there are two radio button options. The first option is a selected radio button (indicated by a blue dot) followed by a plus sign (+). The second option is an unselected radio button (indicated by a grey dot) followed by a minus sign (-).

The + and - options determine the compensation direction of the point along the vector of the reference (measured) plane. In the case of a measured plane, the + option compensates in the same direction as the vector. The - option compensates in the opposite direction of the vector.



The compensation area does not display when projecting to a workplane. This is because you can choose plus or minus workplanes, which inherently specify the compensation direction.

For Measured Lines and Planes (Toward or Away)

Compensation

☐ Toward

☒ Away

The **Toward** and **Away** options determine the compensation of lines or planes by either using the vector that is toward the Total Station (measuring from the Total Station to the point) or away from the point (measuring from the point to the Total Station) as the vector for compensation.

For Circles, Cylinders, Cones, Spheres, and Slots (In or Out)

Compensation

☒ IN

☐ OUT

The **IN** and **OUT** options determine the compensation direction for hole or stud type features. If you are measuring the inside of a feature, you should choose **IN**. If you are measuring the outside of a feature, you should choose **OUT**.

For Circles and Slots (Toward or Away)

Compensation

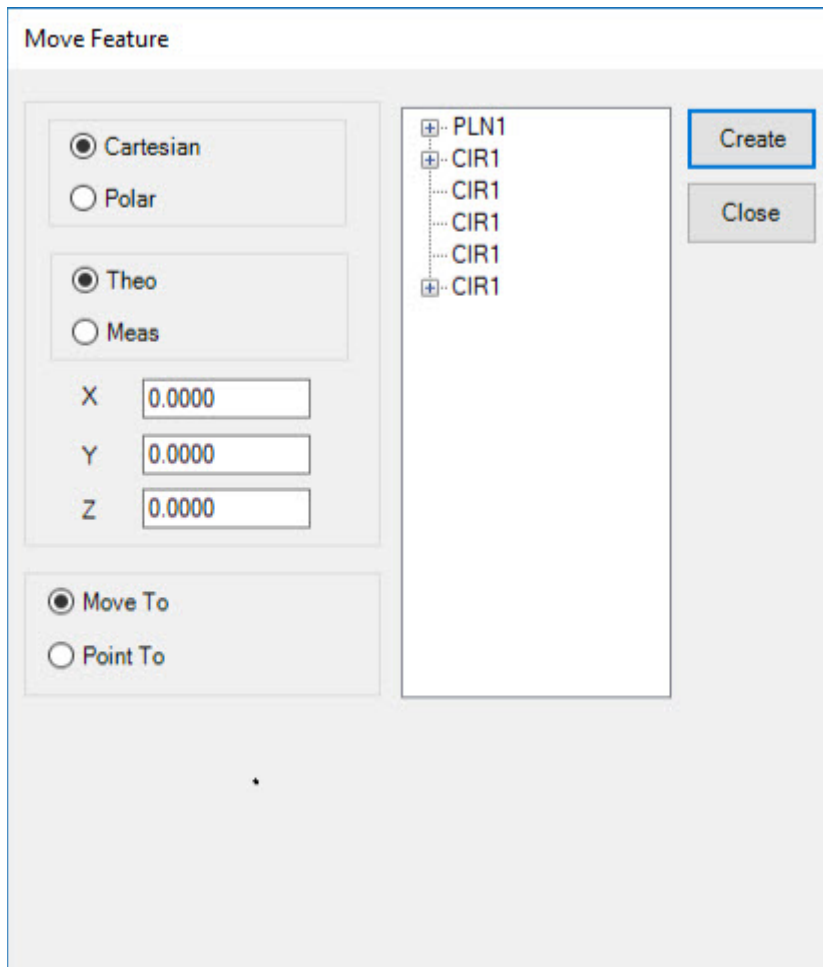
☒ IN ☒ Toward

☐ OUT ☐ Away


The **Toward** and **Away** options appear for circles or slots if you selected the **3D** type from the **Reference Feature** area of the Quick Start interface. They determine the compensation of circles or slots by letting you specify whether a feature's normal vector should point more toward the Total Station or more away from the Total Station. PC-DMIS mathematically evaluates the feature's current vector and flips it as needed based on your selection.

This does not mean that the vector then points directly at or directly away from the device, because a feature's vector might be more perpendicular to the vector of the device's optics than parallel to it. But the vector is flipped as needed so that normal vector that points more toward or away from the device as specified.

Using Move Feature (Move To / Point To)



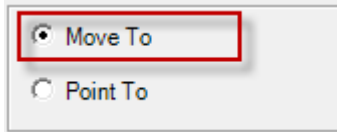
Move Feature dialog box

The **Move Feature** dialog box is available when you use either a Leica Tracker or a Leica Total Station device. It appears when you select the **Move Feature** toolbar icon  from the **Tracker Operation** or **Total Station Operation** toolbar. You can also select the **Tracker | Move Feature** or **Total Station | Move Feature** menu item.

The **Move Feature** dialog box contains the **Move To** and **Point To** options. These commands are used only with the Leica Total Station or Leica Tracker devices. In addition to the standard

move ability of other DCC systems, the **Point To** command exploits the unique capabilities of these tracker-type systems by using the device as a laser pointer to identify, directly on the part, the location of out-of-tolerance points.

Move To



This option moves the device to a specific location where it then tries to find a reflector.

To move to a point, select the **Move To** option and then define where it should move to. There are three ways to specify the location to which it should move.

- **Method 1:** Type the values into the **X**, **Y**, and **Z** boxes (or **R**, **A**, and **Z** if you use the **Polar** option).
- **Method 2:** Select the feature that you are going to move to out of the **Feature** list. When you select the feature, PC-DMIS fills in the **X**, **Y**, and **Z** values based on the centroid of the feature.
- **Method 3:** Expand the feature by selecting the + symbol next to it to display the hits on the feature. While "hits" is something of a misnomer, it means the point measured by the laser device. Select one of the hits from the list. PC-DMIS fills in the **X**, **Y**, and **Z** values for that hit.

To move to the measured or theoretical value for the point, choose either the **Theo** or **Meas** option.

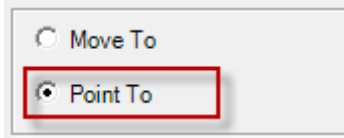
Once you have set up the command correctly, click **Create** to insert the command into the Edit window.

```
MVF1      =MOVE FEATURE/MOVE TO,CARTESIAN,THEO,<-
36.3574,33.3898,-10.8127>,
          FILTER/NA,N WORST/1,
          POINT TO METHOD/NA,DELAY IN SEC/0.0000,
          REF/PNT1,
```

When PC-DMIS executes this command, the device automatically moves to the position indicated and attempts to find a reflector. If no reflector is found, an error displays that says "AUT_FineAdjust - Request timed out". To get past this error, if there is a nearby reflector, use the **Execution Options** dialog box and stop the execution, adjust the location to point nearer the

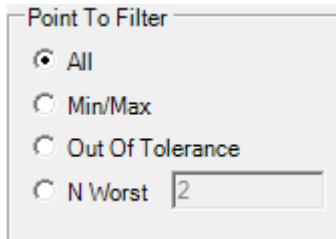
reflector, and then click **Continue**. If a reflector is not close by, click **Skip** to move onto the next point.

Point To



To point to different hits, the procedure is the same as the "Move To" information above, but there are some additional options. With **Point To** you can also select from available dimensions in the measurement routine. If you select a dimension, PC-DMIS displays the **Point To Filter** and **Point To Method** areas. You do not need to select individual hits in the expanded dimension. All of the hits visible in the dimension will be pointed to, although you can use the **Point to Filter** area to filter hits.

Point To Filter

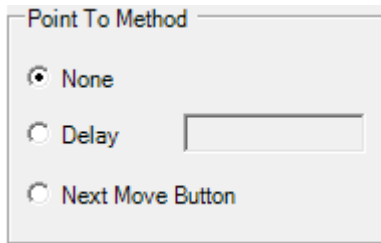


The **Point To Filter** area displays options that control which hits are pointed to. The options include:

- **All** - PC-DMIS points to each point in the dimension.
- **Min/Max** - PC-DMIS identifies and points to only the Min and Max points.
- **Out Of Tolerance** - PC-DMIS points to only the out-of-tolerance points.
- **N Worst** - PC-DMIS points to a number of "worst points". These points may or may not be in tolerance. This sorts the data based on the proximity to the theoretical values.

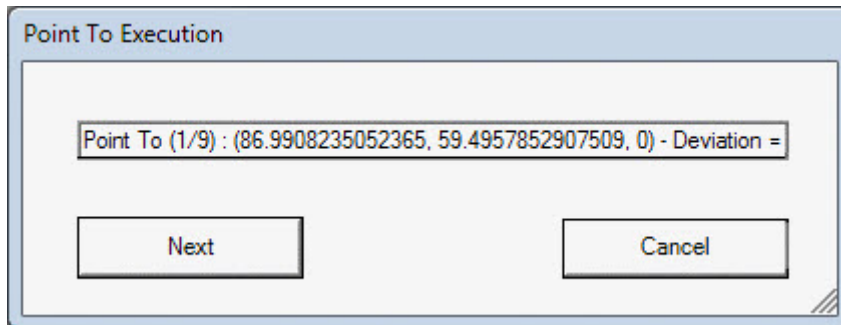
When you choose one of the options in the **Point To Filter** area, PC-DMIS updates the list of hits for the selected dimension in the dialog box to reflect the points to which PC-DMIS points the laser beam. For example, if you select **Min/Max**, the list of hits in the selected dimension updates with only two hits in the list, which represent the min and the max points for that dimension. If you choose **All**, the list updates and displays all of the input hits of that dimension.

Point To Method



The **Point To Method** area lets you indicate how the device cycles through the list of points. The options include:

- **None** - No delay or user input is needed to move to the next point. It points to each of the points without delay just as soon as the device can physically proceed to the next point.
- **Delay** - This delays the cycle time by a specified number of seconds. When executed, the device points to the first point in the list, turns on the laser, and waits the specified amount of time. When the time expires, the laser turns off, and the device moves to the next point and repeats this process until all of the points in the list have been pointed to.
- **Next Move Button** - During execution, a **Point To Execution** dialog box appears and shows the index of the point in the list and its location.



The dialog box has **Next** and **Cancel** buttons, which allow the operator control over when to point to the next hit in the list. The device moves to the first point, turns on the laser, and then waits until the operator clicks **Next**. It then moves to the next point in the list.

You can use the Edit window's Command mode to edit the command. Or, you can select the command in the Edit window and press F9 on the keyboard to edit the command.

Finding a Reflector

The Find function allows you to search in a spiral pattern to find the actual location of a reflector or T-Probe (6dof system only) with your Leica Tracker or Total Station device.

Finding a Reflector Location Using a Leica Tracker Device

1. Point the Tracker laser approximately to the location of the desired reflector. You can do this in these ways:
 - "[Releasing Tracker Motors](#)" (6dof system only) and manually moving the laser to the location.



You do not need to release the motors on the 3D systems.

- Use the control buttons on the **ADM** tab of the **Machine Options** dialog box (**Edit** | **Preferences** | **Machine Interface Setup**).
 - Use the [Overview camera](#).
 - Use the Alt + left arrow, right arrow, up arrow, and down arrow keyboard keys to move the tracker head. Use Alt + Space to stop movement of the laser.
2. Select the **Tracker** | **Find** menu item. The tracker device searches in a spiral pattern and take readings until the reflector sends the signal back to the device. This locates the position.

Finding a Reflector Location Using a Total Station Device

1. Point the Total Station laser approximately to the location of the desired reflector. You can do this in these ways:
 - Manually move the laser to the location.
 - Use the Alt + left arrow, right arrow, up arrow, and down arrow keyboard keys to move the tracker head. Use Alt + Space to stop movement of the laser.
2. Select the **Total Station** | **Find** menu item. The total station device searches in a spiral pattern and takes readings until the reflector sends the signal back to the device. This locates the position.



You can only execute this function from the [View Camera](#) dialog box.

Creating Alignments

Alignments are crucial to setting the coordinate origin and the X,Y, Z axes. This chapter discusses alignments commonly used with a portable device. For information on other alignment methods, see the "Creating and Using Alignments" chapter in the PC-DMIS Core documentation.

- [Quick Start Alignments](#)
- [6 Point Alignment](#)
- [Nominal Point Best Fit Alignment](#)
- [Performing a Leapfrog Operation](#)
- [Using Bundle Alignments](#)

Quick Start Alignments

Various alignments can be created using the Quick Start interface with your portable device. The basic alignment examples provided here relate directly to Leica reflectors and T-Probes, but the principles are the same for all portable devices.

Example Plane-Line-Point Alignment with CAD and Reflectors

1. Import a CAD model. See "[Importing Nominal Data](#)".
2. Select **Alignments | Plane/Line/Point** from the **Quick Start** interface.



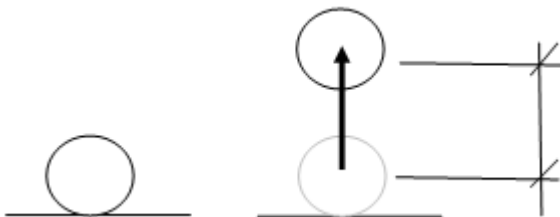
Quick Start showing Plane-Line-Point Alignment

- Follow the instructions provided by the Quick Start interface to measure the alignment features.






While not aligned yet to your part, make sure to use the [Pulled Hits Method](#) to take measurements. For more information on "pulled hits", see the "[Options tab](#)" topic in the "[Leica Interface](#)" chapter.

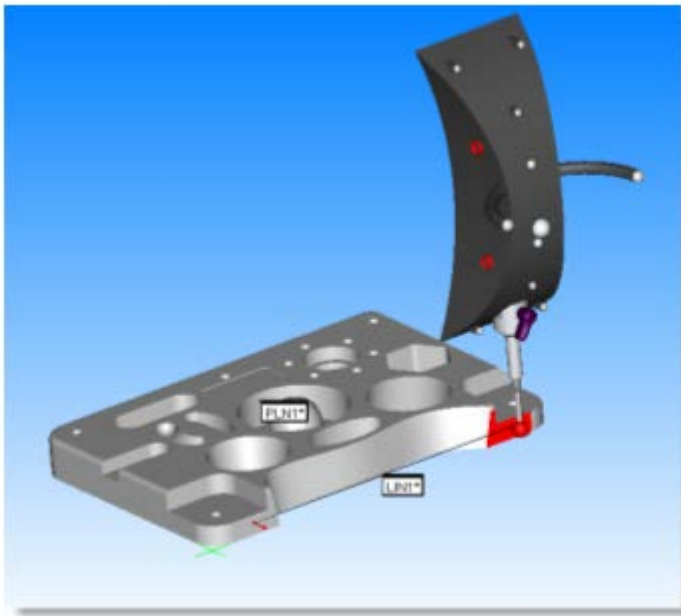
Take Hit (Ctrl + H) stores the current stationary measurement internally. After moving the vector distance, PC-DMIS calculates the IJK vector between the first and second point and compensates the offset of the resulting point accordingly.



Vector Distance depicted for reflector movement

Example Plane-Line-Line Alignment with CAD and T-Probe

1. Import a CAD model. For information, see "Importing CAD Data or Measurement Routine Data" in the "Using Advanced File Options" chapter in the PC-DMIS Core documentation.
2. From the **Graphic Modes** toolbar, enable **Program Mode** ().
3. From the same toolbar, select the mode for your CAD data:
 -  **Curve Mode** - Used for CAD with curve and point data.
 -  **Surface Mode** - Used for CAD with surface data.
4. Select **Alignments | Plane/Line/Line** from the **Quick Start** interface.
5. Follow the instructions provided by the Quick Start interface to measure the alignment features in Programming Mode.



Measuring Alignment Features with a T-Probe

6. Once the measurement routine is completed, execute it by pressing Ctrl + Q or by selecting the **File | Execute** menu item.



While not aligned yet to your part, make sure to use the [Pulled Hits Method](#) to take measurements. For more information on "pulled hits", see the "[Options tab](#)" topic in the "[Leica Interface](#)" chapter.

Creating Alignments Offline

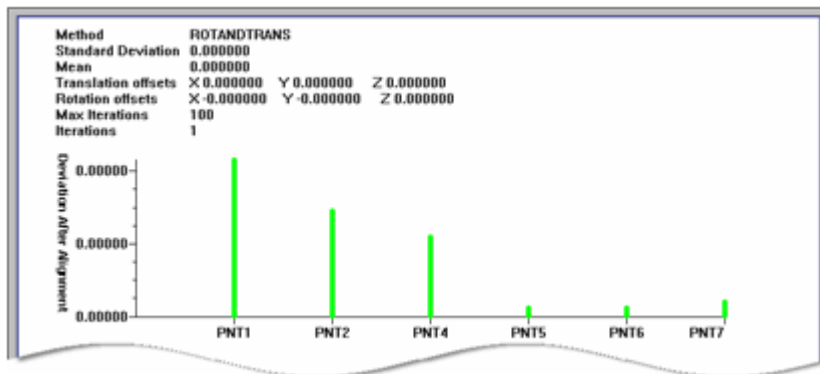
It is also possible to create an alignment offline using features that were previously measured by selecting features from the Edit window instead of measuring them using the Quick Start interface.

6 Point Alignment

The 6 Point Alignment allows you to perform an iterative 3D Best Fit alignment. The following steps outline a typical procedure that would be used to establish a 6 Point Alignment:

1. Measure three points on the top surface to level to the Z Axis.
2. Measure two points on the front surface to rotate to the X Axis.
3. Finally, measure one point to define the origin for the Y axis.
4. Click Finish. This establishes the correct origin for the alignment.

PC-DMIS inserts the Best Fit 3D Alignment. Following execution, PC-DMIS displays a 3D Alignment Best Fit Graphical Analysis in the Report window.



A Sample Best Fit Alignment Graphical Analysis

This graphical analysis of the 3D Best Fit alignment displays this information in the Report window:

Header: This contains various values used in the Best Fit alignment: Method, Standard Deviation, Mean, Translation offsets, Rotation offsets, Max iterations, Iterations.

Vertical Axis: This shows the amount of deviation after the alignment.

Horizontal Axis: This displays the IDs of the points used in the alignment.

Nominal Point Best Fit Alignment

To create a Nominal Point (N-Point) Best Fit Alignment:

1. Create or Import Nominal Point Data. See "[Importing Nominal Data](#)".



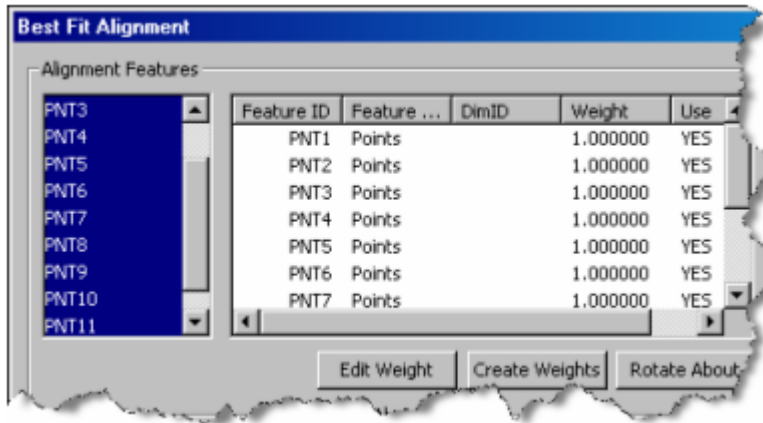
If you use Nominal Data for Leica Reflector offsets and supports, make sure that the probe compensation command in the Edit window is set to off. The probe compensation command needs to be above the points in the measurement routine.

2. Execute the measurement routine by pressing Ctrl + Q or by selecting the **File | Execute** menu item.
3. The **Execution** dialog box opens and guides you through the remaining measurements. You can skip points if needed. Once all measurements have been completed, the dialog box closes. For information on this dialog box, see "Using the Execution Dialog Box" topic in the "Using Advanced File Options" chapter in the PC-DMIS Core documentation.
4. Insert a Best Fit alignment by selecting **Alignments | Align Free** from the **Quick Start** interface or by selecting the **Insert | Alignment | New** menu item. The **Alignment Utilities** dialog box opens.



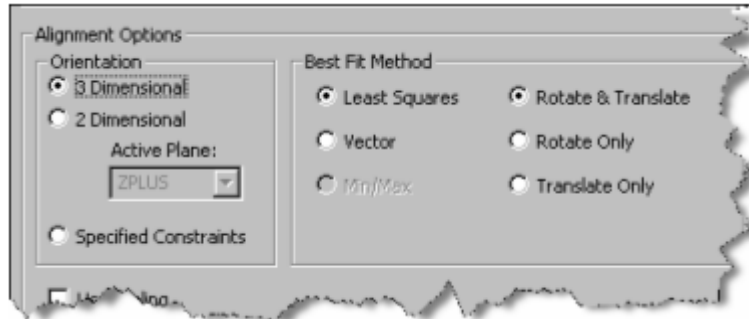
The **Alignment Utilities** dialog box provides the most flexible way to create alignments but requires some experience.

5. Click **Best Fit**.
6. Select all features that should be used in the Best Fit alignment.



Best Fit Alignment dialog box - Selecting Features

7. Exclude nominals for axes of selected input features for which theoretical values are not known. This is done by selecting "NO" under the axis column that should be excluded. This is useful in cases where you only know the theoretical values for one or two of the axes rather than all three.
8. Make sure that the correct options are set. In this example, a Least Squares 3D alignment is created. By default, 3 Dimensional Orientation is selected for trackers.



Best Fit Alignment dialog box - Alignment Options

9. Click **OK** to compute the best fit alignment and insert the command into the measurement routine. Overall results of the transformation are displayed in the standard PC-DMIS Report. The report uses the Enhanced BFAAnalysis ActiveX control plus a new label. This new control adds a grid of results of each input before and after the alignment, as well as the axes that were used in the calculations.

Since the alignment command comes after the measured features in the measurement routine, the measured points are still presented in the previous coordinate system. To get the contributing

point deviations in the newly created active coordinate system, insert Location dimensions into the measurement routine after the alignment command.

Performing a Leapfrog Operation

The Leapfrog alignment allows you to move your portable CMM to measure parts that outside the extent of your current arm location. You should be aware of machine accuracy limitations before you use this method.

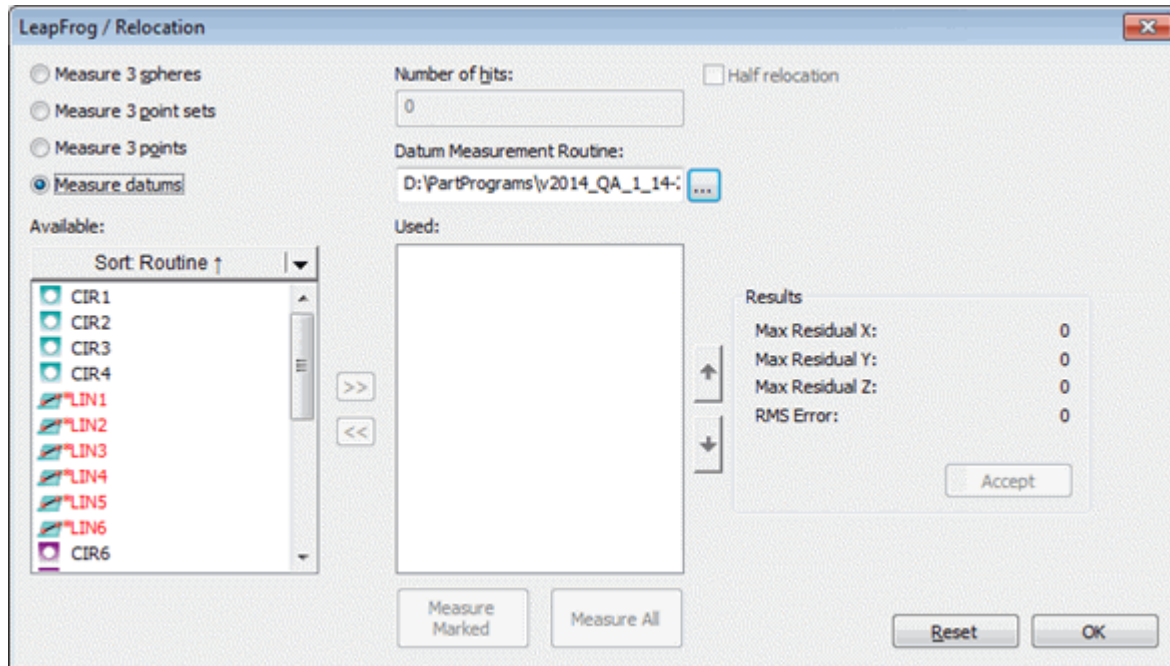
The basis for Leapfrog is to measure a series of features, and then after moving the machine, remeasure the same features in the same order. This creates a transformation and makes the machine behave as if it were the same coordinate system before the move.

The transformation is independent of all measurement routines and affects the way the CMM reports to PC-DMIS. To remove a previously-used Leapfrog transformation, you must reset the Leapfrog by using the **Reset** button in the dialog box.



Leapfrog is available for some portable machines. These include Romer, Faro, and Garda. Your license or hardware key (portlock) also needs to be programmed to support your portable machine.

The **Insert | Alignment | Leapfrog** menu option displays the **LeapFrog / Relocation** dialog box.



LeapFrog / Relocation dialog box



Leapfrog transformation information is stored with the measurement routine that used the Leapfrog operation.

A Leapfrog command enters into the Edit window when you click the **Accept** button. The command line in the Edit window reads:

`LEAPFROG/TOG1, NUM, TOG2`

TOG1: This first parameter in the Leapfrog command is a toggle field that relates to the three types available in the **Measure 3** area of the dialog box. These types include:

1. SPHERES (**Measure 3 spheres** option)
2. Point Sets (**Measure 3 point sets** option)
3. POINTS (**Measure 3 points** option)
4. DATUMS (**Measure datums** option)

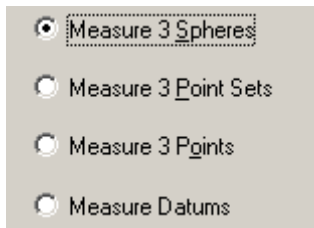
There is also an OFF value for this parameter, in which case the other two parameters do not appear. The OFF value turns off Leapfrog translation

NUM: This second parameter in the Leapfrog command is the number of hits that you want to take. This parameter corresponds to the **Hits** box in the **LeapFrog / Relocation** dialog box.

TOG2: This last parameter in the Leapfrog command is a toggle field that you can use to switch between either a FULL or PARTIAL Leapfrog. This parameter corresponds to the **Half relocation** option in the dialog box.

When this command is executed, you will be prompted to take your hits. After all the hits are taken, a Leapfrog translation is in effect.

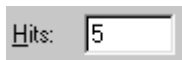
Measure Options



The measure options allow you to select what method PC-DMIS will use to perform the translation comparison.

- The **Measure 3 Spheres** option tells PC-DMIS to use spheres as the features for translation comparison. This method uses the center of each measured sphere.
- The **Measure 3 Point Sets** option tells PC-DMIS to use the centroid of a set of points. It is recommended that you use the bottom of an inverted cone with a hard probe. This method is slightly more accurate than the spheres method and much quicker for the operator.
- The **Measure 3 Points** option tells PC-DMIS to use only three points and is the least accurate of the three methods.
- The **Measure Datums** option tells PC-DMIS to use existing datum features from a measurement routine of your choice. Because the datum features are already assumed to have been measured in your existing measurement routine, you only need to measure them after relocating your machine.

Number of Hits



The **Number of Hits** box allows you to specify the number of hits you wish to use when measuring spheres or point sets; you can select these feature types from the **Measure 3 Spheres** and **Measure 3 Point Sets** options. See the "[Measure Options](#)" topic.

Half Relocation



The **Half Relocation** check box lets you determine whether PC-DMIS performs a FULL RELOCATION (FULL LEAPFROG) operation (if not selected) or performs a PARTIAL RELOCATION (PARTIAL LEAPFROG) operation (if selected).

Relocation refers to moving the portable measuring machine to a new location.

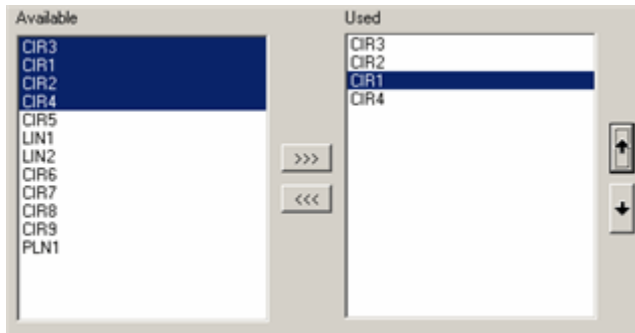
- Doing a full relocation (clearing this check box) means you would need to measure something before you move the portable machine and then remeasure some or all of those items after moving the machine. Remeasuring allows PC-DMIS to determine the new location of the machine.
- A half relocation (selecting this check box) means you move the portable machine first and then measure the datum features.

Datum Measurement Routine

This area lets you specify what measurement routine file to use as the datum measurement routine file. This box becomes enabled when you click the **Measure Datum Features** option button. You can type the full pathway to the measurement routine (.PRG) file or you can use the **Browse** button to navigate through your directory structure and select one that way.

Once you select a file, the features available for use in the Leapfrog operation appear in the **Available** list.

Available and Used Lists



Available and Used lists

The **Available** and **Used** lists display, respectively, datum features that are available for use or datum features that you have chosen to use in the Leapfrog operation.

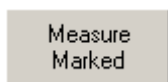
Available List

When you select a measurement routine file to use in the **Datum Measurement Routine** area, the available features from that measurement routine file appear in the **Available** list. You can then assign features to the current Leapfrog operation by selecting them and then clicking the >>> button.

Used List

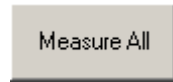
Assigned features that appear in the **Used** list are measured when you click the **Measure Marked** or **Measure All** buttons in the order that they appear in the **Used** list. You can remove them from the **Used** list by clicking the <<< button. You can change a feature's order of execution by selecting a feature clicking the up or down arrow buttons.

Measure Marked



The **Measure Marked** button only functions if you first select the **Measure Datums** option in the **Measure Options** area. Clicking this button causes a Leapfrog operation to begin, using only the features selected in the **Used** list.

Measure All



The **Measure All** button lets opens the **Execution** dialog box.

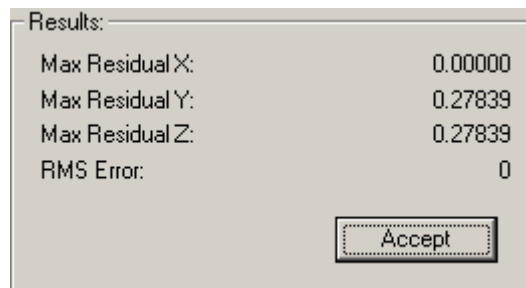
- If you are using **Measure 3 Spheres**, **Measure 3 Point Sets**, or **Measure 3 Points**, then this dialog box first prompts you to measure the three features before it prompts you to move the CMM. After moving the machine, it prompts you to remeasure the same features in the same order.
- If you are using **Measure Datums** then the **Execution** dialog box prompts you to measure all the datum features once you have moved the CMM, not before.

The results box displays the 3D distance between the features taken before the move and after the move of the CMM. If you find the results unsatisfactory, you may remeasure the last set of features again by clicking the **Re-measure** button.



If the remeasure process proves unsatisfactory, you must reset the leapfrog and start again from the beginning. This is a problem with all leapfrog systems and should be remembered.

Results area



Results area

The **Results** area shows the deviations between the machine's first position and its subsequent position(s) by displaying the 3D distance between the features taken before the move and after the move of the CMM.

Accept



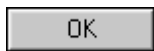
Once you have a filled out the **Leapfrog / Relocation** dialog box, you must click the **Accept** button from the **Results** area before the leapfrog transformation will be used. Click **Accept** to add the **LEAPFROG** command to the measurement routine. If you don't click the **Accept** button but click the X in the upper-right corner or click **OK** first, the constructed leapfrog translation is lost.

Reset



The **Reset** button removes any translation by adding a **LEAPFROG/OFF** command into the Edit window.

OK



Click **OK** to close the **Leapfrog / Relocation** dialog box. If you click this button before clicking the **Accept** button, the dialog box closes without inserting the **LEAPFROG** command.

Using Bundle Alignments

Bundle alignments are used for large or complex measurements where it is possible to create a number of stations in a common network by moving the same sensor to different positions around the object. As measurements are taken from different station positions around the object, measured information is bundled into one network. With all stations belonging to one single network, all measured data is part of the same coordinate system.



Bundle Alignments can be used with any portable devices as long as you have purchased this functionality for your portable device. In this case, your license or portlock must be programmed to allow this functionality.

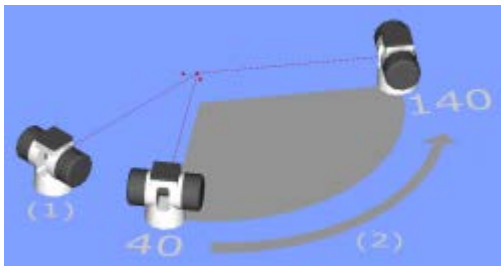


PC-DMIS does not support Leapfrog and Bundle Alignment commands used in the same measurement routine.

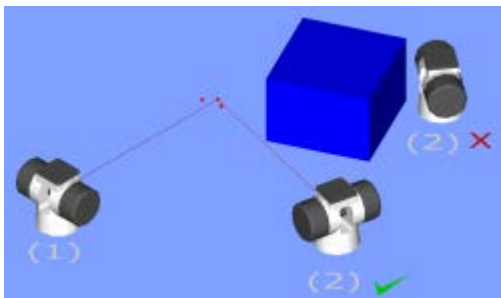
The decision to use more than one station needs to be made well in advance of taking measurements. When you plan for a station location, you should consider the following points:

Station Planning Trackers and Total Stations

1. Points used for computing a network should have reasonable intersecting angles (40° - 140°). In the example, station (2) should be located somewhere between the 40° and 140° angles in relation to the representative line between station (1) and the common measured points.



2. Points used for computing a network must be visible to more than one station (position). In the example, station (2) indicated with the green check mark works, where station (2) with a red X does not work since the line of sight to the common features is blocked.



3. The object points and the common points used for the network calculation must remain stable for the whole measuring process.
4. Avoid station locations that do not vary significantly in position to other station locations.

The bundle adjustment is a least squares optimization. It takes the "bundles" of instrument pointings (measurements of each of the points included in the alignment) and makes successive "adjustments" to the network parameters until there is a best fit between the mathematical model of the network and the actual measurements.

A system may contain a single tracker which is moved to different stations, or you could have multiple trackers which may be moved to different stations. A station is defined as a location where the tracker is placed.

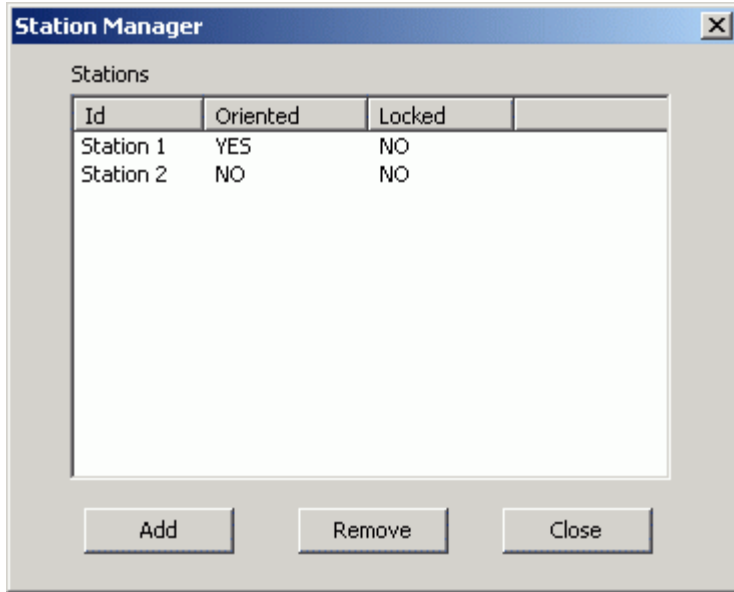
Creating Bundle Alignments

Select the **Insert | Alignment | Bundle** menu option to begin creating a Bundle Alignment. The following topics discuss the process of creating Bundle Alignments and moving stations in the Bundle Alignment:

- [Adding and Removing Stations](#)
- [Setting Fit Options](#)
- [Bundle Alignment Setup](#)
- [Bundle Alignment Results](#)
- [Bundle Alignment Command Text](#)
- [Moving Bundle Alignment Stations](#)

Adding and Removing Stations

To open the **Station Manager** dialog box, from the **Bundle Alignment** dialog box, click **Station Manager**. You can also select the **Tracker | Station Management** menu item or click the active station name in the **Tracker Status Bar**.



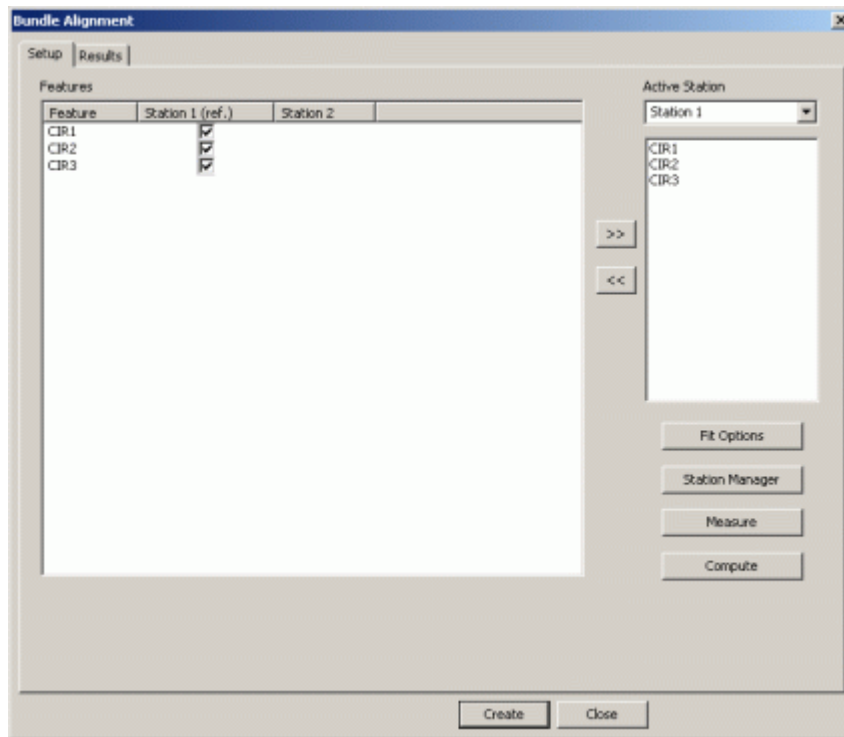
Station Manager dialog box

- **Add** - Adds a new station to the **Stations** list in the measurement routine.
- **Remove** - Removes a selected station from the **Stations** list and from the measurement routine.
- **Oriented** - A value of **YES** in the **Oriented** column means the station's location and orientation has been computed.
- **Locked** - A value of **YES** in the **Locked** column means no further measurements are allowed for that station. A station becomes locked when the Tracker is moved from its position.



The asterisk next to the station name indicates that it is the active station. No more than 99 stations are allowed in a bundle alignment calculation.

Bundle Alignment Setup



Bundle Alignment dialog box - Setup tab

Setting up the Bundle alignment entails associating "Bundle Alignment Features" that will be measured by multiple Leica Tracker stations. To do this:

1. Select the check boxes next to the "Bundle Alignment Features" that you would like to include in the Bundle Alignment. Checked "Bundle Alignment Features" will be included in the bundle calculation. If this is the *first* (reference) station, you would select all of the features that you will measure in Step 3. Only "Bundle Alignment Features" that are added to the **Active Station** feature list are measured when you click **Measure**.





By clicking the station name at the top of the column, you can either select or deselect all the features under that column.

2. Select the next station to use from the **Active Station** drop-down box. "Bundle Alignment Features" can be measured by some or all of the stations.



Stations that are locked cannot be selected as the active station.

3. To define the features that will be measured by the **Active Station** when you click **Measure**, select them from the **Features** list and click the Move Right button . This will add them to the list for the **Active Station**. To remove features from the **Active Station** feature list, select the feature and click the Move Left button .
4. Click **Measure** to begin measuring the selected features from the **Active Station**. The Bundle Alignment is computed after the last measurement has completed.
5. Review the "[Bundle Alignment Results](#)" via the **Results** tab.
6. To re-compute the Bundle Alignment, click **Compute**. This is only needed when you don't like the "[Bundle Alignment Results](#)" and you want to modify certain parameters, such as which features to include (check boxes in the **Features** multi-column list box), or changing the [Fit Options](#) settings (like a balanced network). This will redo the computation based on the changed parameters without remeasuring.

Bundle Alignment Results

Bundle Alignment

Setup Results

Stations

Id	X	Y	Z	Rx	Ry
Station 1	0	0	0	0	0

Features

Id	Source	RMS	Apex Angle	Pointing error
CIR1	Station 1			
CIR2	Station 1			
CIR3	Station 1			

Solution Status:

RMS Error:

Variance:

Warnings

Create Close

Bundle Alignment dialog box - Results tab

After you have measured and computed the configured Bundle alignment, you can verify the results on the **Results** tab. If you are satisfied with the results, click **Create** to insert the alignment into the measurement routine. The alignment is executed as defined during normal measurement routine execution.

Interpreting Bundle Alignment Results:

Stations

- **ID** - Name of the Leica Tracker station
- **XYZ** - Shows the translated position of the station with respect to the origin station.
- **Rx Ry Rz** - Shows the rotations about the origin station x, y, and z axes.

Features

- **ID** - Name of the Measurement Routine feature name.
- **Source** - Station name from which the "Bundle Alignment Feature" was originally measured.

- **RMS** - This is the root mean square error (average error) of the given "Bundle Alignment Feature".
- **Apex Angle** - This provides the largest angle between two observations of a measured "Bundle Alignment Feature". If a "Bundle Alignment Feature" is measured from more than two trackers, then the angle which is closest to 90 degrees is given as the Apex angle.
- **Pointing error** - This is a measurement of the angular error for a given "Bundle Alignment Feature".
- **XYZ** - Displays the XYZ location for the "Bundle Alignment Feature".
- **Dev XYZ** - These values provide the deviation from the measurement taken from each individual station to the respective best-fitted value.
- **Dev 3D** - This value provides the magnitude of the XYZ deviation.

Solution Status - This is either **OK** or **FAILED** indicating whether the algorithm was able to solve the bundle alignment.

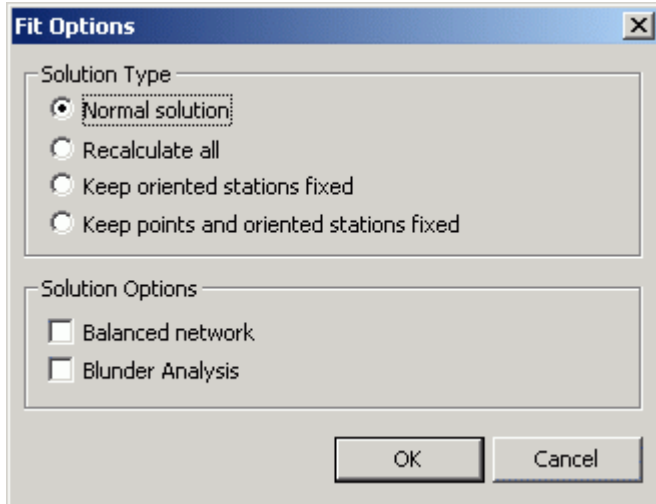
RMS Error - The total RMS error of ALL of the "Bundle Alignment Features".

Variance - The variance of ALL the "Bundle Alignment Features" combined.

Warnings - Specific messages are provided to assist in adjusting the Bundle Alignment Solution.

Setting Fit Options

To open the **Fit Options** dialog box, from the **Bundle Alignment**, click **Fit Options**.



Fit Options dialog box

Typically, the default options (shown above) will be used. Select from the following options to determine how the Bundle Alignment solution is calculated:

- **Normal Solution:** Computes the orientation of each station and each "Bundle Alignment Feature" based on the current orientation of the stations and common "Bundle Alignment Features".
- **Recalculate all:** This recomputes the orientation of "Bundle Alignment Features" and stations disregarding current orientation of stations and common "Bundle Alignment Features".
- **Keep oriented stations fixed:** Previously oriented stations will remain unchanged and only the last station will be recomputed. The common "Bundle Alignment Features" will be recomputed.
- **Keep points and oriented stations fixed:** Both previously measured stations and the common "Bundle Alignment Features" will remain fixed.
- **Balanced network:** This is used to "balance" the system so that a single station is not constrained to be the origin.
- **Blunder Analysis:** This option makes the bundle program display the orientation results as computed by the approximation computations, before any adjustment is carried out. This is the best time to detect blunders, because blunders distort the parameters (coordinates and station parameters); the earlier blunders are detected, the better they can be identified.

Bundle Alignment Command Text

```
BUNDLE ALIGN/ID = 1,SHOW DETAIL = TOG1
FIT OPTIONS/TYPE = TOG2,BALANCED = TOG3,BLUNDER ANALYSIS = TOG4
MEASURE FEATURES/PNT1,PNT2,PNT3,
BUNDLED FEATURES/
STATION = 1,PNT1,PNT2,PNT3,PNT4,
STATION = 2,PNT1,PNT2,PNT3,,
STATION = 3,PNT1,PNT2,PNT4,,
STATION =
```

- **ID:** This field provides the active station number. This is the station from which "Bundle Alignment Features" will be measured.
- **TOG1 (SHOW DETAIL = YES/NO):** When this value is set to **YES**, a detailed listing of the Bundle Alignment appears in the Edit window. By default, this value is set to **NO**, which does not display the FIT OPTIONS.
- **TOG2 (FIT OPTIONS/TYPE = *type*):** Choose one of four available Fit Options: **NORMAL**, **POINTS AND STATIONS FIXED**, **RECALCULATE ALL**, and **STATIONS FIXED**. See "[Setting Fit Options](#)".
- **TOG3 (BALANCED = OFF/ON):** When this value is set to **ON**, a balanced network solution is used. By default, this value is set to **OFF**. See "[Setting Fit Options](#)".
- **TOG4 (BLUNDER ANALYSIS = OFF/ON):** When this value is set to **ON**, Blunder Analysis is used. By default, this value is set to **OFF**. See "[Setting Fit Options](#)".
- **MEASURE FEATURES:** Lists the "Bundle Alignment Features" that will be measured for the active station number.
- **BUNDLED FEATURES:** Lists the stations and "Bundle Alignment Features" that are included in the Bundle Alignment computations.

Moving Bundle Alignment Stations

To move to a new Bundle Alignment station:

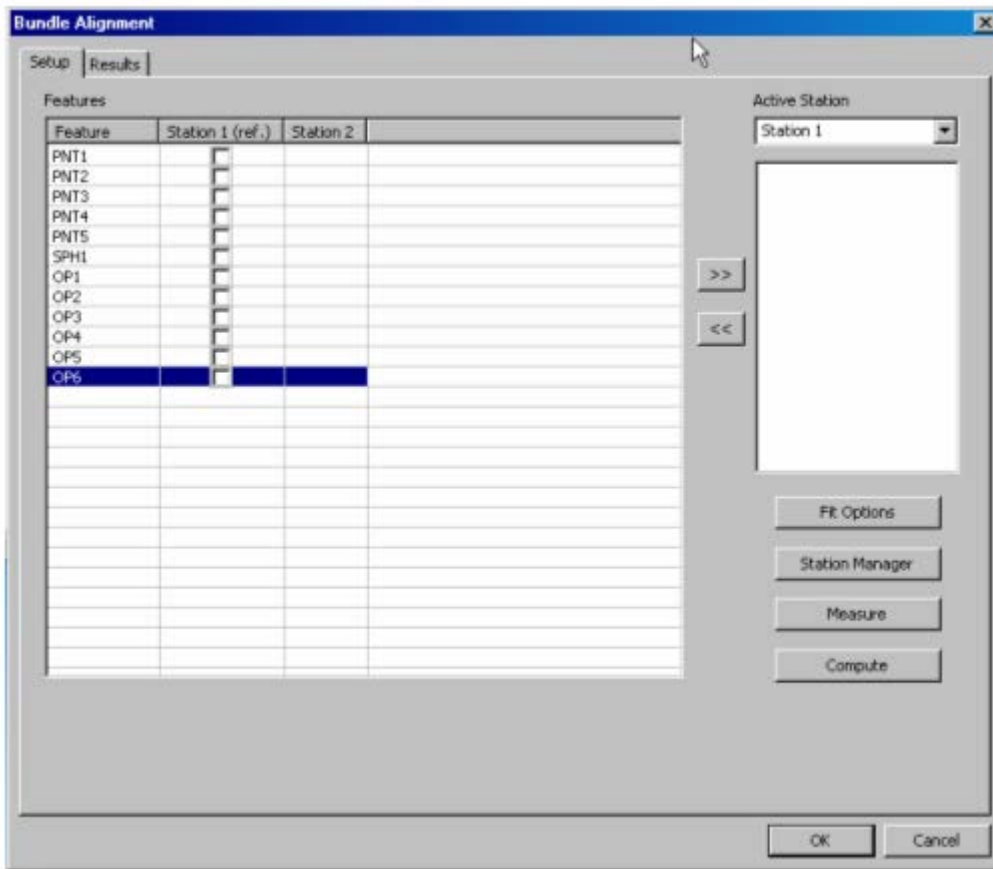
1. Measure all the features that you can measure from the first tracker position.
2. Create new station by selecting the **Tracker | Station Management** menu item or by clicking in the station name of the **Tracker Status** bar.

- Click **Add** to add a new station to the **Stations** list and then click **Close**.




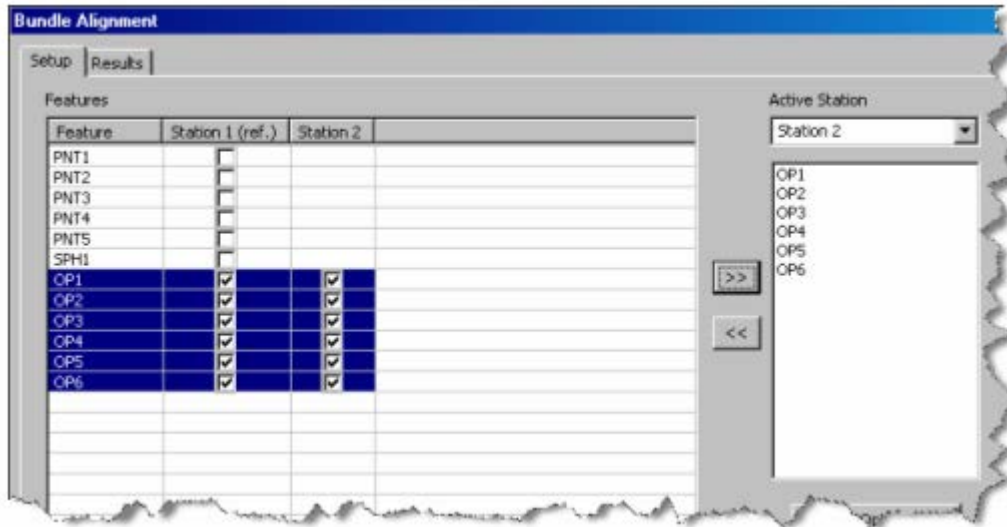
If you use points, make sure that the probe compensation has been turned off before you insert a bundle alignment command.

- Select the **Insert | Alignment | Bundle** menu item to insert a Bundle alignment command. All point-reducible features like points, circles, and spheres are displayed under Station 1 and can be selected to be part of the bundle alignment.



Bundle Alignment dialog box showing measured features under Station 1

- Select the next station (created in step 3) to where the tracker from the **Active Station** combo box is to move.
- Select the check boxes next to the features in the column of the first tracker position that should be used for the bundle alignment at the next station position.
- Click  to add the selected features to the **Active Station** list for the next station.



Features selected from the first station added to the next Active Station

8. Physically move the Tracker station to the new **Active Station** position.
9. Click **Measure** and the **Execution Mode Options** dialog box guides you through the available bundle measurements for the new **Active Station**.



The Status bar indicates if the station is not yet oriented in the bundle network by highlighting it in red, like this:



10. Review the overall results from the "[Results Tab](#)" once all necessary features have been measured. The results for the measured features provide source station, orientation, RMS errors and variance.

Bundle Alignment

Setup Results

Stations

Id	X	Y	Z	Rx	Ry	Rz
Station 1	0	0	0	0	0	0
Station 2	979.45	4990.867	-56.441	0.983	-1.051	-165.466

Features

Id	Source	RMS	Apex Angle	Pointing error	X	Y	Z	Dev X	Dev Y	Dev Z	Dev 3D
OP1	Station 1				220.003	180.004	48.57	0.019	-0.02	-0.007	0.028
OP1	Station 2				220.009	179.969	48.606	0.012	0.015	-0.042	0.046
OP1	Bundled	0.038	149.401	0.046	220.021	179.984	48.564				
OP2	Station 1				245.998	164.975	48.61	-0.001	0.006	0.001	0.006
OP2	Station 2				246.014	164.989	48.586	-0.017	-0.007	0.025	0.031
OP2	Bundled	0.023	148.744	0.031	245.997	164.982	48.611				
OP3	Station 1				246.007	134.976	48.611	0.013	-0.009	-0.002	0.016
OP3	Station 2				246.028	134.962	48.615	-0.008	0.004	-0.007	0.011
OP3	Bundled	0.014	148.542	0.016	246.021	134.967	48.608				
OP4	Station 1				220.024	119.955	48.611	-0.002	0.004	0.008	0.009
OP4	Station 2				220.024	119.96	48.618	-0.002	-0.001	0	0.002

Warnings

Solution Status: OK

RMS Error: 0.022

Variance: 2.046

OK Cancel

Results tab after measuring features from the new Active Station

- If **Solution Status** reads OK, click **OK** to insert a bundle alignment command into the measurement routine. The new station is now oriented and available in the network.



If necessary, you can exclude certain features from the actual bundle computation and recompute it on the **Setup** tab.

- Complete the previous steps if you are moving to the next station position.

Measuring Features

Adding measured features using portable devices is typically accomplished by means of the [Quick Start interface](#).



Measure toolbar on the Quick Start interface

As you take hits on the part, PC-DMIS interprets the number of hits, the hit vectors, and so on to determine the feature that should be added to the measurement routine.

The supported measured features are: Point, Line, Plane, Circle, Cylinder, Cone, Sphere, Torus, Round Slot, and Square Slot. From the **Measure** toolbar, you can also add [manual scans](#) or create features in guess mode. For more information on measuring square slots, see "[A Note on Square Slots](#)".

For detailed information on creating measured features, see "Inserting Measured Features" in the PC-DMIS CMM documentation. You can find additional information for measured features in the "Creating Measured Features" chapter in the PC-DMIS Core documentation.

You can also create auto features using portable devices.

For information, see "Creating Auto Features" in the PC-DMIS CMM documentation. You can find additional information for auto features in the "Creating Auto Features" chapter in the PC-DMIS Core documentation.

Quick Start Interface for Trackers

The Quick Start interface is essentially the same for all devices, except for the Tracker device. For this device, the Quick Start interface has a **Project** check box. For all other details about Quick Start Interface, see the "[Quick Start Interface](#)" topic.

Project Check Box

The **Project** check box (the default setting is cleared) is available in Portable for Leica Trackers and TDRA6000. This check box enables a projection to the FEATURE (plane) referenced by the selection from the **Name** drop down list.



This check box is available only if the measurement task is set to **POINT** and if the **Reference Feature** list has **Type** set to **FEATURE** is active.

If the **Project** check box is cleared (the default setting), the software does not project the point but it instead compensates it with respect to the active compensation settings.



PC-DMIS was doing the same in versions earlier than v2012 if the software was installed for Leica TDRA (LeicaTPS interface setting) when measurement task was **POINT** and reference type was **FEATURE**. The **Project** check box in Portable now additionally enables projection of the point to the reference feature.

A Note on Square Slots

When measuring square slots, it is important that hits are taken clockwise or counter-clockwise in order around the slot. For example, a square slot with 5 hits should have 2 hits on the first side, and one hit on the remaining 3 sides in order around the slot.

If there are 6 hits, there should be 2 on the first side, 1 on the next, 2 on the next, and 1 on the last. The hits should be strictly clockwise or counter-clockwise.

A Note on Thickness Type: None

When measuring auto features using a portable arm machine, the thickness type of "None" still applies the thickness value if specified. The thickness is applied to shank style measurement.

When you use a shank probe for measurement, you use the cylindrical shank of the probe to measure instead of the probe tip. To do this, you need to first define sample hits. PC-DMIS can then determine the location of the supported feature (Circles, Ellipses, Slots, and Notches) using the shank.

Creating "Single-Point" Measured Circle Features



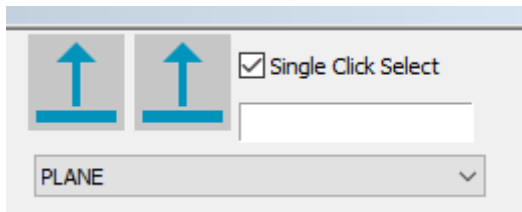
Portable devices can create a measured circle feature by taking only one hit on that feature. This is termed a "single-point" circle. This is useful when attempting to measure a hole with a probe whose sphere size is larger than the hole's diameter and therefore cannot fit entirely into the hole to take the usual minimum three hits required. In this case, PC-DMIS creates the feature at the intersection of the workplane (or projection plane if a measured plane is currently active) and the probe sphere.

When a Measured Plane Feature is not available

If a Measured Plane feature is not available, a message appears.

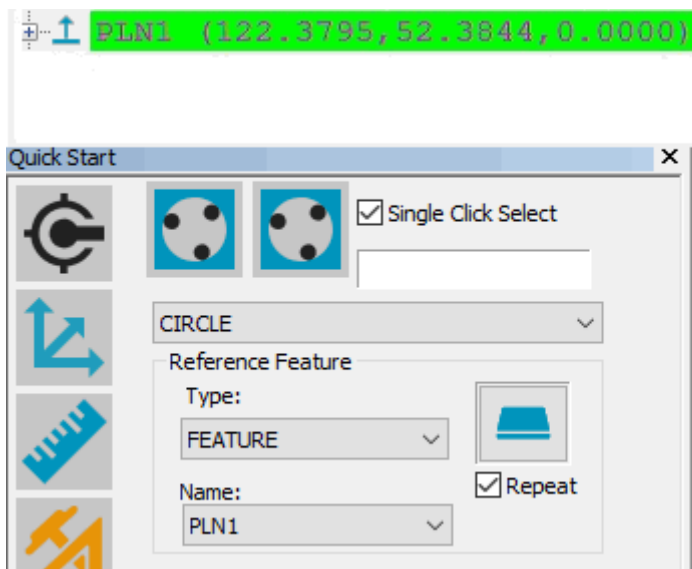
If **No** is selected, the Reference Feature type defaults to "WORKPLANE".

If **Yes** is selected, the Quick Start for Measure Plane mode is displayed to define the appropriate reference feature.



Measure Plane Mode Quick Start dialog box

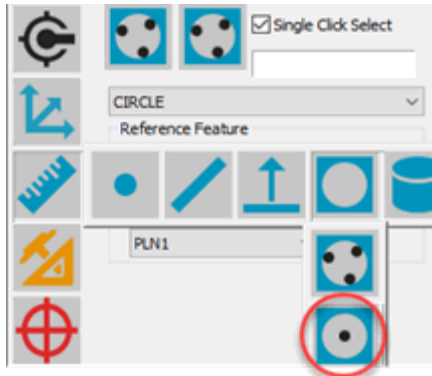
After the plane is done, the Quick Start dialog box returns to the Measured Circle mode. PC-DMIS Portable automatically adds the Measured Plane into the reference feature name list, and highlights it in the Edit window.



Measured Plane added into the Edit window Reference Feature name list

Creating a single-point measured circle

1. Select **View | Other Windows | Quick Start** to access the [Quick Start interface](#). Single-point measured circles do not work using any other creation method.
2. From the **Measure** toolbar, select the **Measure Single Point Circle** toolbar item.



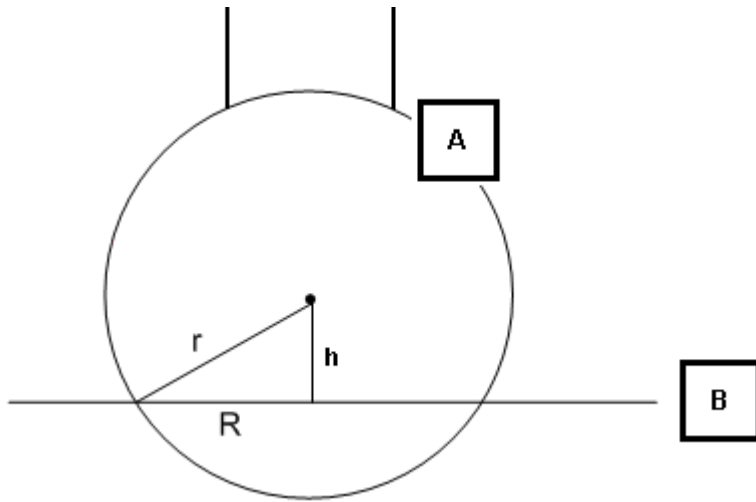
Measure Single Point Circle icon

3. Position the probe in the hole, and take a single hit. PC-DMIS enables the **Finish** button.
4. Click **Finish**. PC-DMIS creates the feature at the intersection of the workplane (or projection plane if a measured plane is currently active) and the probe sphere (see "How It Works" below).



Remember that the calculation is done at the intersection of the probe tip with the workplane or projection plane. If the probe sphere is too high or too low, PC-DMIS generates an error message indicating that the feature has failed. Also, be aware that measuring holes that are much smaller than the diameter of the probe will result in less accuracy in the resulting circle diameter.

How It Works:



Side view of the workplane and the probe sphere

A - Probe sphere

B - workplane

h - height of the sphere center to the workplane

R - radius of the measured circle

r - radius of the probe sphere

$$R = \sqrt{r^2 - h^2}$$



If the probe sphere is so high that r is less than h , the intersection math will fail and PC-DMIS will not solve the circle. If the sphere center is below the workplane (B), PC-DMIS will also not solve the circle.

Creating "Two-Point" Measured Slot Features



Measured Two Point Round Slot button



Measured Two Point Square Slot button

Similar to creating ["single-point" measured circle features](#), portable devices can also create a measured square or round slot feature by taking only two hits, one on each end of the slot. This is termed a "two-point" slot. This is useful when attempting to measure a slot with a probe whose sphere size is larger than the slot's diameter and therefore cannot fit entirely into the slot to take the usual minimum number of hits required for a measured slot. In this case, PC-DMIS creates the feature at the intersection of the workplane (or projection plane if a measured plane is currently active) and the probe sphere.



For more information, see "[When a Measured Plane Feature is not available](#)".

To create a two-point measured slot feature:

1. Select **View | Other Windows | Quick Start** to access the [Quick Start interface](#).
2. From the **Measure** toolbar, select either the **Measured Two Point Round Slot** button



or the **Measured Two Point Square Slot** button





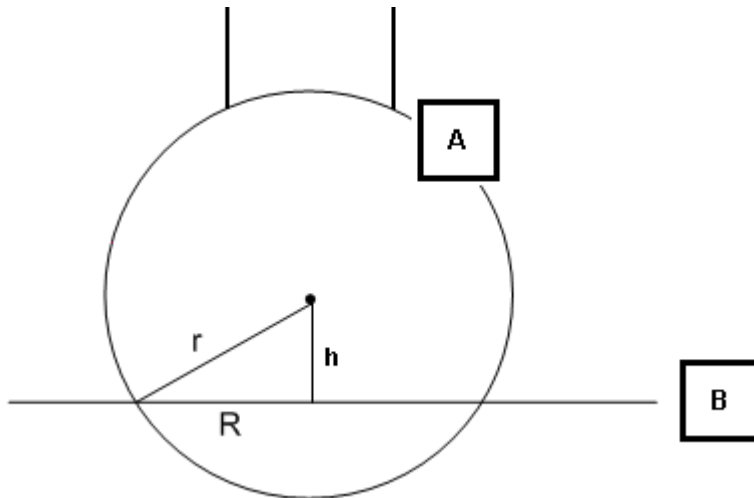
You don't have to use the Quick Start interface. If desired, you can instead click the desired slot feature from the standard **Measured Features** toolbar. However, this topic assumes that you are using the Quick Start interface.

3. Position the probe as far as it will go down into one of the ends of the slot, and take a hit. The hit should be on the bottom hemisphere of the probe sphere.
4. Position the probe as far as it will go down into the other end of the slot, and take a hit. The hit should be on the bottom hemisphere of the probe sphere.
 - If the probe sphere properly intersected with the workplane (or projection plane) with both hits then PC-DMIS will enable the **Finish** button.
 - If the first hit did not intersect properly with the workplane or projection plane, a message box will appear that says, "Hit 1 out of range". If the first hit did intersect with the work or reference plane, but the second did not, it will display, "Hit 2 out of range". If you receive one of these error messages, you will need to retake both hits, adjusting your workplane or projection plane as needed so that a proper intersection with the probe sphere takes place.
5. Click **Finish**. PC-DMIS creates the feature at the intersection of the workplane (or projection plane if a measured plane is currently active) and the probe sphere (see "How It Works" below).
 - The width of the slot is based on the amount of probe sphere that intersects with the work or projection plane when the probe comes in contact with the feature on the part.
 - The length of the slot is based on the distance between the two slot points.



Remember that the calculation is done at the intersection of the probe sphere with the workplane or projection plane. If the probe sphere is too high (it doesn't intersect with the plane at all) or is too low (the hit is on the upper hemisphere or higher), PC-DMIS will generate an error message indicating that the feature has failed.

How It Works:



Side view of the workplane and the probe sphere

A - Probe sphere

B - workplane

h - height of the sphere center to the workplane

R - radius of the measured slot. The slot's width is twice this value.

r - radius of the probe sphere

$$R = \sqrt{r^2 - h^2}$$



If the probe sphere is so high that r is less than h, the intersection math will fail and PC-DMIS will not solve the slot. If the sphere center is below the workplane (B), PC-DMIS will also not solve the slot.

Portable Hard Probe Scanning

PC-DMIS Portable allows you to scan features using one of six manual scanning methods. Measured points are collected as fast as they are read by the controller during the scanning process. Once the scan is complete, PC-DMIS will offer you an opportunity to reduce the collected data based on the scanning method selected. You must have PC-DMIS configured for using a hard probe for these scanning types to be available.

To begin creating manual scans, from the **Probe Modes** toolbar, place PC-DMIS into **Manual**

Mode () and then select one of the available manual scan types from the **Scan (Insert | Scan)** submenu. These include:

- [Fixed Distance](#)
- [Fixed Time / Distance](#)
- [Fixed Time](#)
- [Body Axis](#)
- [Multisection](#)
- [Manual Freeform](#)

The appropriate manual scan dialog box will open.

For information on the options available in the **Scan** dialog box, the dialog box used to perform these scans, see the "Common Functions of the Scan Dialog Box" in the "Scanning Your Part" chapter in the PC-DMIS Core documentation.

When creating Auto Features, sample hits can be taken using a manual scan. For information, see "[Scanning for Auto Feature Sample Hits](#)".

Rules for Manual Scans

This topic discusses rules for manual scanning using a hard probe on a portable device.

Rules for Manual Scans in General

The following description lists the rules that you must follow to have manual scanning compensate correctly and with greater speed on Arm CMMs.

- You should not lock any axis during the scan. PC-DMIS takes the scan by crossing the probe over a keyed-in **Body Axis** location. Each time the probe crosses this given plane, the CMM takes a reading and passes it to PC-DMIS.
- On this type of scan, you must type the **InitVec** and **DirVec** values in the **Part Coordinate System**. This is required to work together with the **Body Axis** location.
- Make sure you type the **Body Axis** in the **Part Coordinate System**.

When multiple rows of manual scans are being done, we recommend that every other scan line be reversed.

For example (continuing the scan of the sphere as outlined above):

1. Begin the scan along the surface in the +X direction.
2. Move to the next row and scan along the -X axis.
3. Continue to switch the direction of the scan as needed. The internal algorithms depend on this kind of regularity and could give poor results if the scheme is not followed.

Compensation Limitations

With Fixed Distance, Fixed Time / Distance, and Fixed Time scan, PC-DMIS automatically lets you take manual hits in a three-dimensional manner and in any direction. This is useful when scanning using free moving manual CMMs (such as a Romer or Faro arm) whose axes cannot be locked.

Since you can move the probe in any direction, PC-DMIS cannot accurately determine the proper probe compensation (or the Input and Direction vectors) from the measured data.

There are two solutions to the compensation limitations:

- *If CAD surfaces exist*, then you can select **FINDNOMS** from the **Nominals** list. PC-DMIS attempts to find the nominal values for each measured point in the scan. If the nominal data is found, then the point is compensated along the found vector, which allows proper probe compensation; otherwise, it remains at Ball Center.
- *If CAD surfaces do not exist*, then probe compensation does not occur. All data remains at Ball Center with no probe compensation occurring.

Scanning for Auto Feature Sample Hits

If you measure an Auto Feature that uses sample hits, PC-DMIS prompts you to take those sample hits during measurement routine execution. Instead of taking just a few individual hits with your portable arm, however, you can now scan the surface with the probe to retrieve multiple hits very rapidly on each surface. This helps to improve your accuracy.

Some features, such as an Auto Circle, have one sample plane. Other auto features, such as Auto Angle Point or Auto Corner Point, have multiple sample planes. To scan a surface, press the button on your portable machine that begins retrieving hits from the controller, then pass the probe over the surface for as long as you like. PC-DMIS will read in multiple hits. When you release the button and finish scanning the surface, PC-DMIS prompts you to take the next set of sample hits on the next surface. Continue this process until you have scanned all necessary sample hits on all surfaces.

Rules of Scanning for Sample Hits

- You cannot scan for multiple sample planes in one scan segment. In other words, you can't scan sample hits around corners. When you scan for sample hits, each scan must remain on a single surface. If a feature needs sample hits from more than one surface, such as a corner point feature that uses three surfaces, each surface needs its own scan.
- You cannot scan for sample hits and then measure a feature using the same scan segment. When scanning sample hits prior to actually scanning the feature to measure it, you should perform a scan segment for each surface needing sample hits, and then a separate scan segment for the actual feature measurement.
- When scanning the actual feature, not the sample hits, you can perform the feature measurement in a single scan. For example, for an Auto Square Slot, you will scan all four sides in one continuous segment.

For information on Auto Features and sample hits, see the "Creating Auto Features" chapter in the PC-DMIS Core documentation.

Registry Entries for Hard Probe Scanning

There are several registry entries in the PC-DMIS Settings Editor that control how when points are read into PC-DMIS from your portable arm's controller. The following registry entries are in the **HardProbeScanningInFeatures** section:

- `MinDeltaBetweenPointsInMM` - Sets the minimum distance (in millimeters) that your probe must pass before a new hit gets sent from the controller to PC-DMIS.
- `MinTimeDeltaBetweenPointsInMilliseconds` - Sets the minimum time (in milliseconds) that must pass before PC-DMIS takes a new hit.
- `MaxPointsForAFeature` - Sets the maximum number of points needed for a feature. Any points read into PC-DMIS from the controller beyond this maximum number are ignored.

For information on these registry entries, start your PC-DMIS Settings Editor, and press F1 to access its online Help. Then navigate to the appropriate topics.

Performing a Fixed Distance Manual Scan

The Fixed Delta method of scanning allows you to reduce the measured data by setting a distance value in the **Distance Between Hits** box. PC-DMIS will start from the first hit and reduce the scan by deleting hits that are closer than the distance specified. The reduction of hits happens as data comes from the machine. PC-DMIS only keeps the points that are set apart by *more* than the specified increments.

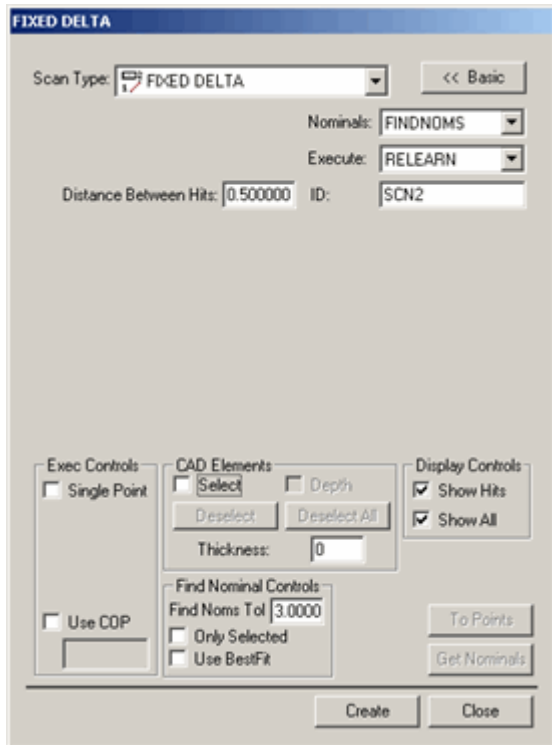


If you have specified an increment of 0.5, PC-DMIS only keeps hits that are at least 0.5 units apart from each other. The rest of the hits from the controller are discarded.

For information on this tab's other controls, see the "Common Functions of the Scan Dialog Box" topic in the "Scanning Your Part" chapter in the PC-DMIS Core documentation.

To create a Fixed Distance (Delta) scan:

1. Select the **Insert | Scan | Fixed Distance** menu option to open the **FIXED DELTA** dialog box.



FIXED DELTA dialog box

2. Specify a custom name for the scan in the **ID** box if you don't want to use the default name.
3. In the **Distance Between Hits** box, type the distance that the probe will need to move before PC-DMIS takes a hit. This is the 3D distance between points. For example, if you type 5, and your units of measurement are millimeters, the probe has to move at least 5 mm from the last point before PC-DMIS accepts a hit from the controller.
4. If you're using a CAD model, type a **Find Nominals** tolerance in the **Find Nominals Control** area. This defines how far away the actual ball center point can be from the nominal CAD location.
5. Set any other dialog box options as needed.
6. Click **Create**. PC-DMIS inserts the basic scan.
7. Execute your measurement routine. When PC-DMIS executes the scan, the **Execution Options** dialog box appears, and PC-DMIS waits for data to come from the controller.
8. Manually drag the probe over the surface you want to scan. PC-DMIS will accept hits from the controller that are separated by any distance greater than the distance you defined in the **Distance Between Hits** box.

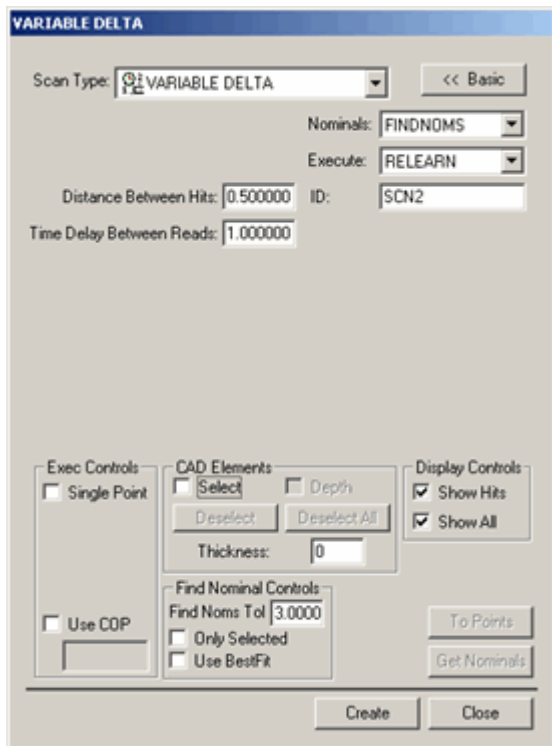
Performing a Fixed Time / Distance Manual Scan

The Fixed Time / Distance (Variable Delta) method of scanning allows you to reduce the number of hits taken in a scan by specifying the distance the probe must move as well as the time that must pass before additional hits can be accepted by PC-DMIS from the controller.

For information on this tab's other controls, see the "Common Functions of the Scan Dialog Box" topic in the "Scanning Your Part" chapter in the PC-DMIS Core documentation.


To create a Fixed Time / Distance (Variable Delta) scan:

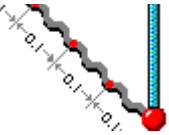
1. Select the **Insert | Scan | Fixed Time / Distance** menu option to open the **VARIABLE DELTA** dialog box.



VARIABLE DELTA dialog box

2. Specify a custom name for the scan in the **ID** box if you don't want to use the default name.

- 
3. In the **Time Delay Between Reads** box, type the time in seconds that will need to elapse before PC-DMIS takes a hit.

- 
4. In the **Distance Between Hits** box, type the distance that the probe will need to move before PC-DMIS takes a hit. This is the 3D distance between points. For example, if you type 5, and your units of measurement are millimeters, the probe has to move at least 5 mm from the last point before PC-DMIS accepts a hit from the controller.
5. If you're using a CAD model, type a **Find Nominals** tolerance in the **Find Nominals Control** area. This defines how far away the actual ball center point can be from the nominal CAD location.
6. Set any other dialog box options as needed.
7. Click **Create**. PC-DMIS inserts the basic scan.
8. Execute your measurement routine. When PC-DMIS executes the scan, the **Execution Options** dialog box appears, and PC-DMIS waits for data to come from the controller.
9. Manually drag the probe over the surface you want to scan. PC-DMIS checks the amount of time elapsed and the distance the probe moves. Whenever the time and distance exceed the values specified, it will accept a hit from the controller.

Quick Start Manual Scan



You can also begin the execution of a variable scan from the **Quick Start** interface by clicking the **Scan** button from the **Measure** toolbar. You will be prompted to take hits for manual scanning. Once you have completed taking scan hits, click **Finish** to add the manual scan (variable delta) feature to the measurement routine.

Performing a Fixed Time Manual Scan

The Time Delta method of scanning allows you to reduce the scan data by setting a time increment in the **Time Delay Between Reads** box. PC-DMIS will start from the first hit and reduce the scan by deleting hits that are read in faster than the specified time delay.

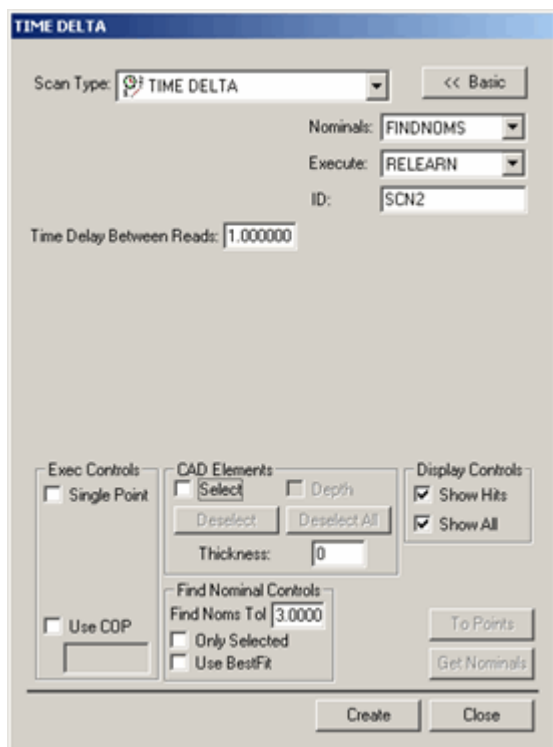


If you specify a time increment of 0.05 seconds, then PC-DMIS only keeps hits from the controller that are measured at least 0.05 seconds apart. The other hits are excluded from the scan.

For information on this tab's other controls, see the "Common Functions of the Scan Dialog Box" topic in the "Scanning Your Part" chapter in the PC-DMIS Core documentation.

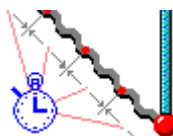
To create a Fixed Time (Time Delta) scan:

1. Select the **Insert | Scan | Fixed Time** menu option to open the **TIME DELTA** dialog box.



TIME DELTA dialog box

2. Specify a custom name for the scan in the **ID** box if you don't want to use the default name.



3. In the **Time Delay Between Reads** box, type the time in seconds that will need to elapse before PC-DMIS takes a hit.

4. If you're using a CAD model, type a **Find Nominals** tolerance in the **Find Nominals Control** area. This defines how far away the actual ball center point can be from the nominal CAD location.
5. Set any other dialog box options as needed.
6. Click **Create**. PC-DMIS inserts the basic scan.
7. Execute your measurement routine. When PC-DMIS executes the scan, the **Execution Options** dialog box appears, and PC-DMIS waits for data to come from the controller.
8. Manually drag the probe over the surface you want to scan. Whenever the elapsed time exceeds the values specified in the Time Delay Between reads box, PC-DMIS will accept a hit from the controller.

Performing a Body Axis Manual Scan

The Body Axis method of scanning allows you to scan a part by specifying a cut plane on a certain part axis and dragging the probe across the Cut Plane. As you scan the part, you should scan so that the probe crisscrosses the defined Cut Plane as many times as desired. PC-DMIS then follows this procedure:

1. PC-DMIS gets data from the controller and finds the two data hits that are closest to the Cut Plane on either side as you crisscross.
2. PC-DMIS then forms a line between the two hits which will pierce the Cut Plane.
3. The pierced point then becomes a hit on the Cut Plane.

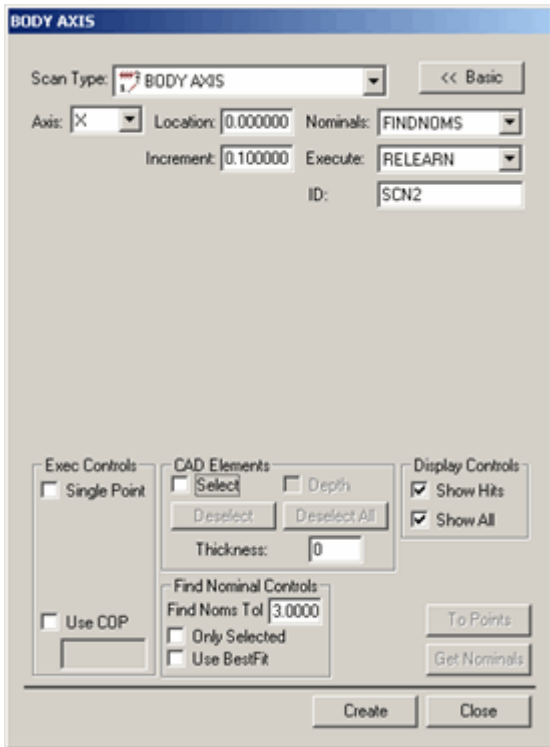
This operation happens every time you cross the Cut Plane, and you will finally have many hits that are on the Cut Plane.

You can use this method to inspect multiple rows (PATCH) of scans by specifying an increment for the cut plane location. After scanning the first row, PC-DMIS will move the cut plane to the next location by adding the current location to the increment. You can then continue scanning the next row at the new Cut Plane location.

For information on this tab's other controls, see the "Common Functions of the Scan Dialog Box" topic in the "Scanning Your Part" chapter in the PC-DMIS Core documentation.

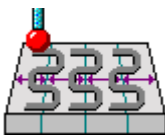
To create a Body Axis scan:

1. Select the **Insert | Scan | Body Axis** menu option to open the **BODY AXIS** dialog box.



BODY AXIS dialog box

2. Specify a custom name for the scan in the **ID** box if you don't want to use the default name.
3. From the **Axis** list, select an axis. The available axes are X, Y, and Z. The cut plane that your probe will crisscross will be parallel to this axis.
4. In the **Location** box, specify a distance from the defined axis where your cut plane will be located.



5. In the **Increment** box, specify the distance between planes if you will be scanning across multiple planes.
6. If you're using a CAD model, type a **Find Nominals** tolerance in the **Find Nominals Control** area. This defines how far away the actual ball center point can be from the nominal CAD location.
7. Set any other dialog box options as needed.
8. Click **Create**. PC-DMIS inserts the basic scan.

9. Execute your measurement routine. When PC-DMIS executes the scan, the **Execution Options** dialog box appears, and PC-DMIS waits for data to come from the controller.
10. Manually drag the probe back and forth over the surface you want to scan. As the probe approaches a defined cut plane, you will hear a continual audible tone that gradually increases in pitch until the probe crosses the plane. This audible cue helps you determine how close the probe is to any cut planes. PC-DMIS will accept hits from the controller each time the probe crosses the defined plane.

Performing a Multisection Manual Scan

The Multisection method of scanning functions much like the [Body Axis](#) manual scan with these differences:

- It can cross multiple sections.
- It does not have to be parallel to the X, Y, or Z axis.

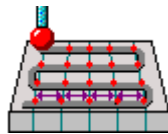
For information on this tab's other controls, see the "Common Functions of the Scan Dialog Box" topic in the "Scanning Your Part" chapter in the PC-DMIS Core documentation.

To create a Multisection scan:

1. Select the **Insert | Scan | Multisection** menu option to open the **MULTISECTION** dialog box.

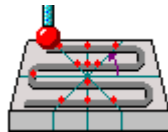
MULTISECTION dialog box

2. Specify a custom name for the scan in the **ID** box if you don't want to use the default name.
3. From the **Section Type** list, choose the type of sections you want to scan. Available types include:
 - *Parallel Planes*



- The sections are planes that run through your part. Every time the probe crosses a plane, PC-DMIS records a hit. Planes are relative to the start point and direction vector. If you select this type, define the vector of the initial plane in the **Initial Vectors** area.

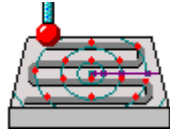
- *Radial Planes*



- These sections are planes that radiate out from the start point. Every time the probe crosses a plane, PC-DMIS takes a hit. If you select this type,

define two vectors in the **Initial Vectors** area: the vector of the initial plane (PlaneVec), the other, the vector around which the planes are rotated (AxisVec).

- *Concentric Circles*



- These sections are concentric circles with increasingly larger diameters centered around the start point. Every time the probe crosses a circle, PC-DMIS takes a hit. If you select this type, define a single vector in the **Initial Vectors** area that defines the plane in which the circle lies (AxisVec).

4. In the **Number of Sections** box, type how many sections you want to have in your scan.
5. If you chose at least two sections, specify the increment between sections in the **Increment** box. For parallel planes and circles, this is the distance between places. For radial planes, this value is an angle. PC-DMIS automatically spaces the sections on the part.
6. Define the scan's start point. In the **Start Point** area, type the **X**, **Y**, and **Z** values, or click on your part to have PC-DMIS select the start point from the CAD drawing. The sections are calculated from this temporary point based on the increment value.
7. If you're using a CAD model, type a **Find Noms Tol** tolerance in the **Find Nominal Controls** area. This defines how far away the actual ball center point can be from the nominal CAD location.
8. Set any other dialog box options as needed.
9. Click **Create**. PC-DMIS inserts the basic scan.
10. Execute your measurement routine. When PC-DMIS executes the scan, the **Execution Options** dialog box appears and PC-DMIS waits for data to come from the controller.
11. Manually drag the probe over the surface you want to scan. As the probe approaches each section, you will hear a continual audible tone that gradually increases in pitch until the probe crosses the section. This audible cue helps you determine how close the probe is to a section crossing. PC-DMIS accepts hits from the controller each time the probe crosses the defined section or sections.

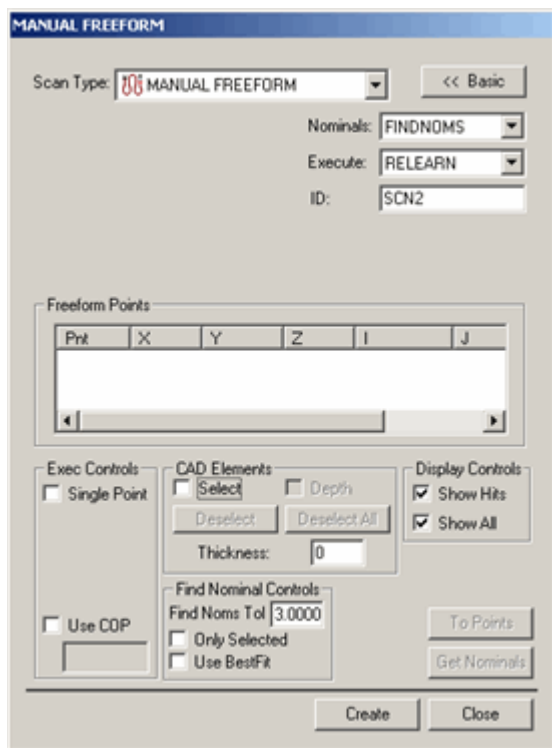
Performing a Manual Freeform Scan

The Manual Freeform scan lets you create a freeform scan with a hard probe. This scan doesn't require an initial or direction vector like many of the other manual scans. Similar to its DCC counterpart, all you need to do to create a freeform scan is to click points on the surface you wish to scan.

For information on this tab's other controls, see the "Common Functions of the Scan Dialog Box" topic in the "Scanning Your Part" chapter in the PC-DMIS Core documentation.

To create a Manual Freeform scan:

1. Select the **Insert | Scan | Manual Freeform** menu option to open the **MANUAL FREEFORM** dialog box.



Manual Freeform dialog box

2. Specify a custom name for the scan in the **ID** box if you don't want to use the default name.
3. If you're using a CAD model, type a **Find Nominals** tolerance in the **Find Nominals Control** area. This defines how far away the actual ball center point can be from the nominal CAD location.

4. Click on the surface of the part in the Graphic Display window to define your scan's path. With each click, an orange point appears on the part drawing. Each new point connects to the previous point with an orange line.
5. Once you have sufficient points for your scan, click **Create**. PC-DMIS inserts the scan into the Edit window.

Portable Laser Probe Scanning

PC-DMIS allows you to manually scan the surface of your part into pointclouds. From pointclouds, you can then extract Auto Features for addition to your measurement routine. Portable laser probe scanning can be accomplished with a Perceptron or CMS laser probe, or you can use a Leica T-Probe scanner.

- For information on setting up and using a Perceptron or CMS laser probe, see the "Getting Started" chapter of the PC-DMIS Laser documentation.
- For information on setting up and using Leica T-Probe scanners, see "[Using a Leica Laser Tracker](#)" in this documentation.

Creating a Manual Scan

To begin scanning in Learn Mode, you should do the following:

1. [optional] Add a COP command to your measurement routine to which the scanned data will be added. To do this select the **Insert | Pointcloud Feature** menu item, or click the **Pointcloud** button on the **Pointcloud** toolbar.



If you begin scanning without first creating a COP command, PC-DMIS automatically creates a COP for the scanned data.

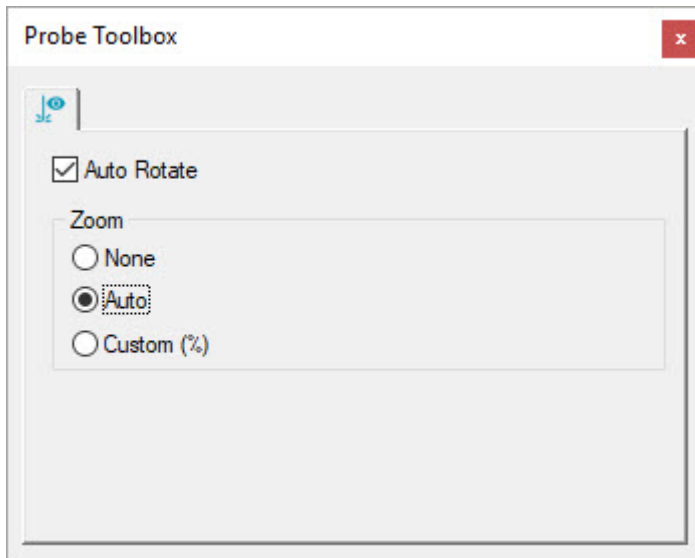
2. Scan the surface of the feature or features. This may take more than one pass. The software displays the scanned stripes in the Graphic Display window in real-time. If you are using an existing COP, PC-DMIS prompts you to empty it.
3. Select Auto Features that reside within the pointcloud as described in the "Extracting Auto Features from Pointclouds" topic in the Laser documentation. When an Auto

Feature is created, the pointcloud for the feature is extracted and appears on the **Laser Scan Properties** tab in the Laser Probe Toolbox.

Auto Zoom and Auto Rotate

When you use a portable arm or laser tracker to scan, PC-DMIS automatically rotates and zooms the pointcloud in real-time in the Graphic Display window to show the proper view.

This is done with the **Auto Rotate** check box and the **Zoom** options located on the **Laser Scan Display Properties** tab of the Probe Toolbox (**View | Other Windows | Probe Toolbox**).



Probe Toolbox - Laser Scan Display Properties tab with Auto Rotate and Auto Zoom options selected

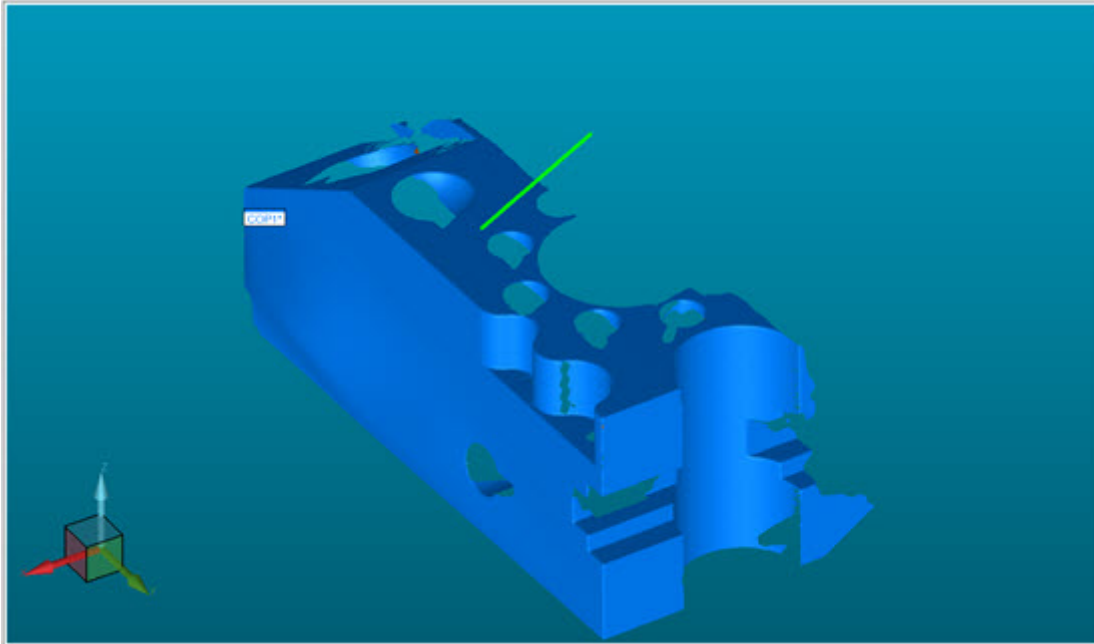
PC-DMIS enables the **Auto Rotate** and the **Auto** option in the **Zoom** section by default.

Auto Rotate check box - If this check box is selected, the pointcloud automatically rotates in the Graphic Display window based on the laser line orientation. The rotation occurs even you are not scanning. This allows you to position the scan line on the part before triggering a scan pass. When disabled, no rotation occurs in the Graphic Display window while laser scanning.

Zoom section - You have three options:

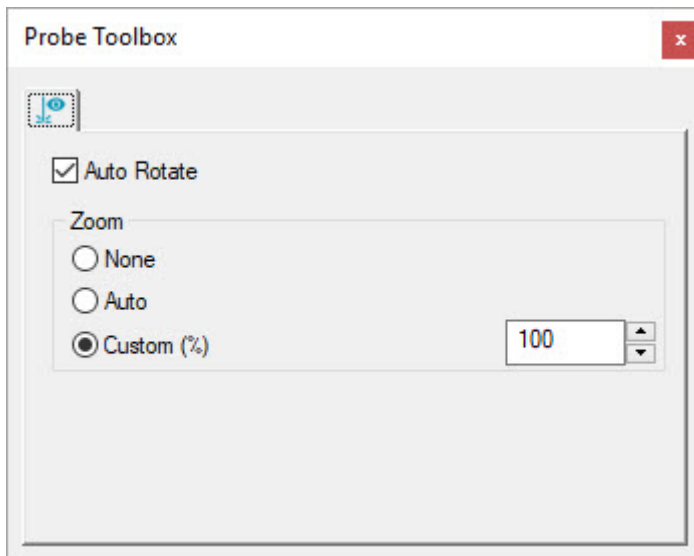
None - This disables auto zoom. The software uses the last manual user-defined zoom setting to show the pointcloud scan in the Graphic Display window.

Auto - If this option is selected, the Graphic Display window zooms into a close-up view, centered in the middle of the laser scan line. As you scan more of the part, the Graphic Display window zooms out to show the collected pointcloud data.



Graphic Display window showing the scan line with Auto Zoom option selected

Custom (%) - If this option is selected, you can set the zoom percentage. 100% indicates the zoom factor is set using the actual part size (1:1 relationship). You can set the zoom percentage larger to get a close-up view of the scan or smaller to see more of the pointcloud at a reduced size. For example, 50% would be half size.

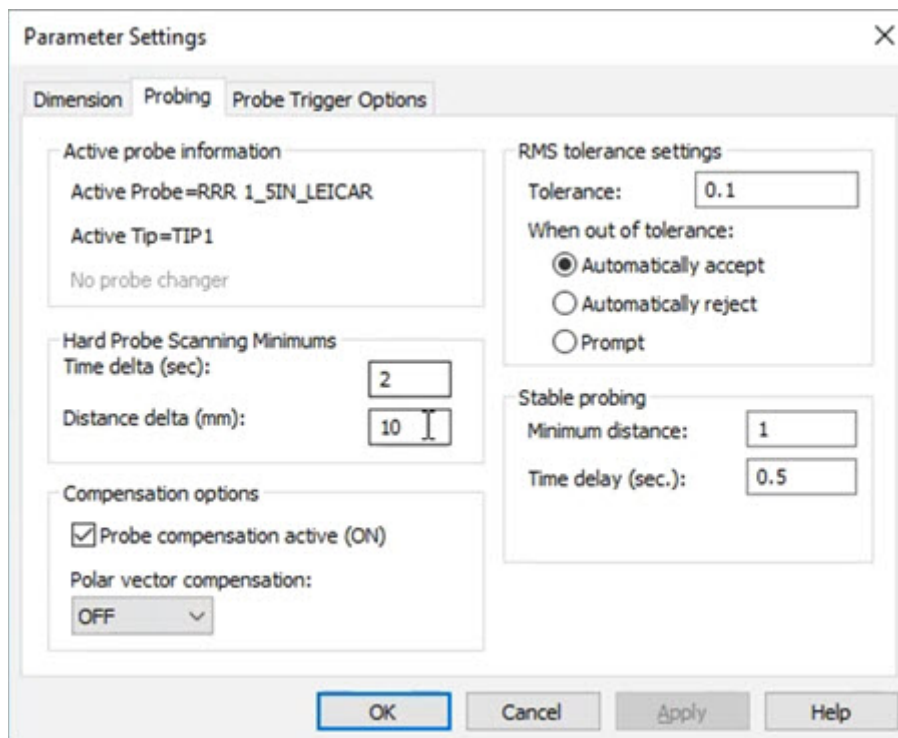


Probe Toolbox - Laser Scan Display Properties tab with Auto Rotate and Custom (%) Zoom options selected

AT403 and AT9x0 Continuous Scanning Modes

To set the continuous scanning modes for the AT403 and AT9x0 laser trackers:

1. From the **Parameter Settings** dialog box (**Edit | Preferences | Parameters**), click the **Probing** tab.



Parameter Settings dialog box - Probing tab

2. In the **Hard Probe Scanning Minimums** area, set one or both values:
 - **Time delta (sec)** - Used for Continuous Time mode
 - **Distance delta (mm)** - Used for Continuous Distance mode
3. Click **Apply** to save the settings and then **OK** to close the dialog box.
4. From the **Tracker Operation** toolbar, choose the mode:

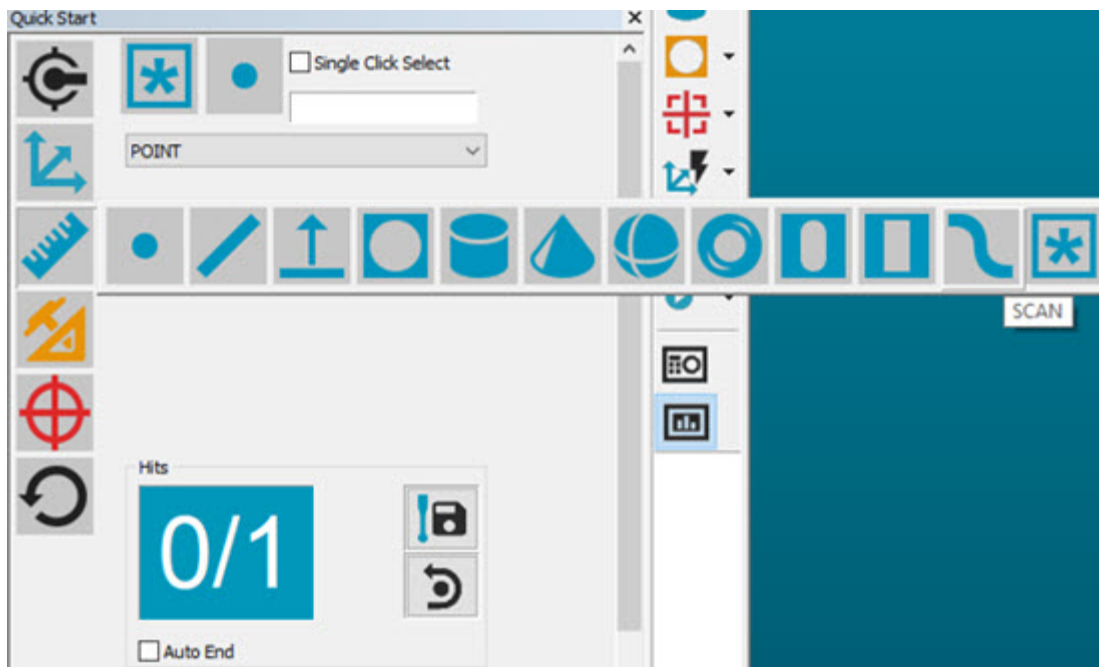


Continuous Distance



Continuous Time


5. (Optional) If you are aligned to the physical part and a CAD model, from the **Probe Mode** toolbar (**View | Toolbars**), turn on **Find Nominals from CAD Mode**. This step allows each scanned point to have a nominal value and also allows you to view the hits as they are scanned.
6. From the **Quick Start** window, select the type of feature you wish to scan (for example, Plane or Scan).



Quick Start window for continuous scan mode

The scan process is: Start the scan, scan the feature, stop the scan, END.

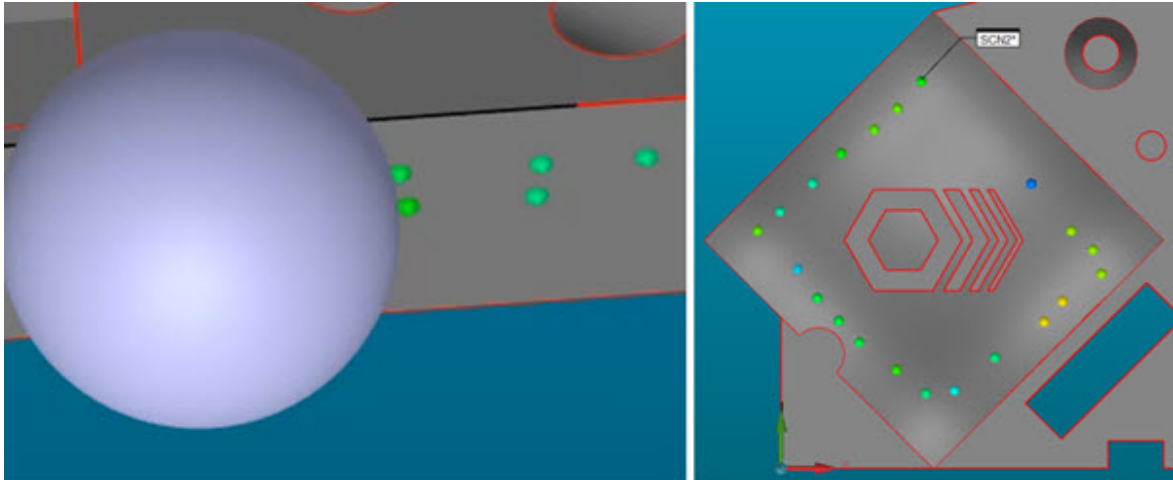
To do this:

- Press Ctrl+I to start the scan and Ctrl+I to stop the scan, or use the **Continuous Scan** button () on the **Tracker Measure** toolbar.
- For the AT403 tracker, use the A button on the remote control to start and stop the continuous scan.
- For the AT960 T-Probe, hold down the D button for the continuous scan.



If Continuous Scan mode is not selected, the D button defaults to the Continuous Distance mode.

- When you finish scanning a feature (such as a circle or plane), compensate correctly and then press the **END** button.



7. Continuous Distance and Continuous Time can also be inserted into the measurement routine as Tracker Commands. During execution, you can Start, Stop, and END the continuous scan as described above.

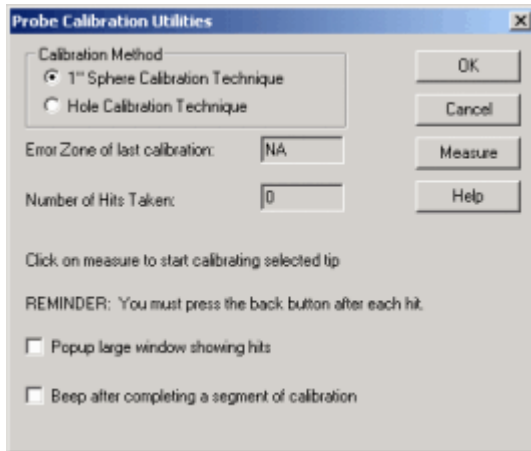
```

MOC1 = TRACKER COMMAND ( SET MEASUREMENT PROFILE (CONTDIST)
SCN1 = Manual Scan - VARIABLE DELTA
SCN2 = Manual Scan - VARIABLE DELTA
    
```

Appendix A: Faro Portable Arm

Using a Faro portable arm is similar to using a Romer arm. For general information on using a portable arm machine, refer to the "[Using a Romer Portable CMM](#)" topic and other sections throughout the Portable documentation.

If you are using a Faro arm, the **Probe Calibration Utilities** dialog box appears in place of the standard **Measure** dialog box that appears when you click **Measure** from the **Probe Utilities** dialog box.



Probe Calibration Utilities dialog box

Available Dialog Box Options

The following table lists each option in the [Probe Calibration Utilities dialog box](#) and what each option does.

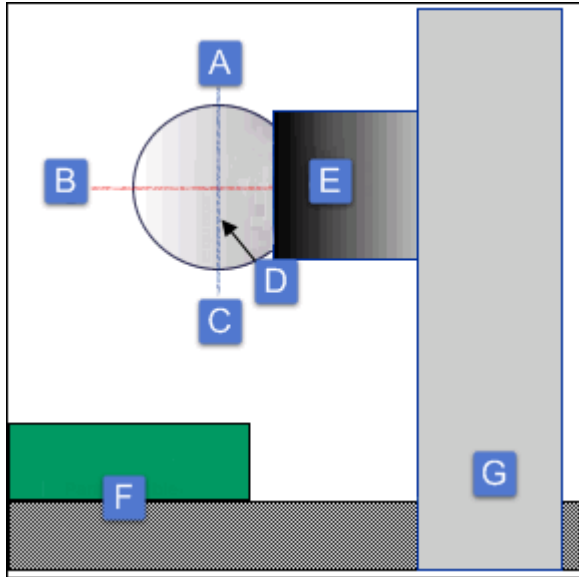
Option	Description
Calibration Method	<p>The Probe Calibration Utilities dialog box allows for two methods of calibration:</p> <ul style="list-style-type: none"> • 1" Sphere Calibration Technique. Most Faro arms have a calibration sphere built into them which is usually a 1.000" ball so PC-DMIS defaults to this method of calibration. • Hole Calibration Technique. If preferred, you can use a hole to calibrate the Faro probe instead of the sphere.
Error Zone of Last Calibration	<p>The Error Zone of last calibration box displays the volumetric number that Faro calculates after the calibration routine is complete. The Faro Controller generates this number and it is only used for display purposes. You cannot edit it.</p>
Number of Hits Taken	<p>The Number of Hits Taken box displays the number of hits taken per calibration zone.</p>

Popup large window showing hits	Selecting the Popup large window showing hits check box shows the XYZ and number of hits in real-time as the calibration process takes place.
Beep after completing a segment of calibration	Selecting the Beep after completing a segment of calibration check box causes the computer system to emit a beeping sound when a specific calculation zone or segment is complete. The status area on the dialog box (located just below the Number of Hits Taken box) then tells the user what calibration zone to measure next and how many hits to take.

Faro Calibration Procedure

To correctly calibrate your probe using a Faro arm, follow this procedure:

1. Access the [Probe Calibration Utilities dialog box](#).
2. Select the appropriate calibration method from the **Calibration Method** area.
3. Select any useful check boxes.
4. Click the **Measure** button. The calibration process will begin. PC-DMIS displays some visual aids to assist you in calibrating the Faro arm.
5. Follow any on-screen instructions (including instructions that may appear in the dialog box's status area).
6. *If you're using the one inch sphere method*, take the following hits on the spherical tool, using this diagram and any on-screen aids to assist you:



Side view of spherical tool and Faro magnet and clamp

A - West

B - North pole (red line)

C - East

D - Equator of the spherical tool
(blue line)

E - Side view of Faro magnet
showing spherical tool attached

F - Side view of the part on the table

G - Side view of the clamp attached
to the table

- Take five hits around the equator.
 - Flip the last axis, and take another five hits around the equator.
 - Take five hits normal to the sphere east to west.
 - Flip the last axis, and take four hits normal to the sphere from west to east.
 - Take four hits normal to the sphere from north to south.
 - Flip the last axis, and take four hits normal to the sphere from south to north.
7. *If you're using the hole calibration technique*, PC-DMIS will ask you to take these hits:
- Take 10 hits in the hole while rotating the handle.
 - Take 10 hits in the hole from the opposite direction.
8. Click **OK** when you finish calibrating.

Appendix B: SMX Tracker

To use the SMX laser interface, you need to do the following.

1. Connect your portlock (dongle) to your USB port. The portlock must be present during PC-DMIS installation.
2. Execute setup.exe from the PC-DMIS Installation CD. Follow the on-screen instructions.
 - If **SMX Laser** interface is programmed in your portlock, PC-DMIS loads and uses the SMX Laser interface when working on-line.
 - If **All interfaces** is programmed in your portlock (like a demo dongle), you may need to manually rename smxlaser.dll to interfac.dll. The smxlaser.dll file is found in the PC-DMIS installation directory.
3. Download the SMX laser DLL located at:
<ftp://ftp.wilcoxassoc.com/Hardware/CMM/3rdPartyDrivers/Faro/Tracker1331.zip>.
4. Unzip the contents of the *Tracker1331.zip* file into the PC-DMIS installation directory. In addition to the SMX Laser dll, there are JAR files and a JRE directory and subdirectories included in zip file. These files and directories must be copied to PC-DMIS installation directory.
5. Test the communication with your tracker by typing the following command from the command prompt:

```
ping 128.128.128.100
```



For older trackers, the last number of the IP address is your tracker's serial number.

If there are problems with the communication, you can use FTP to access the tracker and test its response. Use the following commands:

```
ftp 128.128.128.100
login: supervise (doesn't work with new Faro trackers)
> quote home
> quit
```

This should home the machine. If this fails then power down the machine, wait 1 minute, and power it back up. If this still fails, and SMX Insight software is loaded on the machine, you can try to perform a 'Startup' in Insight.



Be aware that once the Tracker has been powered down for a while, it can take up to 30 minutes for a reliable connection to be established.

The Faro SMX Tracker has added capability from the Faro Utilities application that can be accessed from PC-DMIS.

Using the Closure Window

PC-DMIS allows you to access Closure window settings. Closure is simply the reflector's current distance from the Home position. Closure helps you ensure the accuracy of your measurements, in that you would see non-zero Closure values if there was a problem.

Performing Operational Checks

The Faro Utilities provides the **Operational Checks** dialog box, which has two tabs: **General Page** and **Repeatability**.

- The **General Page** tab displays environmental conditions and monitors the return intensity of the laser.
- The **Repeatability** tab provides access to the Static and Dynamic repeatability tests in addition to another way to access Closure.

Glossary

6

6DoF: Six Degrees of Freedom

A

ADM: Absolute Distance Meter

B

Birdbath: Your reflector can be attached to this known position via a magnetic connector located on the front of the laser tracker.

D

DRO: Digital Readout

H

Hardstop: A physical holder against which the arm rests when not in use.

I

ID: Inside Diameter

IFM: Interferometer

L

LAS: Leica Absolute Scanner

M

MIIM: Machine Interface Installation Manual

N

NIC: Network Interface Card

Nivel: Inclination sensor designed to be used with Leica Laser Tracker. This device attaches to the laser tracker to establish orientation to gravity or monitor tracker stability.

Normal Hit: A "Normal Hit" is taken when you press and release the hit button in the same location.

O

OD: Outside Diameter

P

Pulled Hit: Changes the vector to that of the line between the location where you first depress the hit button (at the "Normal Hit" location) to the location where you release the hit button. This line must be longer than the Use Vector Distance to successfully register a "Pulled Hit".

R

RMS: Root Mean Square

T

TCU: Tracker Control Unit

TTP: Touch-Trigger Probe

Index

A

Alignments 152

6 Point Alignment 155

Leapfrog Operation 158

Nominal Point Best Fit Alignment 156

Quick Start Alignments 153

Auto-Inspect Mode 119

AutoTrigger 57

B

B-Probe Button Assignments 130

Bundle Alignments 164

Adding and Removing Stations 166

Command Text 172

Results 169

Setting Fit Options 170

Setup 167

C

Camera 88

Closure Window 209

Constructing Points 136

Contour.dll Registration 72

Converting Hits to Points 61

COP 12

D

Dual-Point Measured Slots 180

E

Edge Point Mode 62

F

Faro Arm Interface 36

Faro Portable Arm

Available Dialog Box Options 205

Calibration Procedure 206

Machine as Mouse Settings 37

H

Hard Probes 55

Hidden Point Devices 136

I

Importing Nominal Data 52

Interfaces 24

L

LAS Scanning 131

Launching PC-DMIS Portable 2

Leapfrog Alignment 158	Configure the Leica Interface 95
Accept 164	Connecting 93
Available and Used Lists 162	Defining Environmental Parameters 116
Datum Measurement Routine 161	Feature Parameters in Offline Mode 113
Half Relocation 161	Finding a Reflector 118, 151
Measure All 163	Getting Started 92
Measure Marked 162	Hotkeys 113
Measure Options 160	Initializing 114
Number of Hits 160	Install PC-DMIS Portable 92
OK 164	Introduction 91
Reset 164	Launch PC-DMIS 95
Results Area 163	Leica Probes 125
Leica Interface 26, 131	Measuring with a B-Probe 128
Aiming Tab 44	Measuring with a T-Probe 125
Environmental Parameters 33, 116	Nivel Commands 105
Leica User Interface 97	Orienting the Tracker to Gravity 115
Level to Gravity Tab 35	Other PC-DMIS Menu Items 109
Options tab 27	Other PC-DMIS Windows and Toolbars 19, 109
Reset tab 30	Overview Cam 107
Sensor Configuration tab 32	Quick Start Alignments 153
Leica Laser Tracker 90, 125, 128, 130, 131	Releasing Tracker Motors 118
Auto-Inspect Mode 119	Resetting the Tracker Beam 117
B-Probe Button Assignments 130	Scanning with Reflectors 134

Special Controls 107

Toggling the Laser and Probe
Compensation 117

T-Probe Button Assignments 127

Tracker Menu 97

Tracker Overview Cam 107

Tracker Status Bar 105

User Interface 96, 97

Utilities 114

M

Manual Point Trigger Tolerance 60

Measuring Features 175

Dual-point Measured Slots 180

Single-Point Measured Circles 177

Measuring with a B-Probe 128

Measuring with a T-Probe 125

N

Nominal Point Best Fit Alignment 156

O

Overview Cam 107

P

PC-DMIS Portable

Introduction 1

User Interface 2

Perceptron Sensor 86

Attach Your Contour Sensor 70

Calibrating 72, 73, 74

Calibration Results 78

Complete the PC-DMIS Configuration 71

Configuring 68

Connecting 68

Define the Laser Probe 73

Network Card 69

Sound Events 87

Verify Sensor Installation 71

Pointcloud 12

Pointcloud Toolbar 12

Portable Functionality 51

Portable Interface 2

Edit Window 20

Portable QuickMeasure Toolbar 6

Probe Mode Toolbar 11

Settings Toolbar 16

Status Bar 22

Status Window 23

Portable Interfaces 24

Portable QuickMeasure Toolbar 6

Probe Compensation 52

Probe Readout

 Customizing 110

Probe Readouts 23

Probe Shaft Compensation 53

Probe Trigger Options 56

Pulled Hits Method 54

Q

Quick Start 176

Quick Start Interface 21

QuickCloud 12

R

Romer Arm Interface 25

Romer Portable Arm 63

 Calibrating a Hard Probe 72

 Getting Started 64

 Hard Probes 55

 Install PC-DMIS Portable 67

 Introduction 64

 Romer Arm Buttons 79

 Set Up 65

 Three Button Configuration 82

 Two Button Configuration 80

WinRDS Environment Variables 66

RomerRDS Integrated Camera 88

S

Scanning, Hard Probe 183

 Auto Feature Sample Hits 186

 Body Axis 192

 Fixed Distance 187

 Fixed Time 190

 Fixed Time Distance 188

 Freeform 197

 Multisection 194

 Rules for Manual Scans 184

Scanning, Laser 131, 198, 201

Single-Point Measured Circles 177

SMX Tracker

 Closure Window 209

 Performing Operational Checks 209

SMX Tracker Interface 38

 Options tab 39

 Reset tab 42

Sound Events 87

T

Thickness Type 177

Toolbar 4, 6, 12

3D Trackers 4

6dof Trackers 4

Build and Inspect 4

Portable 4

Portable QuickMeasure Toolbar 6

Probe Mode 4

QuickCloud 4, 12

Settings 4

Tracker 4

Total Station 137

Machine Interface 45

User Interface 138

Total Station Modes 139

T-Probe 172

Button Assignments 127

Tracker Continuous Distance Mode 201

Tracker Continuous Time Measurement
Mode 201

Tracker Overview Cam 107

Tracker Pad 44

Trigger Plane 59