
PC-DMIS Portable Manual

For Version 2020 R2



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Hexagon Manufacturing Intelligence

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Copyright and Licensing

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PC-DMIS Portable

PC-DMIS Portable: Introduction

This documentation covers how to use PC-DMIS Portable to measure features on a part with your portable measuring device. 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 probed points or "hits".

Supported Hardware Configurations

- [Romer arms](#) - Romer or Hexagon Absolute arms (RA7 and RA8).
- [Leica Laser Trackers](#) - For supported Leica versions, see the "[Leica Laser Tracker: Introduction](#)" topic.
- [Faro arms](#)
- [SMX Trackers](#)
- [Aicon MoveInspect XR8](#)

The main topics in this documentation include:

- [Switchable Portable Interface](#)
- [Launching PC-DMIS Portable](#)
- [Recommended Settings](#)
- [PC-DMIS Portable: User Interface](#)
- [Configuring Portable Interfaces](#)
- [Common Portable Functionality](#)
- [Using a Romer Portable Arm](#)
- [Using a Leica Laser Tracker](#)
- [Using a Total Station](#)
- [Using a MoveInspect System](#)
- [Creating Alignments](#)
- [Measuring Features](#)

- [Portable Hard Probe Scanning](#)
- [Portable Laser Probe Scanning](#)
- [ATS600 Tracker Interface](#)
- [AT403 and AT9x0 Continuous Scanning Modes](#)
- [Appendix A: Faro Portable Arm](#)
- [Appendix B: SMX Tracker](#)
- [Appendix C: Troubleshooting Portable Systems](#)

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

Switchable Portable Interface

With PC-DMIS 2019 R1 and above, you can select from a list of portable devices and connect to any supported device.

When you select a device from the menu, the software dynamically switches the portable interface without having to close and then reopen PC-DMIS. Once you select a portable device, it becomes the default device until you change it. You can select the interface anytime you start PC-DMIS. For details, see "[Set Portable Interface Menu](#)".

You can run PC-DMIS online or offline with the portable interface.

PC-DMIS supports the following portable interfaces:

- RomerRDS Arm
- RomerRDS Arm (WinRDS)
- AT40x Leica Tracker
- ATS600 LeicaLMF Tracker
- AT9x0 LeicaLMF Tracker
- AT901 Leica Tracker
- Leica TDRA6000 Total Station
- Aicon - Offline
- MoveInspect

- Faro Arm

Portable License

New Users – A new interface license PCD_Interface.AllPortable is available and should be used for all new portable systems running PC-DMIS 2019 R1 or higher.

The license option allows the user to select from a list of portable devices and connect to any supported device. Once the user selects a portable device, it becomes the default device until the user changes it. This can be done when PC-DMIS starts. For details, see "Set Portable Interface Menu".

Existing Users – Existing portable users running PC-DMIS versions earlier than 2019 R1, have a license which can run only one specific portable machine interface (for example, RomerRDS, LeicaLMF).

After the installation of 2019 R1, the interface is automatically set to the original portable interface. The user can change it from the **Edit | Set Portable Interface** menu option. To do this, the user must have a valid SMA.

Existing users can run PC-DMIS versions older than 2019 R1 using their originally purchased device interface only.

Portable users with a valid SMA may request to add the "PCD_Interface.AllPortable" option to their license. This allows them to select the default device during installation.

Portable Installation

During installation, the user can select the default portable device if the license contains PCD_Interface.AllPortable. This is particularly useful if the customer only has one machine.



Portable at Runtime

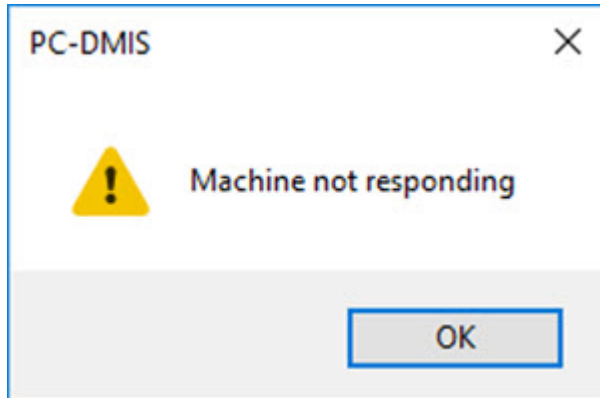
When you start PC-DMIS, it dynamically loads and connects to the default portable device. You can select the default device during installation (if you have the PCD_Interface.AllPortable) or from the **Edit | Set Portable Interface** menu option.



It is important that you make sure your RDS and TCP/IP settings are correct.

PC-DMIS displays the machine status in the Status bar.

If PC-DMIS cannot connect to a Leica Tracker (AT9x0, AT40x or AT901), the software informs you with a message in the Status bar. This occurs if the machine was not turned on, for example.



If PC-DMIS is unable to connect to the machine, you can work offline.

When you connect to a machine online that has an RDS scanner as the active probe, the scanner is automatically recognized.

Set Portable Interface Menu Option

You can select or switch the portable interface at start-up.

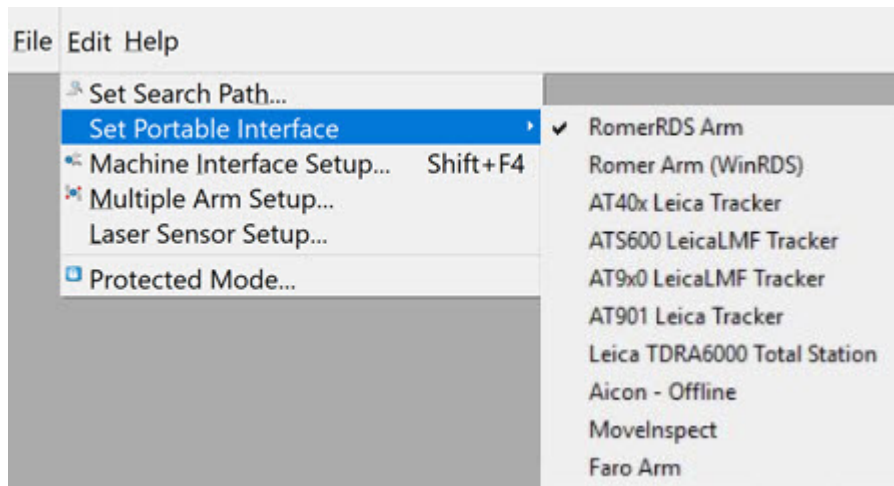
To do this:

1. Start PC-DMIS but do not open a measurement routine.
2. From the opening PC-DMIS screen, click **Edit | Set Portable Interface** from the menu.
3. Select the portable interface you want PC-DMIS to run from the list of available interfaces. A check mark identifies the active portable interface.



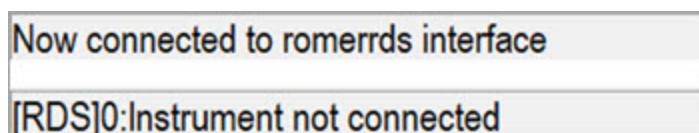
You can uncheck a selected Portable interface and run PC-DMIS with no portable interface selected. In this case, the software uses the `interfac.dll` (if it exists) the next time PC-DMIS starts up.

When you select a device from the menu, the software dynamically switches the interface without having to close and then reopen PC-DMIS.

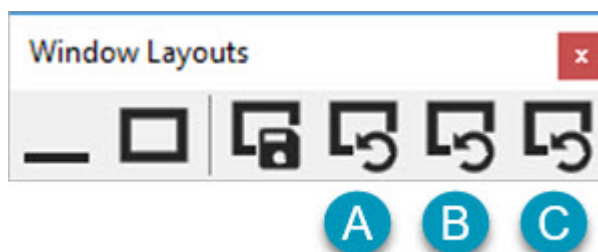


When you select a portable interface:

- The Status bar shows the selected interface and the machine status.



- The toolbars specific to the selected interface are available but are not automatically displayed. If you work with multiple portable interfaces, you can define a layout in PC-DMIS for each portable interface type and then save them to the **Window Layouts** toolbar. This saves you time by not having to redefine your PC-DMIS screen components whenever you change interfaces. For details on how to setup PC-DMIS window layouts, see "Setting Up the Screen View" in the PC-DMIS Core documentation.



A - LeicaLMF

B - RomerRDS Scan

C - Aicon Offline

- When you open a measurement routine with one interface, but the routine was created with another interface, PC-DMIS does not change machine-specific commands. For example, Tracker parameters are recorded for measured features. The software does not remove these parameters when you open the measurement routine with a different portable interface.

What This Menu Option Does Not Do

- If you run PC-DMIS in offline mode, the software does not insert a probe command. PC-DMIS may display the **Probe Utilities** dialog box and allow you to select a probe.
- PC-DMIS does not check or make changes to the RDS and TCP/IP settings. You are responsible for ensuring these communication parameters are correct for the selected interface.
- If you create a program with one device type, and then run it on another device type, PC-DMIS does not modify the program. This means that you are responsible for changing the probe commands.

Also, some additional information is recorded for tracker measurements. PC-DMIS does not remove this information if you run a program with a different device, nor will PC-DMIS add the information if you run a program from another device on a tracker.

Portable Interface Information for Applications and Sales

Hexagon Application Engineers and Sales typically have demo licenses with the All Interfaces option.

- There is no need to add the All Portable option to your license as it only allows you to select the default portable interface during installation.
- You no longer need to add Portable shortcut flags or copy interfac dlls. Instead, you can select or switch the portable device from the **Edit | Set Portable Interface** menu when you start PC-DMIS.

- When you select a device from the **Edit | Set Portable Interface** menu, PC-DMIS dynamically switches the interface without you having to close and then reopen PC-DMIS. The software does not copy or modify the `interfac.dll` file. If you select a portable device from the menu, the existing `interfac.dll` is ignored. Uncheck the portable device from the menu if you want to run PC-DMIS using a non-portable `interfac.dll` (for example, when you want to run a CMM). If you don't select any portable interface, the software uses the `interfac.dll` (if it exists) the next time PC-DMIS starts up.

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. For details on switching your portable interface, see "[Switchable Portable Interface](#)".

You need to create one or more configuration files. These are XML files created from a configuration utility. These files 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 you do this, 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.

About Feature Highlighting

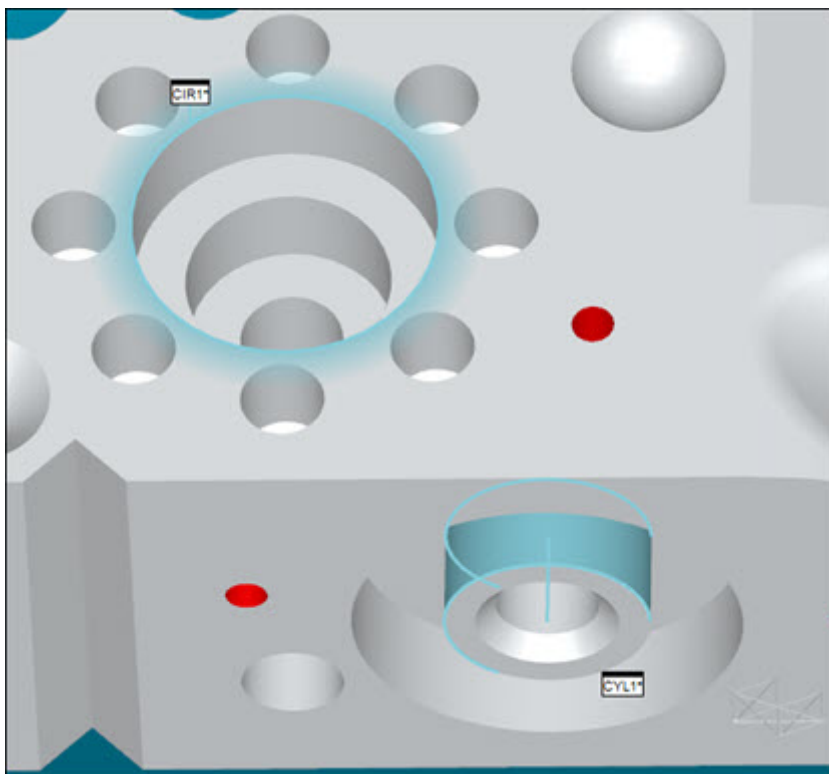
PC-DMIS can highlight auto features during both routine creation and execution. PC-DMIS can also automatically scale and rotate to the auto features during

execution in the Graphic Display window. These abilities provide a better user experience when you create and execute a routine with a portable device.

Feature Highlighting During Creation

When you create an auto feature, PC-DMIS draws the outline of the auto feature in the Graphic Display window in a blue outline color. PC-DMIS also highlights the current feature once you select it in the Edit window. If it's a 2D feature, such as a circle, PC-DMIS gives the feature outline a glow in the highlight color. If it's a feature that has a surface, such as a cylinder, PC-DMIS draw the surface in the highlight color, but there is no glow.

The example below shows two highlighted (or selected) features, a circle on the top surface and a cylinder on the front surface:

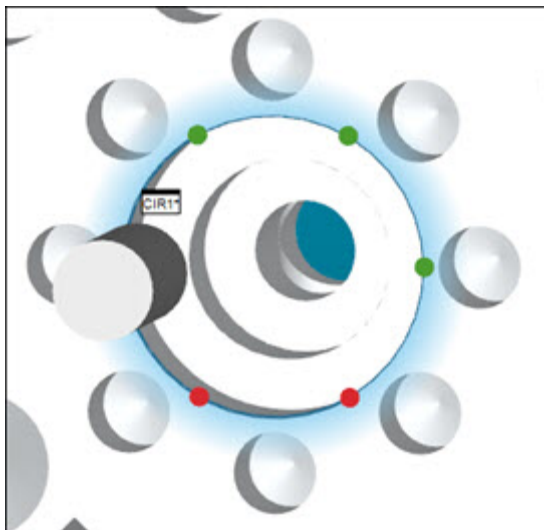
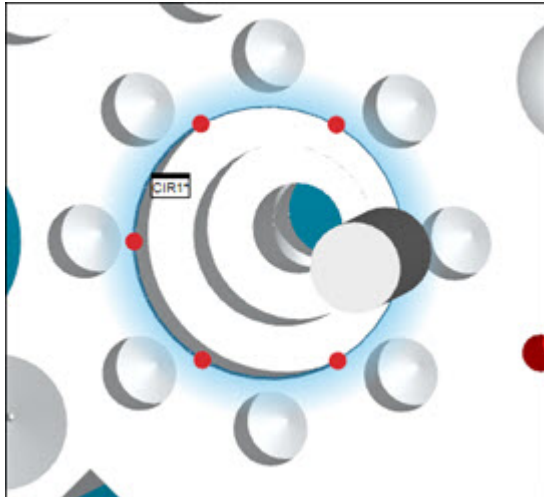


Feature Highlighting During Execution

After an alignment command, if you execute any manual feature, PC-DMIS rotates and zooms the part to show the manual feature in a slightly isometric view. It also highlights the feature, and shows the expected nominal points to measure that feature as red spheres. The red spheres help you know the general location where to probe the points. As you take hits with the probe to

measure the expected points, those spheres turn green in the Graphic Display window.

The images below show the above circle feature, with nominal points in red as execution begins. These turn to green as they are measured:



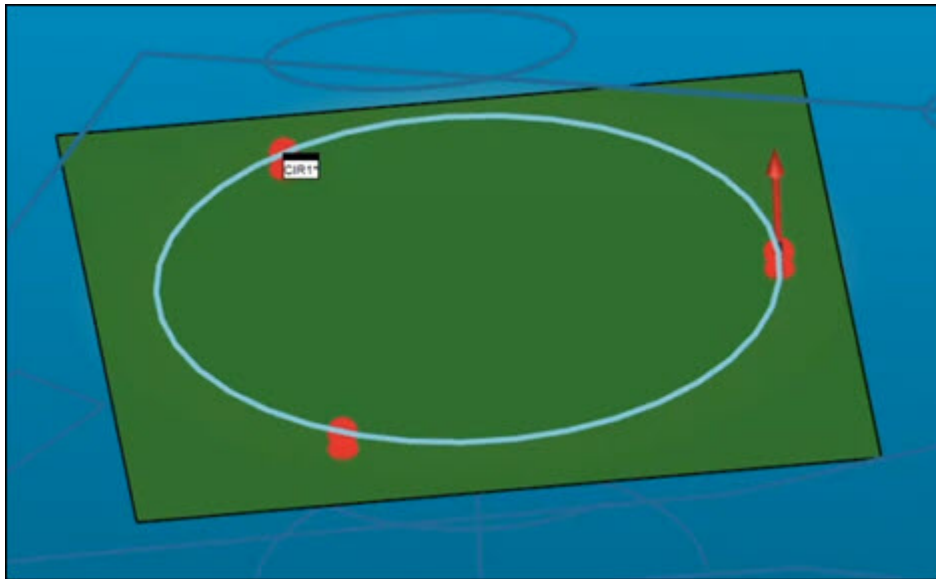
For the rotation and scaling to function, you must have a part alignment before the manual features.

Probe Trigger Highlighting

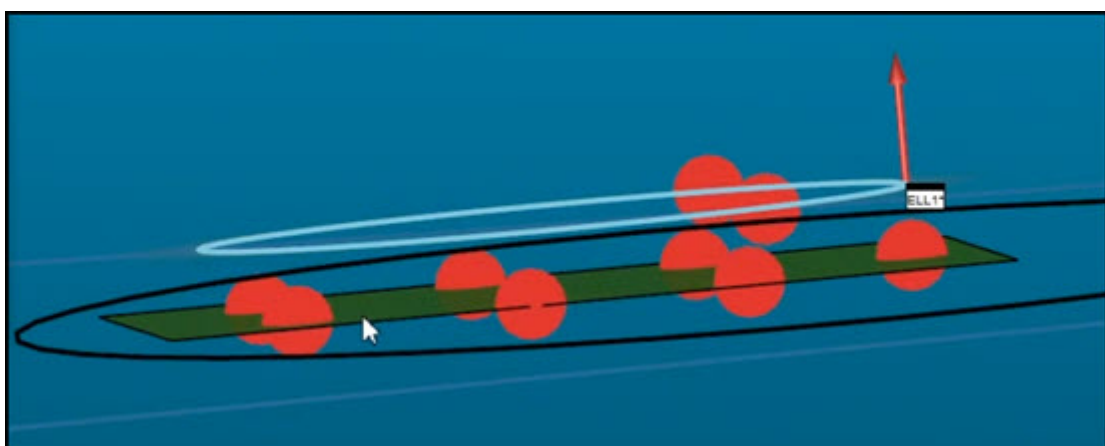
You can set up PC-DMIS to automatically take hits when the probe passes through a plane or moves within a radius of a feature. To set up probe triggers, see "[Probe Trigger Options](#)".

When your routine contains trigger commands, PC-DMIS highlights those trigger areas in the Graphic Display window.

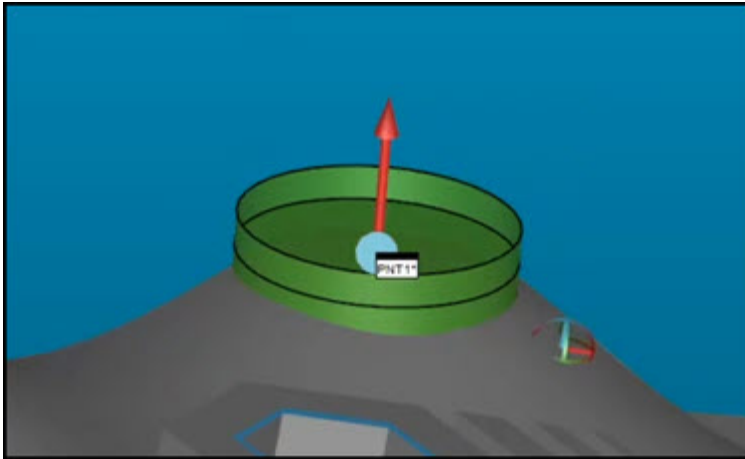
For example, in the Edit window, suppose you have a `PLANE AUTOTRIGGER` command above a circle feature (CIR1). During execution, PC-DMIS highlights the usually invisible trigger plane in green so that you can see where it is. When the probe passes through this plane, it records a hit:



Here's another example that shows the probe trigger plane for an ellipse. Notice how the trigger plane bisects the nominal points:



Here's an example that shows the trigger zone for a point from a `POINT AUTOTRIGGER` command. When the probe enters this zone, it registers a hit:



To see the trigger areas, you must have a part alignment before the manual features.

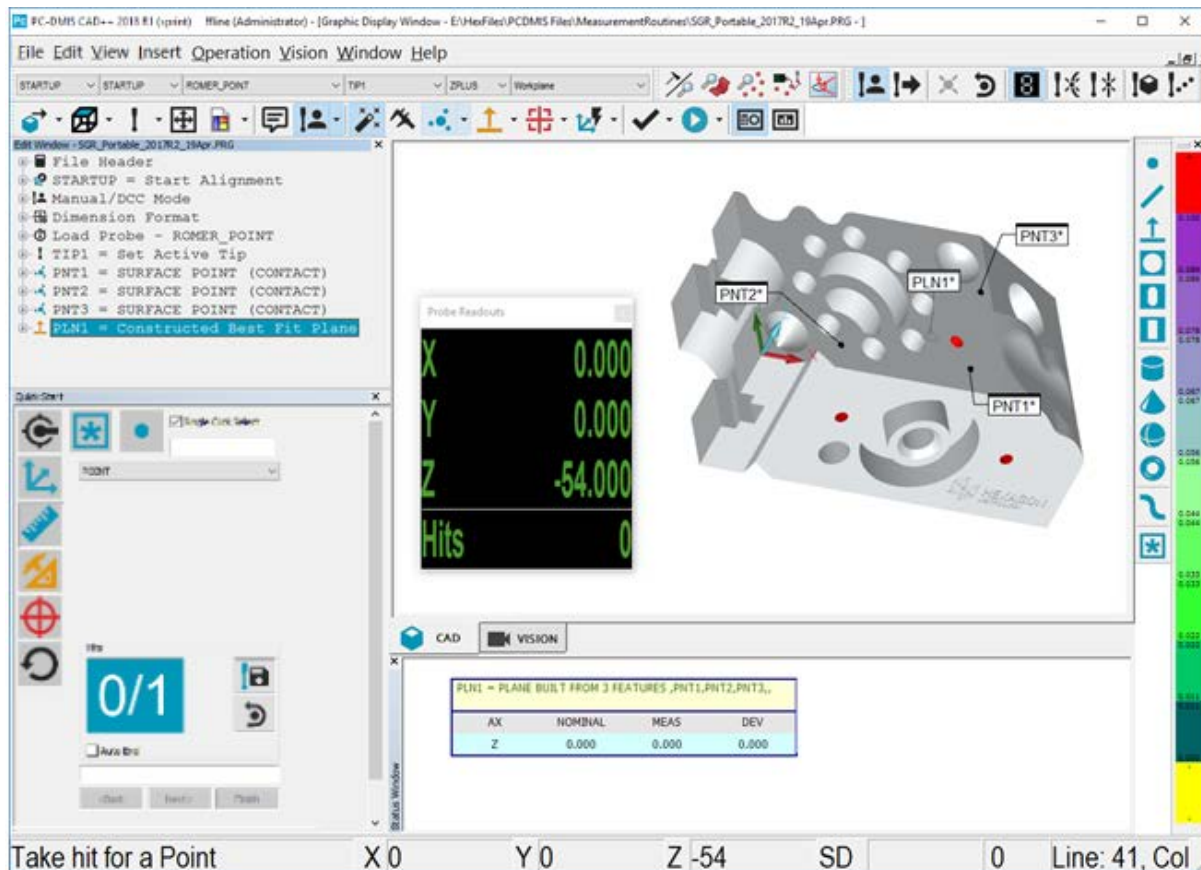
Configuring your Settings

If you don't see the above behavior, check these settings:

1. Access the **Setup Options** dialog box (**Edit | Preferences | Setup**).
2. From the **General** tab, mark the **Auto scale manual feature during execution** check box.
3. Click **OK** to save your changes and close the dialog box.
4. Access the **Symbols** tab on the **CAD and Graphic Setup** dialog box (**Edit | Graphic Display Window | Display Symbols**).
5. From the **Point symbol** area, set the list to **Feature Point**. Also, choose **Sphere**.
6. From the **Sphere Attributes** area, mark **Shaded** and **High Quality**.
7. Click **OK** to save your changes and close the dialog box.

PC-DMIS Portable: User Interface

Some 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

Click an area in the above image to display information on that section of the 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](#)

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

- **Menu** bar - This area of the interface allows you to 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 - This area of the interface allows you to 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 - This area of the interface 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 - This area of the interface 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.
- **Dimension Colors** bar - This area of the interface shows the colors for dimension tolerances and their associated scale values. For more information on this item, see "Using the Dimension Colors Window (Dimension Colors Bar)" in the "Using Other Windows, Editors, and Tools" chapter in the PC-DMIS Core documentation.



If your LMS 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 install with the LMS license or portlock programmed for a specific interface, the software installs the correct interface automatically.

You can also switch to another Portable interface from the menu before you load a measurement routine. For more information, see the "[Switchable Portable Interface](#)" section of this documentation.

Hexagon Portable Arm (RA8) Wrist Display

The new Absolute 7-axis Portable Arm (RA8) by Hexagon includes a small wrist display. The wrist display shows communications from PC-DMIS when you measure features or execute a measurement routine.

The wrist display updates when you measure these features:

- Contact Auto features
- Measured features in Guess mode
- Measuring features with Find Nominals with CAD mode enabled
- Contact scans
- Laser scans

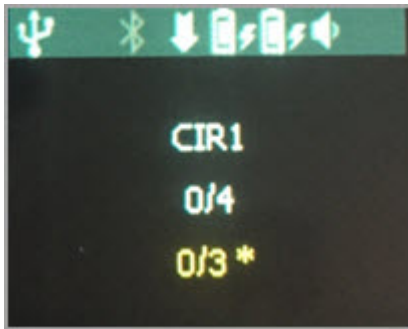
RA8 Wrist Display - Contact Auto Features

When you measure contact auto features, the feature ID and hit count appear in the wrist display. The hit count shows the number of hits taken followed by the number of hits required. For example, 0/4 indicates 0 hits taken and 4 hits required.

Sample Hits

When the contact auto feature contains sample hits, the sample hits are first measured followed by the feature hits. The sample hit count has an asterisk (*) and the wrist display highlights it in yellow showing it is the focus measurement. The display updates the number of hits taken during the measurement process.

When you complete all the sample hit measurements, the hit count turns green.



RA8 wrist display for contact auto feature - sample hits

Feature Hits

Once you complete the sample hits, the feature hit count turns yellow to show it is the focus measurement. The wrist display updates the number of hits taken during the measurement process. After you complete the required number of hits, the hit count turns green.



RA8 wrist display for contact auto feature - feature hits

You can end the feature measurement with the appropriate arm button.

The wrist display shows the feature form and size for ten seconds, or until you start the next measurement.

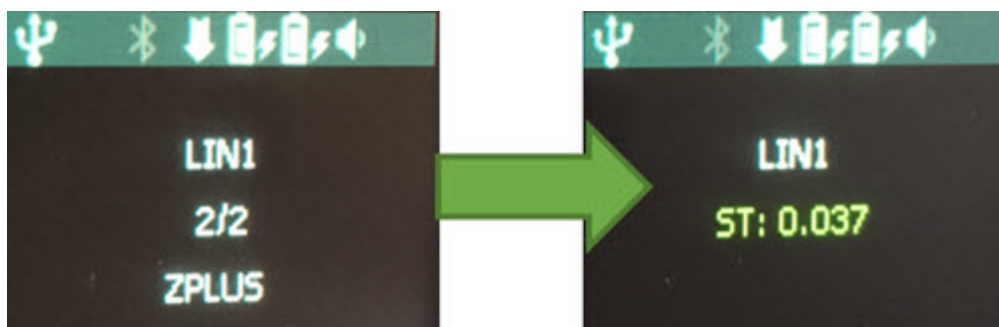


RA8 wrist display for contact auto feature - feature hits completed

RA8 Wrist Display - Measured Features in Guess Mode

When you measure features in Guess mode, PC-DMIS can determine the feature type. For details on guessing a measured feature type, see "Guessing a Measured Feature Type" in the PC-DMIS Core documentation.

The wrist display shows the feature type and hit count. The wrist display also shows the active reference plane for 2D features (LIN, CIR, SLT). When you end the feature measurement, the wrist display shows the feature form and size (where applicable) for ten seconds, or until you start the next measurement.



Example of the RA8 wrist display - Guess mode, Line feature



Example of the RA8 wrist display - Guess mode, Circle feature

RA8 Wrist Display - Re-executing Measured Features

When you re-execute measured features, the RA8 wrist display shows the hit count (number of hits taken followed by the number of hits required) in yellow.



Once you take the required number of hits, the hit count turns green.



The wrist display shows the feature form. If the measurement routine contains another feature, the wrist display shows the feature form momentarily, and then shows the hit counts in yellow for the next feature.



RA8 Wrist Display - Measured Features with Find Nominals Enabled

When you align the part to the CAD model and you enable Find Nominals from CAD mode, the wrist display shows the feature form after you complete the hits for the feature.

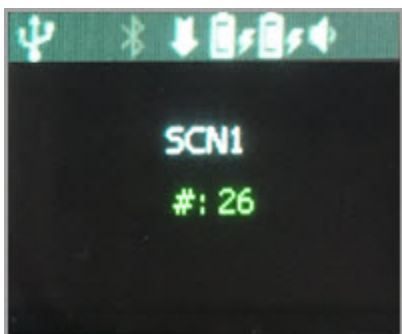
For details on Find Nominals from CAD mode, see "Find Nominals" in the "Setting Your Preferences" chapter of the PC-DMIS Core documentation.

For points, the wrist display shows the "T" value.



RA8 Wrist Display - Contact Scans

When you measure contact scans created in Guess mode, from the Quick Start window, or from one of the **Insert | Scan** menu options (Fixed Distance, Fixed Time, Body Axis, etc.), the wrist display shows the scan feature ID and hit count.



RA8 Wrist Display - Laser Scans

When you perform a laser scan, the wrist display shows the feature ID and number of points collected.



Using the Portable Toolbars

To decrease the time it takes to program your part, PC-DMIS Portable offers you 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.

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.

Probe Mode Toolbar



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



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.

This icon inserts a [MODE / MANUAL](#) command into the Edit window at the cursor's location. Edit window commands that follow this command execute 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.

This icon inserts a **MODE /DCC** command into the Edit window at the cursor's location. Edit window commands that follow this command execute 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 that was 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 AutoTrigger](#)" topic.



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

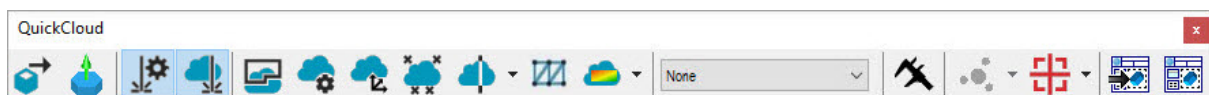


Find Nominals from CAD Mode - Automatically finds the appropriate nominal from the CAD model when measuring online.



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

QuickCloud Toolbar



Portable QuickCloud toolbar

The **QuickCloud** toolbar is only available if you configure your PC-DMIS license as a Portable device. It provides the buttons to complete all the steps from start to finish for working with Pointclouds.

The toolbar provides drop-down button functionality for the **Cross Section**, **Pointcloud Colormap**, **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.

You can add drop-down buttons to any customizable toolbar 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 **QuickCloud** toolbar provides these options:



Import from CAD file - This button displays an **Open** dialog box to 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 - This button displays the **CAD Vectors** dialog box to view and manipulate surface vectors. For details, see "Editing CAD Vectors" in the "Editing the CAD Display" chapter in the PC-DMIS Core documentation.



Portable Scanning Widget - This button displays the **Portable Scanning Widget** toolbar. When you connect to a portable device, and the active probe is a laser scanner, PC-DMIS automatically shows the **Portable Scanning Widget** toolbar. For details on the **Portable Scanning Widget** toolbar, see "[Portable Scanning Widget Toolbar](#)" in this documentation.



Pointcloud Filtering Plane - This button displays the **Laser Data Collection Settings** dialog box. You can use it to define scan profiles, 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 button 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 the software only applies the function and does not add it as a command. To create the command, open the pointcloud operator and choose the **Select** method.



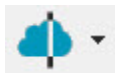
Pointcloud Operator - This button displays the **Pointcloud Operator** dialog box. You can use it to perform different operations on Pointcloud (COP) commands and other Pointcloud operator commands. For details, see "Pointcloud Operators" in the PC-DMIS Laser documentation.



Pointcloud Alignment - This button allows you to create Pointcloud (COP) 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 you click this button, the CLEAN operation immediately eliminates outlier COP points. The outlier points are 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 software considers the point an outlier that does not belong to the part. To use this operation, you must have established at least a rough alignment. For details on how to create 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 - This button opens the **Pointcloud Operator** dialog box with the CROSS SECTION option selected in the **Operator** list. For details on how to create cross section features, see "CROSS SECTION" in the "Pointcloud Operators" chapter in the PC-DMIS Laser documentation.

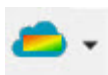
Click the drop-down arrow to display the **Cross Section** toolbar:



For details on this toolbar, see "Show and Hide Cross Section Polylines" in the PC-DMIS Laser documentation.



Pointcloud Mesh - This button displays the **Mesh Command** dialog box. You can use this dialog box to define a Mesh command from pointclouds. For details, see "Creating a Mesh Feature" in the PC-DMIS Laser documentation.



Pointcloud Colormap - This button displays the dialog box for the operator shown on the button.

Click the drop-down arrow to display the **Pointcloud Colormap** toolbar:



The **Pointcloud Colormap** toolbar allows you to select between the **Surface Colormap**, **Point Colormap**, and **Thickness Colormap** options.

From left to right, the buttons are:



Surface Colormap - This button displays the **Pointcloud Operator** dialog box with the Surface Colormap operator selected. The SURFACE COLORMAP operation applies a colored shading to the CAD model. PC-DMIS shades the model according to the deviations of the pointcloud compared to the CAD. The Pointcloud Surface Colormap operator uses the colors defined in the **Edit Dimension Color** dialog box, 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 PC-DMIS Laser documentation.

You can create multiple surface colormaps in a PC-DMIS measurement routine. However, only one is active. The last applied and created surface colormap, or the last one executed, is always the currently active colormap.

You can also select which colormap is the active one from the **Colormaps** list box. When you activate a new colormap, PC-DMIS displays its associated scale with tolerance values and any annotations in the Graphic Display window. To select a new color map, click the **Colormaps** list box and select the colormap from the list of defined Surface or Point Colormap operators:



Point Colormap - This button displays the **Pointcloud Operator** dialog box with the Point Colormap operator selected. The Point Colormap operation evaluates the deviations of the data points contained in a COP command compared to a CAD object. For details on the Pointcloud Point Colormap operator, see "POINT COLORMAP" in the PC-DMIS Laser documentation.



Thickness Colormap - This button displays the **Pointcloud Operator** dialog box with the Thickness Colormap operator selected. The Thickness Colormap allows you to show and measure the part thickness as a colormap from only the Mesh or Pointcloud (COP) data object. You can also compare the measured thickness to the nominal CAD model thickness. For details on the **Thickness Colormap** option, see "Thickness Colormap" in this documentation.

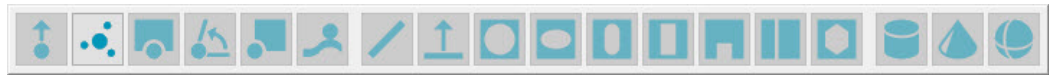


Caliper button - The **Caliper** is a quick-check tool that works similarly to a physical caliper. It provides a local two-point size check on the Pointcloud (COP), Mesh, or COPOPER (such as the COPSELECT, COPCLEAN, or COPFILTER) object. The Caliper shows the measured length along the selected axis or direction. For details on this gage, see the "Caliper Overview" section in the PC-DMIS Laser documentation.



Auto Feature button and drop-down arrow - This button displays the **Auto Feature** dialog box for 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 - This button displays the **Dimension** dialog box for 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 Geometric Tolerances" chapters in the PC-DMIS Core documentation.

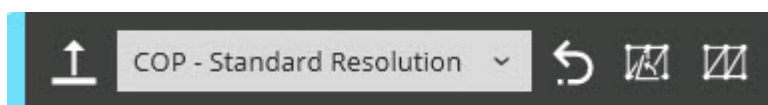


Edit Custom Report from other Measurement Routine - This button creates a Custom Report from another measurement routine in your current measurement routine. For details, see "Creating Custom Reports" in the "Reporting Measurement Results" chapter in the PC-DMIS Core documentation.



Insert Custom Report - This button 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.

Portable Scanning Widget Toolbar



PC-DMIS automatically displays the **Portable Scanning Widget** toolbar in the Graphic Display window when you connect to a portable device and the active

probe is a laser scanner. When you connect to a portable device, and your active probe is a laser scanner, you can use the **Portable Scanning Widget** button

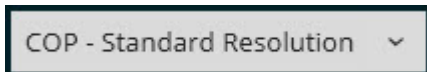


to show and hide the **Portable Scanning Widget** toolbar. You can find the **Portable Scanning Widget** button on the **Pointcloud**, **QuickCloud** and **Mesh** toolbars (**View | Toolbars**).

The toolbar options are:



Exclusion Plane button - Click this button to display the **Exclusion Plane** dialog box. The dialog box allows you to measure and enter settings to exclude data while scanning. You can also set the exclusion plane from the **Laser Data Collection Settings** dialog box. For details, see "Laser Data Collection Settings" in the PC-DMIS Laser documentation.



Profile list - This list allows you to select a scanning profile. PC-DMIS comes with pre-defined profiles for laser scanning using the Pointcloud or Mesh Display. You can also create or edit profiles from the **Laser Data Collection Settings** dialog box. For details, see "Laser Data Collection Settings" in the PC-DMIS Laser documentation.



Delete last scan pass button - Click this button to delete the last scan pass. When using a Hexagon Portable Absolute arm, you can also use the arm's left button to delete the last scan pass.



Low Quality Triangles On/Off button - If you click this button, while scanning, the software displays the triangles that form the mesh which have an angle greater than the **Quality Angle** setting for **Mesh** in the **Pointcloud Display** area of the **Laser Data Collection Settings** dialog

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

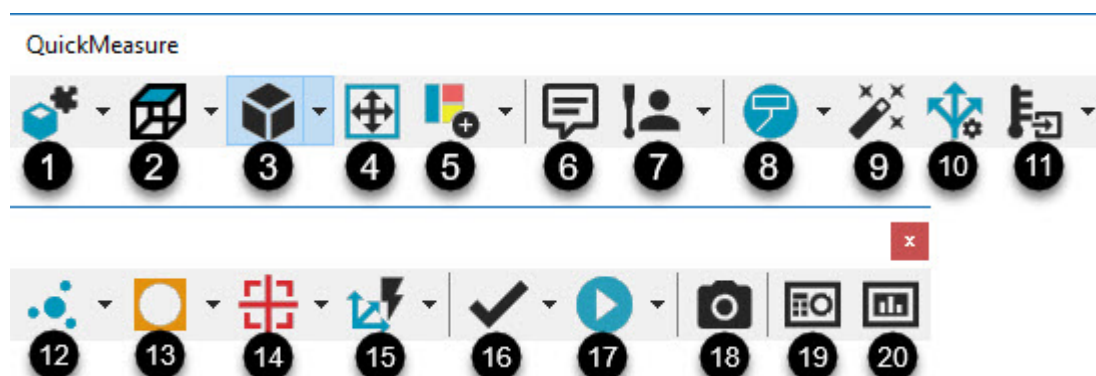


Create Mesh button - Click this button to create a mesh data object from the scanned data. This process finalizes the mesh and then creates the mesh data object. The process uses the current **Finalize** mode setting for **Mesh** in the **Pointcloud Display** area of the **Laser Data Collection Settings** dialog box. For details, see "Laser Data Collection Settings" in the PC-DMIS Laser documentation.



This may be a time-consuming operation based on the parameters you use.

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 small black 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 Display window to the graphical view shown on the button.

Click the small black 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 Display window to display or hide the graphical item properties shown on the button.

Click the small black arrow to display the **Graphic Items** toolbar:

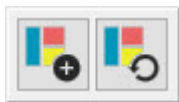


For details, see "Graphic Items Toolbar" in the "Using Toolbars" chapter in the PC-DMIS Core documentation.

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 small black 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 small black 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. **Graphic Modes** button - Sets the screen mode that is related to the icon shown on the button, either **Program Mode** or **Translate Mode**.

Click the small black arrow to display the **Graphic Modes** toolbar:



For details on changing screen modes, see "Changing Screen Modes" in the PC-DMIS Core documentation.

9. **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.

10. **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.

11. **Gage** button - Opens the **Gage** dialog box to add a Caliper, Thickness or Temperature command into the current measurement routine.

Click the small black arrow to display the **Gage** toolbar.

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

For details on the Thickness gage, see "Thickness Gage" in the PC-DMIS Core documentation.

For details on the Temperature gage, see "Temperature Gage" in the PC-DMIS Core documentation.

12. **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.

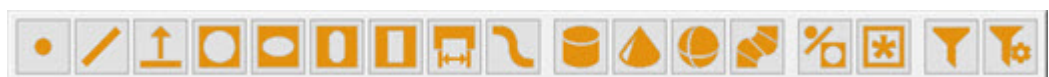
Click the small black arrow to display the **Auto Feature** toolbar:



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

13. **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 small black arrow to display the **Constructed Feature** toolbar:



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

14. **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 small black arrow to display the **Dimension** toolbar:



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

15. **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 small black 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.

16. **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 small black arrow to display the **Mark** toolbar:



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

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

Click the small black arrow to display the **Execute** toolbar:



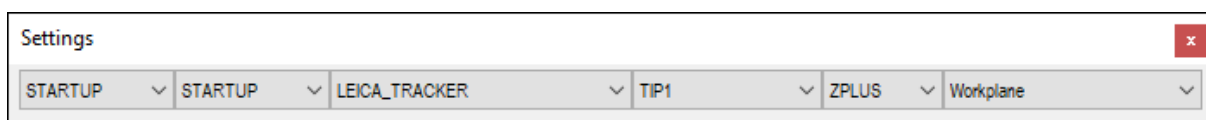
For details on executing your measurement routine, see "Executing Measurement Routines" in the "Using Advanced File Options" chapter in the PC-DMIS Core documentation.

18. **Snapshot** button - Inserts a [SNAPSHOT](#) command of the current Graphic Display window state into the Edit window. When you execute this command, it inserts an image capture at that state into your report. For more information see "Inserting Snapshots" in the "Inserting Report Commands" chapter in the PC-DMIS Core documentation.

19. **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.

20. **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.

Settings Toolbar



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

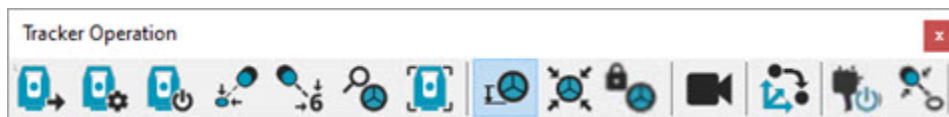
- Saved views

- 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 | 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](#) (This is only a menu option and is not found on the **Tracker Operation** toolbar.)
- [Tracker | Probe Comp. ON/OFF](#)
- [Tracker | Stable Probing ON/OFF](#)
- [Tracker | PowerLock ON/OFF](#)
- [View | Other Windows | Tracker Overview Cam](#)
- [Insert | Alignment | Bundle Alignment](#)
- **Connect to Scanner** - This button toggles the tracker scanner connection to the scanning application on and off. For the LAS and LAS-XL scanners,

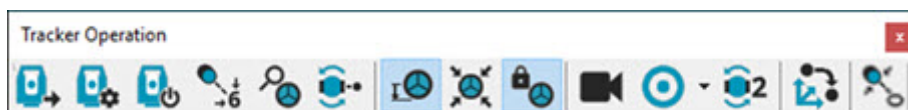
the scanning application is RDS; for the T-scan scanner, the scanning application is T-Collect.

When the **Connect to Scanner** button is on, PC-DMIS disables all other buttons on the **Tracker Operation** toolbar.

When re-executing a Tracker program with the scanner, you should not use the **Connect to Scanner** button. PC-DMIS automatically connects to the scanner application when re-executing.

- [Tracker | Move Feature](#)

Tracker Operation toolbar (for AT-901 Trackers)



- [Tracker | Insert Tracker Command](#)
- [Tracker | Station Management](#)
- [Tracker | Initialize](#)
- [Tracker | Go 6DoF 0 Position](#)
- [Tracker | Find](#)
- [Tracker | Change Face](#)
- [Tracker | Probe Compensation ON/OFF](#)
- [Tracker | Stable Probing ON/OFF](#)
- [Tracker | PowerLock ON/OFF](#)
- [Tracker Overview Camera](#)
- [Tracker | Measurement Profile](#)

On the **Tracker Operation** toolbar, click the arrow to display the **Profile** drop-down toolbar:



The buttons from left to right are:

- **Standard Measurement Profile**
- **Fast Measurement Profile**
- **Precise Measurement Profile**
- **Continuous Distance Mode**
- **Continuous Time Mode**
- [Tracker | Two Face Measurement Mode ON/OFF](#)
- [Insert | Alignment | Bundle](#)
- [Tracker | Move Feature](#)

Tracker Operation toolbar (for AT-930/960, AT-40x and ATS600 Trackers)



- [Tracker | Insert Tracker Command](#)
- [Tracker | Station Management](#)
- [Tracker | Initialize](#)
- [Tracker | Go 6DoF 0 Position](#)
- [Tracker | Find](#)
- [Tracker | Change Face](#)
- [Tracker | Probe Compensation ON/OFF](#)
- [Tracker | Stable Probing ON/OFF](#)
- [Tracker | PowerLock ON/OFF](#)
- [Tracker Overview Camera](#)
- [Tracker | Measurement Profile](#)

Click the arrow to display the drop-down toolbar:



The buttons from left to right are:

- **Standard Measurement Profile**
- **Fast Measurement Profile**
- **Precise Measurement Profile**
- **Continuous Distance Mode**
- **Continuous Time Mode**
- [Tracker | Two Face Measurement Mode ON/OFF](#)
- [Insert | Alignment | Bundle](#)
- **Connect to Scanner** - This button toggles the tracker scanner connection to the scanning application on and off. For the LAS and LAS-XL scanners, the scanning application is RDS; for the T-scan scanner, the scanning application is T-Collect.

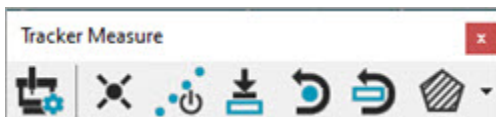


When the **Connect to Scanner** button is on, PC-DMIS disables all other buttons on the **Tracker Operation** toolbar.

When re-executing a Tracker program with the scanner, you should not use the **Connect to Scanner** button. PC-DMIS automatically connects to the scanner application when re-executing.

- [Tracker | Move Feature](#)

Tracker Operation toolbar (for LAS, LAS-XL and T-Scan Trackers)



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

- **Edit | Delete | Last Feature**
- **Insert | Scan | Area Scan** and **Insert | Scan | Ring Scan**

On the **Tracker Measure** toolbar, click the arrow to display the **Scan** drop-down toolbar:



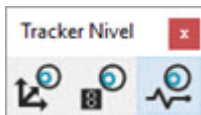
The buttons from left to right are:

- **Area Scan** - For details, see the "[Performing an Area Scan](#)" topic.
- **Ring Scan** - For details, see the "[Performing a Ring Scan](#)" topic.



The **Area Scan** and **Ring Scan** buttons are only available when you use the ATS600 interface and a surface probe is your active probe.

Tracker Measure



- **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.

Tracker Nivel

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.

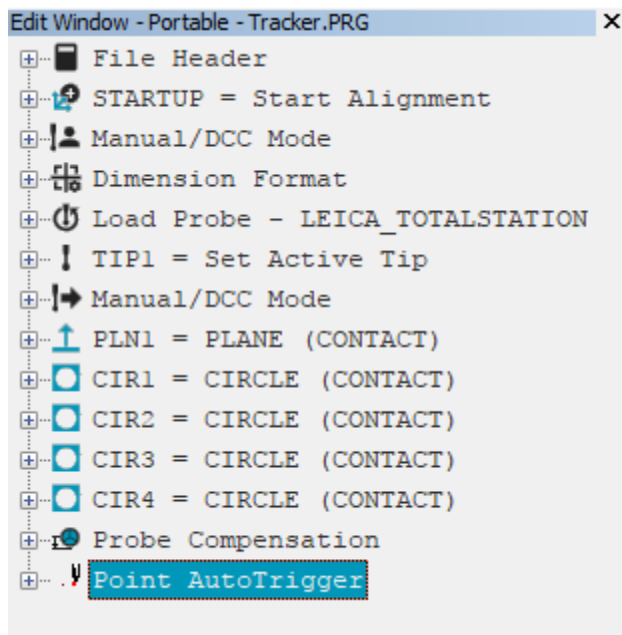
Status window:

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

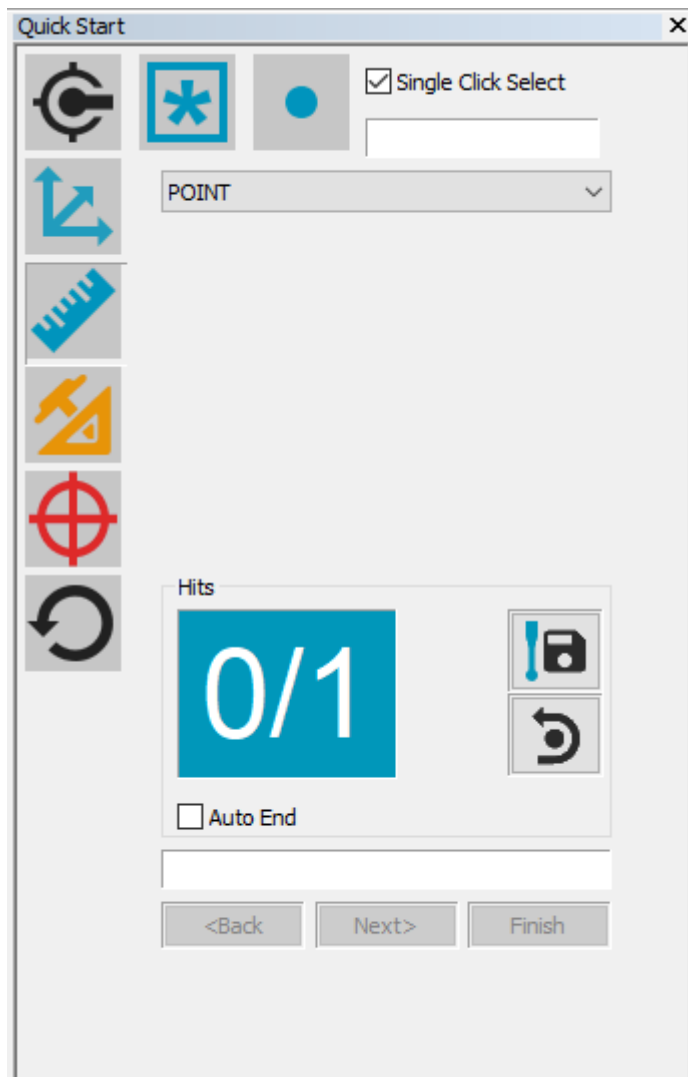
The Edit window displays the commands for the measurement routine that you are creating.

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 a good place to perform 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 (SD) 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.

A Note on Loading Probes During Portable Execution

When running a measurement routine using the Hexagon Absolute Portable Arm with the RomerRDS and LeicaLMF smart probes, PC-DMIS no longer asks you to load a probe if it is already the active probe.

This applies to these probes:

- RomerRDS
- Leica Smart Probes: LAS/LAS-XL, T-Probe and T-Scan

Configuring Portable Interfaces

The **Edit | Preferences | Machine Interface Setup** menu option opens the **Machine Options** dialog box. You can use this dialog box to set 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 these machine interfaces:

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

For information on 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 files inside and run the setup file.

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 you

need to add ";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.

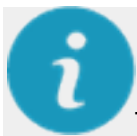
The **Machine Option** dialog box has five tabs for the Romer interface:

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 help file in the language subfolder where you installed the offline PC-DMIS documentation. For the English 2020 R2 Release version of PC-DMIS, it is located here: "C:\Program Files\Hexagon\PC-DMIS 2020 R2 64-bit English Help".

Romer Pulled Hit Feature

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

Leica Tracker Interface

You can configure how PC-DMIS interfaces with the Leica interface from the **Edit | Preferences | Machine Interface Setup** menu. This opens the **Machine Options** dialog box with these tabs:

- [Options tab](#)
- [Reset tab](#)
- [Sensor Configuration tab](#)
- [Environmental Parameters tab](#)
- [Level To Gravity tab](#)
- **System Information** tab - This tab displays information for your configured Leica system. The 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 on this tab, see the "Generating a Debug File" topic in the "Setting Your Preferences" chapter of the PC-DMIS Core documentation.



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

You can access the MIIM help file in the language subfolder where you installed the offline PC-DMIS documentation. For the English 2020 R2 Release version of PC-DMIS, it is located here: "*C:\Program Files\Hexagon\PC-DMIS 2020 R2 64-bit English Help*".

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	0.01 mm You need to set the

	when setting a minimum time value less than 0.01 mm as Time Delta.	403 min / max settings for 10Hz (901 is 1000 Hz).
--	--	---



For Leica AT9x0 trackers, if you lose communication between PC-DMIS and your AT9x0 tracker, the software displays a Connection Lost message and PC-DMIS goes into a "disconnected" state. Check your cabling or wifi to re-establish communication. Once you re-establish the communication, PC-DMIS returns to Online mode without restarting.

Options tab

Machine Options

Environmental Parameters | Level To Gravity | System Information | Debug

Options | Reset | Sensor Configuration

ICU Options

Disable Stable Probing

Execute Option

Results:

IP: 192.168.0.1

Vector Distance: 25.4

☐ Use Vector Distance
☐ Use Last IJK
☒ No Vector

Measurement Time: 500

OK Cancel Apply Help

Machine Options dialog box - Options tab

Use the **Options** tab 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:

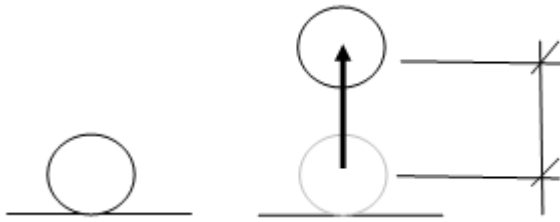
- **Disable Stable Probing** - Disables stable probing. See the **Stable Probing ON/OFF** menu item in the "[Tracker Menu](#)" topic for information.
- **Enable Stable Probing** - Enables stable probing. See the **Stable Probing ON/OFF** menu item in the "[Tracker Menu](#)" topic for information.
- **Go 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, regardless if you are scanning or not.
- **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

Environmental Parameters | Level To Gravity | System Information | Debug

Options | Reset | Sensor Configuration

Absolute Distance Meter (ADM)

Target Stability Tolerance: mm

Time Frame For Retry: ms

Number of Retries:

Search Settings

Spiral Search Diameter: mm

Abort Criteria: ms

Distance To Point: mm

Go Birdbath

☐ Clockwise

☒ Counter Clockwise

OK Cancel Apply Help

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 rotates to the Birdbath position in the **Clockwise** or **Counterclockwise** 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:

Pressure:

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 there is no Meteo Station 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.

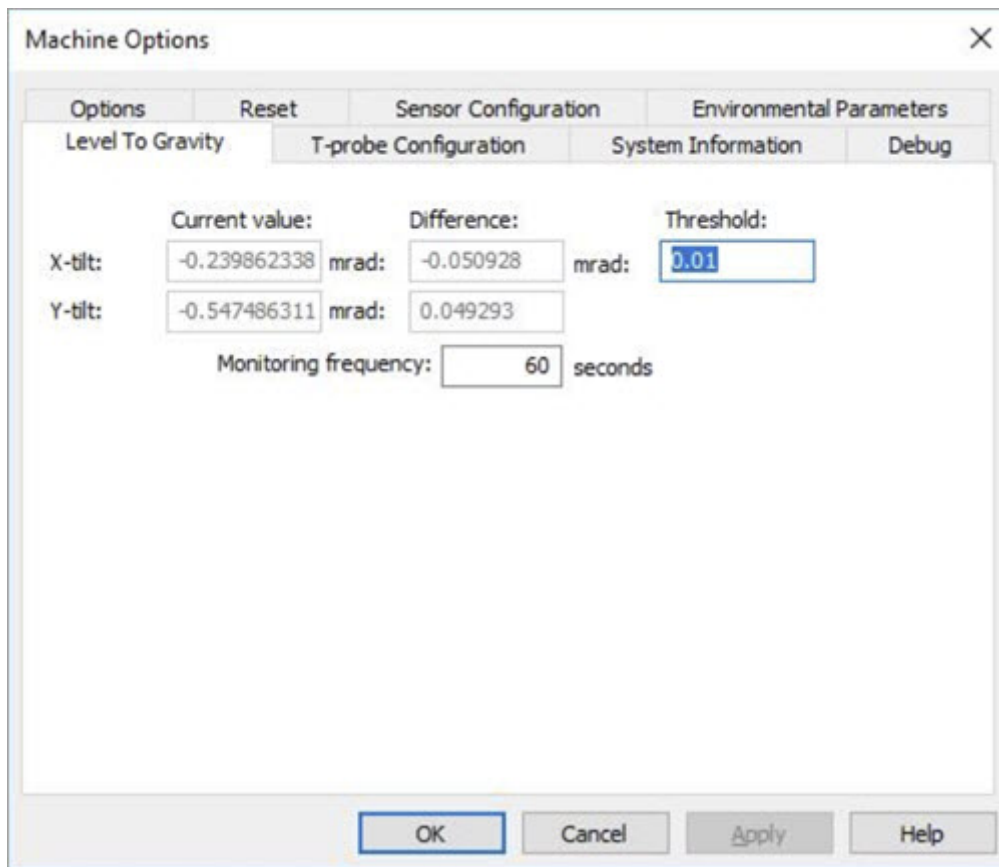


These Meteo parameters have a direct influence on the distance measurement. A change of 1 °C causes a measurement difference of 1 ppm. A change of 3.5 mbar causes a measurement difference of 1 ppm.

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.

Threshold - 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.

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 communication 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

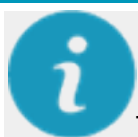
For information, see the "Generating a Debug File" topic in the "Setting Your Preferences" chapter in the PC-DMIS Core documentation.

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.

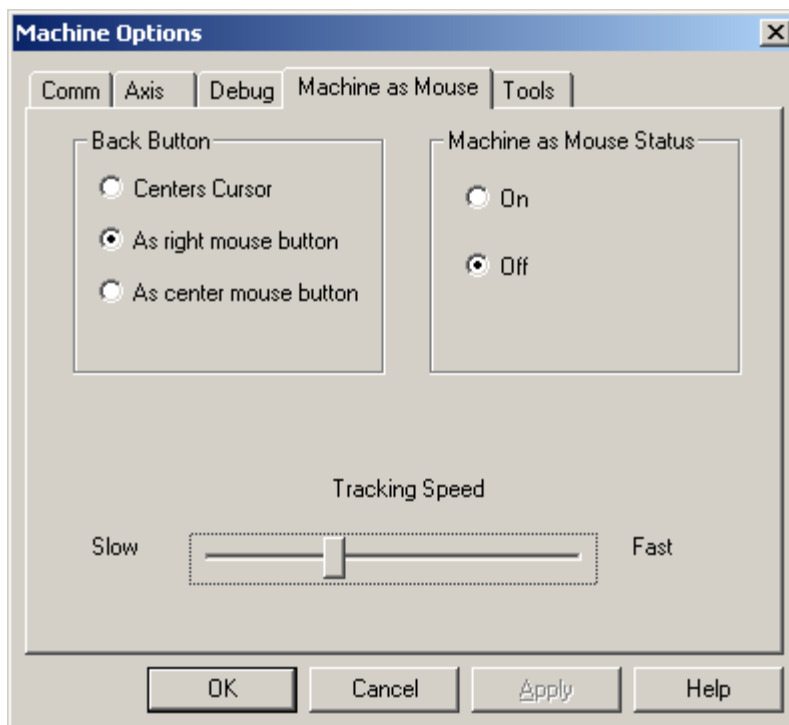
You can access the MIIM help file in the language subfolder where you installed the offline PC-DMIS documentation. For the English 2020 R2 Release version of PC-DMIS, it is located here: "*C:\Program Files\Hexagon\PC-DMIS 2020 R2 64-bit English Help*".

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.

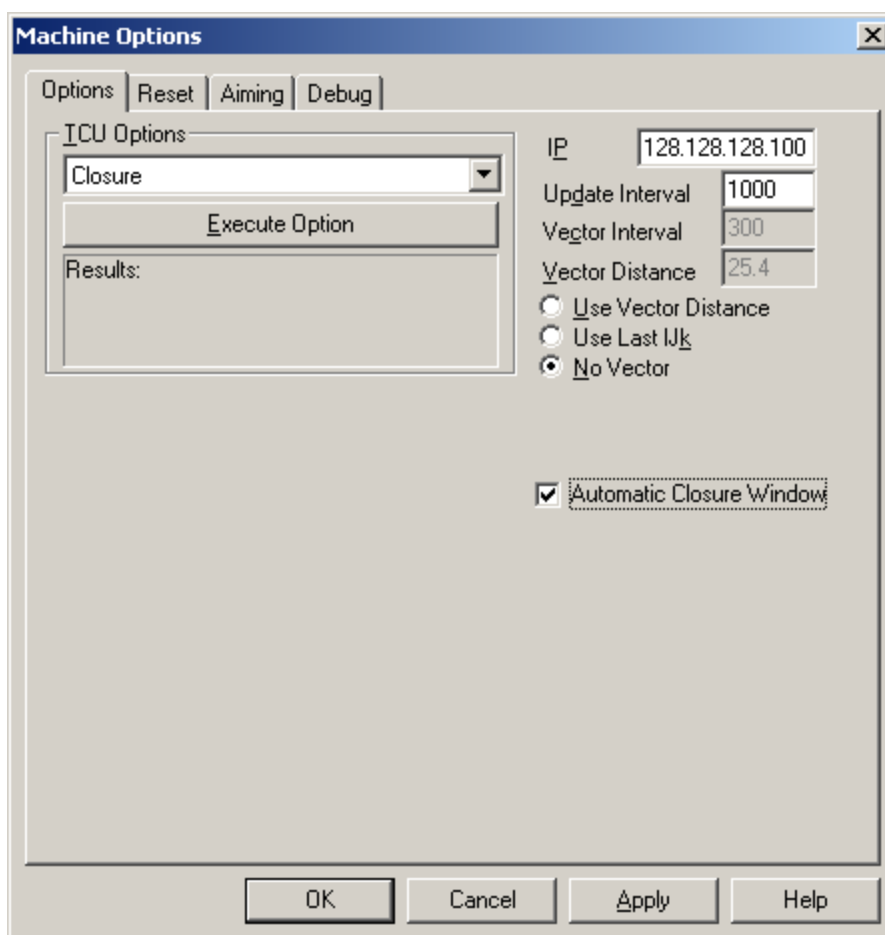
You can access the MIIM help file in the language subfolder where you installed the offline PC-DMIS documentation. For the English 2020 R2 Release version of PC-DMIS, it is located here: "*C:\Program Files\Hexagon\PC-DMIS 2020 R2 64-bit English Help*".

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

Use the **Options** tab 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.



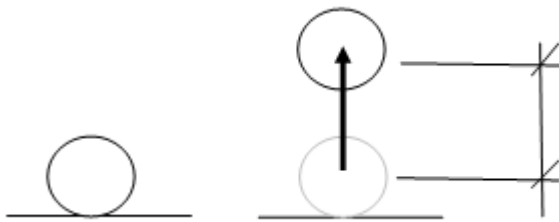
TCU Options are more readily available from the **Tracker** toolbar and menu.

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.

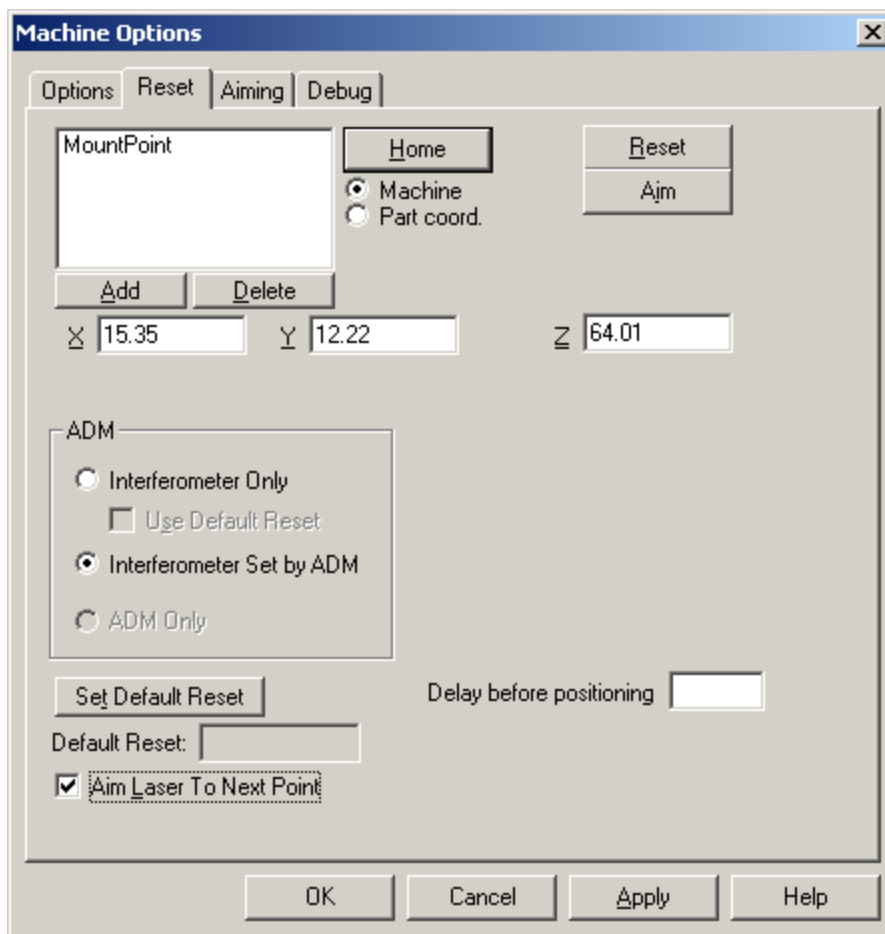
Vector Option - Choose one of these vector options:

- **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 finds it. Once the ADM laser locates and sets the distance to the target, the interferometer laser calculates all distance measurements.

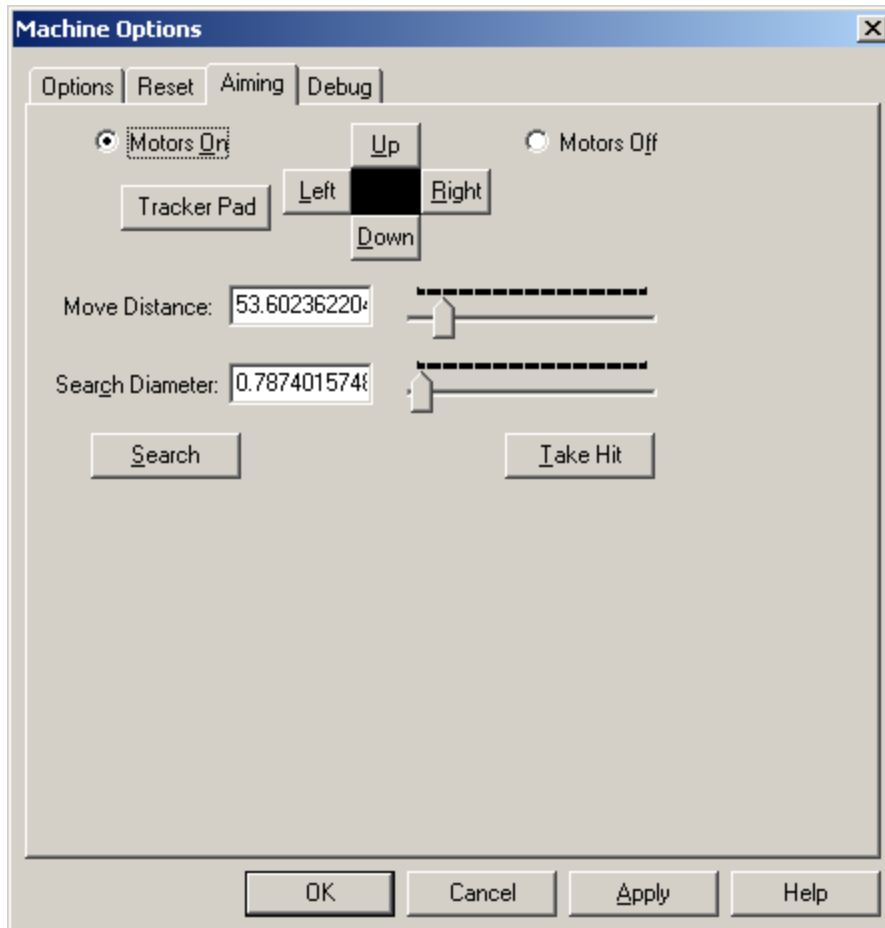
ADM Only - The software calculates all distance measurements with the ADM laser. If the target gets lost by the Laser Tracker, the ADM laser finds it.

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.

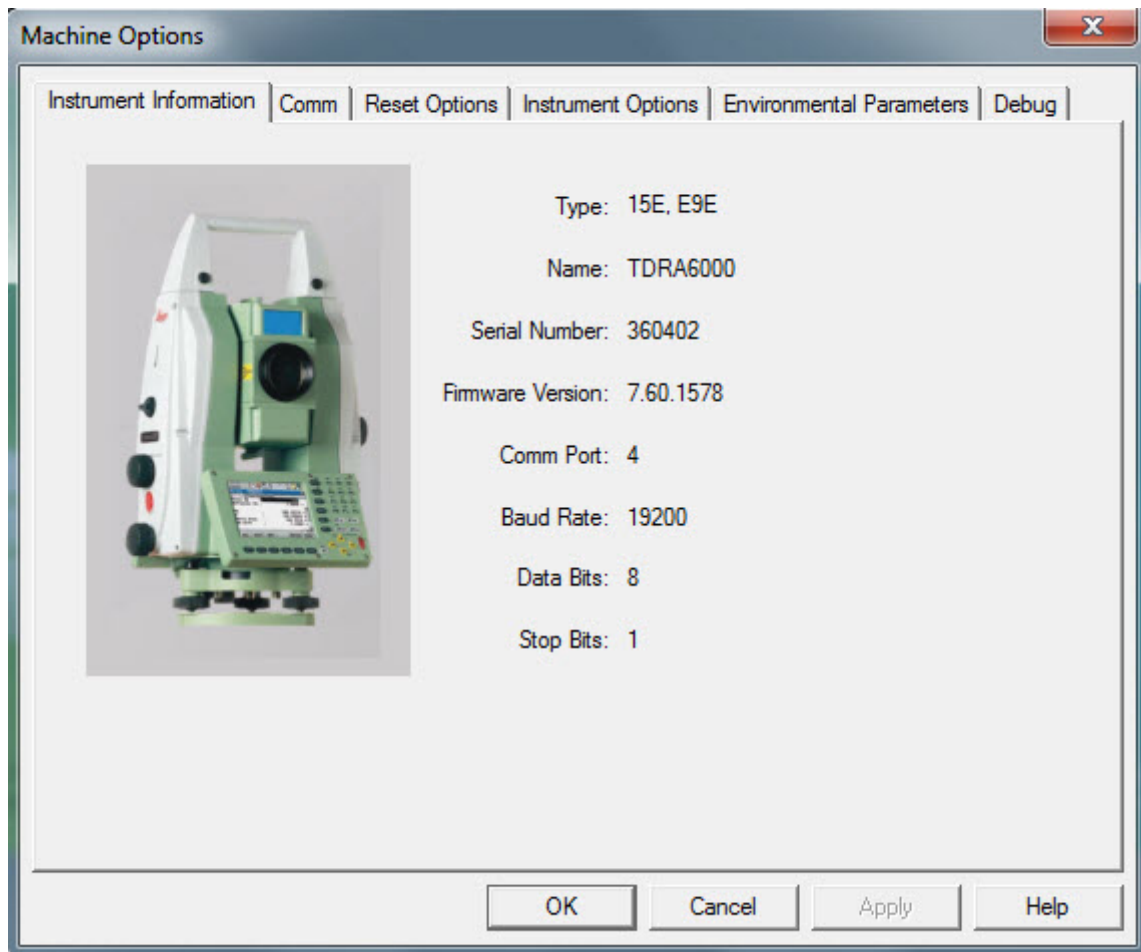
Total Station Interface

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](#)

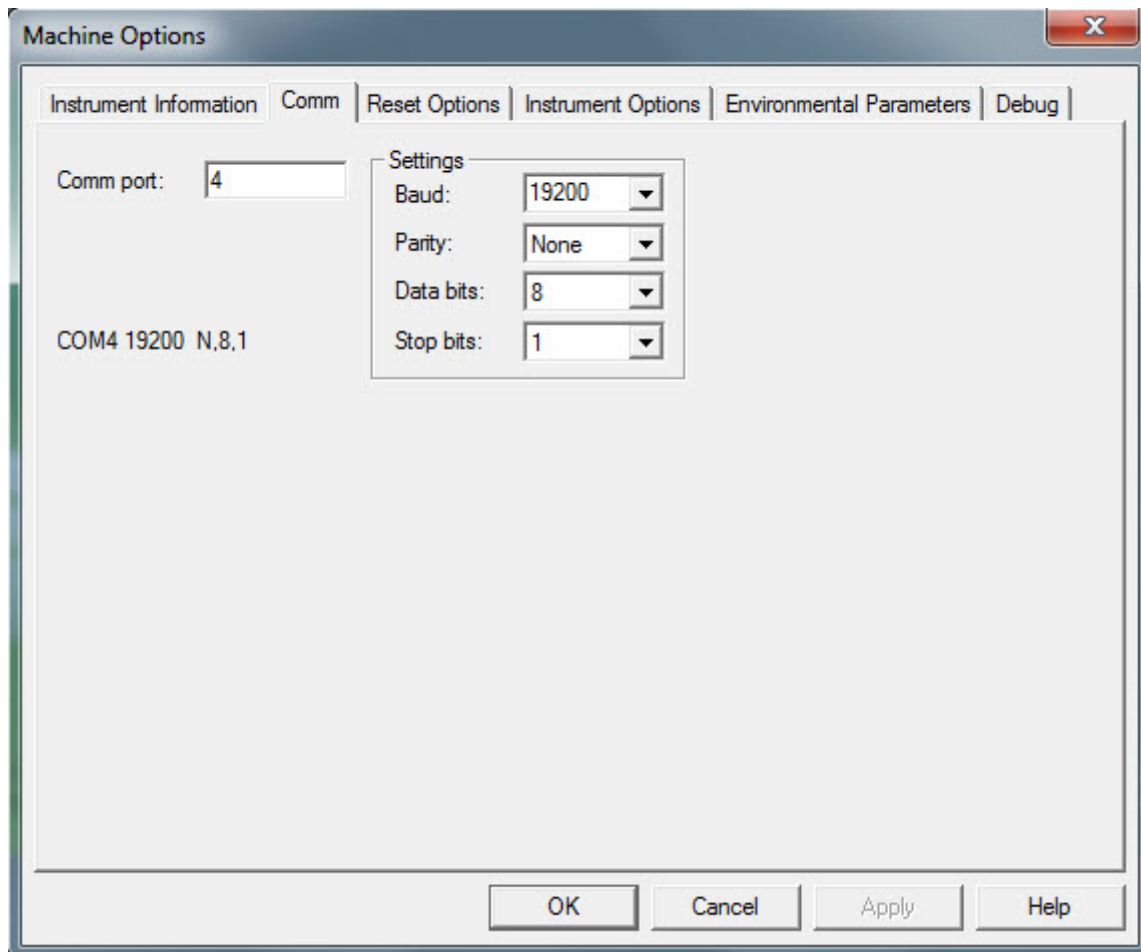
Please refer to the your machine interface documentation for details.

Instrument Information tab



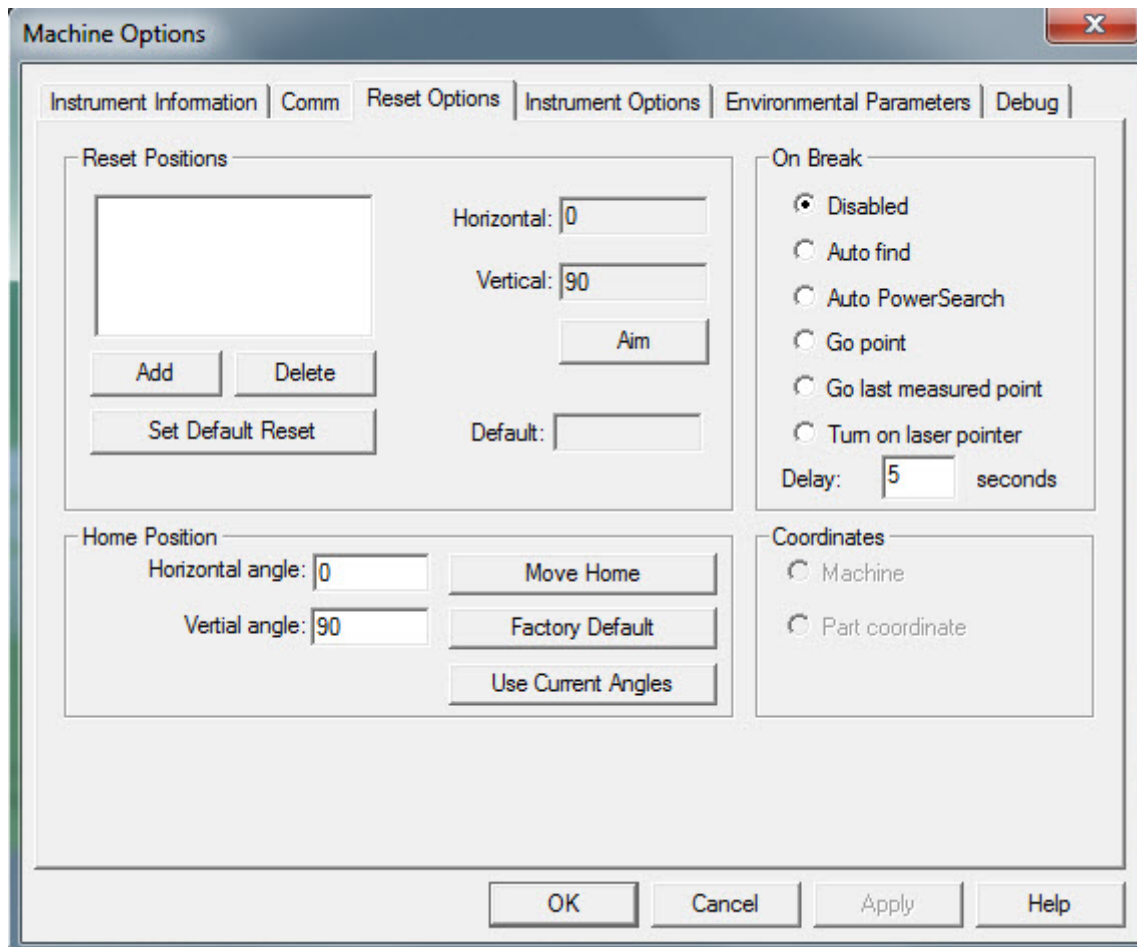
Measurement Options dialog box - Instrument Information tab

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. For more information on the laser pointer, see the **Laser Pointer ON/OFF** menu item discussed in the "[Total Station Menu](#)" topic.

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 main 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.

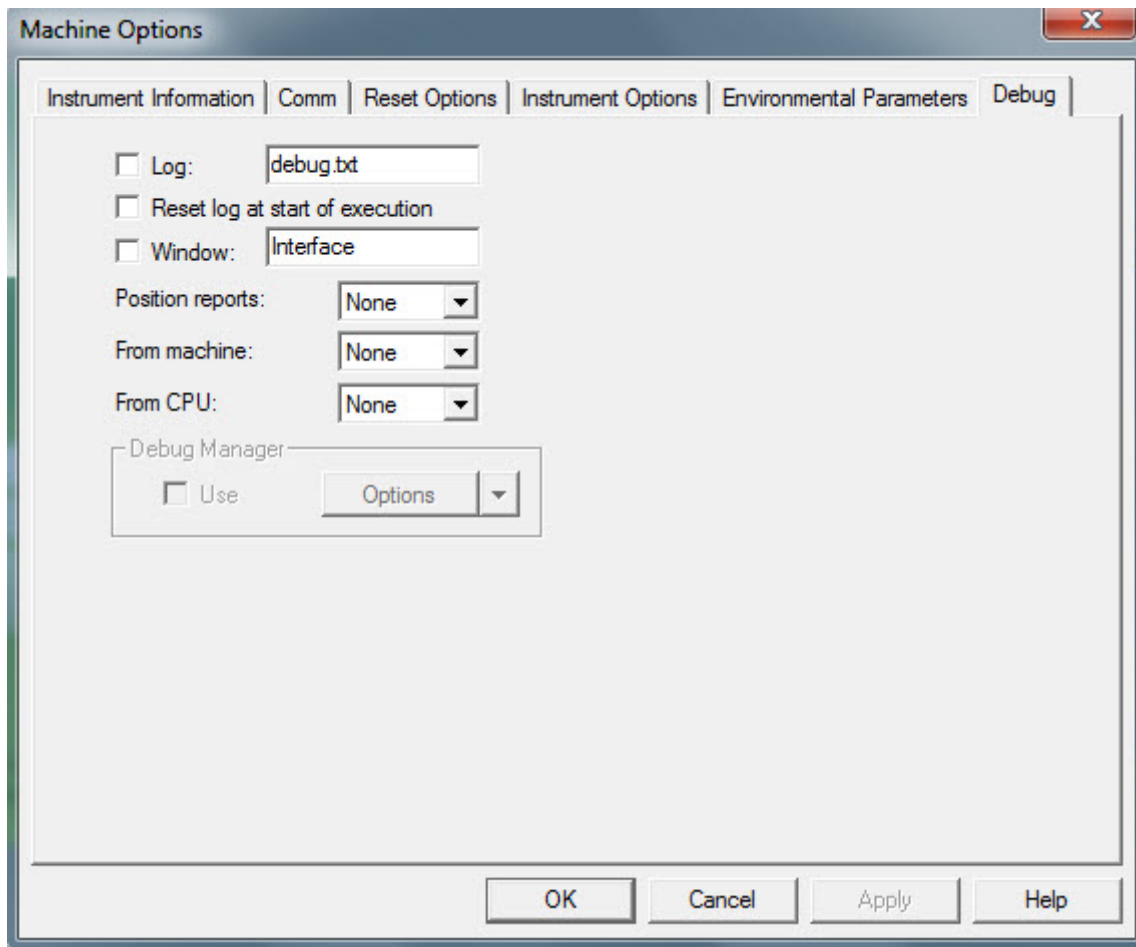
Atmospheric conditions	
<input type="checkbox"/> Use temperature station	Air temperature: 20.00 C
Serial Port: 1	Pressure: 1013 mBar
Update Interval: 300 seconds	Humidity: 20 %
Update Temperature	

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 Formats:** Catia 4, Catia 5, Parasolid, Pro-engineer, NX
- **Direct CAD (DCI) Formats:** ACIS, CATIA V5, Pro-engineer, Solidworks, NX

For information on how to import, 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 LMS license or 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 using one of these 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 you perform a measurement on portable CMMs with a hard probe, the software uses the probe's shank vector 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.

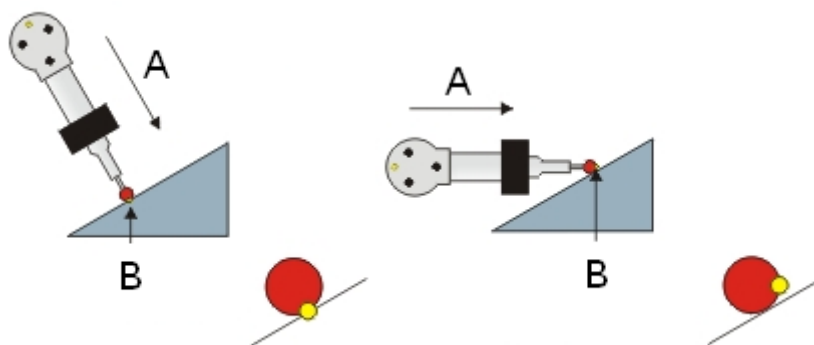


If you want to measure a small, deep hole, but the end of the arm is too large to fit into that hole, you need to take "pulled hits" to get each hit vector to properly point towards the center of the hole. This allows for the software to determine the proper in/out compensation. Pulled hits are hits 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, follow this procedure to measure a point on a top surface using the probe shaft for probe compensation:

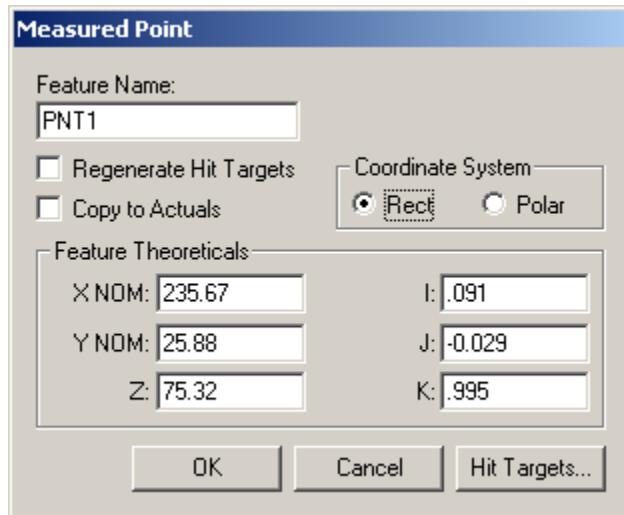
1. Place the probe on the top surface with the probe shaft straight up (perpendicular to the surface) from the point location (B). The point will be compensated in the direction (A) of the probe shaft.



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.
4. With the point highlighted, press F9 to open the **Measured Point** dialog box.



The image shows the 'Measured Point' dialog box in PC-DMIS. It has a title bar 'Measured Point'. Inside, there is a 'Feature Name' field with 'PNT1' entered. Below it are two checkboxes: 'Regenerate Hit Targets' and 'Copy to Actuals', both of which are unchecked. To the right of these is a 'Coordinate System' section with two radio buttons: 'Rect' (selected) and 'Polar'. Below these is a 'Feature Theoreticals' section containing six input fields arranged in two columns. The left column has 'X NOM: 235.67', 'Y NOM: 25.88', and 'Z: 75.32'. The right column has 'I: .091', 'J: -0.029', and 'K: .995'. At the bottom of the dialog are three buttons: 'OK', 'Cancel', and 'Hit Targets...'.

Measured Point example that shows hit vector pointing up

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

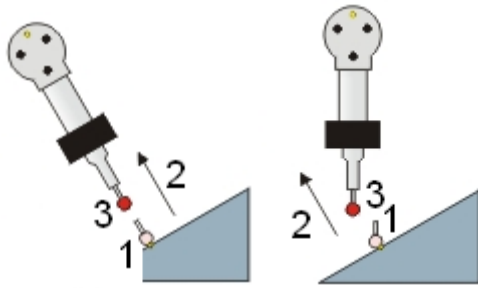


When you probe single points, be sure hold the probe normal to (perpendicular to) the surface.

Pulled Hits Method

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

1. 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), 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 you must move the probe from the hit to register a pulled hit, modify the `VectorToIMM` registry entry in PC-DMIS Settings Editor.
4. Release the hit button, and the computer emits a different lower audible tone. Notice that the software inserts the measured point into the Edit window.
5. With the point highlighted, press F9 to open the **Measured Point** dialog box. Verify that the vector follows 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](#)

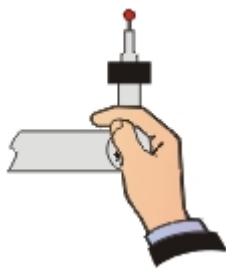
- [SMXLaser](#) (Faro tracker)
- [Leica](#)

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 select a hard probe, PC-DMIS expects a probe that does not automatically trigger when it comes in contact with the part. You cannot perform a DCC calibration with a hard probe. Make sure you select the correct probe type.

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



When you measure geometric features (lines, circles, planes, and other features) PC-DMIS compensates the probe radius 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. You should tip the probe 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 highlighted feature in the Edit window. Check the **Circular Feature Type** option.

Probe Trigger Options

Probe trigger options allow you to trigger a hit when certain conditions are met with manual CMMs.

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](#)

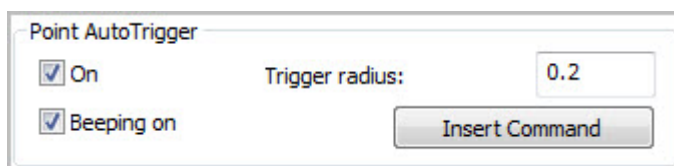
For examples of how PC-DMIS highlights the trigger zones in the Graphic Display window, see "[About Feature Highlighting](#)".

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.

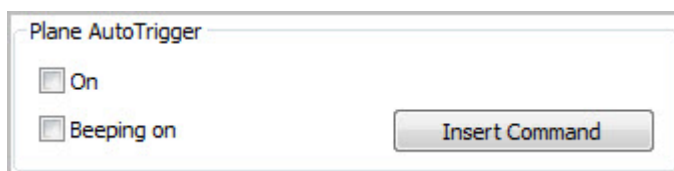
Plane AutoTrigger

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.

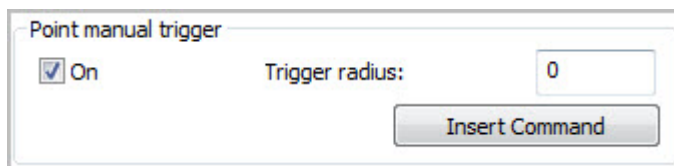
Point Manual Trigger

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 that you generate in this are all Measured Features rather than Auto Features with two exceptions:

First, if you are in point only mode, then PC-DMIS creates either an auto vector point or an auto edge point.

Second, 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.

To enable this mode, you must do the following:

- You must have the **Sheet Metal** option enabled in your LMS license or 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 5 mm. Hits taken within this distance from the edge initiate guided mode to complete 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 hits 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 hits buffer in learn mode. This allows PC-DMIS to guess features as you measure them.
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 hits buffer.



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

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 0.1 mm.

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 Arm

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 how to configure and use your Romer arm.

- [Romer / RomerRDS Portable Arm: Introduction](#)
- [Getting Started: Romer Portable Arm](#)
- [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 / RomerRDS Portable Arm: Introduction

Romer and RomerRDS Portable arms are articulated arm machines that use either a hard probe or a laser probe to measure parts.

PC-DMIS uses RDS to interface with your RomerRDS arm, or WinRDS to interface with a Romer arm. For detailed information about configuring and using your portable arm, refer to the RDS or WinRDS documentation.



To use a Romer or RomerRDS arm device with PC-DMIS, you must have your LMS license or portlock programmed with the correct interface option. If you are using a laser scanning probe, you also need to have the **Laser Probe** option with the **Probe Type** programmed.

Also, the **Rotary Table** LMS license or 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 this chapter was written specifically for Romer arms, but may also apply to non-Romer arms.

Once you have the software installed and the arm connected, for a quick start guide to measure a part, see "[Romer Arm - Quick Start for T Deviations](#)".

Getting Started: Romer Portable Arm

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 Absolute 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 Absolute arm. It also contains a quick start topic. For additional setup information, consult the WinRDS documentation and Perceptron Contour sensor documentation.

To configure your Romer Absolute arm, follow these steps:

- [Step 1: Set Up the Romer Absolute Arm](#)
- [Step 2: Set WinRDS Environment Variables](#)
- [Step 3: Install PC-DMIS for Romer](#)
- [Romer Quick Start for T Deviations](#)

Step 1: Set Up the Romer Absolute Arm

1. Mount the fixturing base to a stable platform with 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. Then 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 3.6 is available via this link: <ftp://ftp.wilcoxassoc.com/Hardware/Portable/Romer/RDS/>. Installing WinRDS places two icons on your computer desktop; one is called **Cimcore Arm Utilities**, and the other one is called **Quick Check Tools**.

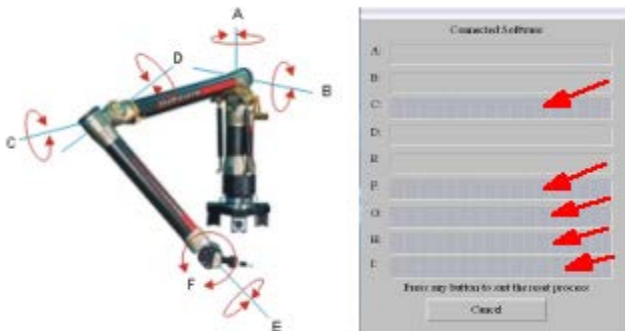


WinRDS versions earlier than 2.3.5 are not adequately supported for use with Perceptron Contour sensors.



There are two ways to communicate with the Absolute 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, we recommend that you connect your computer to the Absolute 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 **Absolute Setup Guide** and other documentation installed with the WinRDS installation.

5. Connect the communication cable into your arm and into one of the USB ports on your computer (or, verify Wi-Fi communication if you are not using a Perceptron Contour sensor).
6. Turn on the arm's 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 to launch 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 click 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, like this:
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" based 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 computer to the arm, install PC-DMIS by doing the following:

NOT using a Perceptron Laser Sensor

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



If **All interfaces** is programmed in your LMS license or 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 LMS license or 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 your LMS license or portlock, you will not have the necessary Perceptron files as indicated below. When you install PC-DMIS, additional files are installed that are required by WinRDS.



If **All interfaces** is programmed in your LMS license or 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 is installed by PC-DMIS during the install process as long as your LMS license or 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** LMS license or portlock option **MUST NOT** be selected when you use a portable device. It can cause problems with your portable device.

Romer Arm - Quick Start

You can follow this topic to get started with your Romer Absolute arm with PC-DMIS. This procedure assumes you have a CAD model for your part.

1. Ensure that the base of the Romer Absolute arm is fixed in place.
2. Install the RomerRDS software. After you install RDS, the software displays a small red icon in your taskbar.




3. Physically connect the Romer Absolute arm to your computer. If your computer detects that the arm is ready for use, the red icon turns green.





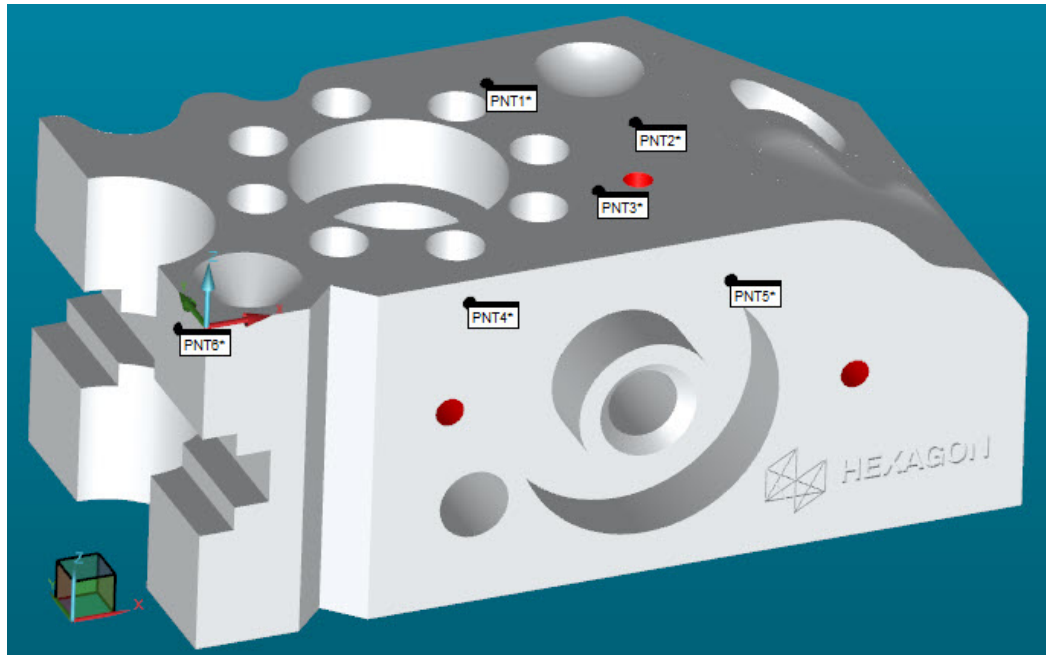
[Arm](#)".

For information on steps 1 -3, see "[Step 1: Set Up the Romer Absolute](#)

4. Start PC-DMIS.
5. From the **Edit** menu, choose **Set Portable Interface** and choose **RomerRDS Arm**.
6. Create a new measurement routine.
7. Choose **File | Import** to import a CAD model for your part.
8. Place your physical part on a sturdy, non-moveable, flat surface near the arm.

9. Orient the part so it more or less matches how it appears in the CAD model on the screen.
10. Fix your part in place so that it won't move when you probe it with the arm.
11. Select **View | Other Windows | Status Window** to show the Status window.
12. Select **View | Other Windows | Quick Start** to show the **Quick Start** interface.
13. From the **Quick Start** interface, on the toolbar, click **Alignments** ()

and then select **SIX POINTS BEST FIT** ().
14. From the **QuickMeasure** or **Graphic Modes** toolbar, choose **Program Mode** ().
15. Define the six points for the alignment on the CAD model:
 - a. On the top face, click three points spread out.
 - b. On the front face, click two points from left to right in a rough line.
 - c. On the left face, click a final point and click **Finish** to accept the alignment features.



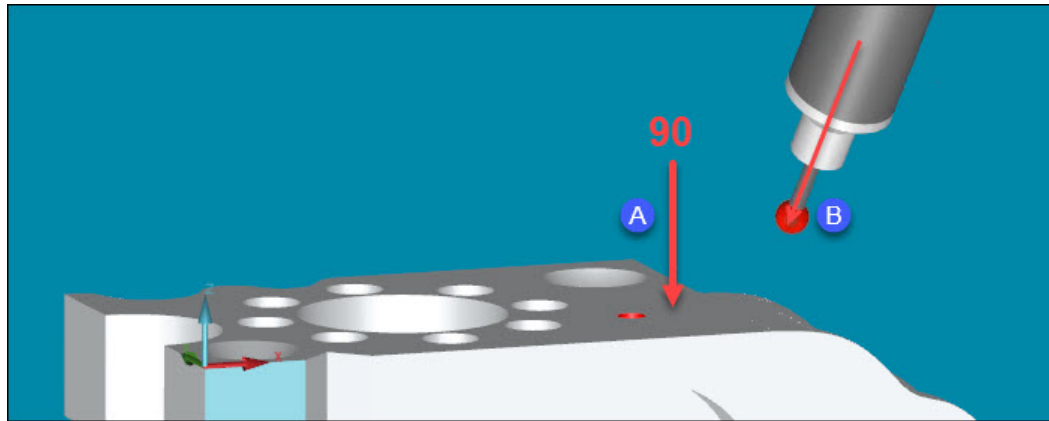
Sample Part with Six Points

16. Click **File | Execute** to measure the six points with your arm. If the software prompts you to load a probe, click **OK**.
17. From the **Execution** dialog box, follow the instructions below to take the alignment hits:



Because you physically contact the probe against the part to probe the points, the process of probing the part is often referred to as "taking a hit".

- a. Use the arm to place the ball of the probe on the top surface of the part in position to take hits. Ensure that the probe points to the surface you want to measure.
- b. Tilt the probe so that it is at an angle that is less than 90 degrees to the surface. This helps PC-DMIS find the surface.



Example of angle at 90 degrees (A) and a probe tilted to less than 90 degrees (B)



The next step directs you take hits with the probe for the alignment.

- You take hits with the middle button (Take Hit) on the arm.
- If you make a mistake, you can press the right button to remove it (Delete Hit).
- You press the left button (Done) to accept the hit or hits.

c. Measure these hits with your arm. After each hit, press the left button (Done) to accept the hit:

- Take three hits on the top surface (Z+).
- Take two hits from left to right on the front surface (Y-).
- Take the final hit on the left surface (X-).

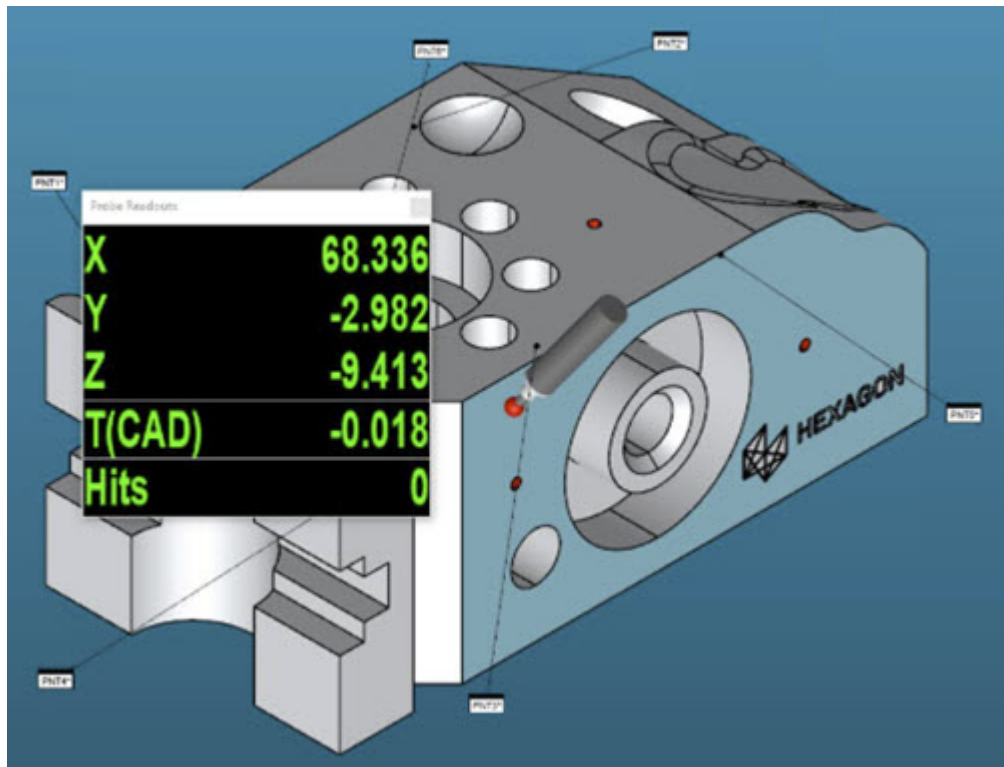


Until you measure these alignment points, the probe representation in the Graphics window is not close to the CAD model on the screen when you take the hits.

You now have a functioning alignment.

18. Test the alignment:

- a. On the arm, press and hold the cancel button (right button) twice. The first time you hold the button, PC-DMIS shows the **Probe Readouts** window. The second time you hold it down, the **Probe Readouts** window shows the **T** value. The **T** value shows the distance of the current probe's position to the part.
- b. Whenever the probe touches the part, the **T** value should be close to zero.
- c. Move the probe around the part and look at the **T** value in the **Probe Readouts** window. If the **T** value is close to zero all over the part, you know your alignment is good.



Example T Value - The distance (T value) decreases as the probe approaches one of the surfaces

19. From the **Probe Mode** toolbar, choose **Find Nominals from CAD Mode**

(). This highlights the CAD element closest to the probe. When you

probe hits, it uses the nominal value from the CAD model for each hit you take.

20. Define any features you want to verify:

- a. If you have a CAD, use QuickFeatures. To do this, press Shift (or Ctrl + Shift for points), and with your pointer, click on the feature in the CAD model. This adds that feature into the measurement routine. For information, see "Creating QuickFeatures" in the Core documentation.
- b. If you do not have a CAD model, from the toolbar on the **Quick Start** interface, click **Measure**, and then choose the feature to measure.
- c. Take the suggested number of hits to measure the feature and add it to the measurement routine.

21. Add dimensions you want to test:

- a. From the **Quick Start** interface, on the toolbar, click **Dimension**



- b. Select the dimension you want to test.
- c. Follow the on-screen instructions to add the dimensions. For information, see "Quick Start: Dimension Toolbar" in the Core documentation.

Configuring a Perceptron Contour Sensor

This section discusses the configuration of your Perceptron Contour sensor once you have configured your Absolute 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). Because the Perceptron requires a dedicated NIC for communication with their Perceptron Sensor controller box, you need to use the integrated NIC on your computer or purchase an additional NIC .



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:

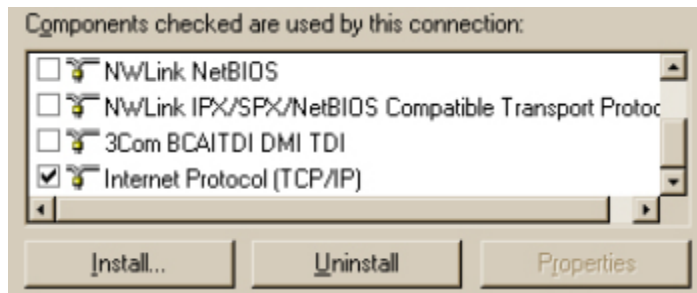
1. Remove the cap on the back of the Absolute arm labeled "SCANNER".
2. Take the sensor cable from the Perceptron box and plug it into the "Sensor" connector on the Perceptron controller box. Plug the other end into the "SCANNER" connection on the back of the arm.
3. There may be a small pigtail cable that comes off of the end that is plugged into the Perceptron controller box. This depends on what version of Perceptron controller you have. If you have a pigtail cable, plug the pigtail cable 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

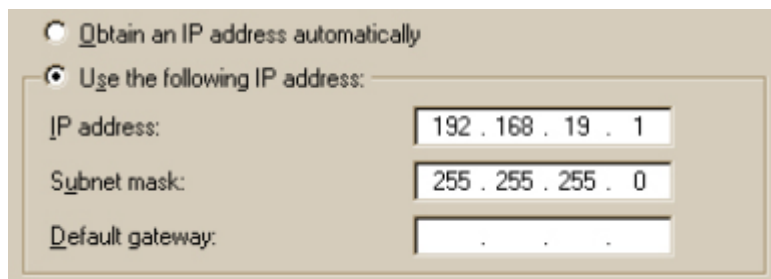
To communicate with the Perceptron controller box, you need to configure your dedicated NIC by following these steps:

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. Clear all check boxes except **Internet Protocol (TCP/IP)** so that the **Internet Protocol (TCP/IP)** item is the only selected item.



6. Select the text (not the check box) to highlight **Internet Protocol**.
7. Select **Properties**.
8. 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

9. Click **Advanced** to open the **Advanced TCP/IP Setting** dialog box.
10. From the **Advanced TCP/IP Settings** dialog box, select the **WINS** tab.
11. Select the **Disable NetBIOS over TCP/IP** option in the **NetBIOS setting** area.
12. 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 Absolute arm, 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. To do this press the power button located near the power connector and the trigger connector. Don't confuse this 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 can know when the boot cycle finishes when the green Ready LED lights up.
3. When the boot cycle finishes, 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 LEDs 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 launches, it tries to establish communication with the sensor. If it succeeds, 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. If you are within the camera's field of view, you should see 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, follow these steps:

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 Absolute 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 (**Insert | Hardware Definition | Probe**) 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

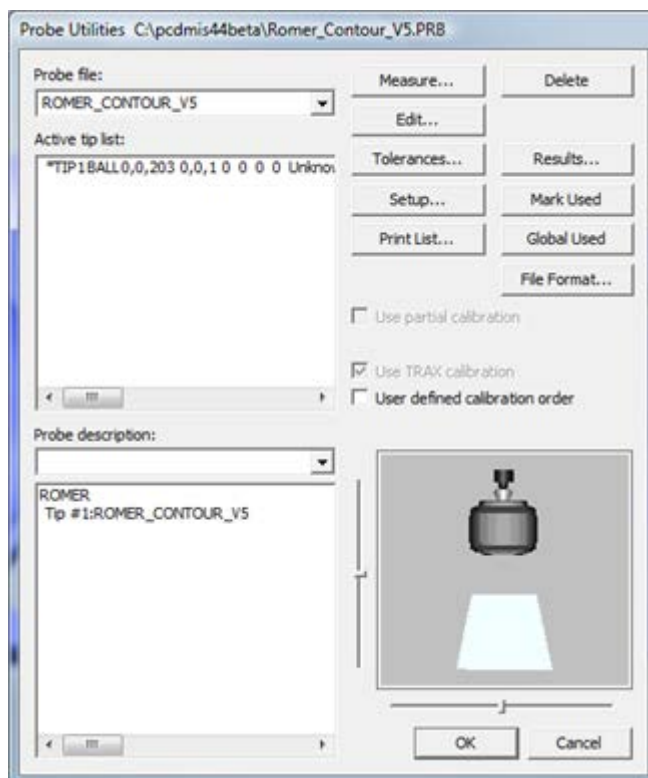
An exposure value of 300 is sometimes not sufficient in rare lighting conditions, such as V4i in a sodium lighting environment. If, due to such lighting conditions, it appears that PC-DMIS has trouble accepting the laser arcs during the calibration process, you may need to lower the default calibration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

`PerceptronDefaultCalibrationExposure` registry entry in the **NCSensorSettings** section.

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 based 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 to use 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 (flat target calibration) by doing the following:
 - a. Place a white piece of paper on a flat surface where you intend to 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 you move the probe away to the full extent of the laser's range so 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

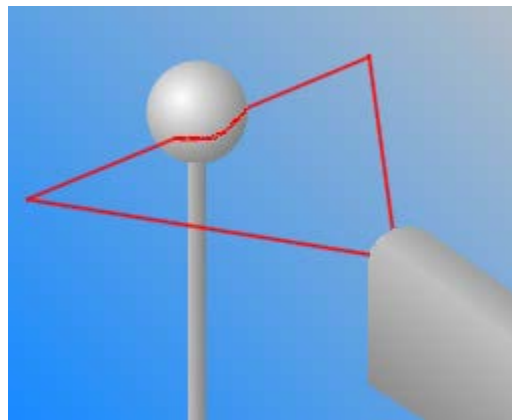
3 different fields at each position). The laser probe will continually be probing, but it only accepts a stripe of data when *certain criteria* are met. The system needs 5 stripes of data at each of the 15 *different locations* to complete the calibration.

When you calibrate 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. The tropics are indicated as "Band 1" and "Band 2" in the above image). Also, when you probe 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.

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.



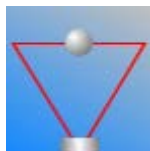
Position 2: Rotate the sensor 120 degrees around the sphere from Position 1.

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

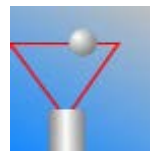
Position 4: Point the sensor straight down on the top of the sphere.

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

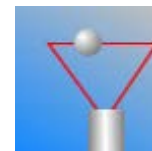
- 3 *Sensor Fields* (Far, Right, and Left) within the laser's range:



Field 1: Far

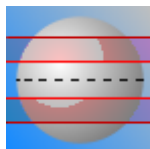


Field 2: Right



Field 3: Left

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



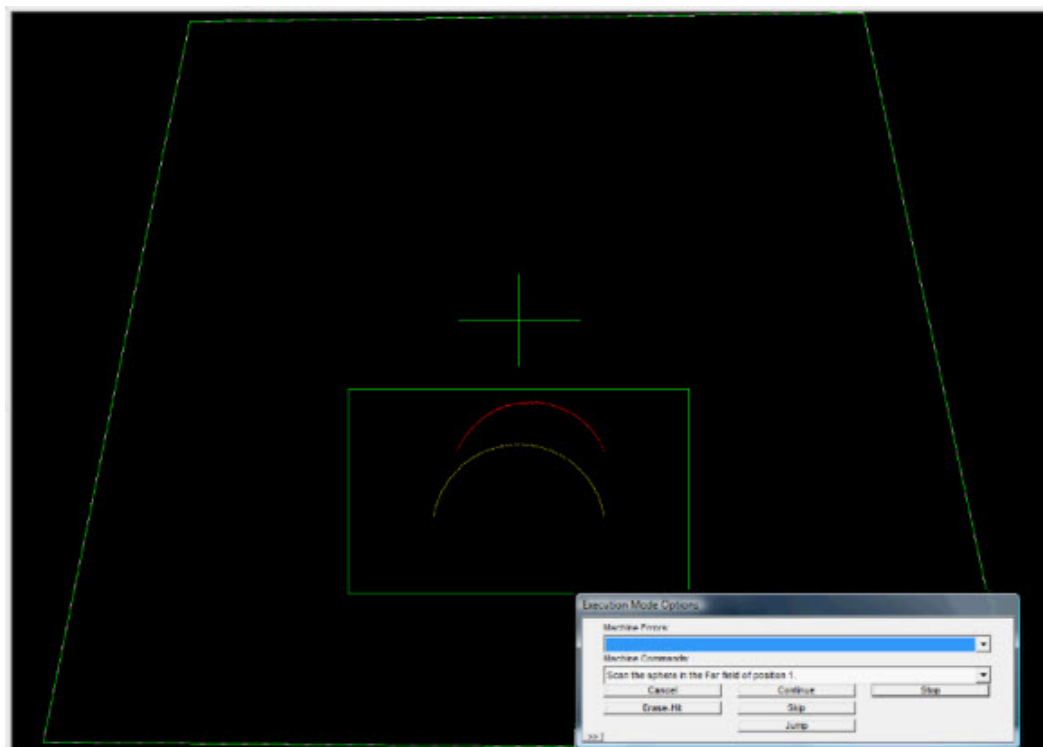
Band 1: 20 Degrees *above* the equator (mid-line) of the sphere.

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 have 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.

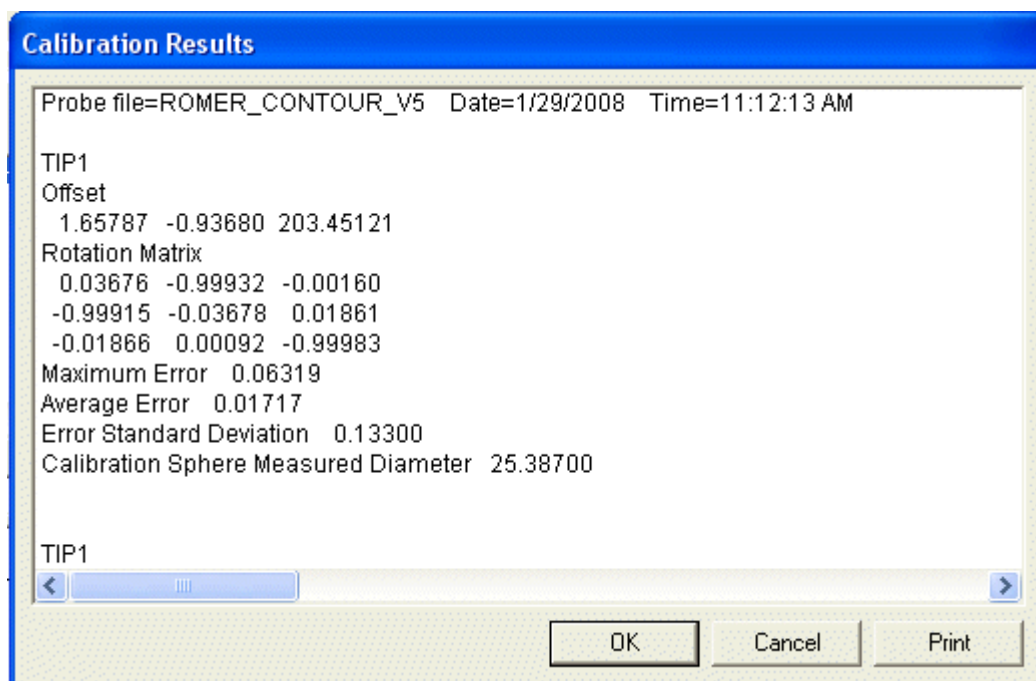
- The solved circle that is created by the laser's arc must have at least 100 degrees of arc angle. This is the difference between the starting vector and the ending vector of the arc.
 - The laser must probe a diameter of .875 multiplied by the theoretical diameter of the calibration sphere. This means 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.
- 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.

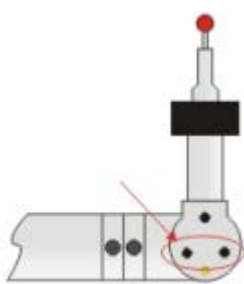
You are now done with the setup up and calibration of your laser probe. You should now have access to all laser-related functionality.



If the calibration exceeds the tolerance value defined for the `StandardDeviationLimit` registry entry in the **USER_Option** 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.

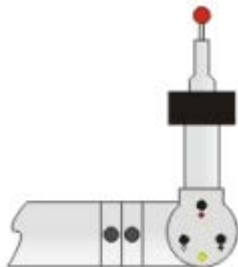
Using Romer Arm Buttons

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. You can do this 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.

When PC-DMIS is in Mouse mode, if you attempt to pick up and use your regular mouse, it behaves erratically. To use your regular mouse, exit out of Mouse mode.

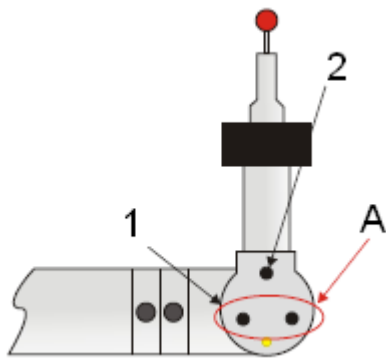
Mouse mode also functions outside of PC-DMIS, but PC-DMIS must remain running and be minimized in the background.

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 - To complete your measurements, press this button for less than one second.

1 : ERASE - To erase the last hit, press and hold this button for longer than one second.

1 : OPEN DRO - If there is no hit in the buffer, press and hold this button for longer than one second.

1 : TOGGLE DRO - With the Readouts window (DRO) already open, press button 1 for less than one second. PC-DMIS shows the T value with the XYZ values in the DRO: XYZT

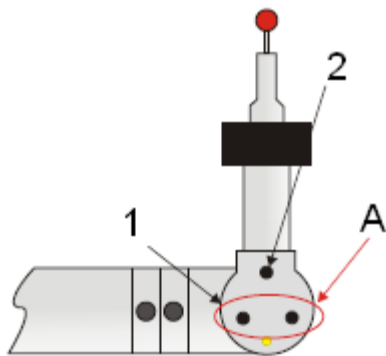
2 : HIT POINT - To take a hit, press this button for less than one second.

2 : PULLED HIT - To take a Pulled Hit, press this button, pull back, and then release the button within one second. For details on how to take a Pulled Hit, see "[Using Pulled Hits for Probe Compensation](#)".

2 : SCAN - To scan your part, press and hold this button for longer than one second. While the button is held, drag your probe over your part to begin the scan.

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 - Press this button to interact with popup menus.

1 : PAN - In the Graphic Display window, press and hold this button on the CAD model to pan the image.

2 : Mouse LEFT Button - Press this button to interact with screen selections.

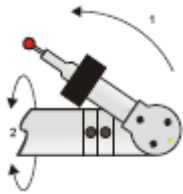
A : Buttons indicated by a circle with a red arrow perform the same function.

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:

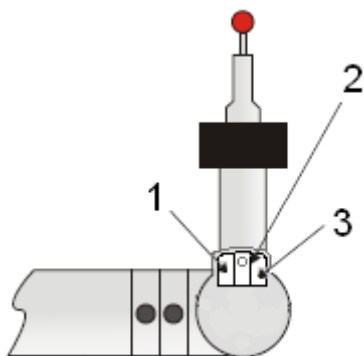


1. Turn the "F" axis to the limit, then
2. Turn the "E" axis 90 degrees.

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 - To complete your measurements, press this button for less than one second.

1: ERASE - To erase the last hit, press and hold this button for longer than one second.

1: OPEN DRO - If there is no hit in the buffer, press and hold this button for longer than one second.

1: TOGGLE DRO - With the Readouts window (DRO) already open, press button 1 for less than one second. PC-DMIS shows the T value with the XYZ values in the DRO: XYZT

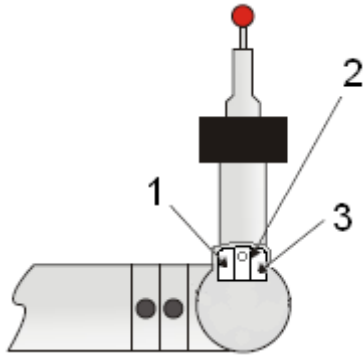
2: HIT POINT - To take a hit, press this button for less than one second.

2: PULLED HIT - To take a Pulled Hit, press this button, pull back the probe, and then release the button within one second. For details on how to take a Pulled Hit, see "[Using Pulled Hits for Probe Compensation](#)".

2: SCAN - To scan your part, press and hold this button for longer than one second. While the button is held, drag your probe over your part to begin the scan.

3: TOGGLE - To toggle between modes, press this button for less than one second.

Mouse Mode



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

1: PAN - Press and hold to pan the CAD model.

2: Mouse LEFT Button - Used for screen selections.

1+ 2: BOX ZOOM - Press and hold.

3: TOGGLE Between Modes - Press for less than 1 second.

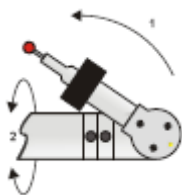
3: ROTATE - Press and hold to rotate the CAD model.

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

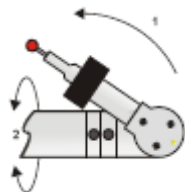
- 2. Turn the "E" axis 90 degrees.

Three Button Configuration for the RA7 and RA8 Arm

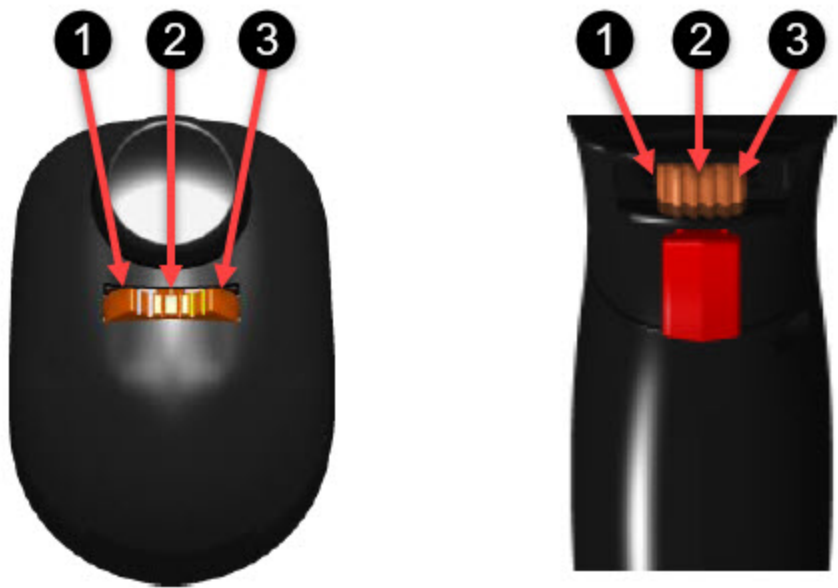
The two modes for a three-button configuration used on the RA7 and RA8 arms are discussed below.

To switch between Measure and Mouse modes,

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



Measure Mode



Romer Absolute Arm 6-axis (left) and 7-axis (right) button configurations

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

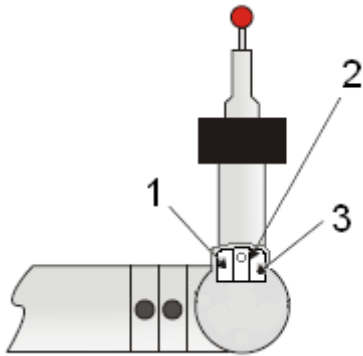
Desired Action	Arm Procedure to Follow
----------------	-------------------------

Click Done , OK , Yes , Finish , Next , or Create on a dialog box	Press button 1 for less than one second.
Erase the last hit or scan pass from the hit buffer.	Press and hold button 1 for more than one second. When you use the Hexagon Absolute Portable Arm with the integrated laser scanner, you can delete the last scan pass using button 1 (the arm left button).
Click Cancel , No , or Previous buttons on a dialog box	Press and hold button 1 for more than one second.
Bring up the Readouts window (DRO)	Press and hold button 1 for more than one second when there are no hits in the hit buffer.
Toggle the display of information in the Readouts window (DRO)	With the DRO already open, press button 1 for less than one second. PC-DMIS shows the T value with the XYZ values in the DRO: XYZT
Take a point	Press button 2 for less than one second without moving the arm.
Take a "Pulled Hit"	Press and hold button 2 while pulling back on the arm, and then release the button within one second. For details, see " Using Pulled Hits for Probe Compensation ".
Scan	Press and hold button 2 for more than one second while dragging the probe along the part's surface.
Select features on the	Position the probe near the feature, press and

part using the arm

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 CAD view	Press button 1 (left mouse click) above the imaginary center 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 below 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 your 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 is the desired range for optimal scanning.

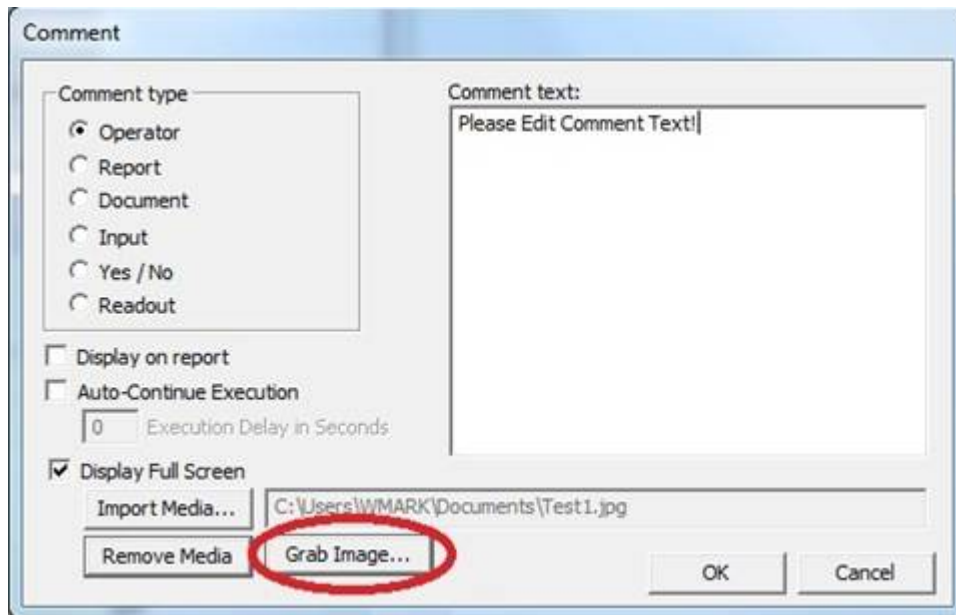


This functionality is probably best used on larger, flatter surfaces. When you use a V5 sensor, you may combine the sound events with the V5 projector option to ensure scanning at the optimal focal length. You can compare the V5 projector in relation to the audible cues to learn what the beeps mean.

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, follow these steps:

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.



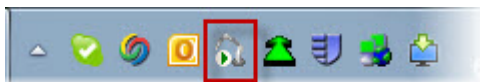
PC-DMIS comments only support the JPEG image format.

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).

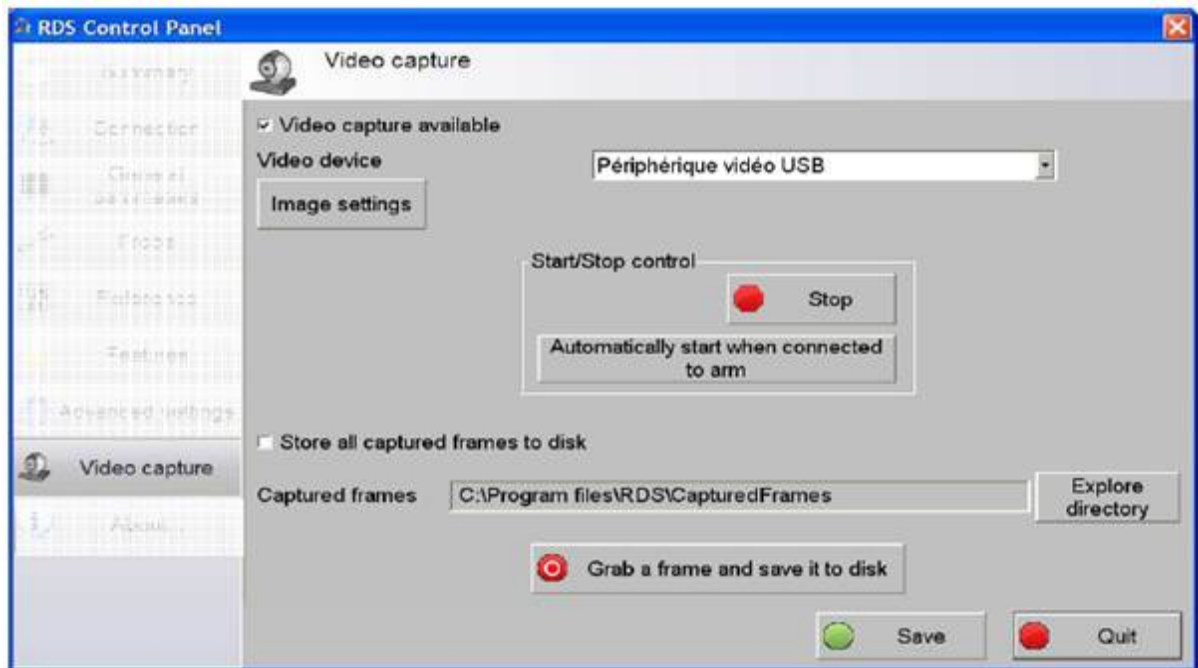
The RDS Control Panel comes bundled with the PC-DMIS installation.

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 how to configure and use your Leica Tracker.

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

- [Leica Laser Tracker: Introduction](#)
- [Getting Started: Leica Tracker](#)
- [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 you can move 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.

PC-DMIS supports both 3D and 6doF machines.

- The data from a 3D machine uses the X, Y, Z position of the Tracker ball.
- The data from a 6doF machine uses the X, Y, Z position of the Tracker T-probe tip as well as the vector (the probe tip's direction).



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

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

Supported 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

Supported emScon Version

emScon version 2.4.666 or higher

Other Supported 6DoF Systems

T-Probell or T-Probel 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: Leica Tracker

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 these 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. If you are using a portlock, connect it to your USB port. You must have a properly configured LMS license or portlock available during the PC-DMIS installation.
2. Execute setup.exe from the PC-DMIS Installation media. Follow the on-screen instructions.

If the **Leica/LeicaLMF** option is enabled on your LMS license or portlock, PC-DMIS loads and uses the Leica/LeicaLMF interface when you work online.

If the **All interfaces** option is enabled in your LMS license or portlock, you may need to manually rename Leica.dll/LeicaLMF.dll to interfac.dll.

Leica.dll/LeicaLMF.dll is in the PC-DMIS install directory.

You can also select the interface from the PC-DMIS menu before you load a measurement routine. For details, see the "[Switchable Portable Interface](#)" topic.

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



You can also select the interface from the PC-DMIS menu before you load a measurement routine. For details, see the "[Switchable Portable Interface](#)" section of this document.

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 the 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" chapter 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 intend to 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 does NOT charge. 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 are 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 pre-configured 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> or <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 OpenGL 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](#) with 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 - This option displays the tracker **Station Manager** dialog box. For details, see the "[Adding and Removing Stations](#)" topic.

Tracker Pilot - For details on this option, see the "[Tracker Pilot Commands](#)" topic.

Measurement Profile - For details on this option, see the "[Tracker Measurement Profile Commands](#)" topic.

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

Find - This option 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 option rotates the tracker 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.

Compensator On/Off - This option 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 - This option releases the horizontal and vertical tracker head motors in order to allow manual tracker head movement.

Probe Comp ON/OFF - When this option 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 measuring points.

Stable Probing ON/OFF - When this option is "on", PC-DMIS automatically triggers 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 option turns the PowerLock functionality on or off. When turned on, the tracker's laser beam can very quickly re-lock on the device. This means you don't need to catch the beam manually. If you break the laser beam, 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 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 is 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 this option's 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 - This option determines whether 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 - For details on this option, 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**).

PC-DMIS displays the currently active measurement profile in the [Tracker status bar](#). The toolbar button is implemented to display a submenu with the available measurement profiles based on the tracker you are using.

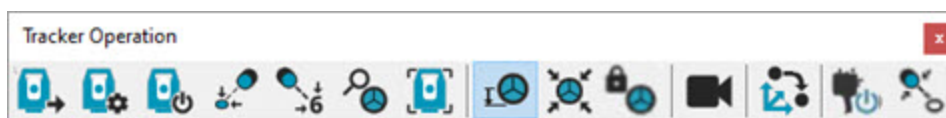
If **Insert Tracker Command** is turned ON in the **Tracker** menu, PC-DMIS inserts the tracker command into the measurement routine that is associated with the current measurement profile. The active measurement profile on the sensor is then updated according to the active measurement profile command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



If the tracker provides measurement profile settings, the Measurement time setting in the Tracker **Machine Interface Setup** dialog box is not 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 | 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](#) (This is only a menu option and is not found on the **Tracker Operation** toolbar.)
- [Tracker | Probe Comp. ON/OFF](#)
- [Tracker | Stable Probing ON/OFF](#)
- [Tracker | PowerLock ON/OFF](#)
- [View | Other Windows | Tracker Overview Cam](#)
- [Insert | Alignment | Bundle Alignment](#)
- **Connect to Scanner** - This button toggles the tracker scanner connection to the scanning application on and off. For the LAS and LAS-XL scanners, the scanning application is RDS; for the T-scan scanner, the scanning application is T-Collect.

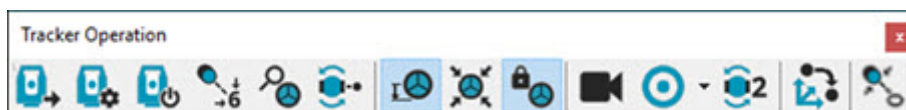


When the **Connect to Scanner** button is on, PC-DMIS disables all other buttons on the **Tracker Operation** toolbar.

When re-executing a Tracker program with the scanner, you should not use the **Connect to Scanner** button. PC-DMIS automatically connects to the scanner application when re-executing.

- [Tracker | Move Feature](#)

Tracker Operation toolbar (for AT-901 Trackers)



- [Tracker | Insert Tracker Command](#)
- [Tracker | Station Management](#)
- [Tracker | Initialize](#)
- [Tracker | Go 6DoF 0 Position](#)
- [Tracker | Find](#)
- [Tracker | Change Face](#)
- [Tracker | Probe Compensation ON/OFF](#)
- [Tracker | Stable Probing ON/OFF](#)
- [Tracker | PowerLock ON/OFF](#)
- [Tracker Overview Camera](#)
- [Tracker | Measurement Profile](#)

On the **Tracker Operation** toolbar, click the arrow to display the **Profile** drop-down toolbar:



The buttons from left to right are:

- **Standard Measurement Profile**
- **Fast Measurement Profile**
- **Precise Measurement Profile**
- **Continuous Distance Mode**
- **Continuous Time Mode**
- [Tracker | Two Face Measurement Mode ON/OFF](#)
- [Insert | Alignment | Bundle](#)
- [Tracker | Move Feature](#)

Tracker Operation toolbar (for AT-930/960, AT-40x and ATS600 Trackers)



- [Tracker | Insert Tracker Command](#)
- [Tracker | Station Management](#)
- [Tracker | Initialize](#)
- [Tracker | Go 6DoF 0 Position](#)
- [Tracker | Find](#)
- [Tracker | Change Face](#)
- [Tracker | Probe Compensation ON/OFF](#)
- [Tracker | Stable Probing ON/OFF](#)
- [Tracker | PowerLock ON/OFF](#)
- [Tracker Overview Camera](#)
- [Tracker | Measurement Profile](#)

Click the arrow to display the drop-down toolbar:



The buttons from left to right are:

- **Standard Measurement Profile**
- **Fast Measurement Profile**
- **Precise Measurement Profile**
- **Continuous Distance Mode**
- **Continuous Time Mode**
- [Tracker | Two Face Measurement Mode ON/OFF](#)
- [Insert | Alignment | Bundle](#)
- **Connect to Scanner** - This button toggles the tracker scanner connection to the scanning application on and off. For the LAS and LAS-XL scanners, the scanning application is RDS; for the T-scan scanner, the scanning application is T-Collect.

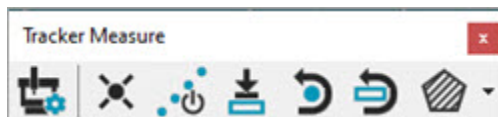


When the **Connect to Scanner** button is on, PC-DMIS disables all other buttons on the **Tracker Operation** toolbar.

When re-executing a Tracker program with the scanner, you should not use the **Connect to Scanner** button. PC-DMIS automatically connects to the scanner application when re-executing.

- [Tracker | Move Feature](#)

Tracker Operation toolbar (for LAS, LAS-XL and T-Scan Trackers)



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

- **Edit | Delete | Last Feature**
- **Insert | Scan | Area Scan** and **Insert | Scan | Ring Scan**

On the **Tracker Measure** toolbar, click the arrow to display the **Scan** drop-down toolbar:



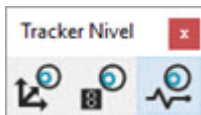
The buttons from left to right are:

- **Area Scan** - For details, see the "[Performing an Area Scan](#)" topic.
- **Ring Scan** - For details, see the "[Performing a Ring Scan](#)" topic.



The **Area Scan** and **Ring Scan** buttons are only available when you use the ATS600 interface and a surface probe is your active probe.

Tracker Measure



- **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.

Tracker Nivel

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.



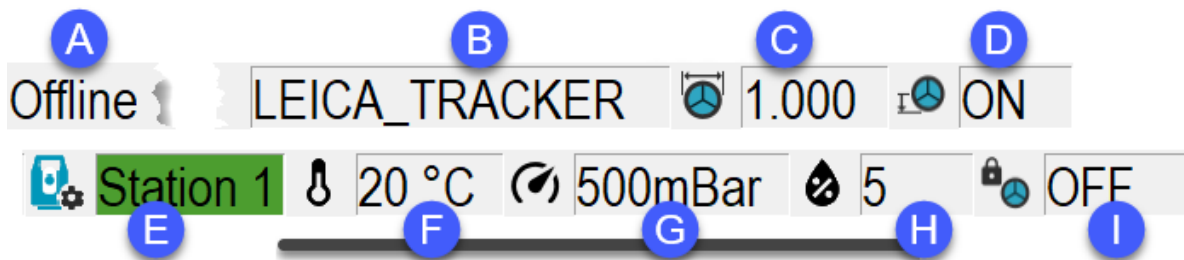
Start/Stop Monitoring: Starts or stops monitoring independent from the Orient to Gravity process.

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



A. **System Laser Status Indicator:** This field indicates the status of the Laser Tracker system.

- **No Color** (Offline): The system is not online.
- **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.
- B. **Probe Name:** This field indicates the name of the probe that you defined in the **Probe Utilities** dialog box.
- C. **Probe Diameter:** This field indicates the diameter of the probe tip that you defined in the **Probe Utilities** dialog box.
- D. **Probe Compensation:** This field indicates whether probe compensation is on or not (**Insert | Parameter | Probe | Probe Compensation**).
- E. **Active Station Indicator:** This field indicates the currently active station. You can double-click on this field to open the [Station Manager](#) dialog box to add or delete stations.
- **Red** (Not oriented): This indicates that the software has not computed the station position yet.
 - **Green** (Oriented): This indicates that the software has computed the station position.
- F. **Temperature:** This shows the temperature if you have a weather station connected.
- G. **Pressure:** This shows the pressure if you have a weather station connected.
- H. **Humidity:** This shows the current humidity if you have a weather station connected.



For temperature, pressure, and humidity, if you don't have a weather station connected to the machine, you can double-click on the boxes to type the values.

- I. **PowerLock (ON/OFF):** When set to ON, this performs an auto-lock on a reflector for Tracker systems that have the PowerLock feature. When set to OFF, you must manually catch the beam to lock onto it.

Status Bar Differences for 3D Machines

Most of the items in a 3D machine status bar are identical to those for 6doF machines. But depending on your hardware and configurations, your status bar may use some of these additional icons.

Connection icons:



- The device is connected to power.



- The device is on battery power.



- The controller is connected to power.



- The controller is on battery power.

Tracker Measurement Profile Mode icons:



- No Profile



- Standard Profile



- Fast Profile



- Precise Profile



- Outdoor Profile



The Tracker measurement profile mode icons require firmware v2.0 or higher.



If PC-DMIS fails to determine the Tracker measurement profile mode, the toolbar button icon and the status bar icon for the measurement profile



display the No Profile symbol (). If this happens, select the measurement profile from the toolbar button or the tracker menu.

Probing Mode icons:



- Average



- Single



- Stable



- Two face

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).

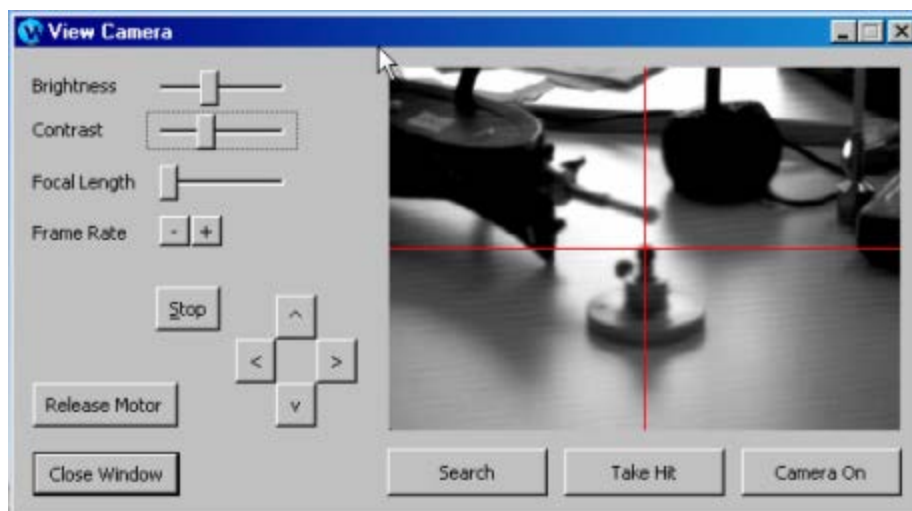
Using the Tracker Overview Cam

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.

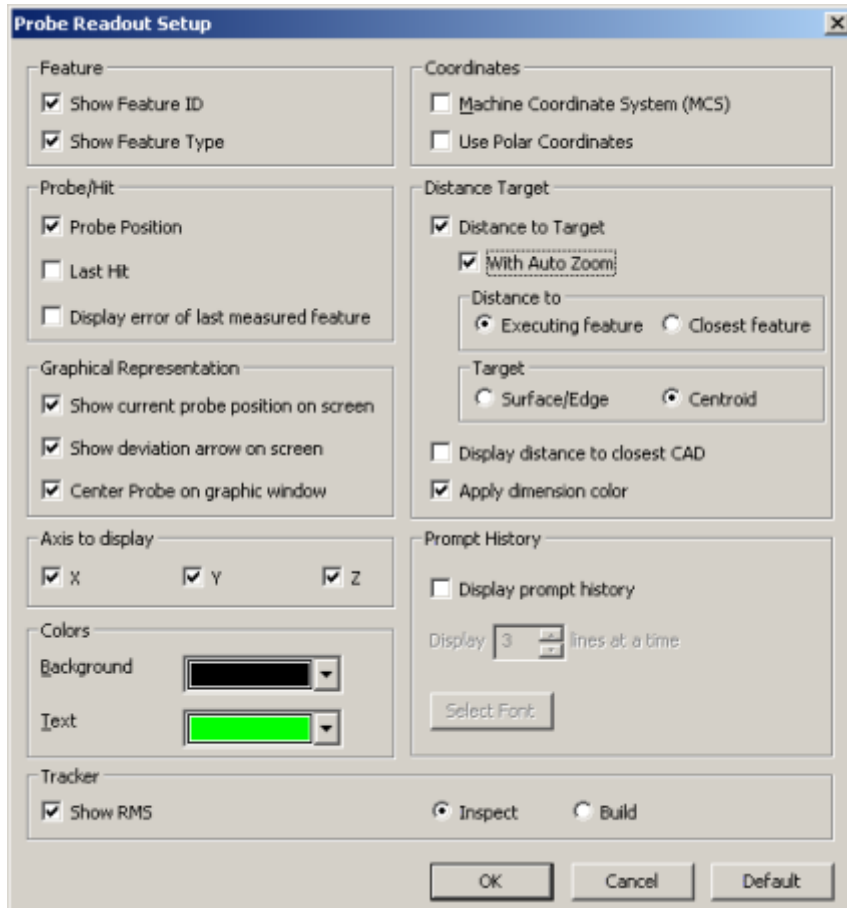
Tracker status bar:

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 0.1mm), 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.

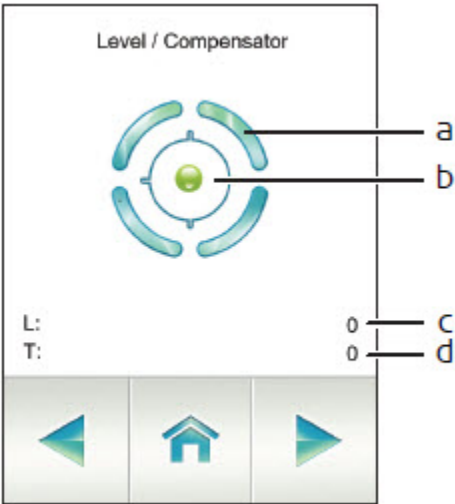
For detailed information on the configuration and use of the Nivel sensor, see the documentation provided with your Nivel sensor. Leveling to gravity is not required, but it does improve the Leica Tracker measurement results.

LMF Trackers

For LMF trackers, the Nivel is contained in the head of the tracker.

To level to gravity and monitor Leica LMF trackers:

1. Adjust the legs of the tripod or the Brunson stand so that the bubble is as close to zero in **L** (Longitudinal Tilt) and **T** (Transversal Tilt) as possible. It must be within +/- 20 of zero.



a - Inclination Sensor Status

b - Electronic Level Bubble

c - Longitudinal Tilt (unitless)

d - Transversal Tilt (unitless)

Inclination Sensor Status	
Status Icon	Description
	Disabled
	Not in working range
	Enabled
	Enabled, levelled enough for a successful Orient to Gravity (OTG)

2. When the tracker is leveled and brought into an acceptable working range, select the **Tracker | Nivel | Level to Gravity Process** menu item. The laser tracker performs Nivel measurements in all four quadrants of the laser tracker. The laser tracker then 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.

3. Once you level the system, 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 screen if needed.

RotX	0.3550
RotY	0.0320

Using the Tilt Readouts window to monitor the tracker's level to gravity

Use the Tilt Readouts window to monitor how level your system is to gravity. For more information, see the documentation provided with your sensor.

4. Optionally, 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.



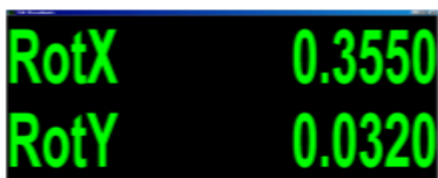
The monitoring process makes sure that nobody moves or hits the tracker. You can start it explicitly if no Gravity plane is needed. In this case, you should monitor only the stability of the system.

AT-90x Trackers

For AT-90x trackers, the Nivel mounts on the top of the sensor unit or on 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.

To level to gravity and monitor Leica AT-90x trackers:

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 documentation provided with your Nivel sensor.
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 screen if needed.



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 documentation provided with your Nivel sensor.
5. When the tracker is roughly leveled and brought into an acceptable working range, select the **Tracker | Nivel | Level to Gravity Process** menu item. The laser tracker performs Nivel measurements in all four quadrants of the laser tracker. The laser tracker then 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 documentation provided with your Nivel sensor.
8. Optionally, 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.

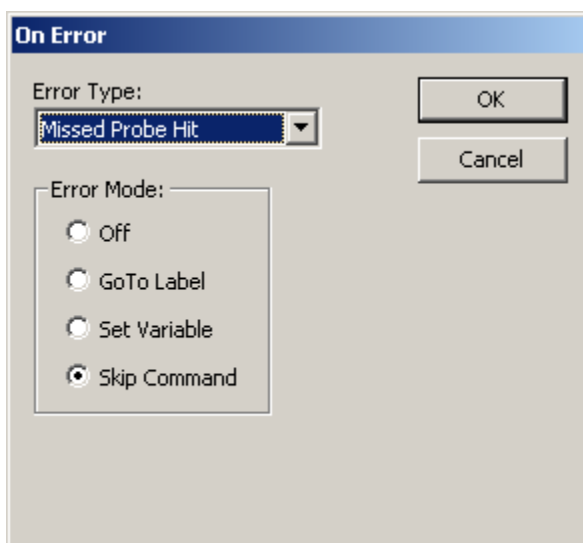
This process is often used for deformation measurements or repeated stability studies over a long time range. Each of the positions that are going to be auto inspected are typically equipped with a separate reflector.

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

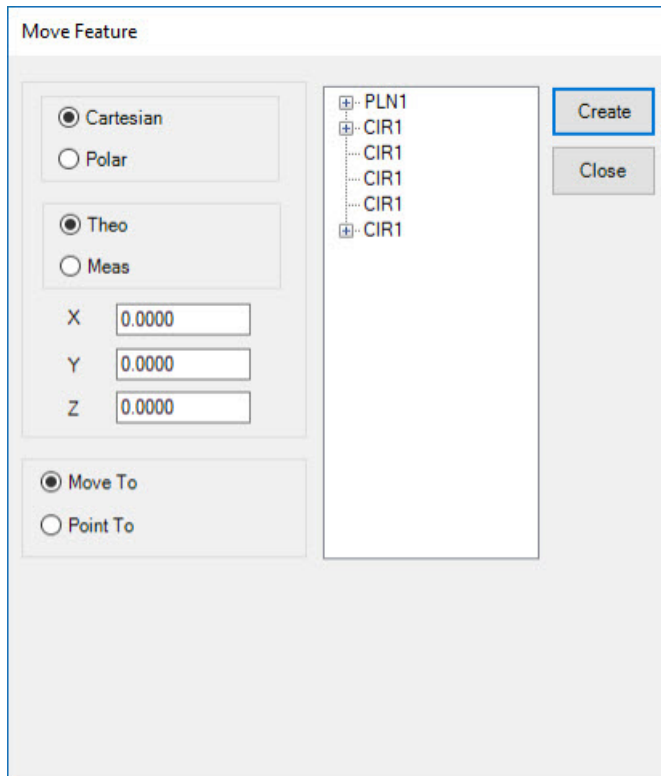
4. Select the 'Missed Probe Hit' **Error Type** and the **Skip Command** option.
5. Insert points for each mounted reflector. To insert each point into your measurement routine:
 - a. Aim the tracker at the reflector.
 - b. Press Ctrl+H to take a hit.
 - c. Press the End key on your keyboard.
6. Execute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

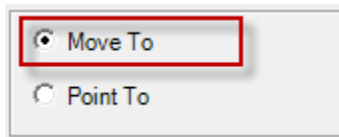


Move Feature dialog box

The **Move Feature** dialog box is available when you use either a Leica Tracker or a Leica Total Station device. PC-DMIS displays the dialog box 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 the location of out-of-tolerance points directly on the part.

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 that location.

- **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 want to move to from 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.

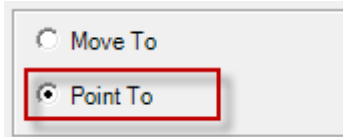
Once you define the command, click **Create** to insert the command into the Edit window.

```
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 the command, the device automatically moves to the position and attempts to find a reflector. If the software does not find the reflector, it displays the error "AUT_FineAdjust - Request timed out". If there is a

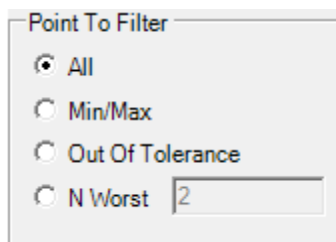
nearby reflector, you can use the **Execution Options** dialog box to stop the execution, adjust the location to point nearer the reflector, and then click **Continue**. If a reflector is not close by, click **Skip** to move to the next point.

Point To



To point to different hits, the procedure is the same as the "Move To" description above with 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. The software points to all of the visible hits in the dimension, although you can use the **Point to Filter** area to filter hits.

Point To Filter



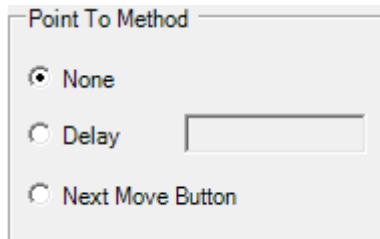
The **Point To Filter** area displays options that control which hits PC-DMIS points to. The options include:

- **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. These are

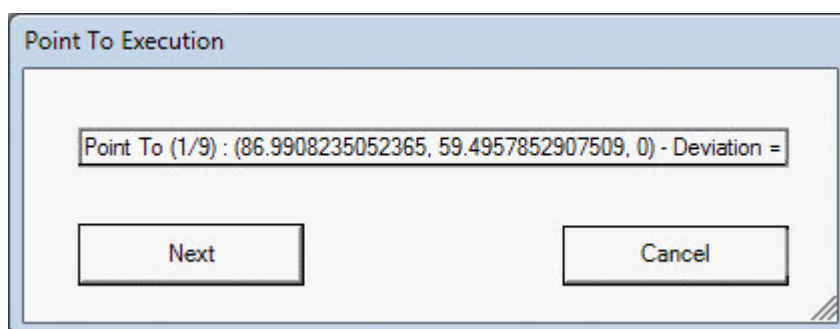
the points that PC-DMIS directs the laser beam to. For example, if you select **Min/Max**, the list of hits in the selected dimension updates with only two hits in the list. These represent the min and the max points for that dimension. If you choose **All**, the list updates and displays all of the 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** - This option cycles through each of the points without delay as soon as the device can physically proceed to the next point. Also, this option does not require any user input to move onto the next point.
- **Delay** - This option 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 the software cycles through all of the points in the list.
- **Next Move Button** - During execution, the software displays a **Point To Execution** dialog box and shows the index of the point in the list and its location.



The dialog box has **Next** and **Cancel** buttons. These buttons allow you to control when to cycle to the next point in the list. The device moves to the first point, turns on the laser, and then waits until you click **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 `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 in the **USER_Option** section of the PC-DMIS Settings Editor.

T-Probe Button Assignments



T-Probe Buttons

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

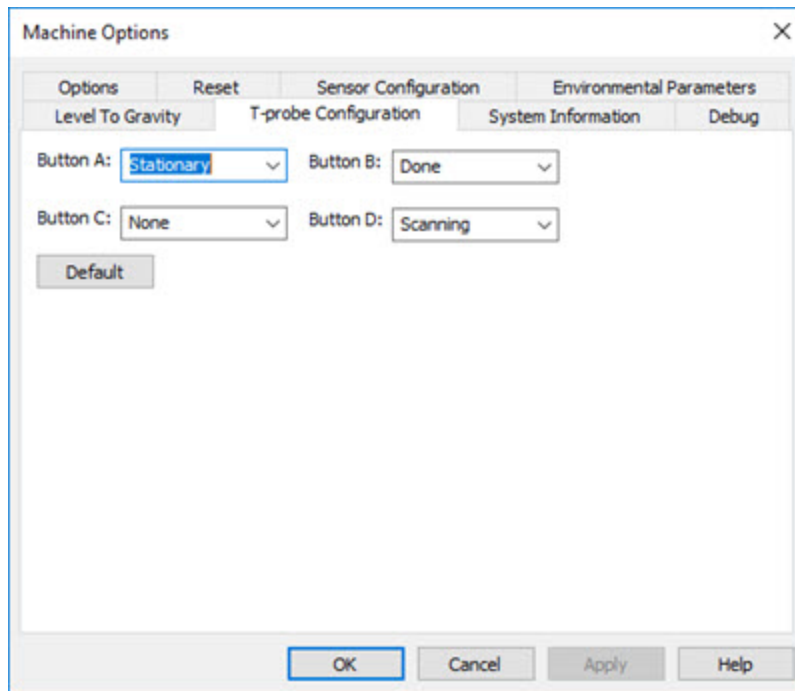
- **Press for less than 1 second** - Measures a regular stationary point (duration as defined on the "[Options tab](#)"). The shank of the stylus determines the probing direction.
 - **Press for greater than 1 second** - Measures a regular stationary point as a "Pulled Hit". To change the vector for the measured point, you can press this button and hold it while you move it 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
 - **Press for less than 1 second** - Ends Feature
 - **Press for greater than 1 second** - Displays the 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

Button assignments can be set in one of these ways:

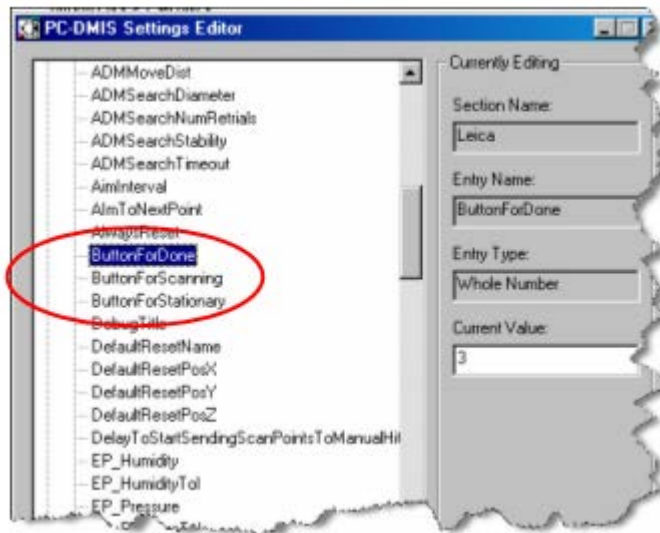
- A. You can change the default button assignments of the T-Probe from the **Machine Options** dialog box (**Edit | Preferences | Machine Interface Setup**).

Select the **T-probe Configuration** tab and edit the options for the individual buttons.



Changes to the button configurations from this dialog box define the values for the corresponding PC-DMIS Settings Editor registry entries described below.

- B. You can also 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.



For details on how to edit registry entries, see the "Modifying Registry Entries: Introduction" chapter in the PC-DMIS Settings Editor documentation.

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.

Before you use the B-Probe with the AT402 Tracker, make sure that 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.

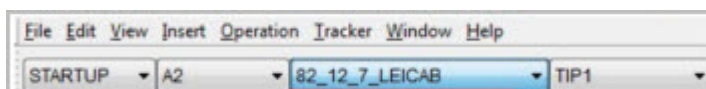
Before measurement can take place, the B-Probe status indicator LEDs must be solid green. When the LEDs are orange or blinking orange, you need to replace the batteries.



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. To do this, click 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. (This probe does not support scans).



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 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 it.
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.

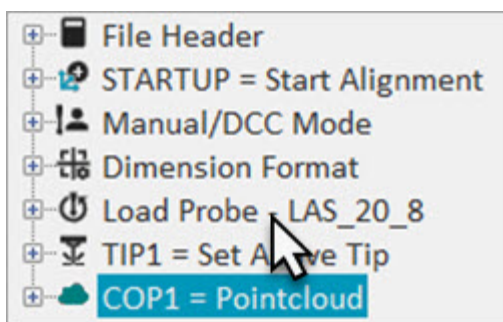
IJK Behavior on B-Probe Points

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.

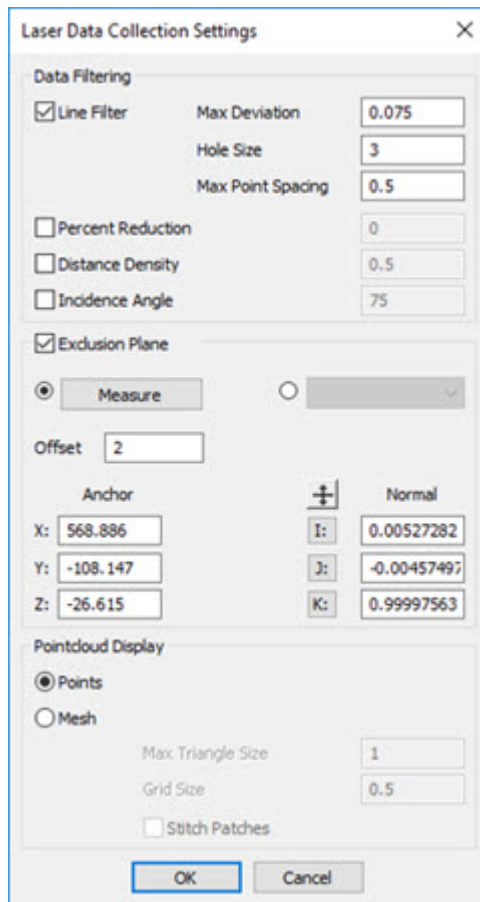


2. From the RDS Control Panel, enter the LAS scanner settings. You can also double-click the LAS scanner button to advance to the next RDS scanning profile.

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.




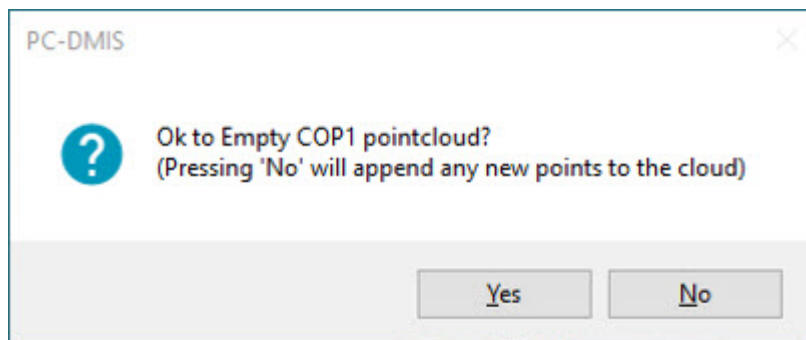
All pointcloud functions (for example: Pointcloud Alignments, Colormaps, etc.) are available when using the LAS scanner.

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

Re-executing the Scan (Ctrl + Q)

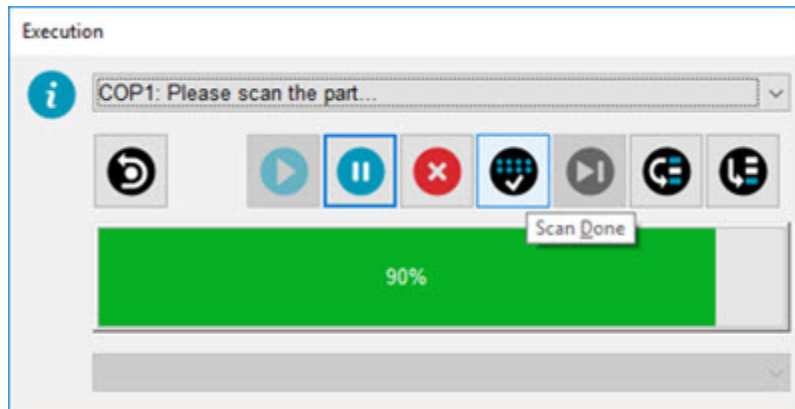
To re-execute the measurement routine:

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.



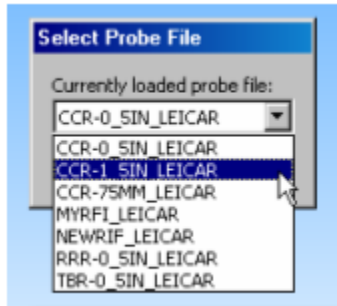
Execution dialog box when hovering over the Scan Done button

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.



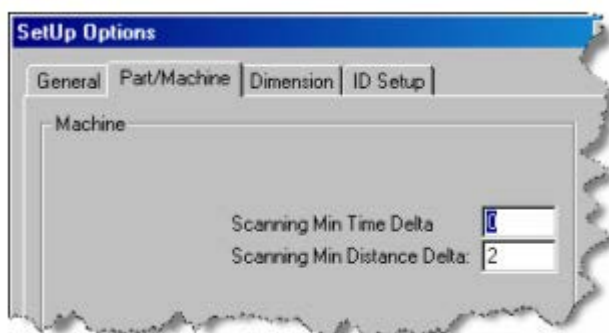
Probe compensation and offset direction

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 these 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 you use a portlock, insert it into your computer and run the PC-DMIS setup program. Your LMS 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 LMS 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 LMS 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, in the status bar, 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 - This option displays the **Station Manager** dialog box for the Total Station. For details, see the "[Adding and Removing Stations](#)" topic.

Go 0 Position - This option moves the **Total Station** to the zero position.

Change Face - This option rotates the Total Station head and camera by 180 degrees. The final target position is the same as it was before PC-DMIS issued the command, except that now the software inverts the optics.

Find - This option 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 option attempts to locate a target either within a user-defined window if you enabled Power Search Window, or a 360-degree search if it is not.

Probe Modes - The items in this submenu control how PC-DMIS takes measurements 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. You can set this on the **Instrument Options** tab of the [Machine Options](#) dialog box.
- **Stable Probing** - Use this mode when you track 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 option 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 you need to reference all measurements off of ground level.

Availability - All target types.

Laser Pointer ON/OFF - This option 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 so that you can issue a Find command to locate and lock-on to the target. Your system must support lock-in (see "Lock-in ON/OFF" below) for that target type. You can also use this option in conjunction with the Point To command to locate points that PC-DMIS identifies by a filter applied to the measurement results (see "Move To Point To" above).

Availability - All target types.

ATR ON/OFF - This option 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 this option is on, the Total Station tracks the movement of the target. This allows you 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. Use this in conjunction with ATR mode. When the Lock-in option is on, PC-DMIS automatically sets ATR to on as well. This works well with the stable probing measurement mode (see "Stable Probing" above).

Availability - Prism target types only.

Power Search Window ON/OFF - Power Search is the ability of a Total Station to recognize targets within the field-of-view (FOV) of its optics. The Power Search window is a user-specified window or region that defines where the Total Station should search for a target. You can set the window's boundaries from 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 option enables or disables the flashing target illumination light. You can use this light to help locate a target while you look through the telescope. The light flashes alternately between red and yellow. When you look through the telescope, you can easily see the targets because of the light reflected to the telescope. When the Total Station loses its lock on a prism, the default action of the machine is to perform a Power Search to try and relocate the prism. If PC-DMIS cannot find a prism, turn on the Target Illumination light.

Availability - All target types.

Probe Compensation ON/OFF - This option enables or disables the probe compensation. When the probe compensation is "on", PC-DMIS compensates by the radius of the probe tip or the reflector sphere. During bundle alignment creation, PC-DMIS automatically activates or deactivates probe compensation as needed when you measure points. See "[Total Station Probe Compensation](#)" for more information on probe compensation.

Live Readout ON/OFF - This option 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, PC-DMIS provides the Live Readout mode if you want to track the location of the target in real time. You can use this in conjunction with Lock-in, and PC-DMIS automatically enables the Lock-in mode if it is not already enabled. If you enable Live Readout and take a measurement, you will notice that the readout update on the DRO pauses. This happens because of the momentary change in the measurement mode to get a precise measurement. The software then switches back to Live Readout mode.

Availability - Prism target types only.

Insert Total Station Command - When you enable this option, 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 option points the total station at a specified feature, or at a hit or hits within a feature. You can also use certain dimensions 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 workplane.
- 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

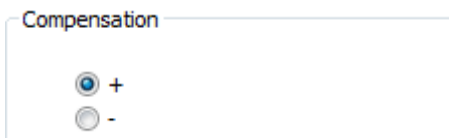
For this device, the **Compensation** area shows a **Predefined** check box and **In** and **Out** options.

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 radio button with a blue dot in the center, followed by a plus sign (+). The second option is a radio button with a grey dot in the center, 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

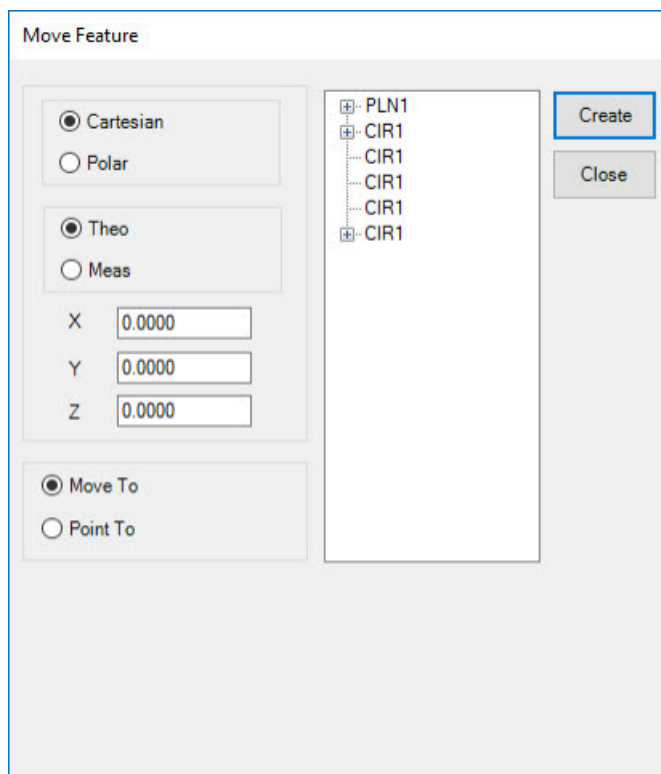
☒ IN ☒ Toward

☐ 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)



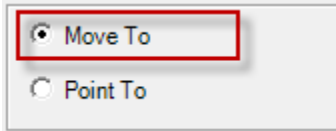
Move Feature dialog box

The **Move Feature** dialog box is available when you use either a Leica Tracker or a Leica Total Station device. PC-DMIS displays the dialog box 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 the location of out-of-tolerance points directly on the part.

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 that location.

- **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 want to move to from 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.

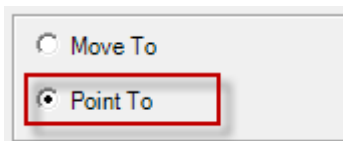
To move to the measured or theoretical value for the point, choose either the **Theo** or **Meas** option.

Once you define the command, 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,
```

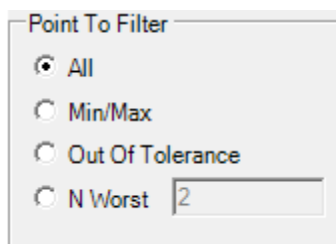
When PC-DMIS executes the command, the device automatically moves to the position and attempts to find a reflector. If the software does not find the reflector, it displays the error "AUT_FineAdjust - Request timed out". If there is a nearby reflector, you can use the **Execution Options** dialog box to 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 to the next point.

Point To



To point to different hits, the procedure is the same as the "Move To" description above with 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. The software points to all of the visible hits in the dimension, although you can use the **Point to Filter** area to filter hits.

Point To Filter

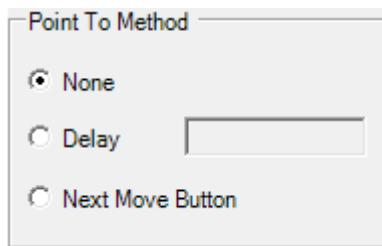


The **Point To Filter** area displays options that control which hits PC-DMIS points to. The options include:

- **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.

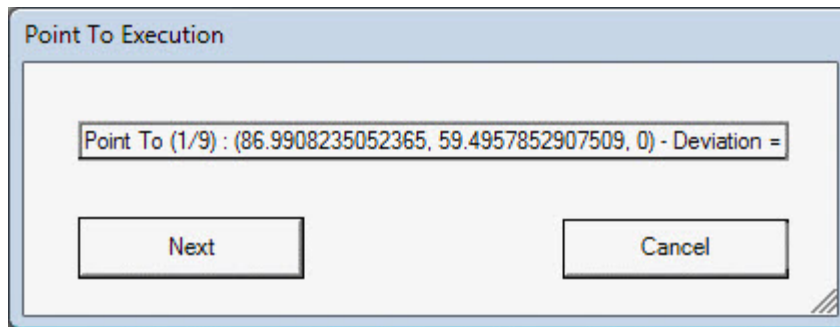
When you choose one of the options in the **Point To Filter** area, PC-DMIS updates the list of hits for the selected dimension in the dialog box. These are the points that PC-DMIS directs the laser beam to. For example, if you select **Min/Max**, the list of hits in the selected dimension updates with only two hits in the list. These 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** - This option cycles through each of the points without delay as soon as the device can physically proceed to the next point. Also, this option does not require any user input to move onto the next point.
- **Delay** - This option 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 the software cycles through all of the points in the list.
- **Next Move Button** - During execution, the software displays a **Point To Execution** dialog box and shows the index of the point in the list and its location.



The dialog box has **Next** and **Cancel** buttons. These buttons allow you to control when to cycle to the next point in the list. The device moves to the first point, turns on the laser, and then waits until you click **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.

Using a MoveInspect System

This section discusses the configuration and general usage of your MoveInspect system with PC-DMIS. Refer to your MoveInspect documentation for more information.

The following topics discuss how to use your MoveInspect system with PC-DMIS:

- [Introduction to MoveInspect](#)
- [MoveInspect User Interface](#)

- [Working with the MI.Probe](#)
- [Measuring with the MI.Probe](#)
- [Continuous Scanning with the MI.Probe](#)

Introduction to MoveInspect

The MoveInspect system has two cameras which allow you to probe the part through optical tracking. You measure parts with the hand-held MI.Probe device.

To use the MoveInspect system with PC-DMIS, you must have the MoveInspect interface option programmed into your license or portlock.

Before you start PC-DMIS:

- Make sure you have the MoveInspect cameras connected to the SyncBox.
- You must connect the MoveInspect system to the MoveInspect Pilot software.
- You must connect the MI.probe to the computer via Bluetooth or USB.

Refer to the MoveInspect topics below for more information.

MoveInspect User Interface

The MoveInspect interface consists of these components:

- [MoveInspect Menu](#)
- [MoveInspect Toolbar](#)

MoveInspect Menu

From the menu, click **MoveInspect** to access these MoveInspect options:

Measurement Mode list - Currently, the only option available is **Probing**.



Live Mode (On/Off) - This button toggles Live Mode On and Off.

When **Live Mode** is On, the software captures snapshots of the measurements from a continuous data stream. This means that PC-DMIS displays the probe data “live” (real-time) in the Graphic Display and Probe Readout windows. This corresponds to the MoveInspect Pilot Trigger Continuous Mode.

When **Live Mode** is Off, PC-DMIS takes a measurement as a single snapshot. PC-DMIS does not update the Graphic Display and the Probe Readout windows. This corresponds to the MoveInspect Pilot Trigger Single Mode.

MoveInspect Toolbar



The **MoveInspect** toolbar consists of these options:

Measurement Mode list - Currently, the only option available is **Probing**.



Live Mode (On/Off) - This button toggles Live Mode On and Off.

When **Live Mode** is On, the software captures snapshots of the measurements from a continuous data stream. This means that PC-DMIS displays the probe data “live” (real-time) in the Graphic Display and Probe Readout windows. This corresponds to the MoveInspect Pilot Trigger Continuous Mode.

When **Live Mode** is Off, PC-DMIS takes a measurement as a single snapshot. PC-DMIS does not update the Graphic Display and the Probe Readout windows. This corresponds to the MoveInspect Pilot Trigger Single Mode.

You can also access the **Measurement Mode** list and the **Live Mode** button from the **MoveInspect** menu.



Take Hit - When you click this button, the software takes a hit. The keyboard shortcut Ctrl+H also performs this action. You can also take hits with the MI.Probe Trigger button.



Erase Hit - When you click this button, the software deletes the last hit. The keyboard shortcut Alt + - (minus) also performs this action. You can also erase hits with the MI.Probe Left Thumb button.



End Feature button - When you click this button, the software ends the feature measurement. You can use the keyboard End key to perform this action. You can also end the feature with the MI.Probe Right Thumb button.

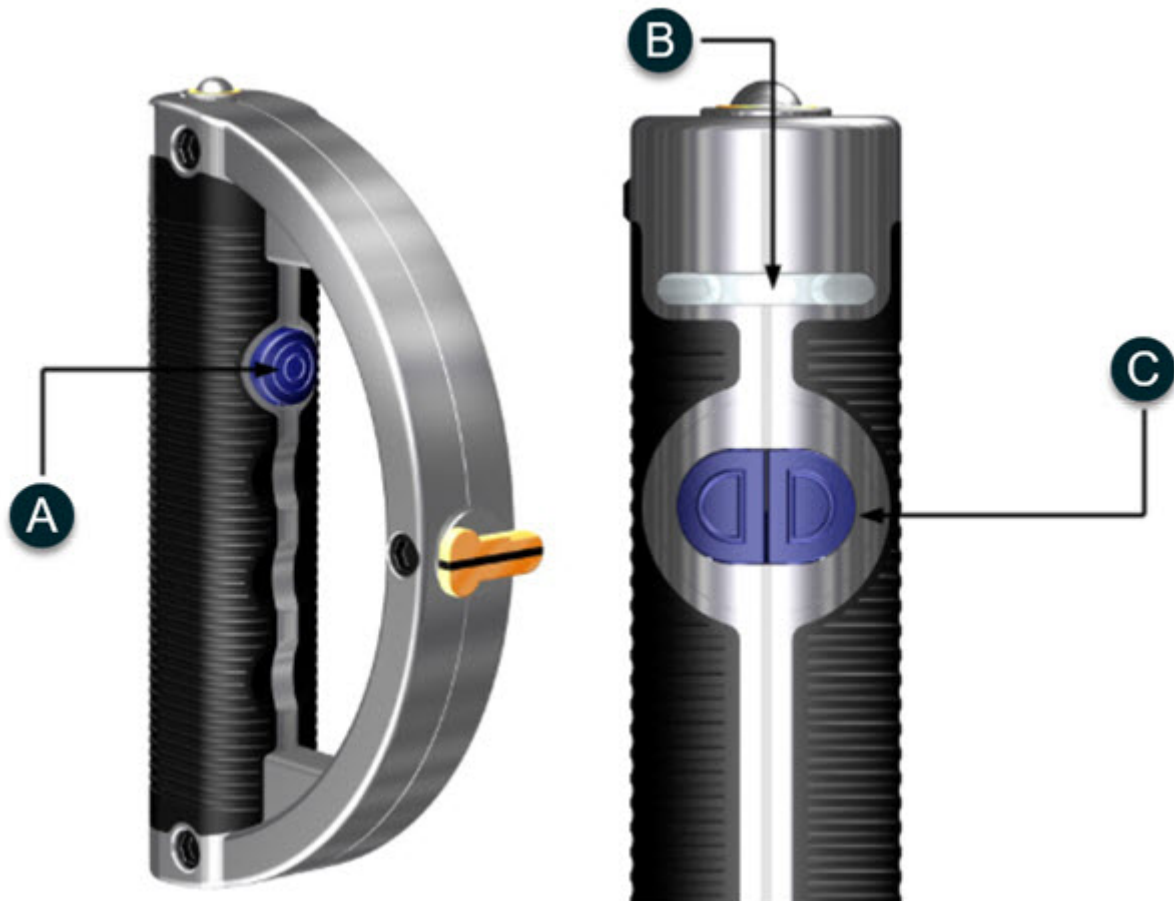
For details on all the MI.Probe button assignments, see "[MI.Probe Button Assignments](#)".



You can also find the **Take Hit**, **Erase Hit**, and **End Feature** functions under the **Operation** menu. For details, see "[MoveInspect Menu](#)".

Working with the MI.Probe

MI.Probe Button Assignments



A - Trigger button

B - LED display

C - Thumb buttons

MI.Probe details

Button	Action	Function
Trigger button	Press	Triggers a single measurement, starts and stops

		scanning.
Left Thumb button	Press less than one second	Deletes the last probed point.
Left Thumb button	Press longer than one second	No action.
Right Thumb button	Press less than one second	Finishes geometry measurements (for example, when completing the last probed point for a plane measurement).
Right Thumb button	Press longer than one second	Switches between Single and Scan modes.
Right and Left Thumb button	Press simultaneously	Activates the unit when in Sleep mode.
Trigger button	Press for six seconds until middle LED turns off, then let go and press until middle LED turns on.	Reboots the unit.
Trigger button	Press and hold for six seconds until the middle LED turns off.	Switches the unit off if it is on.
Trigger button	Press and hold for two seconds until the middle LED turns on.	Switches the unit on if it is off.

MI.Probe LED Display

LED	Color	Status
Left	Red	The last measurement was

		not successful.
Left	Green	The last measurement was successful.
Left	Red and Green	-
Left	Off	The probe is not ready for measuring.
Middle	Blue	The probe is active and the Bluetooth serial communication is established.
Middle	Red	The probe is active but there is no Bluetooth serial communication.
Middle	Blue and Red (one is flashing)	The battery is low.
Middle	Off	The probe is switched off or is in Standby mode.
Right	White	Scan mode is active but scanning has not started.
Right	Red	-
Right	White and Red	Scan mode is active and scanning is in progress.
Right	Off	Single mode is active.

Measuring with the MI.Probe

To measure with the MI.Probe:

1. Ensure you have the required probe tip attached and you have the MI.Probe turned on. For details on how to determine the status of the MI.Probe, see the "[MI.Probe LED Display](#)" area of the "[Working with the MI.Probe](#)" topic.

When the **AICON MoveInspect Pilot** window displays your probe that means that the system recognizes it.



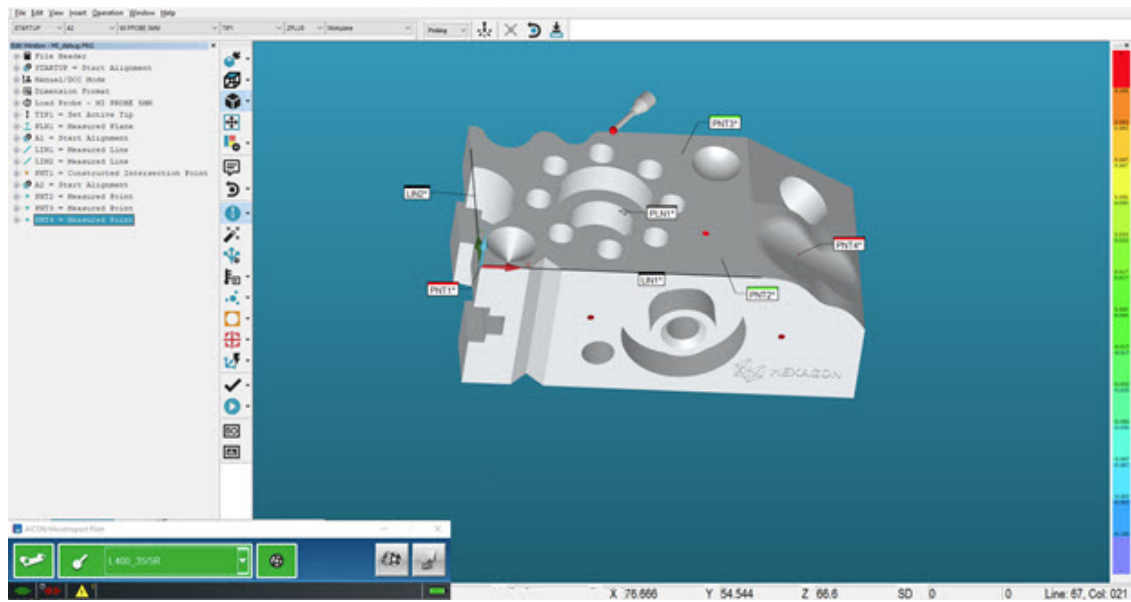
Aicon MoveInspect Pilot window example

PC-DMIS automatically detects the MI.Probe and probe tip diameter. You can see the MI.Probe tip on the **Settings** toolbar (**View | Toolbars**) and in the Graphic Display window.

If the MoveInspect system does not detect the machine within a specified time, PC-DMIS displays a timeout error message that says "Machine not responding".

You can change the timeout value with the `ConnectionTimeoutInSeconds` registry entry. For details, see "ConnectionTimeoutInSeconds" in the PC-DMIS Settings Editor documentation.

2. Position the probe at the measurement location.
3. Take a hit or execute a scan. For details on how to measure with the MI.Probe and the probe's button assignments, see the "[MI.Probe Button Assignments](#)" area of the "[Working with the MI.Probe](#)" topic.



Example of a completed MoveInspect measurement

Continuous Scanning with the MI.Probe

To use continuous scanning with the MI.Probe:

1. Before you begin to measure a feature (Circle, Plane or Scan feature), press and hold the Right Thumb button on the MI.Probe for more than one second.

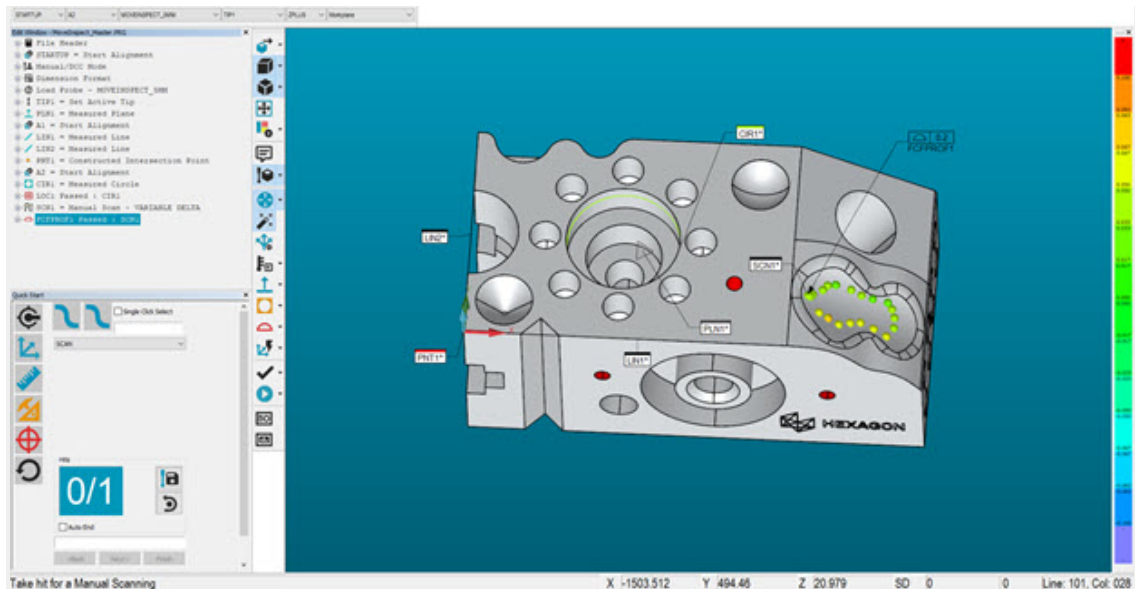
For details on the MI.Probe button assignments, see "[MI.Probe Button Assignments](#)" in the "[Working with the MI.Probe](#)" topic.

2. Position the probe on the part or feature.
3. Press the MI.Probe Trigger button to begin the scan. When you are done with the scan, press the Trigger button again.
4. Press the right Thumb button to end the feature.
5. Press the right Thumb button again for more than one second to exit scan mode.



Description of performing a continuous scan with the MI.Probe:

- In the example below, the part is aligned with the CAD model and the alignment features were measured.



Example of an MI.Probe continuous scan measurement routine

- The **Find nominals from CAD** was turned on from the **Probe Mode** toolbar (**View | Toolbars | Probe Mode**) with the **Features Use Dimension Colors** enabled.

For details on the **Find nominals from CAD** option, see "Probe Mode Toolbar" in the PC-DMIS Core documentation.

For details on the **Features Use Dimension Colors** option, see "Features Use Dimension Colors" in the PC-DMIS Core documentation.

- A contact scan was selected from the QuickStart window.
- Continuous scanning was enabled from the MI.Probe and a manual scan was measured. The measured points are colored based on their deviations from the CAD model.

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

You can create various alignments with the Quick Start interface for 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.



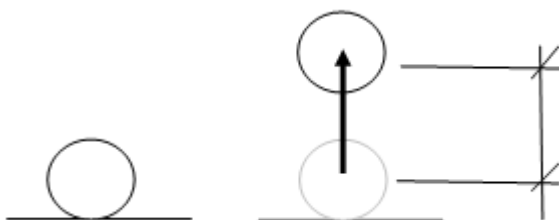
Quick Start showing Plane-Line-Point Alignment

3. 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.

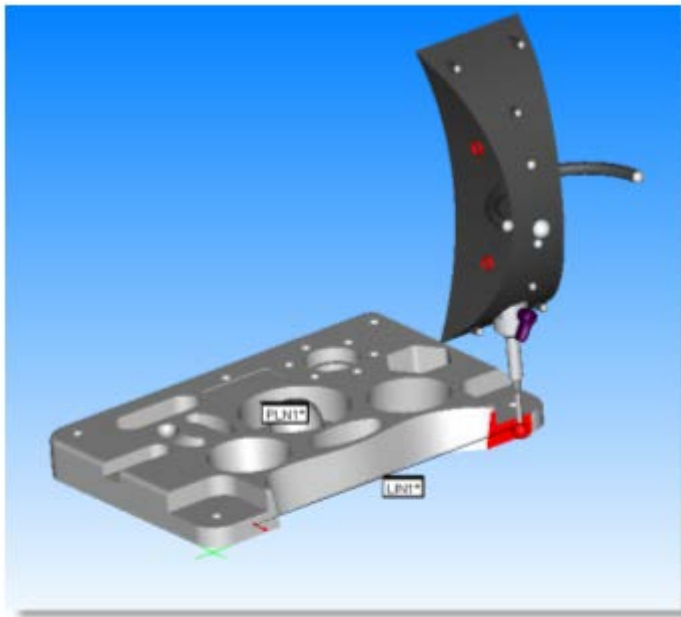
Take Hit (Ctrl + H) stores the current stationary measurement internally. After moving the vector distance, PC-DMIS calculates the IJK vector between the first and second point and compensates the offset of the resulting point accordingly.



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 software completes the measurement routine, execute it by pressing Ctrl + Q, or select 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

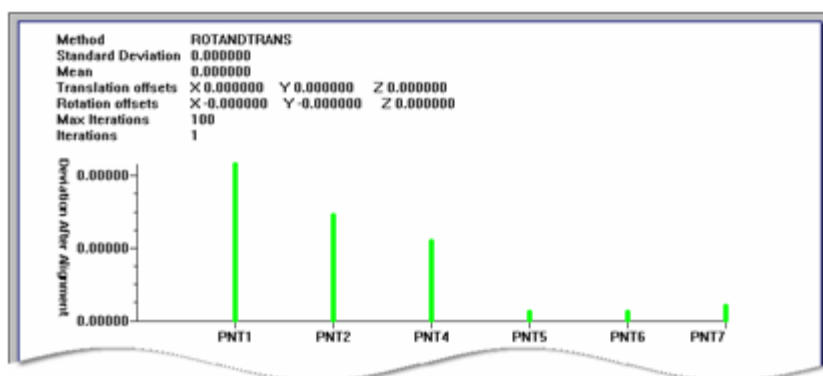
It is also possible to create an alignment offline using features that were previously measured. To do this, select the features from the Edit window instead of measuring them from the Quick Start interface.

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 the nominal point data. For more information, see ["Importing Nominal Data"](#).



If you use nominal data for Leica Reflector offsets and supports, ensure 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. To execute it, press Ctrl + Q, or select the **File | Execute** menu item.

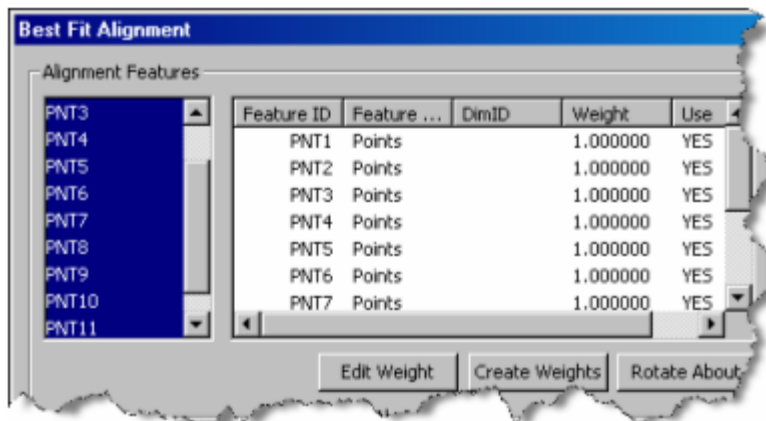
The **Execution** dialog box opens and guides you through the remaining measurements. You can skip points if needed. When PC-DMIS completes all measurements, the dialog box closes. For information on this dialog box, see "Using the Execution Dialog Box" topic in the "Using Advanced File Options" chapter in the PC-DMIS Core documentation.

3. Insert a Best Fit alignment. To do this, select **Alignments | Align Free** from the **Quick Start** interface, or select the **Insert | Alignment | New** menu item. The **Alignment Utilities** dialog box opens.



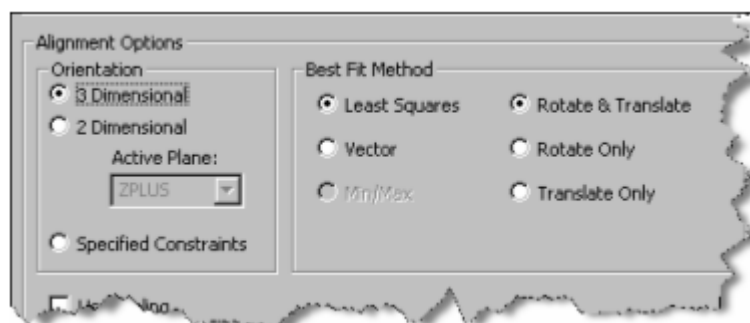
The **Alignment Utilities** dialog box provides the most flexible way to create alignments, but it requires some experience.

4. Click **Best Fit**.
5. Select all of the features that should be used in the Best Fit alignment.



Best Fit Alignment dialog box - Selecting features

6. Exclude nominals for axes of selected input features for which theoretical values are not known. To do this, select "NO" under the axis column that should be excluded. This is useful when you only know the theoretical values for one or two of the axes rather than all three.
7. Ensure that the correct options are set. In this example, PC-DMIS creates a Least Squares 3D alignment. By default, the **3 Dimensional** orientation option is selected for trackers.



Best Fit Alignment dialog box - alignment options

8. Click **OK** to compute the Best Fit alignment and insert the command into the measurement routine. The overall results of the transformation appear 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 the results of each input both 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.

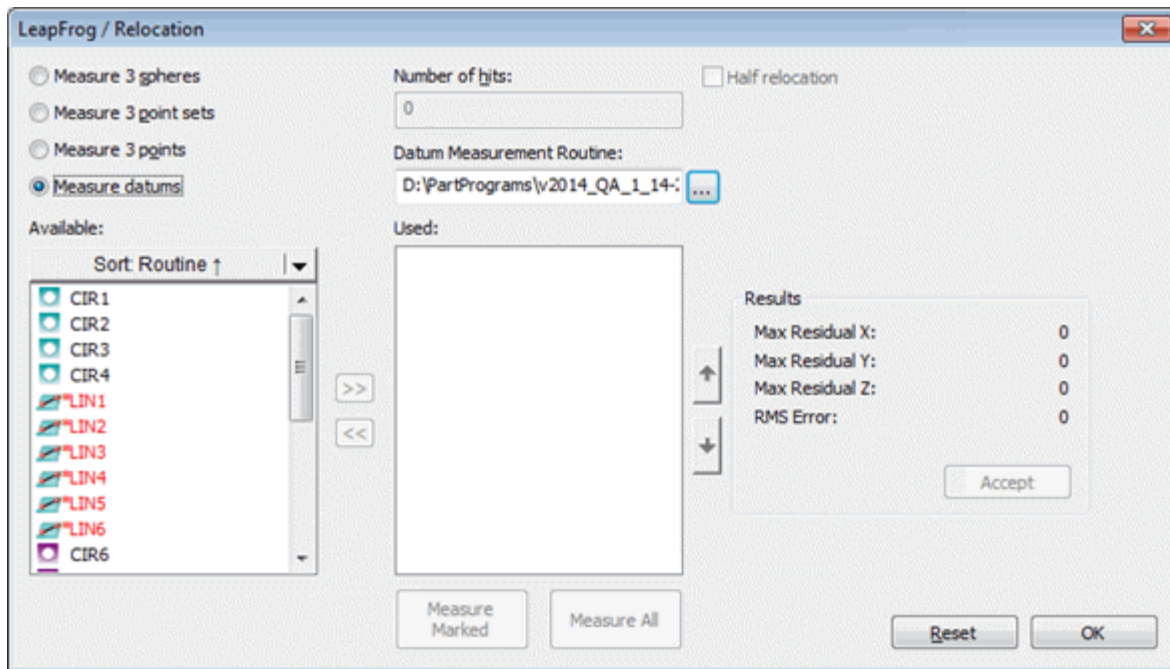
The basis for Leapfrog is to measure a series of features, and then after moving the machine, remeasure the same features in the same order. This creates a transformation and makes the machine behave as if it were the same coordinate system before the move.

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 LMS license or 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)

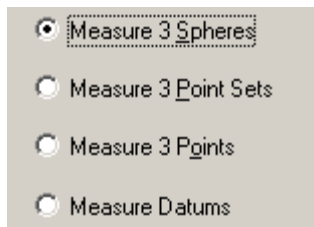
There is also an OFF value for this parameter, in which case the other two parameters do not appear. The OFF value turns off Leapfrog translation

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

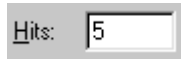


The measure options allow you to select what method PC-DMIS will use to perform the translation comparison.

- 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.

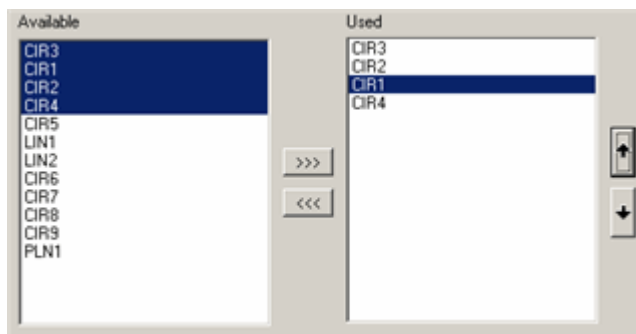
Datum Measurement Routine

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** 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.

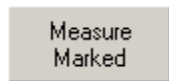
Available List

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

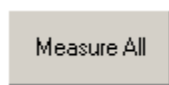
Assigned features that appear in the **Used** list are measured when you click the **Measure Marked** or **Measure All** buttons in the order that they appear in the **Used** list. You can remove them from the **Used** list by clicking the <<< button. You can change a feature's order of execution by 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 opens the **Execution** dialog box.

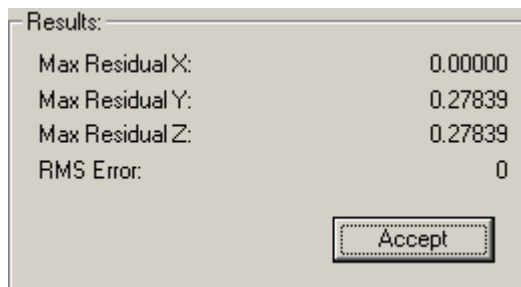
- If you are using **Measure 3 Spheres**, **Measure 3 Point Sets**, or **Measure 3 Points**, then this dialog box first prompts you to measure the three features before it prompts you to move the CMM. After moving the machine, it prompts you to remeasure the same features in the same order.
- If you 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.

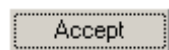
Results Area



Results area

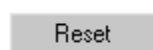
The **Results** area shows the deviations between the machine's first position and its subsequent position(s) by displaying the 3D distance between the features taken before the move and after the move of the CMM.

Accept

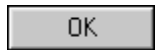


Once you have filled out the **Leapfrog / Relocation** dialog box, you must click the **Accept** button from the **Results** area before the leapfrog transformation will be used. Click **Accept** to add the **LEAPFROG** command to the measurement routine. If you don't click the **Accept** button but 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

You can use bundle alignments for large or complex measurements to create multiple stations in a common network. PC-DMIS does this by moving the same sensor to different positions around the object. As you take measurements from different station positions around the object, the software bundles the measured information into one network. When all stations belong to one network, all measured data is part of the same coordinate system.



You must have Bundle Alignments enabled on your LMS license or portlock to allow this functionality.



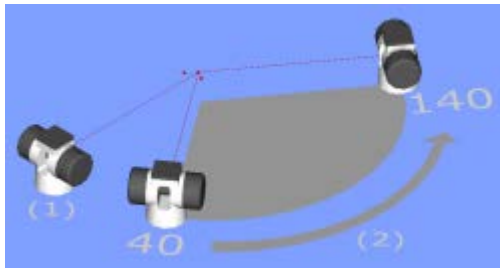
PC-DMIS does not support Leapfrog and Bundle Alignment commands in the same measurement routine.

Before you take any measurements, you must decide to use more than one station well in advance. When you plan for a station location, consider the following points:

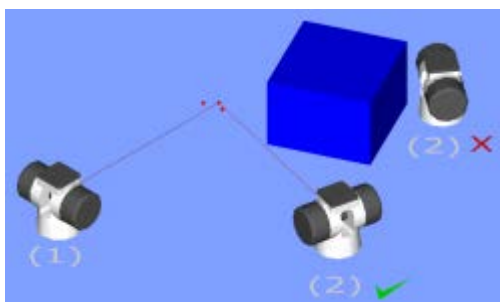
Station Planning Trackers and Total Stations

1. Points used for computing a network should have reasonable intersecting angles (40°-140°). In the example, you should locate station (2)

somewhere between the 40° and 140° angles in relation to the representative line between station (1) and the common measured points.



- 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, whereas station (2) with a red X does not work, because the line of sight to the common features is blocked.



- The object points and the common points used for the network calculation must remain stable for the whole measuring process.
- Avoid station locations that do not vary significantly in position from 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 or multiple trackers that you move to different stations. A station is defined as a location where you position a tracker.

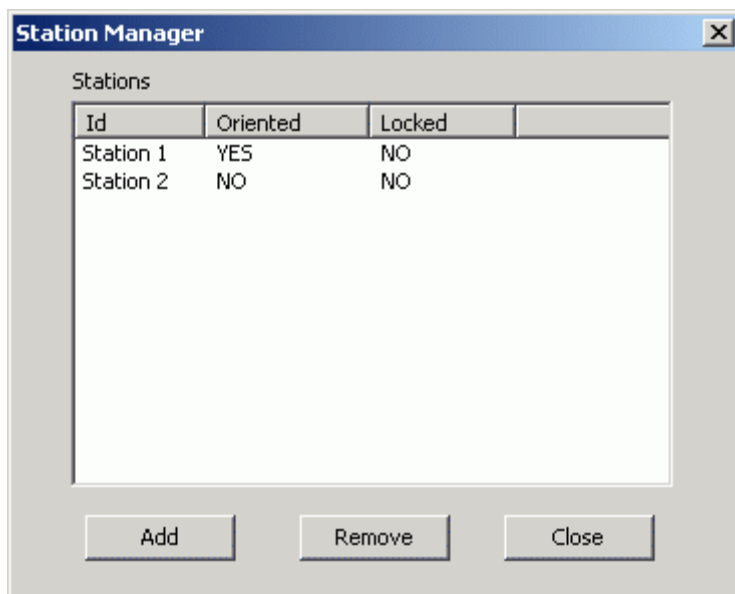
Creating Bundle Alignments

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

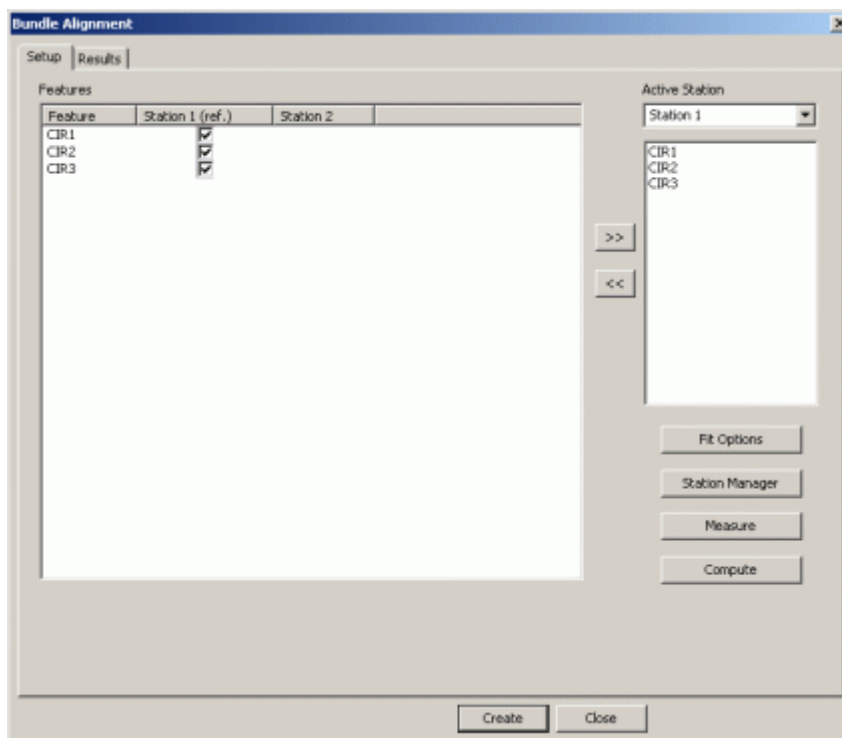
- **Add** - Adds a new station to the **Stations** list in the measurement routine.
- **Remove** - Removes a selected station from the **Stations** list and from the measurement routine.

- **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. PC-DMIS allows up to 99 stations 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 adds 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			

Warnings

Solution Status: OK

RMS Error: 0

Variance: 0

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.

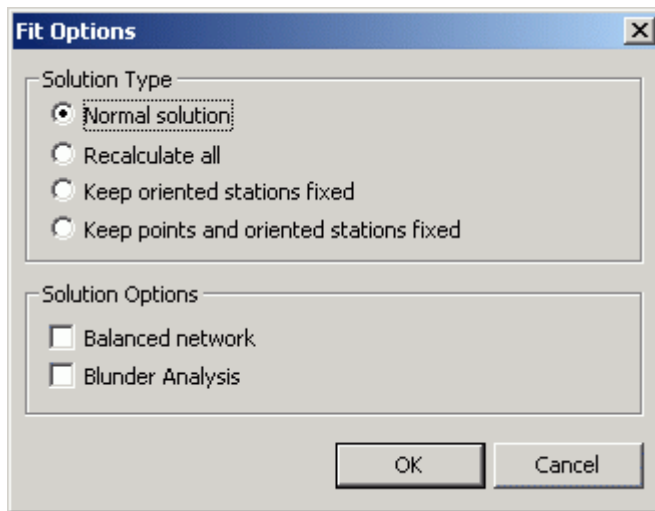
RMS Error - The total RMS error of ALL of the "Bundle Alignment Features".

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) are used. Select from the following options to determine how to calculate the Bundle Alignment solution:

- **Normal Solution:** This option 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 option recomputes the orientation of "Bundle Alignment Features" and stations. It also disregards current orientation of stations and common "Bundle Alignment Features".
- **Keep oriented stations fixed:** Previously oriented stations remain unchanged and only the last station is 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" remain fixed.
- **Balanced network:** This check box balances the system so that a single station is not constrained to be the origin.
- **Blunder Analysis:** This check box 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

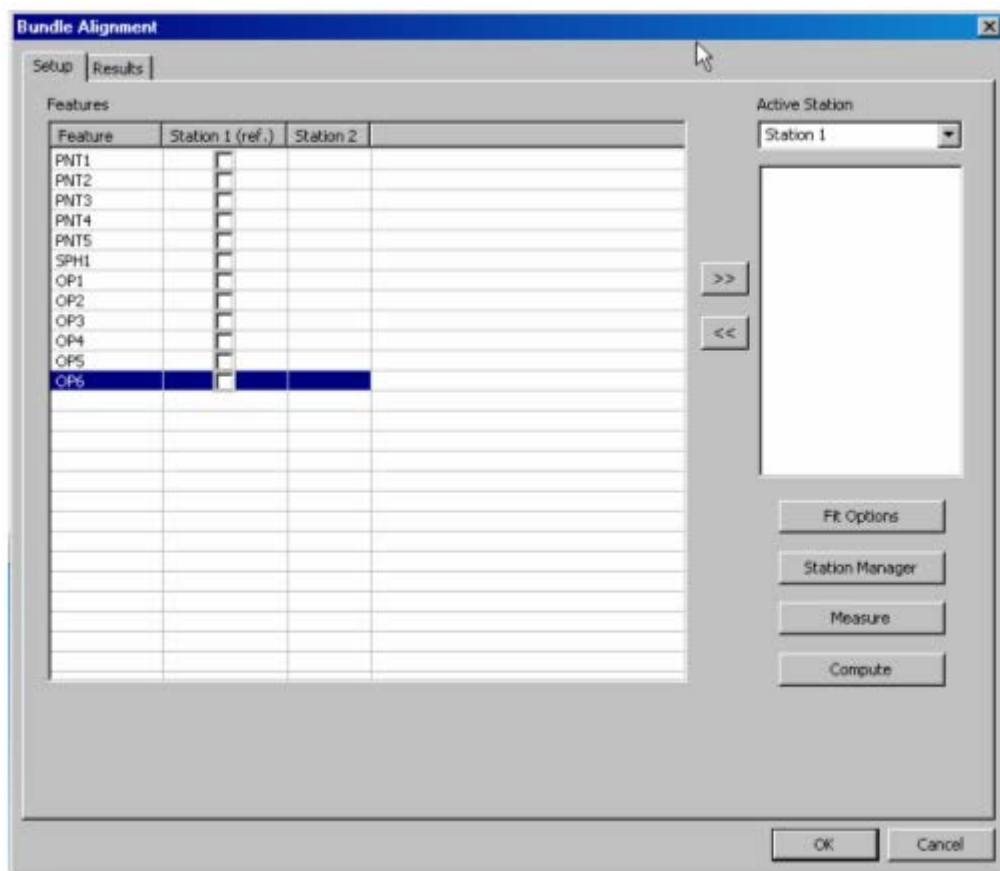
To move to a new Bundle Alignment station:

1. Measure all the features that you can measure from the first tracker position.
2. Create new station in one of these ways:
 - Select the **Tracker | Station Management** menu item.
 - Click in the station name of the [Tracker status bar](#).
3. Click **Add** to add a new station to the **Stations** list and then click **Close**.




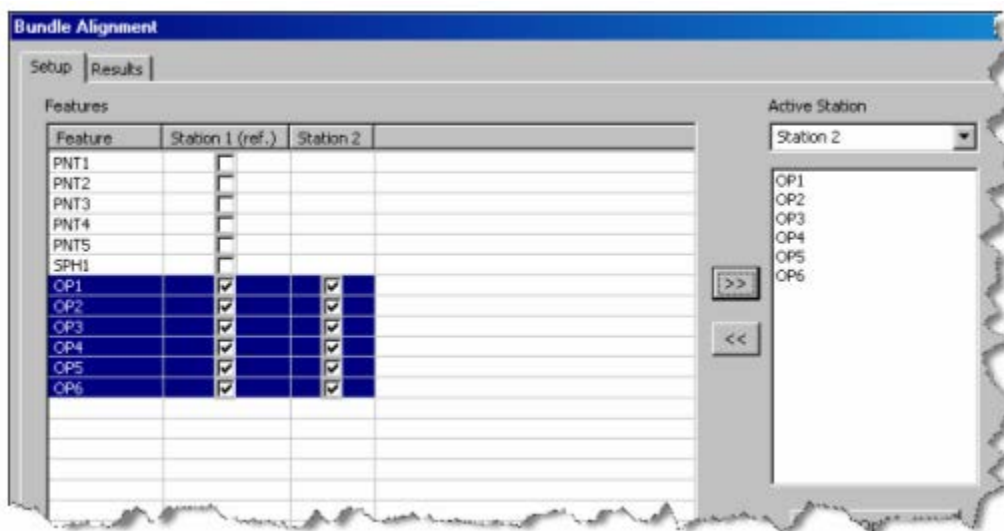
If you use points, make sure that the probe compensation has been turned off before you insert a bundle alignment command.

4. 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

5. Select the next station that you created in step 3 to where the tracker from the **Active Station** combo box is to move.
6. Select the check boxes next to the features in the column of the first tracker position that you want to use for the bundle alignment at the next station position.
7. 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

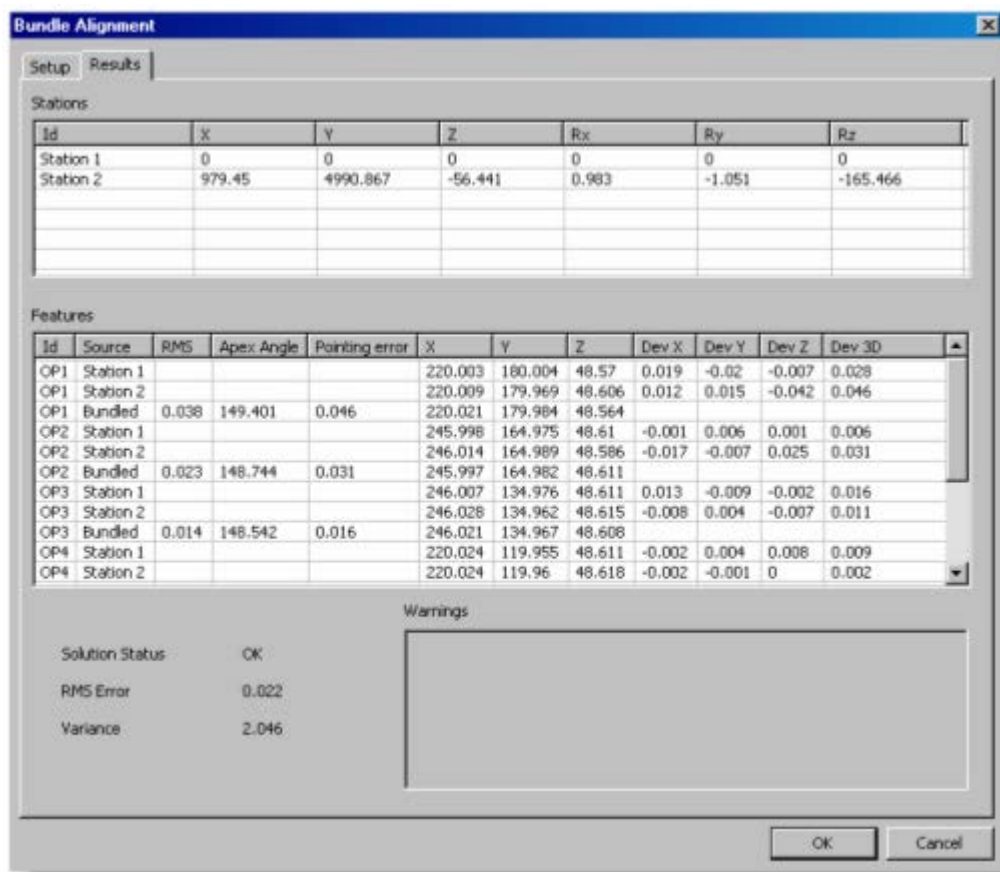
8. Physically move the Tracker station to the new **Active Station** position.
9. Click **Measure** and the **Execution Mode Options** dialog box guides you through the available bundle measurements for the new **Active Station**.



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 the source station, orientation, RMS errors, and variance.



Results tab after measuring features from the new Active Station

11. 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.



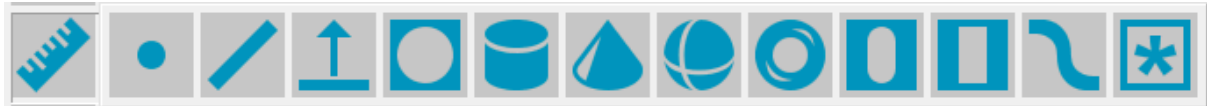
If necessary, you can exclude certain features from the actual bundle computation and recompute it on the **Setup** tab.

12. Complete the previous steps if you are moving to the next station position.

Measuring Features

Measured 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 to add 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.

Auto Features

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.



QuickFeatures provide an alternate way to add auto features without the need to use any dialog boxes. For information, see "Creating QuickFeatures" 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 the Leica TDRA6000 Total Station. 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



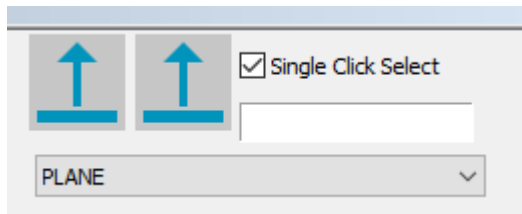
Portable devices can create a measured circle feature by taking only one hit on that feature. This is termed a "single-point" circle. This is useful when attempting to measure a hole with a probe whose sphere size is larger than the hole's diameter and therefore cannot fit entirely into the hole to take the usual required minimum three hits. 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.

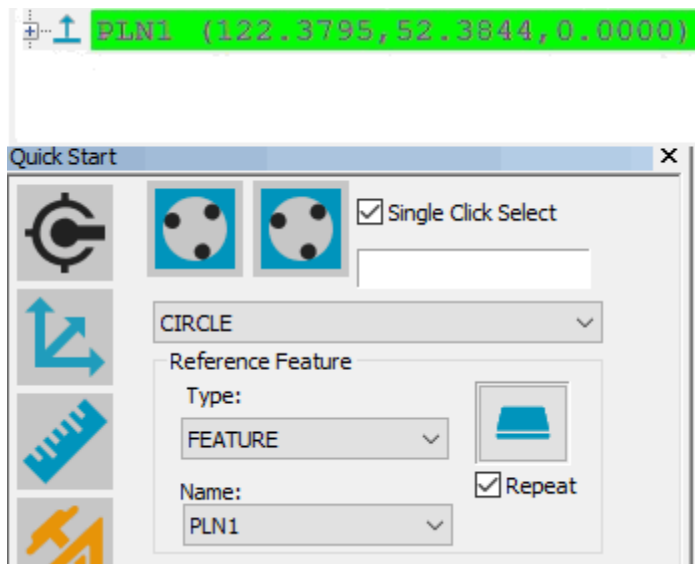
If you choose **No**, the Reference Feature type defaults to "WORKPLANE".

If you choose **Yes**, the Quick Start for Measure Plane mode is displayed to define the appropriate reference feature.



Measure Plane Mode Quick Start dialog box

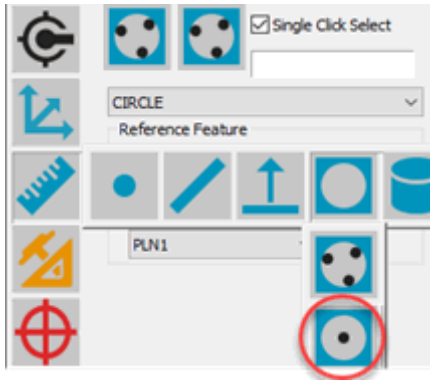
After the plane is done, the **Quick Start** dialog box returns to the Measured Circle mode. PC-DMIS Portable automatically adds the Measured Plane into the reference feature name list, and highlights it in the Edit window.



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 with any other creation method.
2. From the **Measure** toolbar, select the **Measure Single Point Circle** toolbar item.



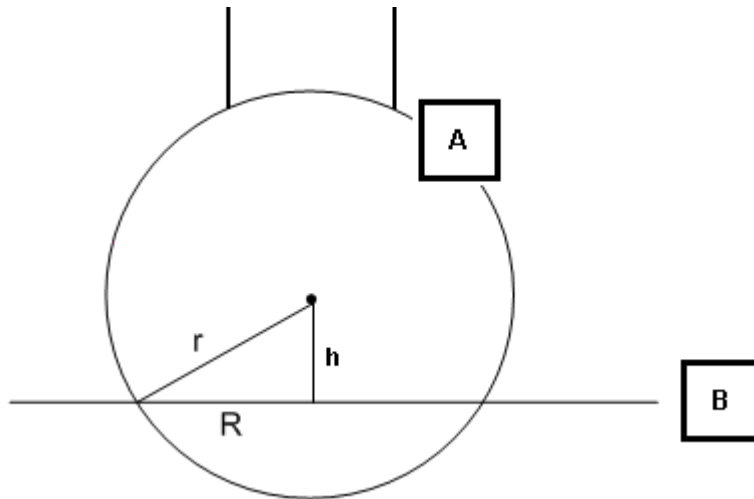
Measure Single Point Circle icon

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 to indicate that the feature has failed. Also, be aware that measuring holes that are much smaller than the diameter of the probe results 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 fails and PC-DMIS does not solve the circle. If the sphere center is below

the workplane (B), PC-DMIS also does 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





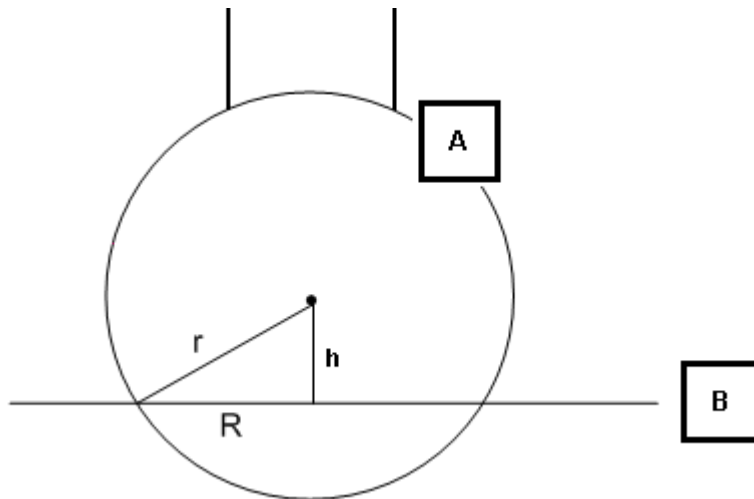
You don't have to use the Quick Start interface. If desired, you can instead click the desired slot feature from the standard **Measured Features** toolbar. However, this topic assumes that you are using the Quick Start interface.

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 devices.

- 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 Arm device 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 a manual device (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. You can do this by specifying the distance the probe must move, and the time that must pass before PC-DMIS can accept additional hits 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.

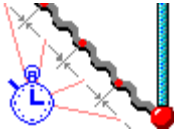
To create a Fixed Time / Distance (Variable Delta) scan:

1. Select the **Insert | Scan | Fixed Time / Distance** menu option to open the **VARIABLE DELTA** dialog box.

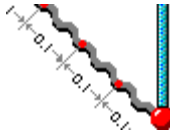


VARIABLE DELTA dialog box

2. Enter 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, enter the time in seconds you want to elapse before PC-DMIS takes a hit.



4. In the **Distance Between Hits** box, enter the distance you want the probe to move before PC-DMIS takes a hit. This is the 3D distance between points. For example, if you enter "5", and the units of measurement are millimeters, the probe must 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, enter 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 opens, 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 accepts 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.



PC-DMIS prompts you 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.

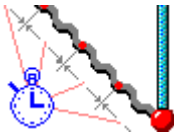
To create a Fixed Time (Time Delta) scan:

1. Select the **Insert | Scan | Fixed Time** menu option to open the **TIME DELTA** dialog box.



TIME DELTA dialog box

- Specify a custom name for the scan in the **ID** box if you don't want to use the default name.



- In the **Time Delay Between Reads** box, type the time in seconds that will need to elapse before PC-DMIS takes a hit.
- 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.
- Set any other dialog box options as needed.
- Click **Create**. PC-DMIS inserts the basic scan.
- 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.
- 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.

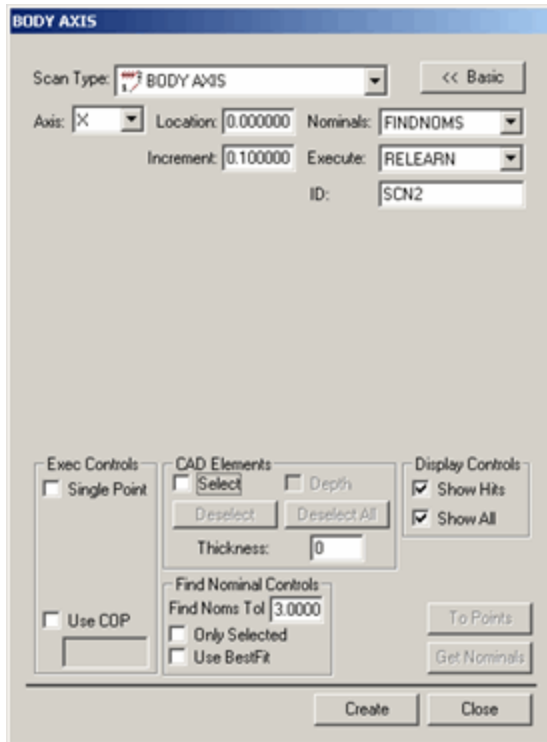
This operation happens every time you cross the Cut Plane, and you will finally have many hits that are on the Cut Plane.

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.

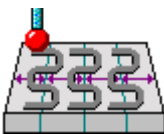
To create a Body Axis scan:

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

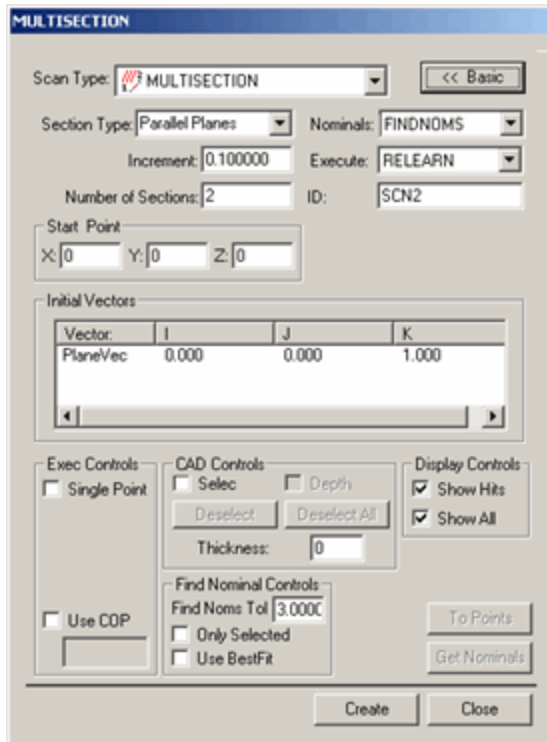
The Multisection method of scanning functions much like the [Body Axis](#) manual scan with these differences:

- 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:

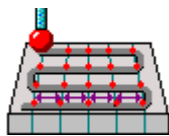
1. Select the **Insert | Scan | Multisection** menu option to open the **MULTISECTION** dialog box.



MULTISECTION dialog box

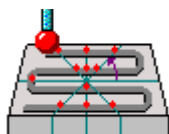
2. Specify a custom name for the scan in the **ID** box if you don't want to use the default name.
3. From the **Section Type** list, choose the type of sections you want to scan. Available types include:

- *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.

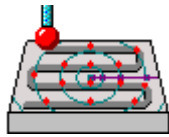
- *Radial Planes*



- 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 a Pointcloud (COP). From pointclouds, you can then perform Pointcloud operations and add Laser Auto Features to your measurement routine. You can perform portable laser probe scanning with a laser scanner, which is supported by RDS (such as the Integrated scanner, the HP-L/CMS, or the Leica LAS/LAS-XL), or you can use a Leica T-Scan.

- For information on setting up and using a HP-L/CMS laser probe, see the "Getting Started" chapter of the PC-DMIS Laser documentation.
- For information on using the Leica LAS laser scanner, see "[LAS Scanning Workflow Example](#)" in this documentation.
- For information on setting up and using Leica T-Scan 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] To add your scanned data into a pointcloud, you must create a COP command to your measurement routine. To do this, select the **Insert**

| **Pointcloud Feature** menu item, or click the **Pointcloud** button on the **Pointcloud** toolbar.



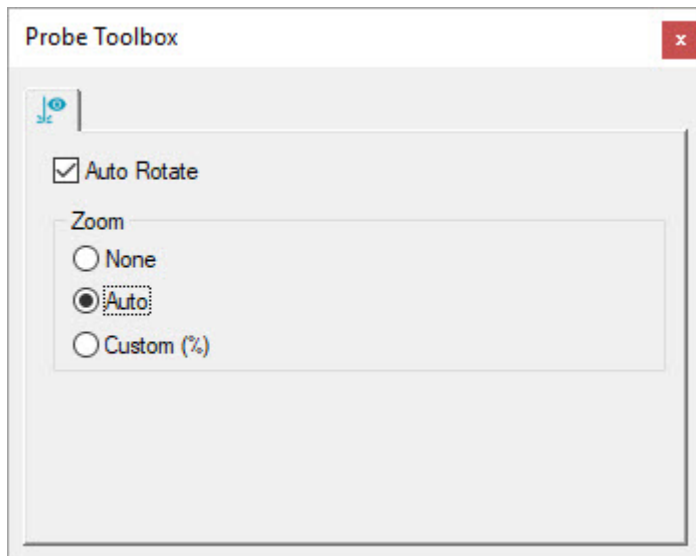
If you begin scanning without first creating a COP command, PC-DMIS automatically creates a COP for the scanned data.

2. Setup the Line Filter and other needed scan settings from the **Laser Data Collection Settings** dialog box (**Operation | Pointcloud | Data Collection**). For details on this dialog box, see "Laser Data Collection Settings" in the PC-DMIS Laser documentation.
3. 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.
4. Select the auto features that reside within the pointcloud as described in the "Extracting Auto Features from Pointclouds" topic in the PC-DMIS Laser documentation. When you create an Auto Feature, PC-DMIS extracts the pointcloud for the feature and inserts it onto the **Laser Scan Properties** tab of the **Laser Auto Feature** dialog box.

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

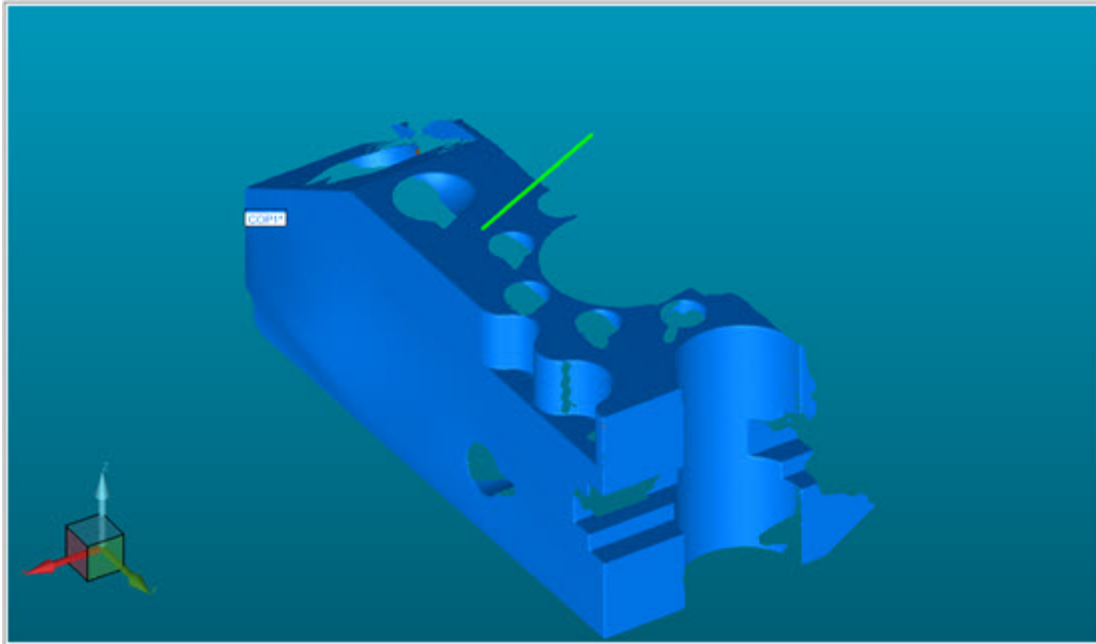
PC-DMIS enables the **Auto Rotate** and the **Auto** option in the **Zoom** section by default.

Auto Rotate check box - When you select this check box, the pointcloud automatically rotates in the Graphic Display window based on the laser line orientation. The rotation occurs even when 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:

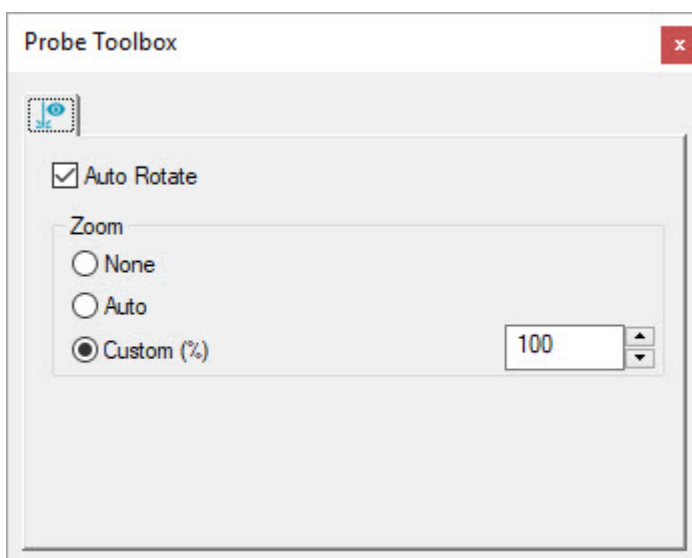
None - This disables auto zoom. The software uses the last manual user-defined zoom setting to show the pointcloud scan in the Graphic Display window.

Auto - If you select this option, the Graphic Display window zooms into a close-up view that is 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

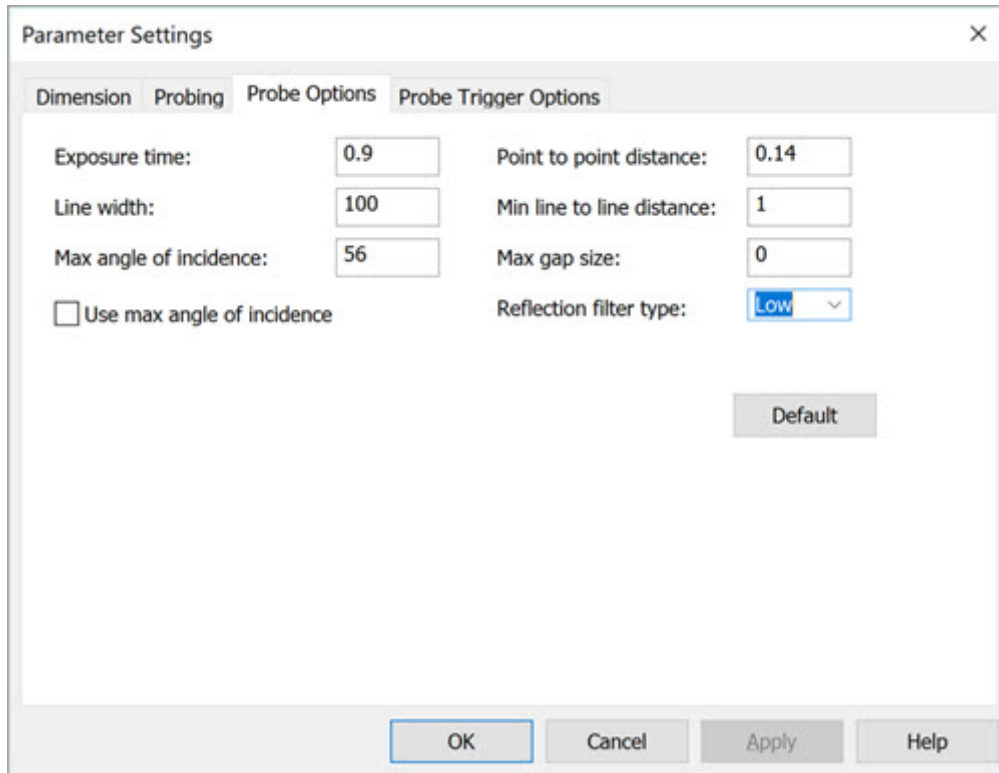
Custom (%) - If you select this option, you can set the zoom percentage. 100% indicates the zoom factor is set using the actual part size (1:1 relationship). You can set the zoom percentage larger to get a close-up view of the scan, or smaller to see more of the pointcloud at a reduced size. For example, 50% would be half size.



Probe Toolbox - Laser Scan Display Properties tab with Auto Rotate and Custom (%) Zoom options selected

Setting Leica T-Scan Probe Options

You can set the properties for Leica T-Scan scanners from the **Probe Options** tab on the **Parameter Settings** dialog box (**Edit | Preferences | Parameters**).



Parameter Settings dialog box - Probe Options tab

The options available are:

Exposure time - This option defines the length of time used by the T-Scan camera for the exposure. You can adjust the exposure time to suit the object you want to measure. For bright objects, use short exposure times (in a range from 0.25 to 5 ms). For dark objects, use longer exposure times (up to 20 ms).

Line width - You can reduce the scan line width down to 40% of the maximum width. If you choose a smaller line width, you can increase the line frequency.

Max angle of incidence - This option defines the maximum angle of incidence between the laser beam and the object's surface. The T-Scan

interface software rejects any measured point that exceeds this value. The smaller the value, the less data the software acquires, but it results in higher data quality.

Use max angle of incidence check box - Select this check box to apply a filter to the data. The filter removes points measured with an angle of incidence that exceeds the specified **Max angle of incidence** value. How this filter works is described in the **Max angle of incidence** description above.

Point to point distance - This option specifies the distance between two consecutive points in a scan line. Valid values are from 0.035 mm and 10 mm inclusive.

Min line to line distance - This option specifies the minimum distance between two consecutive scan lines. Valid values are from 0 mm and 50 mm inclusive.

Max gap size - If gaps appear within a scan line, they can be filled automatically by means of interpolation. This option specifies the maximum gap size up to which the software closes a gap automatically.

Reflection filter type - The available options are: **Standard**, **Low**, **Medium** and **High**. Select the setting which best matches your object's reflective properties.

Default button - Press this button to reset the options on the **Probe Options** tab to their default values.

Once you complete your changes, click the **Apply** button. PC-DMIS adds the settings into your measurement routine.



Example of **Probe Options** settings added to your measurement routine in the Edit window:



```
OPTIONPROBE/ ,PT2PTDISTANCE=0.14 ,LINE2LINEDIST=1 ,
MAXANGLE=56 ,USEMAXANGLE=1 ,FILTERTYPE=1 ,EXPOSURETIME=0 .
9 ,
MAXGAPSIZE=0 ,LINEWIDTH=100
```

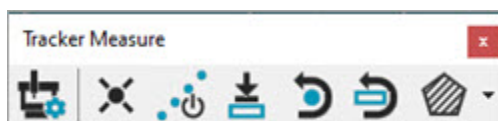
ATS600 Tracker Interface

The ATS600 tracker connects to PC-DMIS using the ATS600 LeicaLMF tracker interface. You can select the ATS600 LeicaLMF interface from the **Edit | Set Portable Interface | ATS600 LeicaLMF Tracker** menu option.

You can take measurements with a reflector probe, or you can measure an area scan and take hits without a reflector.

Area Scan Dialog Box, Menu, and Toolbar Options

You perform an Area Scan from the **Area Scan** dialog box. To open the dialog box, select **Insert | Scan | Area Scan** or click the **Area Scan** button  on the **Tracker Measure** toolbar.



Tracker Measure toolbar

The Area Scan is only available for the ATS600 Tracker when you are online and a surface probe is your active probe.

You can use the settings on the **Area Scan** dialog box to open the Overview Camera window and define the scan region and scan settings. The software stores the region and settings you select so you can re-execute the scan. Since

PC-DMIS stores the data in a pointcloud (COP), you must have a valid **Reference COP** ID defined in your measurement routine to create an Area Scan.

The screenshot shows the 'AREA SCAN' dialog box. It has a title bar 'AREA SCAN'. Inside, there are several controls: 'Scan type' is a dropdown menu showing 'AREA SCAN'; 'ID' is a text box containing 'SCN1'; 'Accuracy' is a dropdown menu showing 'Standard'; 'Signal Filter' is a dropdown menu showing 'Medium'; 'AOI Filter' consists of a checkbox and a text box containing '0'; 'Measure' is a checked checkbox; 'Reference COP' is a dropdown menu showing 'COP1'; and 'Overview Camera' is a camera icon. At the bottom right, there are 'Create' and 'Close' buttons.

Area Scan dialog box

The **Area Scan** dialog box has these options:

Scan type - This list allows you to select one of the available scan types.

ID - This box displays the current scan identification text. You can edit it to a unique alphanumeric text name.

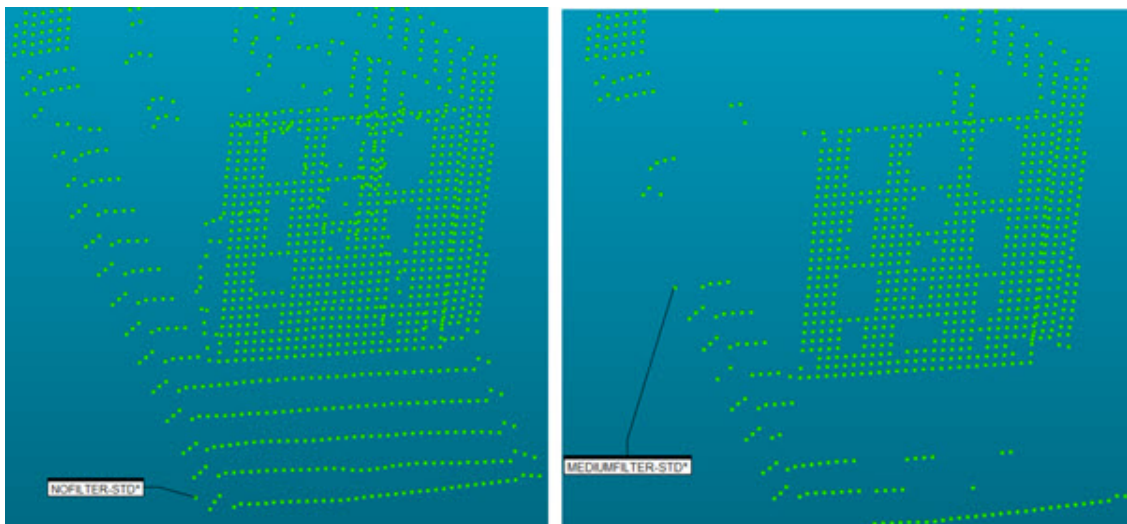
Accuracy - This list allows you to select one of the three scan accuracy options. The options are:

- **Standard** - This option is useful in controlled environments to provide standard measurement accuracies.

- **Fast** - This option is useful for applications when you need measurements as fast as possible.
- **Precise** - This option provides the highest measurement accuracies but requires longer measurement periods.

Signal Filter - This list was called the **Quality Filter** prior to PC-DMIS 2020 R2 and was found on the **Surface Probe** tab of the **Machine Options** dialog box.

Select an option from the **Signal Filter** list to filter and remove measured points that were measured when the laser beam was partially on and partially off the part surface. PC-DMIS filters the points in real-time while it scans.



Example using the Signal Filter setting to None (left) and Medium (right)

AOI Filter check box and input box - This is the angle of incidence filter setting. Click the check box to enable this filter, or un-check it to disable it. When you enable this filter, enter a valid value to define the maximum angle of incidence between the laser beam and the object's surface. The LeicaLMF interface software rejects any measured point that exceeds this value. The valid range for this filter is 0 (zero) - 90 degrees inclusive.

Measure check box - This check box enables you to set up a series of scans that you can insert into the Edit window and measure later. If you select

the **Measure** check box and click the **Create** button, PC-DMIS starts to measure the scan immediately. If you do not select the **Measure** check box when you click **Create**, PC-DMIS inserts a scan object into the Edit window that you can measure later.

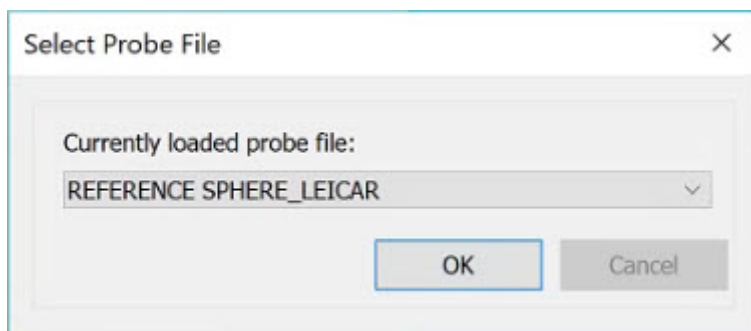
This check box is available only when PC-DMIS is Online.

Reference COP - This is the COP that PC-DMIS stores the scanned data in. If you don't select a COP from the list or enter one that is not yet created, PC-DMIS displays a prompt to ask if you want to create a new COP.

Overview Camera button - Click this button to display the Overview Camera window. For details on this window and its functions, consult the appropriate Leica manual.

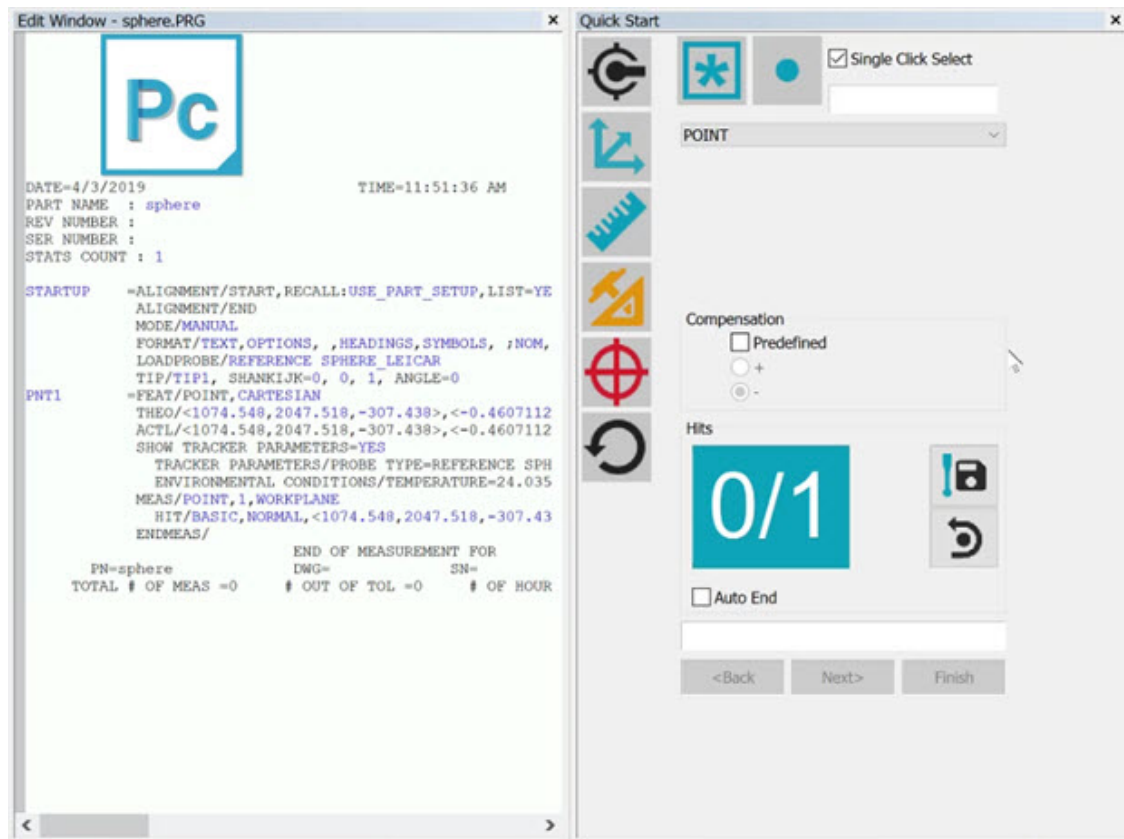
How to Use the Sphere Probe

You can select the probe file for the Sphere probe in PC-DMIS from the **Probes** list on the **Settings** toolbar (**View | Toolbars | Settings**).



To measure the sphere centerpoint:


1. Select the Sphere probe from the **Probe** list on the **Settings** toolbar.
2. Point the tracker beam at the physical sphere.
3. Click the **Take Hit** button or press Ctrl + H to measure the sphere. PC-DMIS returns the sphere centerpoint as the measured point.

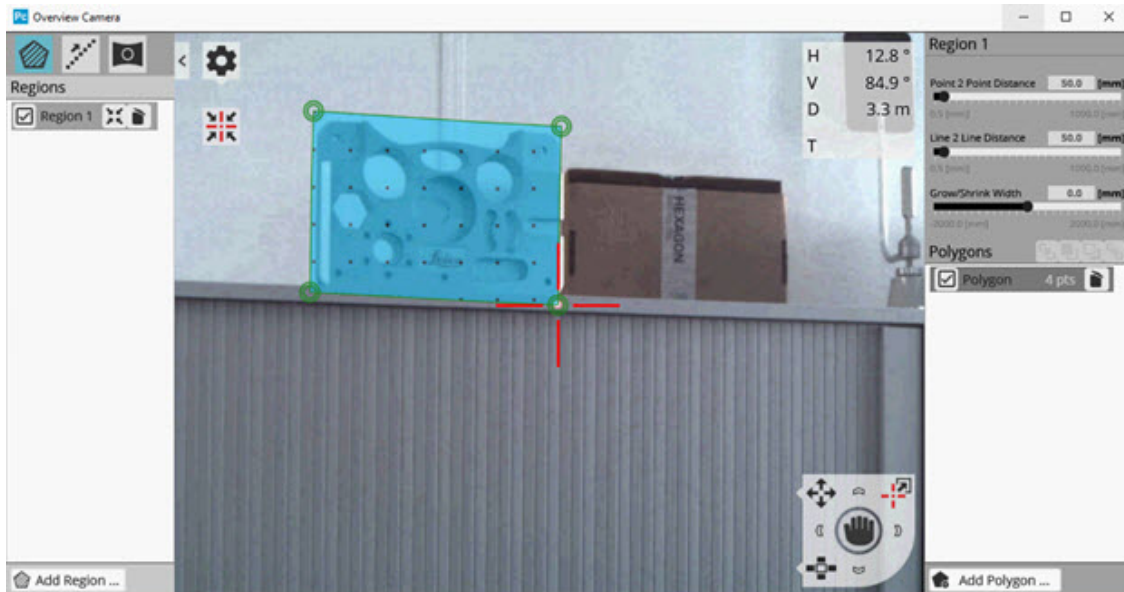


Example of the Edit and Quick Start windows after measuring a sphere with the Sphere probe

Performing an Area Scan

To perform an Area Scan from the **Area Scan** dialog box and create the Area Scan command:

1. Select a Surface probe.
2. Open the **Area Scan** dialog box from the menu (**Insert | Scan | Area Scan**), or click the **Area Scan** button  from the **Tracker Measure** toolbar.
3. Select an accuracy option from the **Accuracy Settings** list of the **Area Scan** dialog box. The available options are: **Standard**, **Fast**, and **Precise**.
4. Click the **Overview Camera** button and define the scan region and settings. When done, click the "X" in the upper-right of the Overview Camera window to close it.



Example of the Overview Camera window



You define the Region settings in the Overview Camera window. PC-DMIS stores these settings in the Area Scan command. The Region settings include the **Point 2 Point Distance**, **Line 2 Line Distance**, and the **Grow/Shrink Width**.

For details on the Overview Camera window including the Region settings, see the appropriate Leica manual.

5. Select the **Signal Filter** option from the list
6. Select the **AOI Filter** check box to enable this filter if necessary, and then enter a valid value.
7. Select a COP from the **ID** list or enter a new COP ID if one does not exist.
8. Select the **Measure** check box if you want to begin measurements immediately after you close the dialog box.
9. From **Area Scan** dialog box, click **Create** to add the Area Scan command into the Edit window, and then click **Close** to return to the PC-DMIS main screen.

```

DATE=4/27/2020          TIME=8:38:27 AM
PART NAME : 1
REV NUMBER :
SER NUMBER :
STATS COUNT : 1

STARTUP  =ALIGNMENT/START,RECALL:USE_PART_SETUP,LIST=YES
ALIGNMENT/END
MODE/MANUAL
FORMAT,TEXT,OPTIONS,,HEADINGS,SYMBOLS,,NOM,TOL,MEAS,DEV,OUTTOL,,
LOADPROBE/SURFACE_LEICAR
TIP,TIP1,SHANKIJK=0,0,1,ANGLE=0
COP1     =COP/DATE,TOTAL SIZE=0,REDUCED SIZE=0,
REF=SCN1,,
SCN1     =FEAT/SCAN AREA SCAN,SHOW HITS=YES,SHOWALLPARAMS=YES,POINTCLOUDID=COP1
AREASCAN:ACCURACY=STANDARD,SIGNAL FILTER=MEDIUM,AOI FILTER=75,SHOW REGIONS=YES,SHOW
REGION/LINE TO LINE DISTANCE=10,PT TO PT DISTANCE=10,GROW SHRINK WIDTH=25
POLYGON/INCLUSION=YES
SHOW TRACKER PARAMETERS=YES
TRACKER PARAMETERS/PROBE TYPE=SURFACE_LEICAR,TIME STAMP=Mon Apr 27 08:40:27 2020,
ENVIRONMENTAL CONDITIONS,TEMPERATURE=20,Temperature unit=C,PRESSURE=1013,PRESSURE UNIT=
BASICS/SCAN/LINE,NUMBER OF HITS=0,SHOW HITS=YES,SHOWALLPARAMS=NO
ENDSCAN
ENDMEAS/

END OF MEASUREMENT FOR
PN=1      DWG=      SN=
TOTAL # OF MEAS =0   # OUT OF TOL =0   # OF HOURS =00:00:00

```

Example of the Edit window showing the Area Scan command with Region settings

Performing a Ring Scan

Use the ATS600 Ring Scan function to perform a 360-degree scan (ring or full dome) within a minimum and maximum vertical angle.

To perform a Ring Scan from the **Ring Scan** dialog box and create the Ring Scan command:

1. Select a Surface probe.
2. Open the **Ring Scan** dialog box from the menu (**Insert | Scan | Ring**

Scan), or click the **Ring Scan** button  from the **Tracker Measure** toolbar.

RING SCAN

Scan type: RING SCAN

ID:

Max Vertical Angle: Read

Min Vertical Angle: Read

Point to Point Distance:

Line to Line Distance:

Reference Distance:

Reference COP: COP1

Create Close

Ring Scan dialog box

3. Type the **Max Vertical Angle** and **Min Vertical Angle** values. You can also click the respective **Read** button to read the current angle from the tracker.
4. Type the **Point to Point Distance** value.
5. Type the **Line to Line Distance** value.
6. Type the **Reference Distance** value.

PC-DMIS uses the **Reference Distance** value to calculate the point-to-point and line-to-line density as the value attainable at this distance. PC-DMIS computes the amount of lines and points it "needs" to achieve the density defined at the **Reference Distance**.

For example, if you keep the default values for **Point to Point Distance** (100), **Line to Line Distance** (100) and **Reference Distance** (10000), and

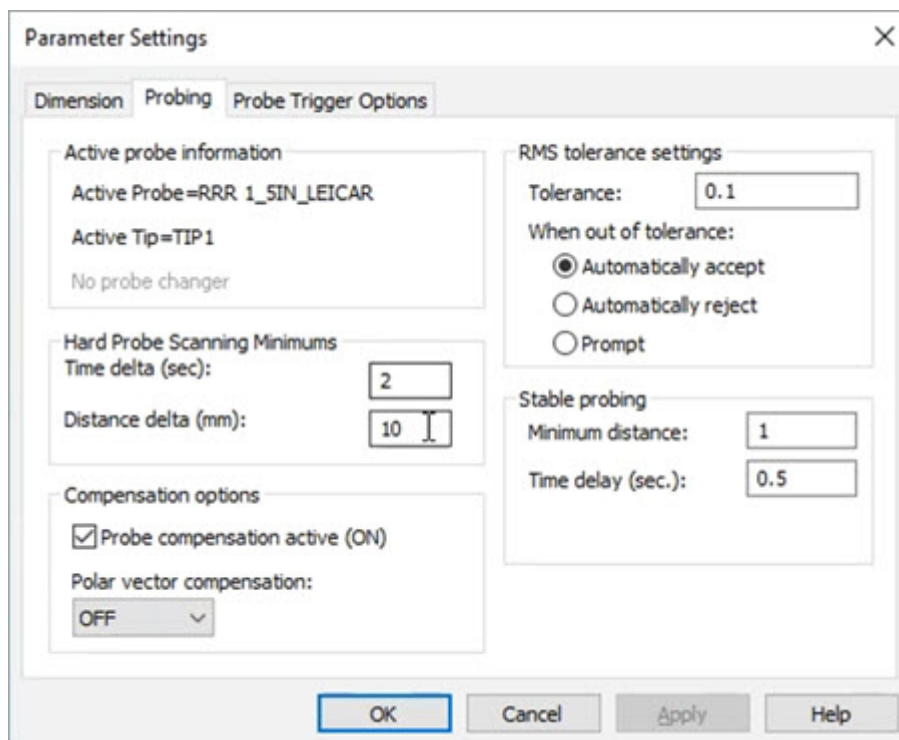
you measure a wall at 5000 mm distance, you should have a higher density.

7. Select the **Reference COP** from the list.
8. Click **Create**.

AT403 and AT9x0 Continuous Scanning Modes

To set the continuous scanning modes for the AT403 and AT9x0 laser trackers, follow these steps:

1. From the **Parameter Settings** dialog box (**Edit | Preferences | Parameters**), click the **Probing** tab.



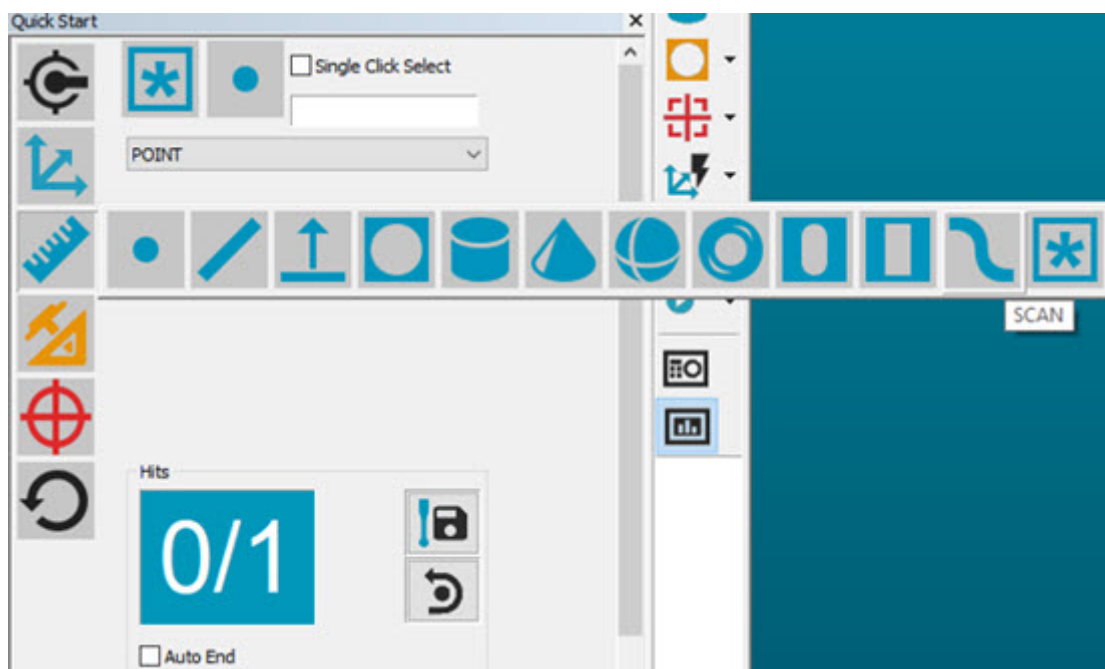
Parameter Settings dialog box - Probing tab

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.

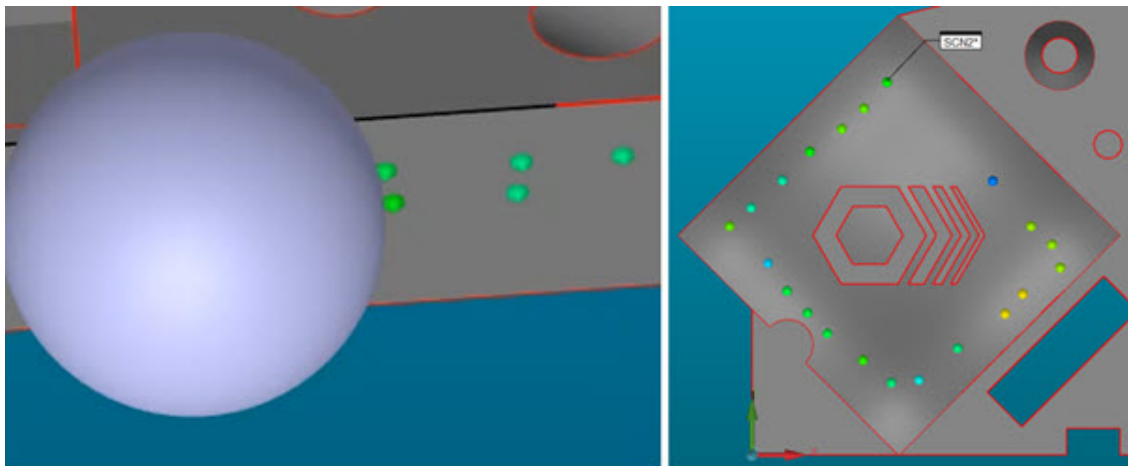
To do this:

- 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.

```

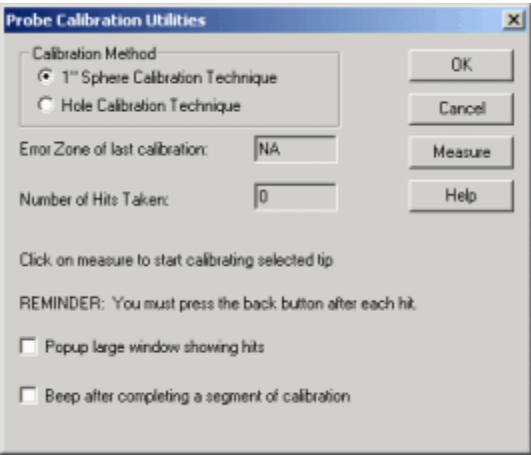
MOC1 = TRACKER COMMAND ( SET MEASUREMENT PROFILE (CONTDIST)
SCN1 = Manual Scan - VARIABLE DELTA
SCN2 = Manual Scan - VARIABLE DELTA
    
```

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

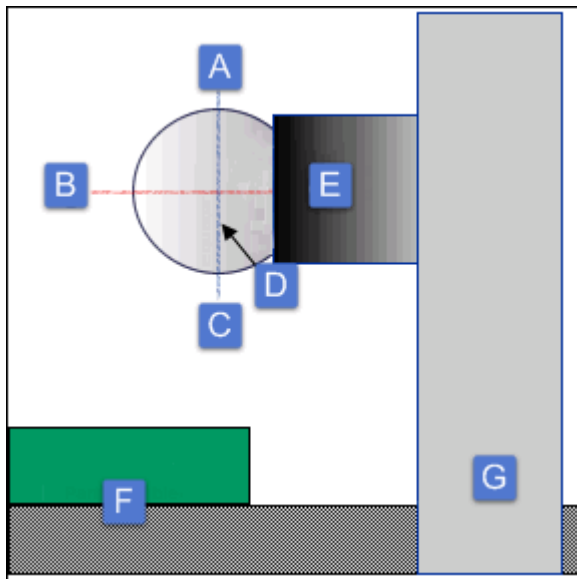
	of the sphere.
Error Zone of Last Calibration	The Error Zone of last calibration box displays the volumetric number that Faro calculates after the calibration routine is complete. The Faro Controller generates this number and it is only used for display purposes. You cannot edit it.
Number of Hits Taken	The Number of Hits Taken box displays the number of hits taken per calibration zone.
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, follow these steps:

1. If you are using a portlock, connect it to a USB port on your computer. A properly configured LMS license or portlock must be present during PC-DMIS installation.
2. Execute setup.exe from the PC-DMIS installation media. Follow the on-screen instructions.
 - If the **SMX Laser** option is programmed in your LMS license or portlock, PC-DMIS loads and uses the SMX Laser interface when you work in Online mode.
 - If the **All interfaces** option is programmed in your LMS license or portlock, you may need to manually rename smxlaser.dll to interfac.dll. The smxlaser.dll file is in the PC-DMIS installation directory.
3. Download the SMX laser DLL 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, .jar files and a JRE directory and subdirectories are included in the zip file. You must copy these files and directories to the PC-DMIS installation directory.

5. To test the communication with your tracker, type the following command in the Command Prompt window:

```
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 the FTP command to access the tracker and test its response. Type the following commands in the Command Prompt window, and press Enter after each command:

```
ftp 128.128.128.100
login: supervise (doesn't work with new Faro trackers)
> quote home
> quit
```

This homes the machine. If this fails, power down the machine, wait 1 minute, and power it back up. If this still fails, and the 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 establish.

The Faro SMX Tracker has added capability from the Faro Utilities application that you can access 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.

Appendix C: Troubleshooting Portable Systems

This section of the PC-DMIS Portable documentation provides information to help you resolve common issues with Portable systems.

There are many articles in the [Hexagon Knowledgebase](#) web site that provide information on troubleshooting hardware and software issues. You can use key words to search the site for specific troubleshooting articles.

For example:

- If you use the key words "troubleshooting arm", you get this list of articles: "[Hexagon Knowledgebase Articles on Troubleshooting Arm](#)".
- If you use the key words "troubleshooting tracker", you get this list of articles: "[Hexagon Knowledgebase Articles on Troubleshooting Tracker](#)".

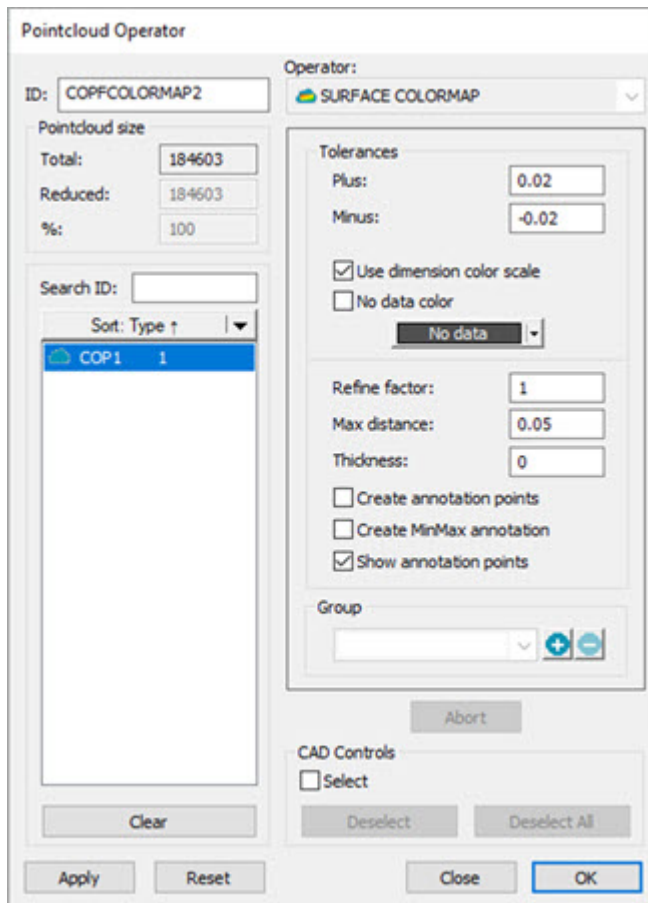
The troubleshooting topics in this section of the PC-DMIS Portable documentation are:

Colormap Processing Time Takes Too Long

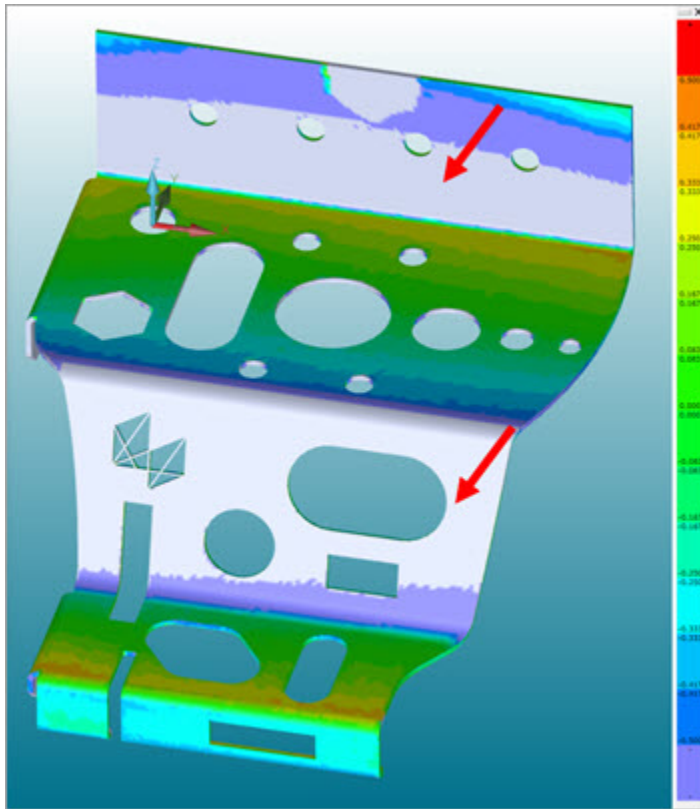
The Pointcloud Surface Colormap uses a **Max distance** setting and searches for all the points within that distance relative to the CAD model.

You should use a **Max distance** value that is only large enough to capture the deviations. Setting the distance too large slows down the Colormap process.

For example, this may occur if you use inch units in a measurement routine. Be aware that if you set the **Max distance** to one inch on a large CAD model, a lengthy processing time results.

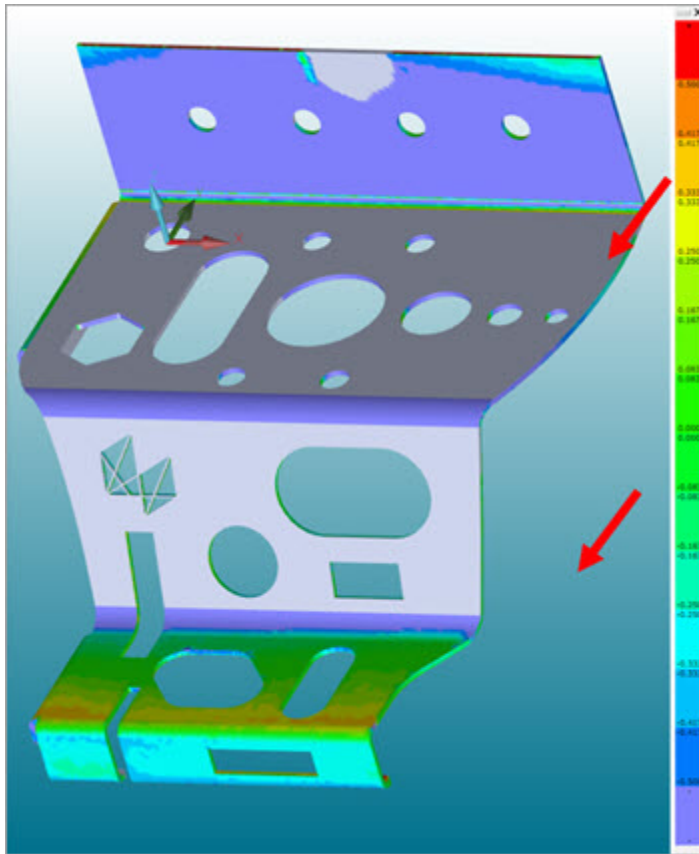


An incomplete colormap is where some areas of the CAD model do not show colormap data. This is most likely due to an issue with the **Max distance** setting. A wrong setting prevents PC-DMIS from color mapping portions of the CAD surfaces.



Colormap example where the Max distance is set too small

Incorrect CAD model vectors prevent the color mapping of entire CAD surfaces.

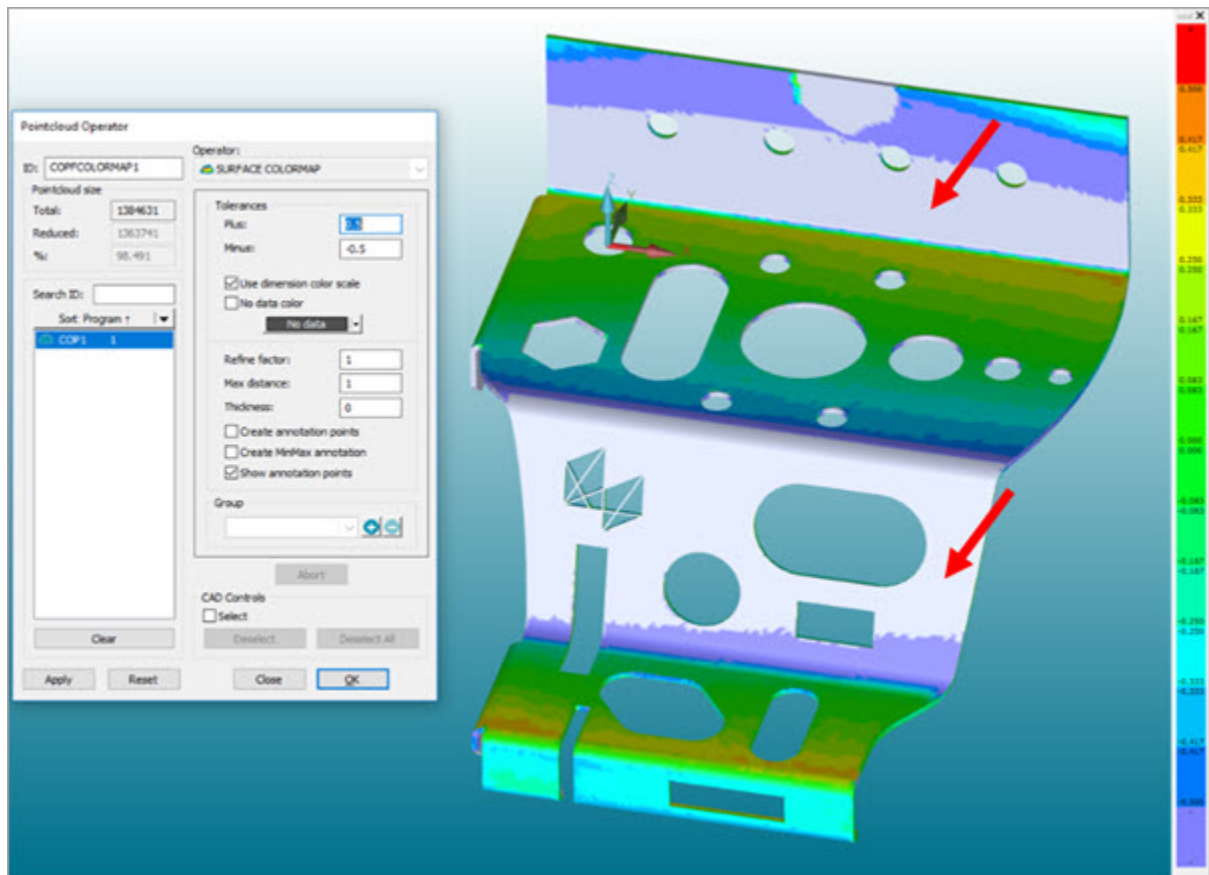


Colormap example where the CAD vectors are incorrect

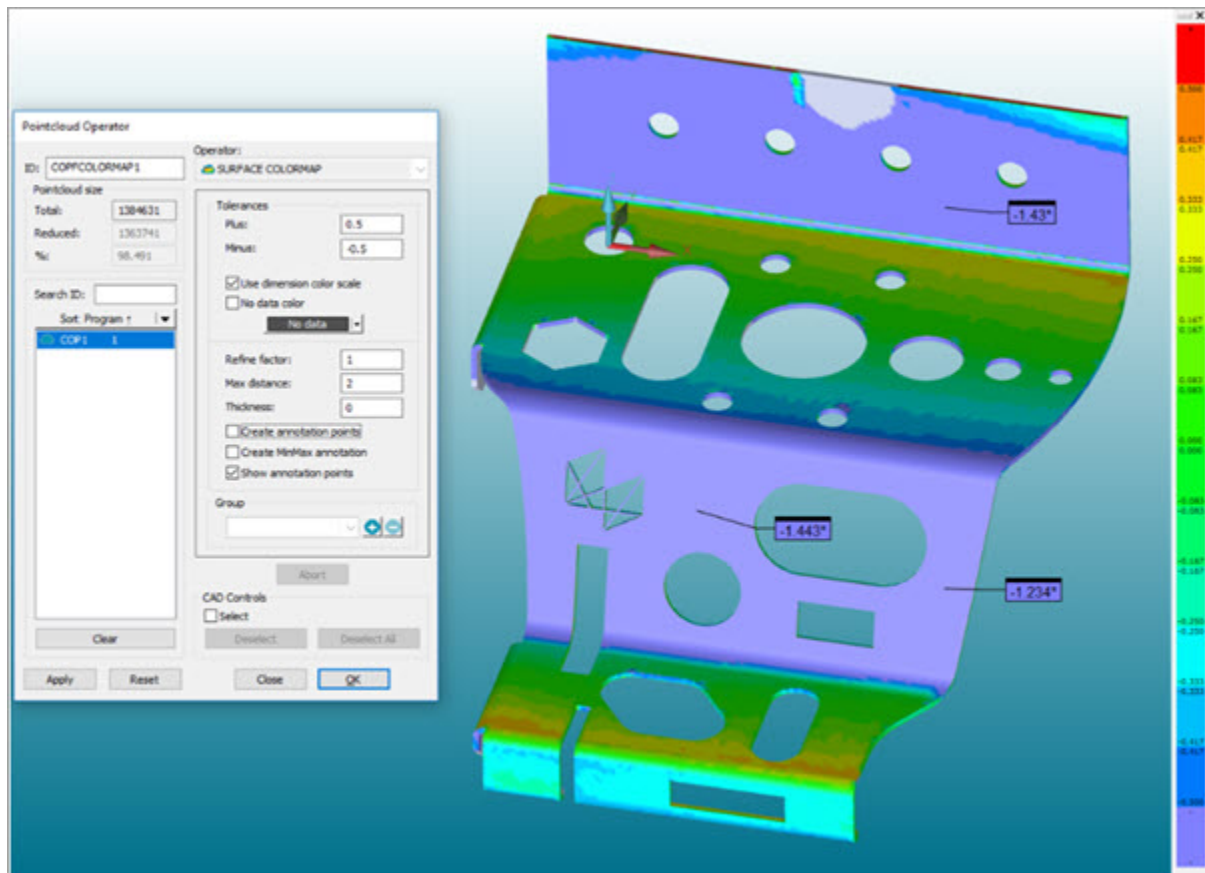
Incomplete Colormap – Understanding the Max Distance Setting

The Surface Colormap operator evaluates all pointcloud data that is within the **Max distance** of the CAD model. PC-DMIS does not use any data outside of the **Max distance** (default = 1 mm or 0.03937 inch) in the calculation. If the colormap is missing on portions of the CAD, you may need to increase the **Max distance**. This can be helpful, for example, on parts with larger deviations, or parts which are poorly aligned.

Use a **Max distance** value that is only large enough to capture the deviations. Setting the distance too large slows down the Colormap process as PC-DMIS searches that distance from all CAD surfaces.



Example of incomplete colormap on portions of CAD surfaces - Max distance = 1 mm

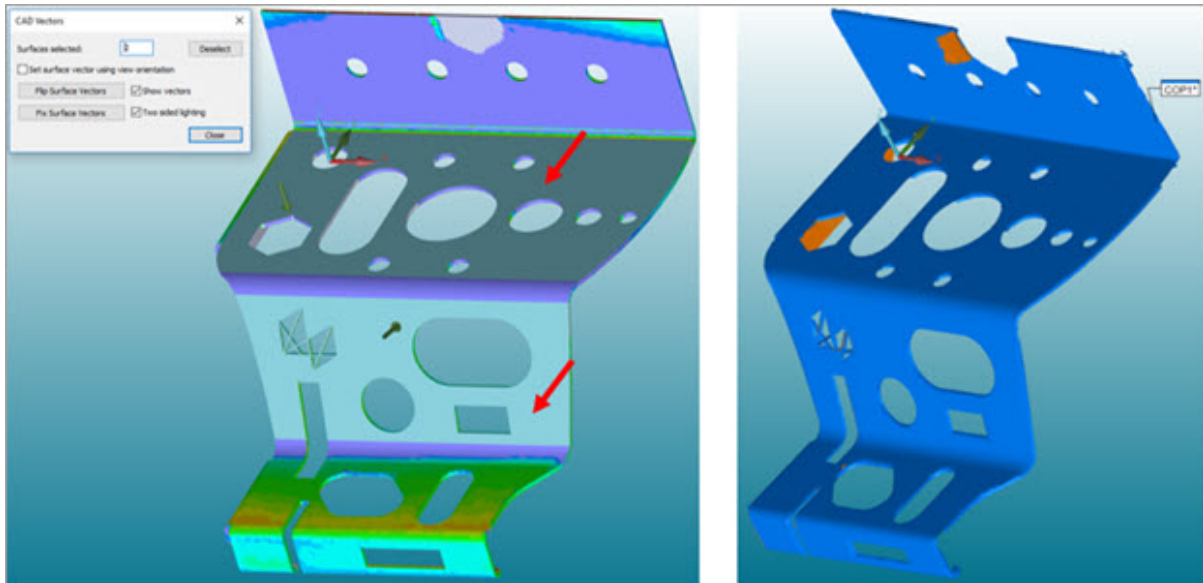


Example of completed colormap on CAD surfaces - Max distance = 2 mm

Incomplete Colormap – Understanding the Role of CAD Vectors

The Surface Colormap compares the vectors of the pointcloud and the CAD surface. If the CAD surfaces are not properly oriented, no colormap appears on those surfaces.

You can see the pointcloud orientation if you set the Pointcloud Display to two-sided. Using the default colors, the scan side is blue, and the opposite non-scanned side is orange.



Example of an incomplete colormap due to incorrect CAD vectors

In the above example, the highlighted surfaces have incorrect vectors. This is because they are 180 degrees opposite the scan orientation. You can use the **Edit | Graphic Display Window | CAD Vectors** menu item to correct this. For more information on editing CAD vectors, see "Editing CAD Vectors" in the "Editing the CAD Display" chapter of the PC-DMIS Core documentation.

For more information on incomplete colormaps, see the "[Why is my CAD model colormap not displaying correctly?](#)" article on the Hexagon Knowledgebase site.

Error Message: Attempted to Access an Unnamed File Past Its End

The error message "Attempted to access an unnamed file past its end" may occur when PC-DMIS tries to open a file or when it tries to execute a measurement routine file. This error may also occur at various points, such as when you click the **Measure** button in the **Probe Utility** dialog box. This indicates that there is a problem with the file or files.

- A corrupted file can cause this error.

- If this is the only error message, it usually indicates an access or permission issue with the file. It can also occur if the folder containing the measurement routine is set to read-only.
- This message is often associated with a serialization error message, for example: "Serialization error ALT".
- Another message sometimes associated with these errors is "Unable to restore Part Program from backup files" or "Unable to restore Measurement Routine from backup file". This too is often due to a corrupted file.

For solutions to these issues and more, see the "[Attempted to access an unnamed file past its end](#)" article at the Hexagon Knowledgebase site.

Error Message - Initializing: Waiting for camera

The RDS Scanning error message "Initialization: Waiting for camera..." occurs when the scanner cannot connect or communicate with the computer.

There are a number of solutions to resolve this issue. The most likely cause is an IP-address mismatch. Make sure that you enter the IP address on the LAN or Wifi connection correctly.

- 6-axis arms with a FP1 + HP-L-8.9 scanner and/or a FP2/FP2P for battery: 192.168.0.100 (You can replace the .100 with any number from .5 to .254)
- 7-axis arms with any feature pack: 192.168.178.100 (You can replace the .100 with any number from .5 to .198)
- You can set the PLUS Feature Packs such as the FP3P and FP2P to automatically assign the IP address (leave on "automatic"), or you can assign a static IP address.
- HP-L-20.8 Scanner on a 7-axis Arm + FP4: 192.168.150.1 (controller @ = 192.168.150.100)

For a complete description on how to set the IP address, see the "[How do I set the Static IP Address for my Scanner or CMM?](#)" article on the Hexagon Knowledgebase site.

For more solutions to this error message, see the "[My ROMER arm is not connecting with the camera.](#)" article on the Hexagon Knowledgebase site.

Error Message: interfac.dll Failed to Load

The error message "interfac.dll Failed to load" can occur when you transfer WinRDS to a new computer, and some files didn't get copied over.

To fix this, do the following:

1. Download the latest WinRDS.
2. Extract and install the software. WinRDS is a 32-bit software, there is no 64-bit version. However, you can install it on a 32 or 64-bit operating system.
3. If available, copy the ArmData and ArmDat.s6x folders from the old computer to the new computer. The location of the folders is in this folder:

C:\Program files x86\CimCore\WinRds

Once you've installed the latest version of WinRDS, and you have copied the folders over to the new computer, do the following:

1. Power the arm off.
2. Open the **CimCore Arm Utilities** short cut on your desktop.
3. Cancel the error message.
4. Click the **Config** button and then select the **Armspecs** tab.
5. From the **Armspecs** tab, navigate to the **Armdata** and **Armdata.s6x** folders.



DO NOT select the **Armdata** folder. Only point to its parent folder.

6. Click **OK** once for the **Armdata** folder, and then click **OK** a second time for the **Armdata.S6X** folder.
7. Power the arm on to connect.

Older Infinite arms mostly use CimCore WINRDS to communicate with the computer. PC-DMIS uses the romer.dll file to interface with the arm.

The newer Absolute arms use RDS to communicate with the computer. PC-DMIS uses the romerRDS.dll to interface with the arm.

Your license must have one of these interfaces programmed into it. During the PC-DMIS installation, the installer reads the interface programmed into your license and renames the appropriate .dll file to "interfac.dll".

You can find the original "interfac.dll Failed to Load Error Message" article at this [Hexagon Knowledgebase](#) site.

Error Message: Machine Not Responding

If you receive the PC-DMIS "Machine not responding" error message, it indicates that PC-DMIS failed to communicate with the equipment. The first step is to make sure the equipment is on and that all cable connections are properly made.

If the issue persists after you've confirmed that all cable connections are secure, try one of these options:

- For arms, this is often a USB connection issue. Plug your arm into a different USB port. This forces Windows to reinstall the drivers. This may also identify a faulty USB port.
- For Laser Trackers, this is often due to an incorrect network connection IP configuration.

For more details on the "Machine not responding" error message, see these Hexagon Knowledgebase articles:

[I receive a "Machine not responding" error message](#)

[PC-DMIS errors with a "Machine not responding" message. How do I connect my Leica Laser Tracker?](#)

Error Message - Motherboard initialization failed

There are several reasons you may get a "Motherboard Initialization Failed" error message. One error is "Motherboard initialization failed, unsupported structure version." With this error, you can have transient communication issues (disconnects) or even data loss.

One cause for this error happens on sites where heavy equipment is present. This type of equipment creates surges on the input power and EFI (Electromagnetic Field Interference) to occur. This gets picked up by the USB cable which serves as an antenna. This then causes the arm to disconnect or can cause other communications issues with the arm.

Another major cause is when you have MIG, TIG, or plasma cutters within 150 feet of the Romer Arm. The arc that these devices creates causes (EMI) Electromagnetic Interference with the USB communication cable between the arm and the computer.

To resolve the issue, try to do one or more of the following:

- Move the arm away from the offending equipment or devices.
- Integrate a power conditioner.
- Use a modified USB cable.
- Instead of a USB cable, use Wi-Fi to communicate with the arm.

For other solutions and related information, see the "[What are some possible causes of Romer Arm disconnects and motherboard initialization errors?](#)" article on the Hexagon Knowledgebase site.

How to Create a Support File for AT9x0 and AT40x Trackers

Hexagon Technical Support uses the support file (.sfile) to debug AT9x0 and AT40x Leica Tracker issues.

The support file is useful for troubleshooting your AT9x0 or AT40x Leica Tracker.

When you send a support file to Technical Support, include the time and date the issue happened. It helps if you include a screen capture of your computer's screen showing the time and date and include that image with the support file. Also, include what you were doing leading up to the issue.

To create the support file:

1. Connect to your Tracker in Tracker Pilot.
2. Click on the **Help** tab.
3. Click **Create Support File**.
4. PC-DMIS saves the support file locally and displays the folder (such as C:\Users\[username]\AppData\Roaming\TrackerPilot\Support\[s/n]).
5. Create a new case at the [Hexagon Technical Support](#) site.
6. Include the support file (.sfile) and any other documents as attachments.
If you have already created a case, you can also send an e-mail with the files to Hexagon Technical Support at TechSupport.US@Hexagon.com.

You can find the original "How to Create a Support File" article at this [Hexagon Knowledgebase](#) site.

Leica AT9x0 Firmware Issues

Leica Controller Firmware Error

If you receive a firmware error message on your Leica AT9x0 controller, the controller may prevent you from locking onto a T-product. Often, you can reboot the controller to resolve this issue.

For more details on this issue, see the "[Why am I seeing a “Firmware problem” on my AT9x0 Leica Tracker controller?](#)" article on the Hexagon Knowledgebase site.

PC-DMIS Firmware Mismatch Error

If you receive a firmware mismatch error when you try to connect the Leica AT9x0 Laser Tracker, ensure that you have the latest version of the firmware installed.

For more details and other possible solutions to this error, see the "[When connecting to an AT9x0 laser tracker with my metrology software, I obtain a firmware mismatch error.](#)" or the "[My Leica Laser Tracker is giving an error Firmware Version Mismatch.](#)" article on the Hexagon Knowledgebase site.

Leica AT9x0 Laser Tracker Battery Issues

The pattern of the four LED lights on the Leica AT9x0 Laser Tracker indicates the cause of battery errors.

For details, see the "[Leica Laser Tracker AT9x0 Battery - LED lights and troubleshooting](#)" article on the Hexagon Knowledgebase site.

RDS Troubleshooting Tips

Computer Often Runs Very Slow

If the computer runs very slow each time you use the RDS Data Collector or any other 3D software, check if the graphic card driver is correct. For example, if the

card displays a low-resolution VGA driver, search for and install a better high-resolution driver.

Unable to Uninstall RDS, and The Computer displays “Could not find RDS install Log”

Locate the registry key “HKEY_LOCAL_MACHINE\SOFTWARE(\Wow6432Node for 64 bits OS) \Microsoft\Windows\CurrentVersion\Uninstall\RDS” and then delete the RDS folder. Once this is done, you can then reinstall RDS.

Maintenance Functions Cannot Connect to the Arm

In RDS Toolbox, you can use most of the maintenance functions only in USB connection mode. If the current connection is Wi-Fi, use the USB cable to connect the arm to the computer.

RDS Freezes after Selecting the Scanner Type

This can happen when you add a new scanner. The solution is to disable the nView Desktop Manager and then open the nVidia nView Desktop Manager control panel. To do this, select **Windows Menu | Settings | Control Panel | nVidia nView Desktop Manager**. From the dialog box that appears, clear the **Enable Desktop Manager** check box and then click **OK**.

Buttons or Text are Cropped

Check that the Windows font size is set to 100%.

Firmware Update of the Mainboard Failed or RA8 Arm Does Not Start after a Firmware Update

Try to install the firmware again.

For the RA8 arm, if the issue occurred when programming the mainboard firmware, boot the arm into Safe mode:

1. Press the Power button on the arm and then press it four more times.
This boots the arm into Safe mode.
2. Reinstall the firmware.

You can find the original "RDS Troubleshooting Tips" article at this [Hexagon Knowledgebase](#) site.

ROMER Arm Unable to Connect to LAN Port

You initialized and connected the RSx scanner to the USB-to-Ethernet adapter, but not to the integrated Local Area Network (LAN) port in your computer. The LAN port does not detect the scanner, but the port works fine when you connect other devices or networks to it.

A possible cause is that the Network Interface Card (NIC) speed setting is set too high (for example, 1 Gbps). If the setting is set at too high a bandwidth, communication with the Arm fails.

If you set the **Speed & Duplex** property to **Auto Negotiation**, the NIC detects the best speed for communication with the arm.

To do this:

1. From Windows, click **Start**.
2. Type **Network Connections**.
3. Click the Control Panel option **View network connections**. You should see a screen with all the enabled and disabled network connections.
4. Right-click **Local Area Connection**.
5. Select **Properties** from the pop-up menu to display the **Local Area Connection Properties** dialog box.
6. Click the **Configure** button.
7. Select the **Advanced** tab.
8. From the **Property** section, select **Speed & Duplex**.
9. In the **Value** section, select **Auto Negotiation** if not already selected.
10. Click the **OK** button to save your changes.

Your LAN network settings should now allow communication with the ROMER Arm.

You can find the original "ROMER Arm Unable to Connect to LAN Port" article at this [Hexagon Knowledgebase](#) site.

T-Scan No Data Is Collected



The following information on troubleshooting this issue relates to the new T-Scan and the new All-In-One T-Scan controller.

This is an issue where everything looks okay for the T-Scan:

- The T-Scan controller boots up without problems.
- The T-Collect and Interface have green lights and look good.

However, when you pull the trigger, no data collection occurs.

Possible causes are:

- You need to connect the T-Scan Trigger cable.
- You need to install the latest software for the scanner controller.
- The config.ini file does not have the correct variable setting.

For more information on this issue, see the "[Connection to T-Scan appears OK however no data is appearing on screen when scanning](#)" article on the Hexagon Knowledgebase site.

For more information on troubleshooting the Leica T-Scan, see the "[Leica T-Scan setup](#)" article on the Hexagon Knowledgebase site.

Glossary

3

3D Machine: A 3D machine collects data based on the XYZ position (three dimensions) of the probe tip. The probe vector is not used.

6

6DoF Machine: Six Degrees of Freedom. A 6DoF machine collects data, not just from three degrees (the probe tip's XYZ position), but from six degrees (The probe's XYZ position along with the probe's IJK vector).

A

ADM: Absolute Distance Meter

ATR: Automatic Target Recognition

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 Readouts window

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

OTG: Orient to Gravity

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

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