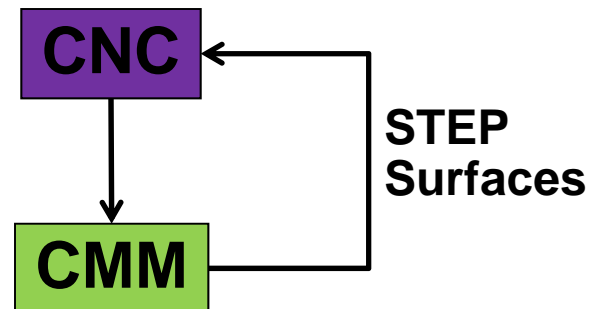


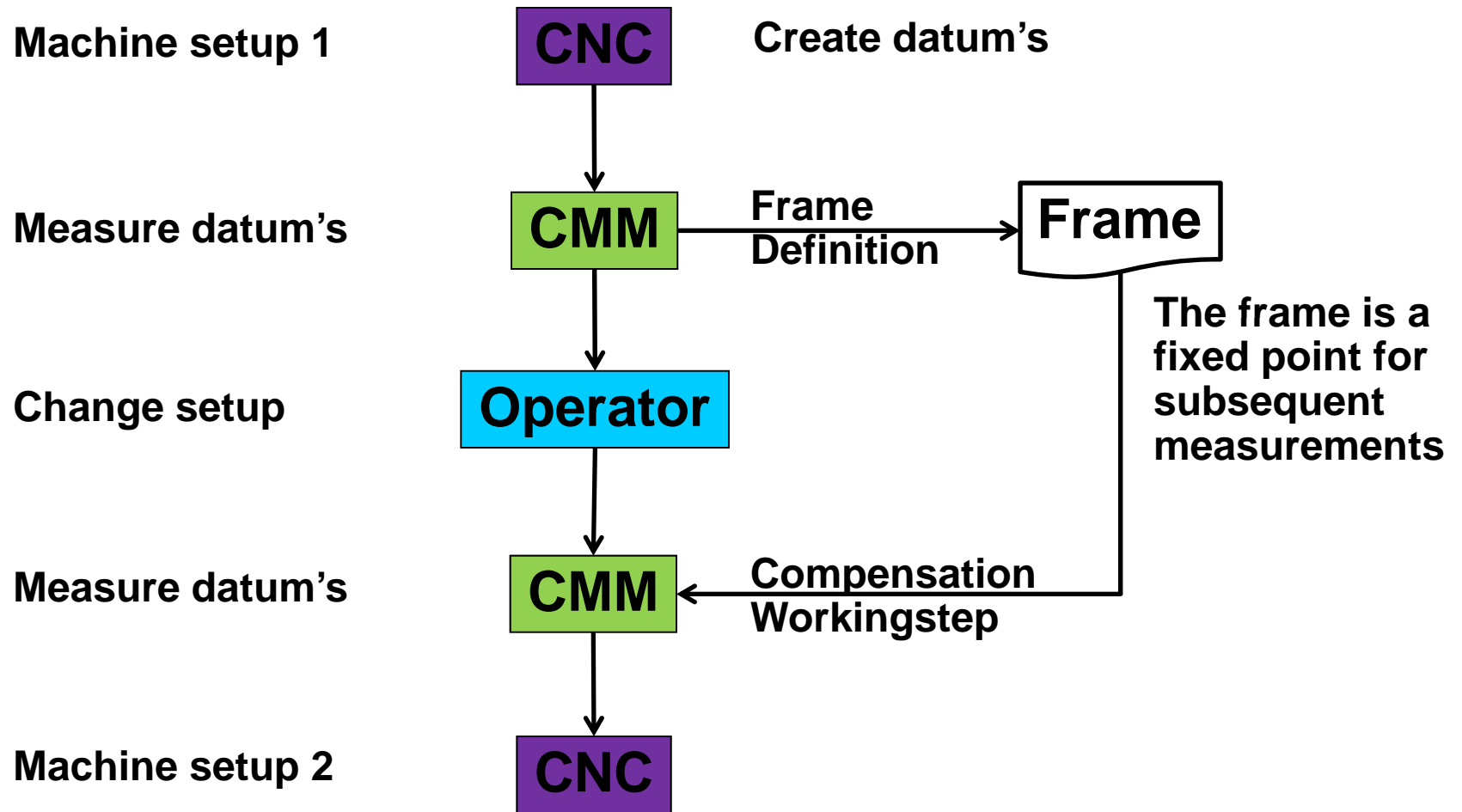
Closed Loop Programming using the STEP-NC Explorer

STEP Tools, Inc.

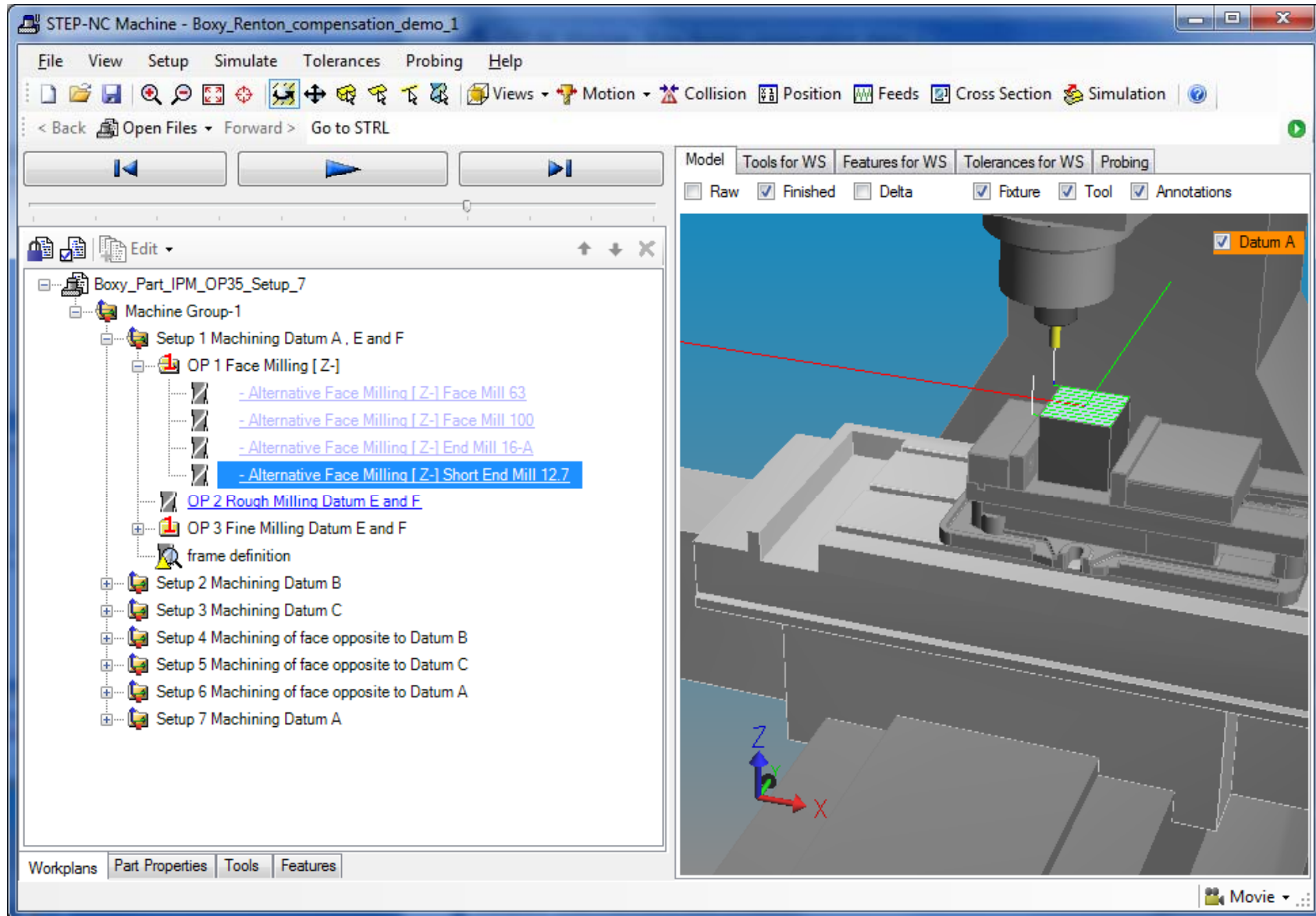
14 First Street, Troy, NY 12180
(518) 687-2848 / (518) 687-4420 fax
<http://www.steptools.com>

- Machine setup 1
- Measure datums and define frame
- Change setup
- Measure frame and compensate new setup



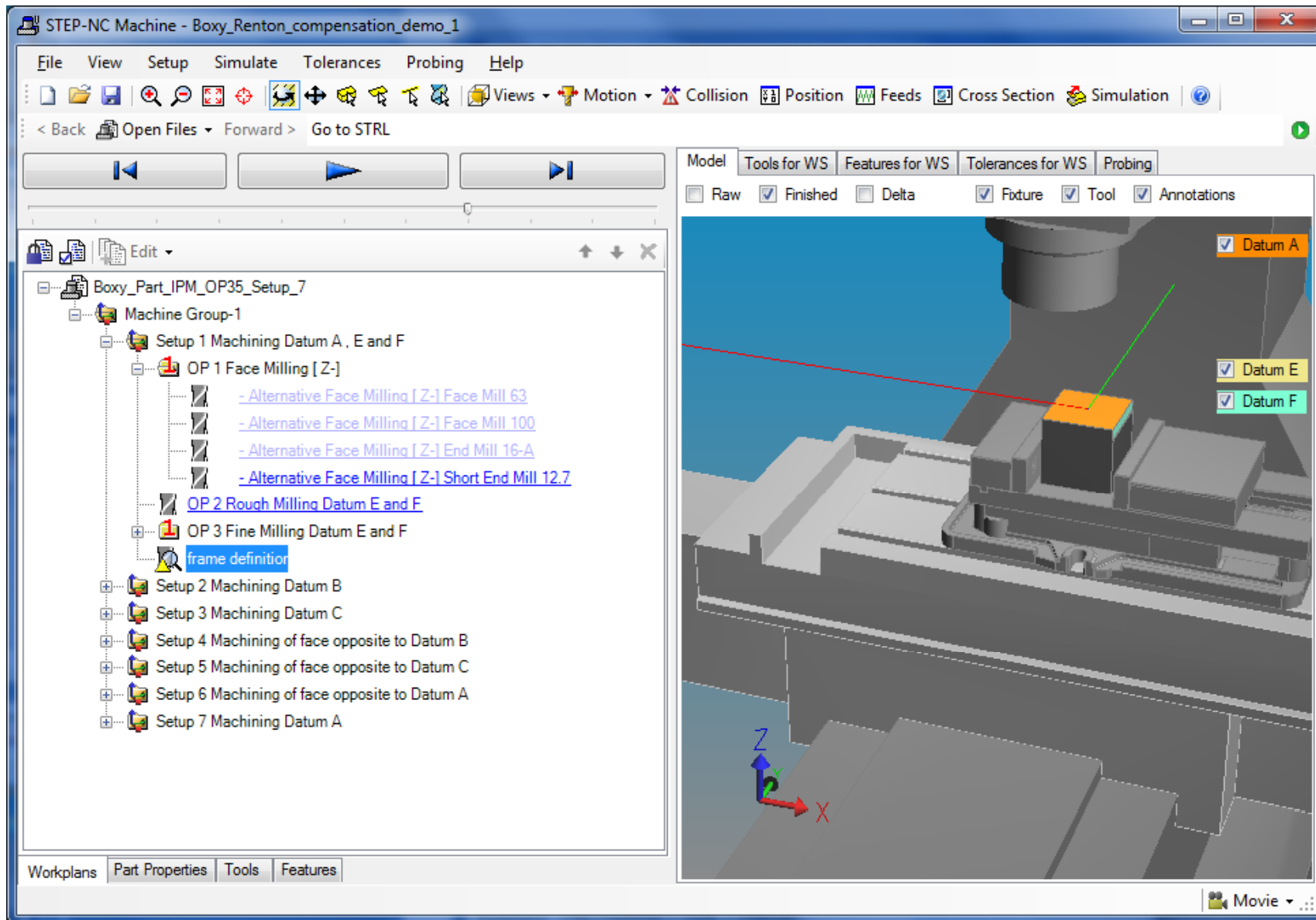


Load the demo_1 data set (Haas Machine) **STEP** Tools, Inc.

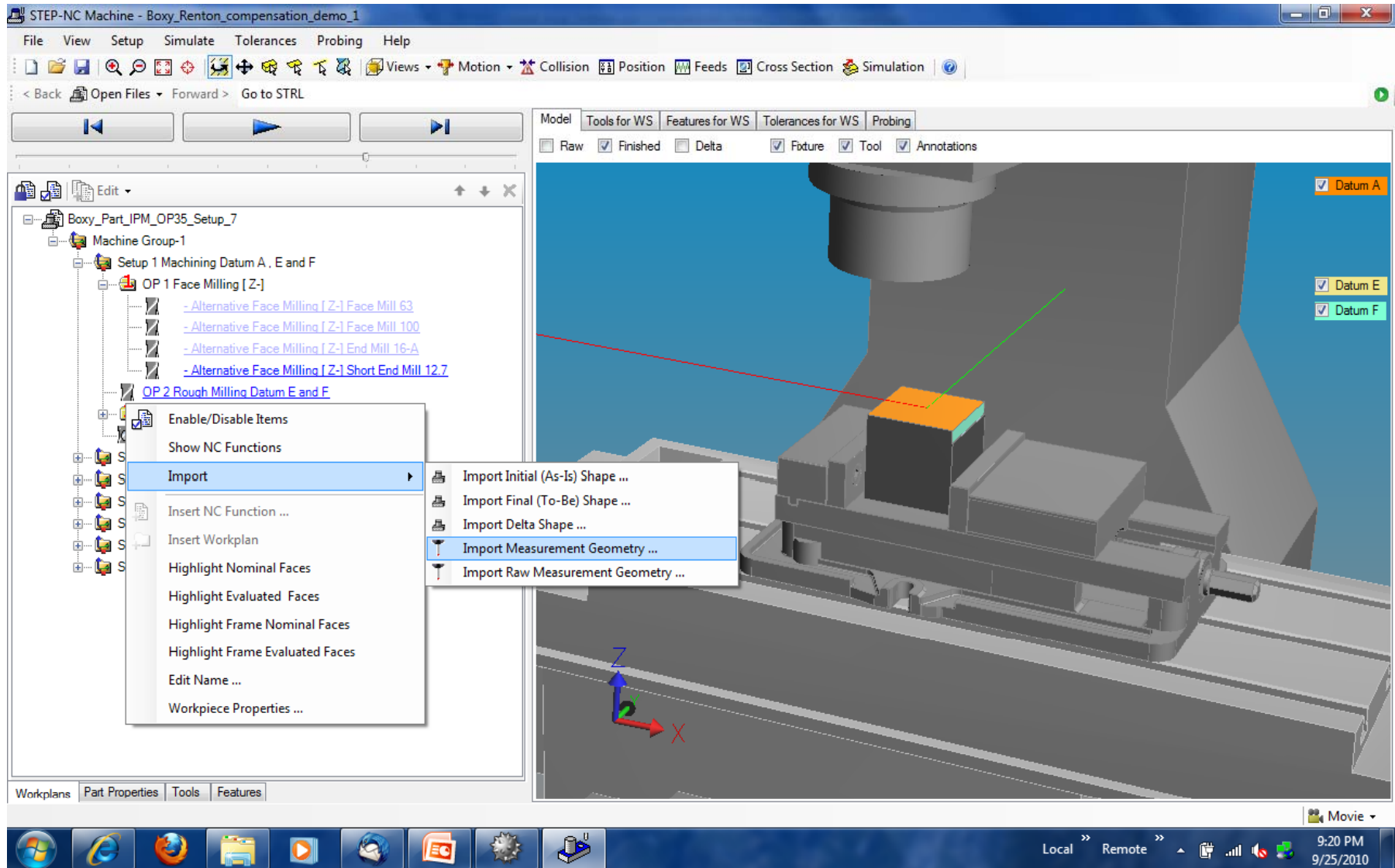


Pick the frame definition workingstep

STEP Tools, Inc.

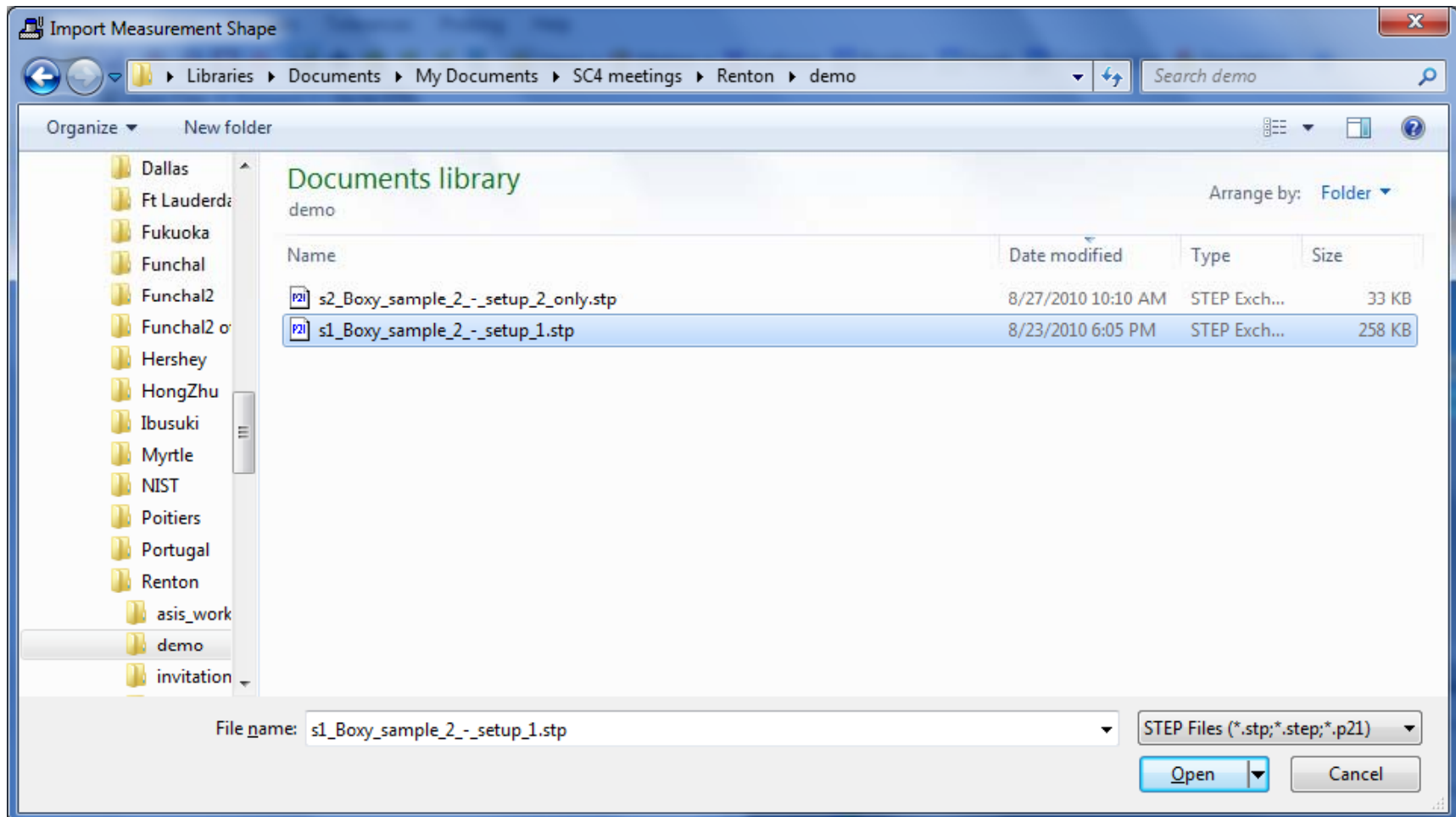


Right click and select Import Measurement **STEP** Tools, Inc.

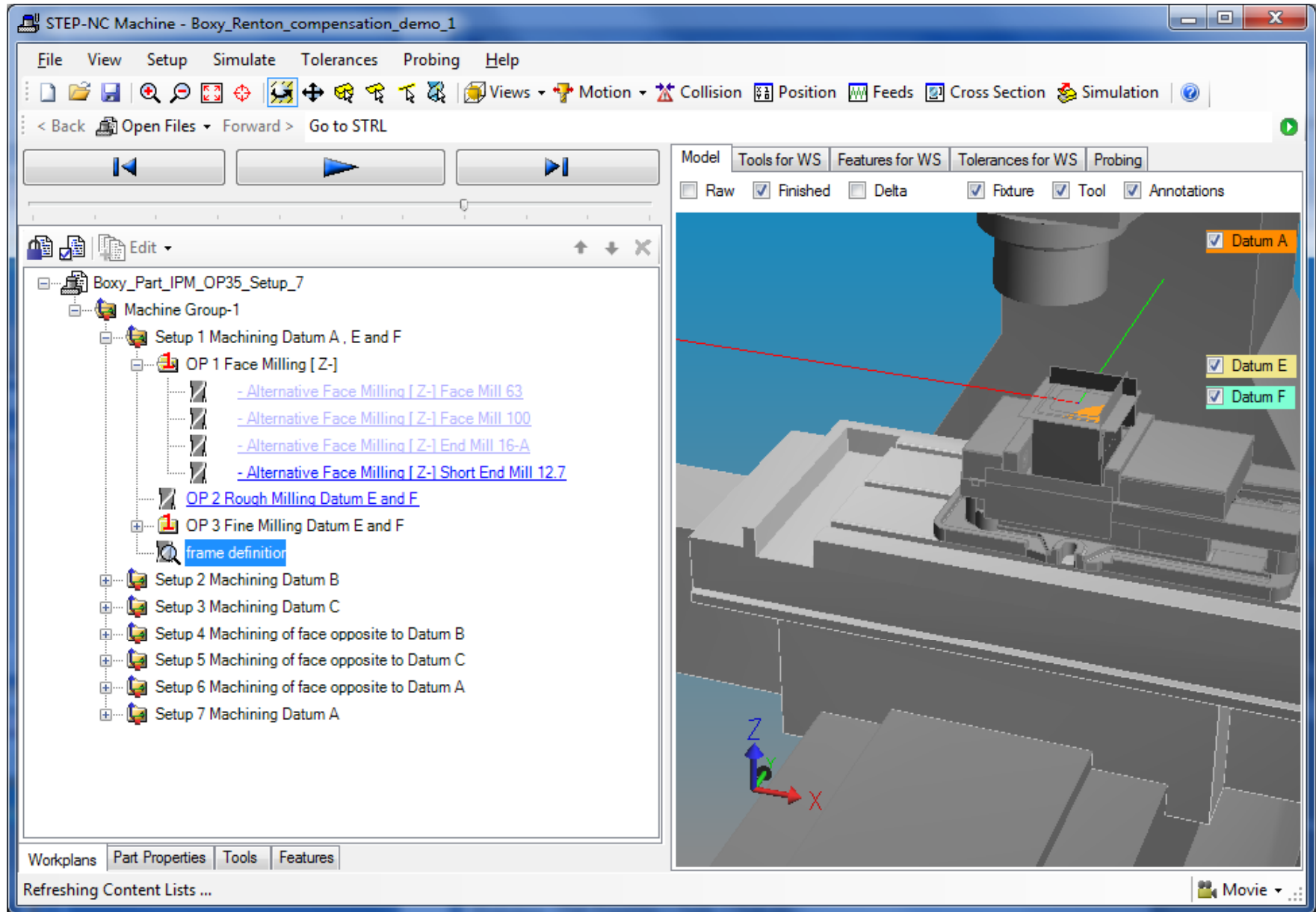


Select the s1_boxy STEP file

STEP Tools, Inc.

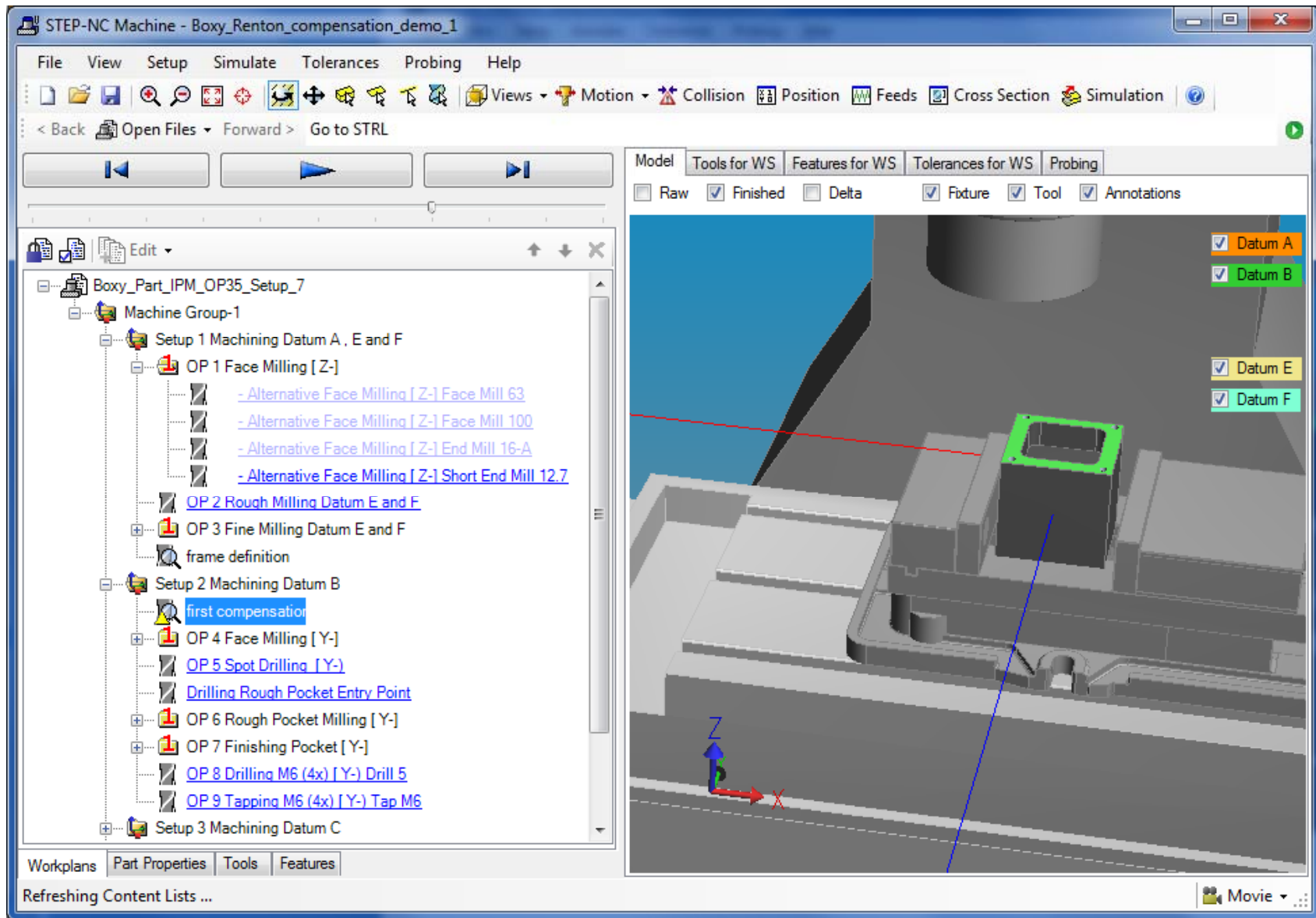


The frame definition has now been applied **STEP** Tools, Inc.



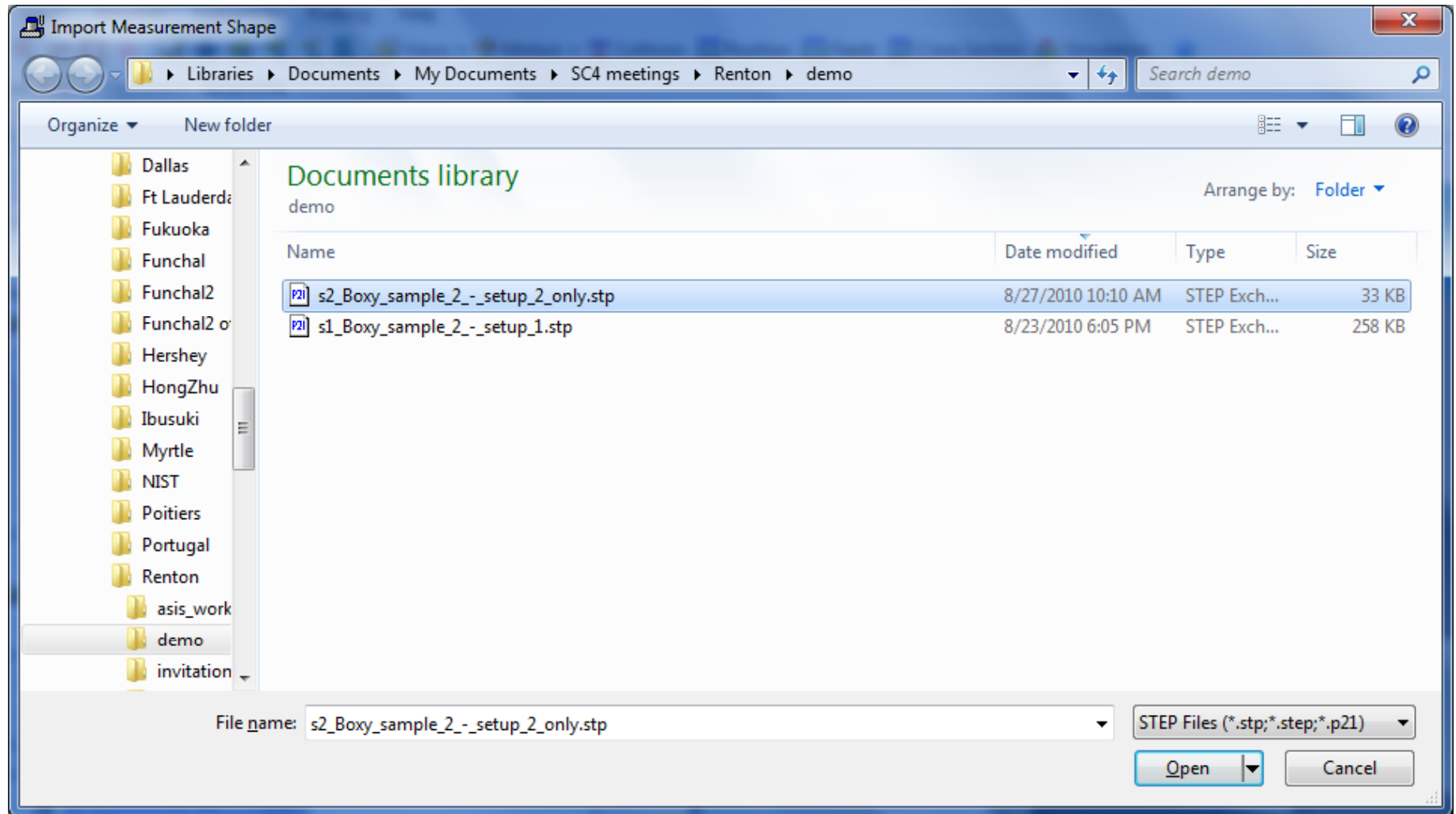
Repeat for the Compensation in Setup 2

STEP Tools, Inc.



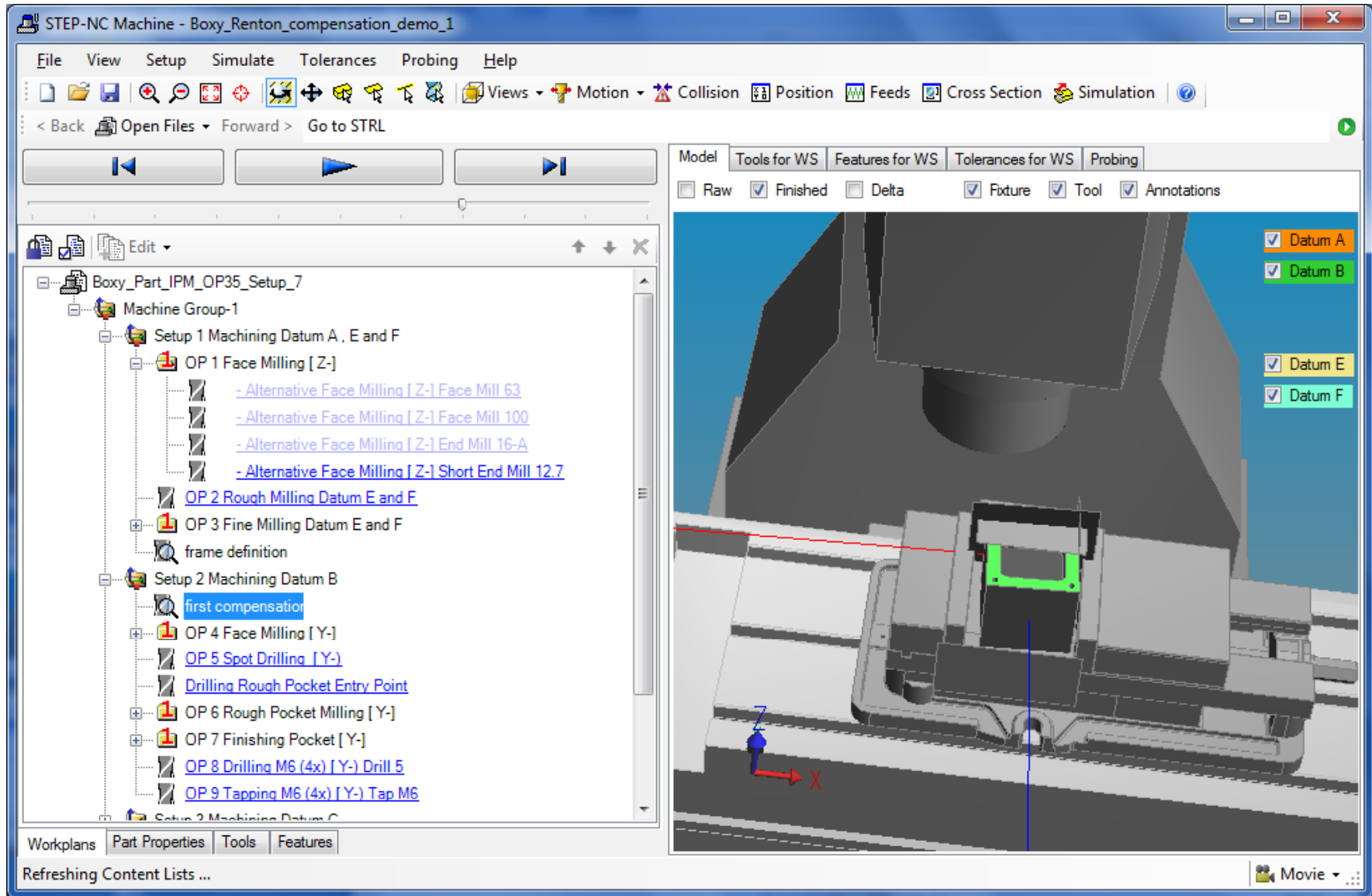
This time read the s2 STEP file

STEP Tools, Inc.



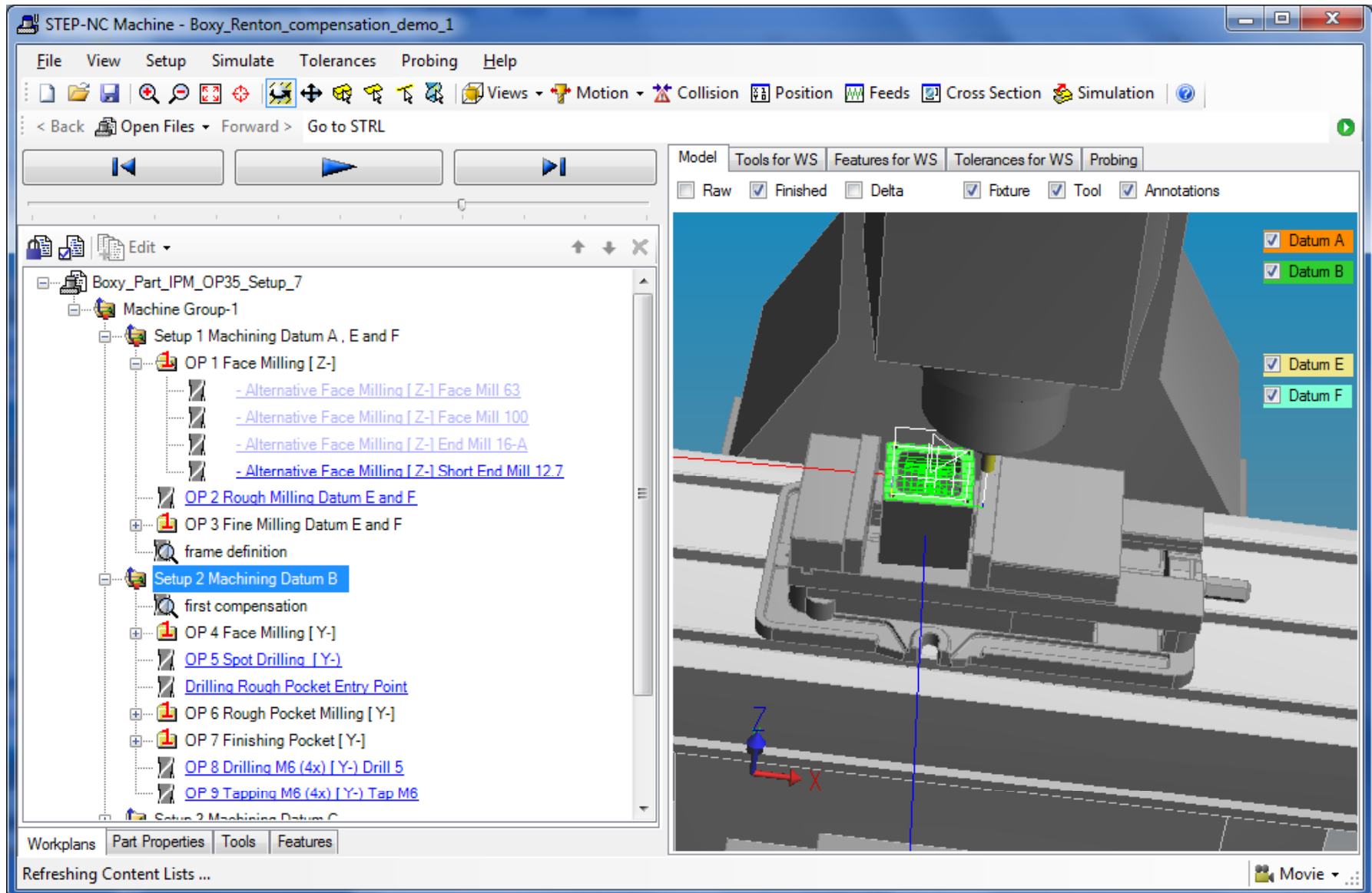
The workpiece has moved!

STEP Tools, Inc.



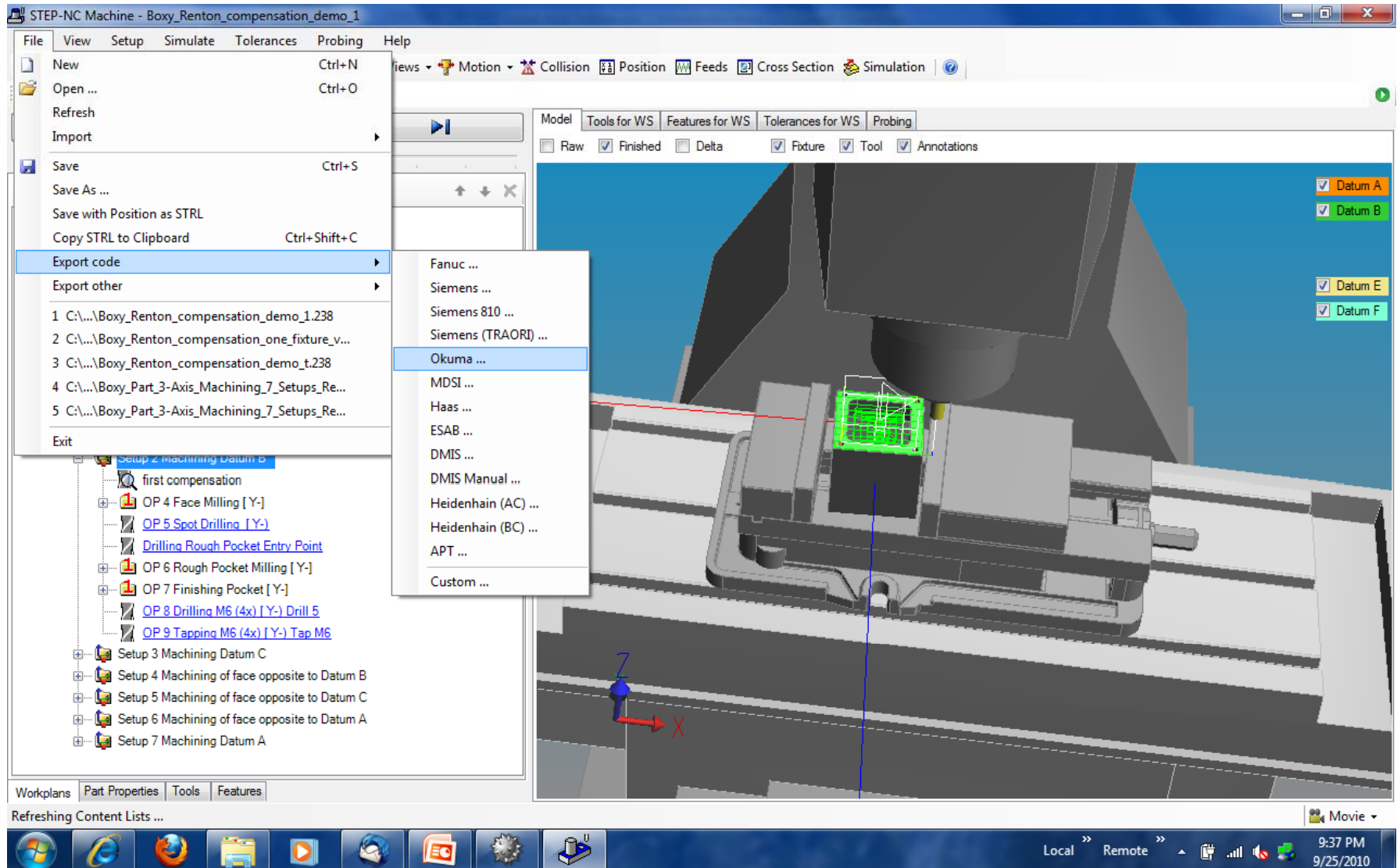
So have the toolpaths

STEP Tools, Inc.



Export the machine codes

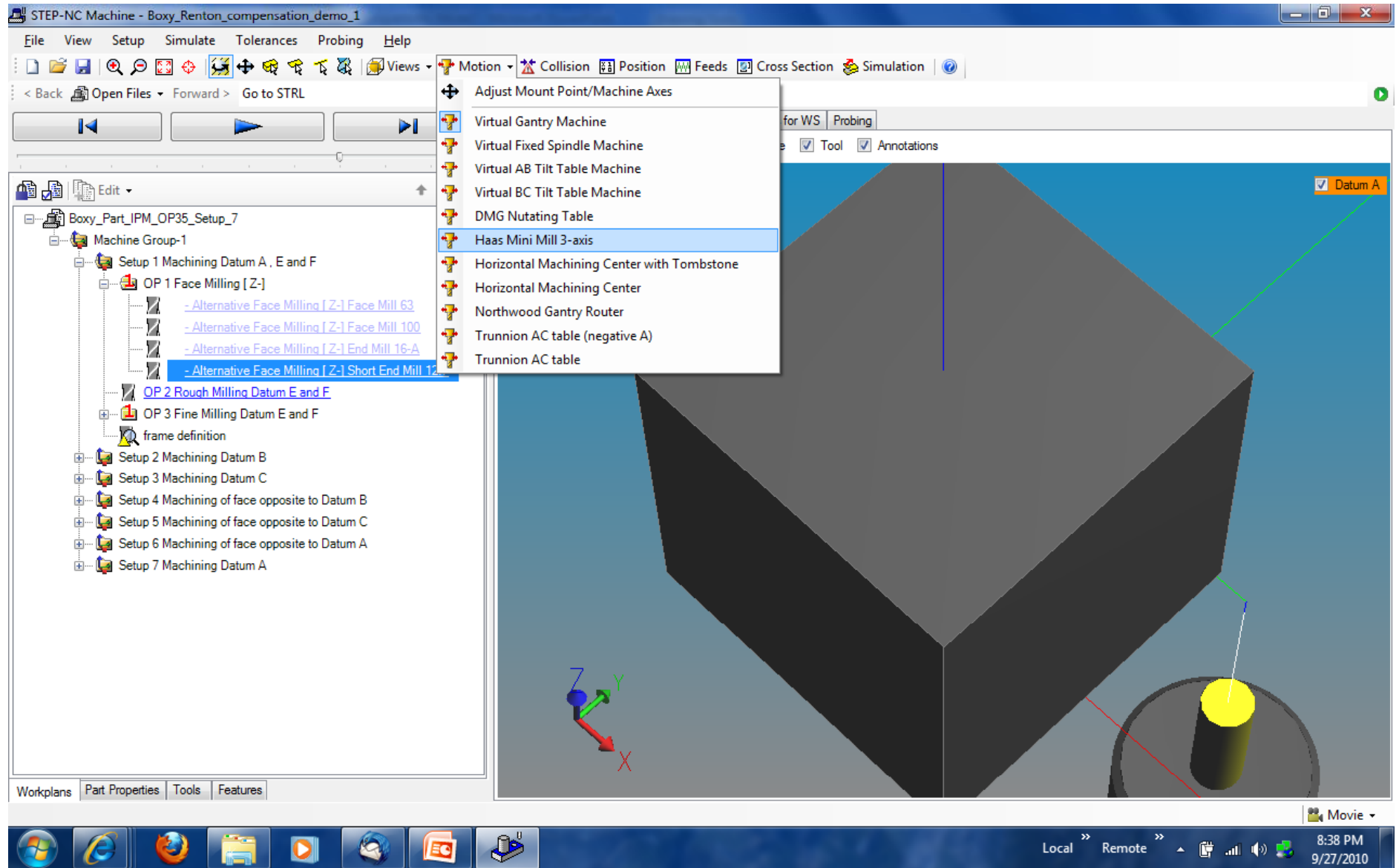
STEP Tools, Inc.



BACKUP

To load a machine tool

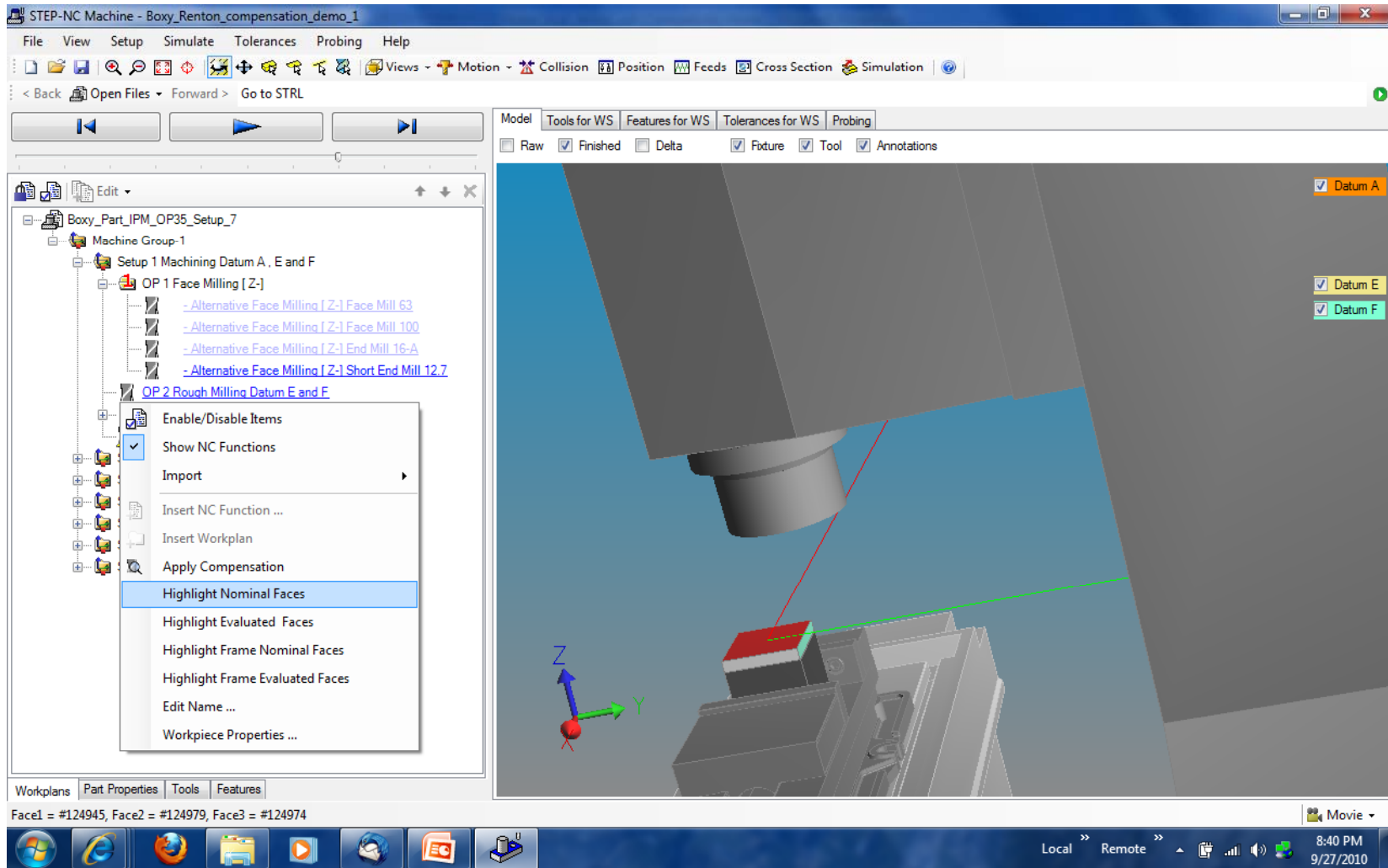
STEP Tools, Inc.



To see the faces that are to be measured

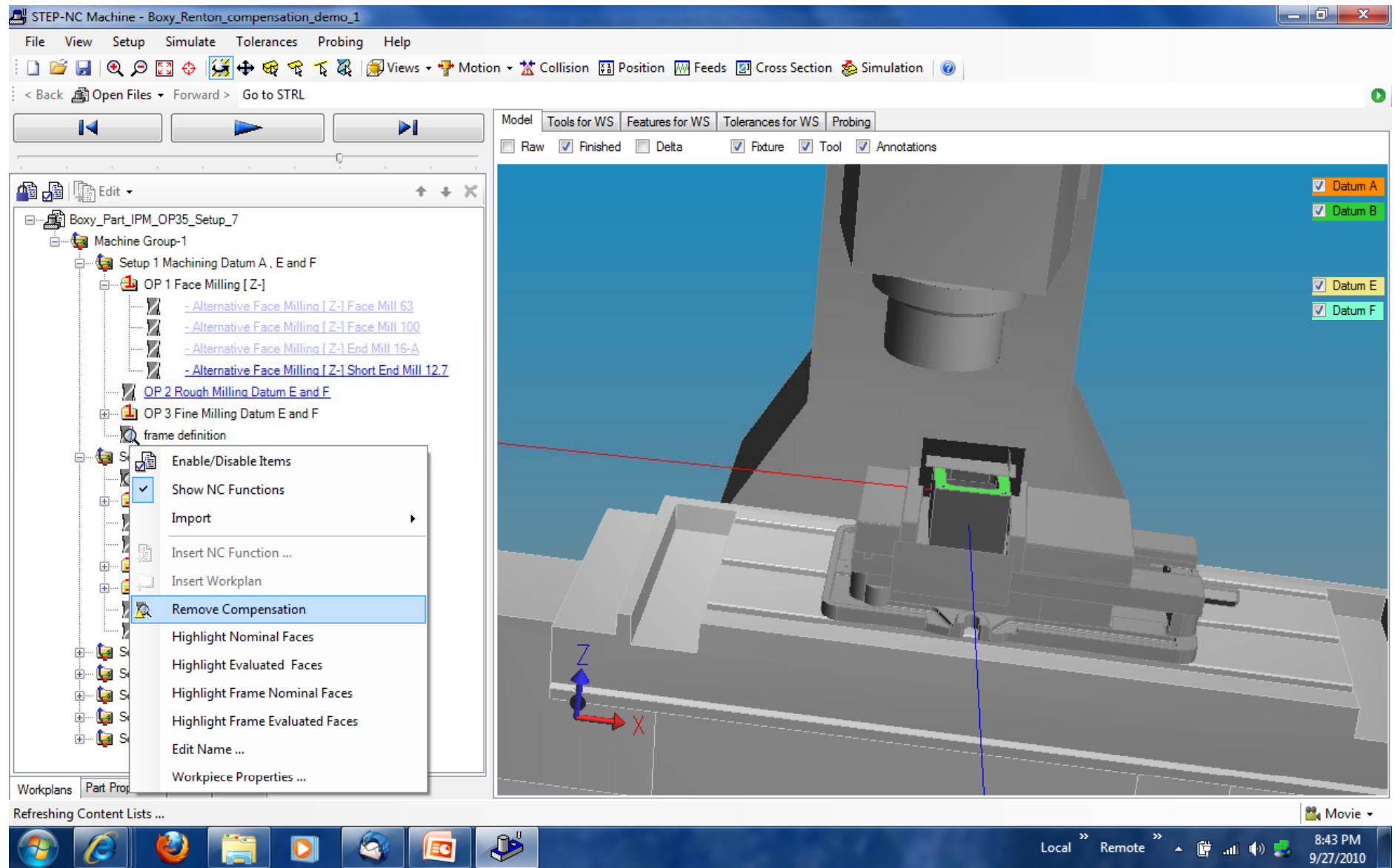
STEP Tools, Inc.

Red first face, **white** second, **light blue** third



To back out a compensation

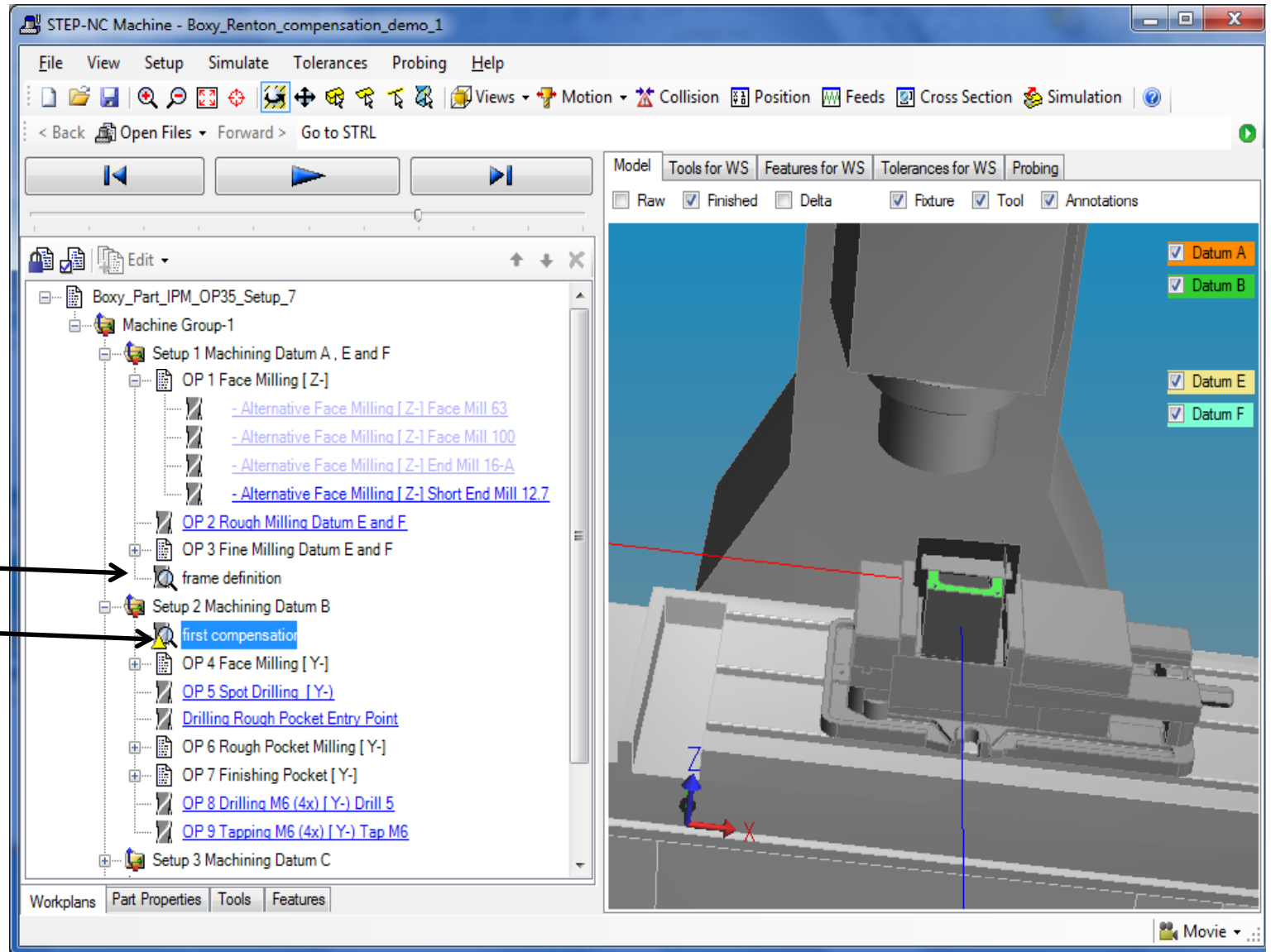
STEP Tools, Inc.



To check the status

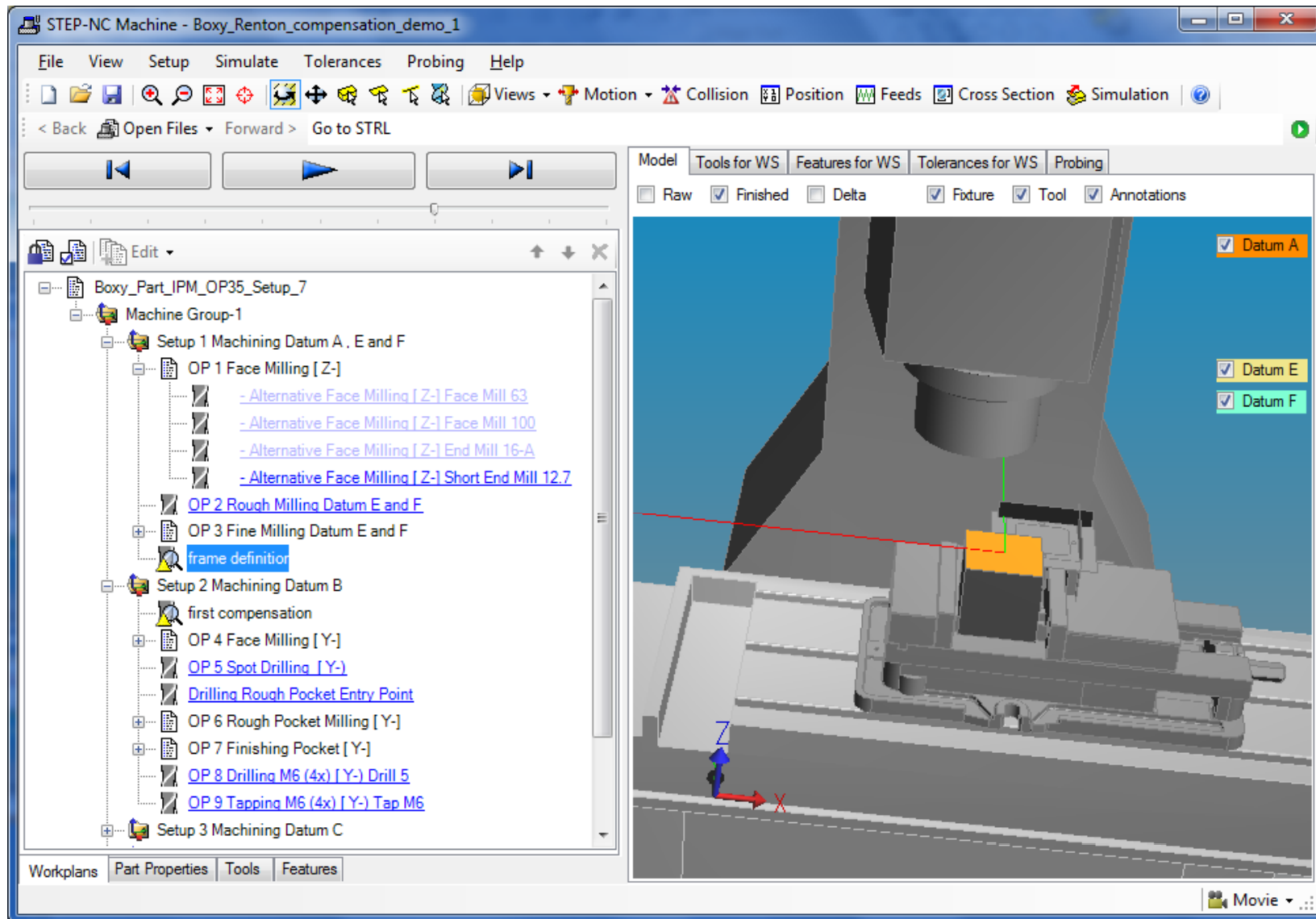
Applied

Removed



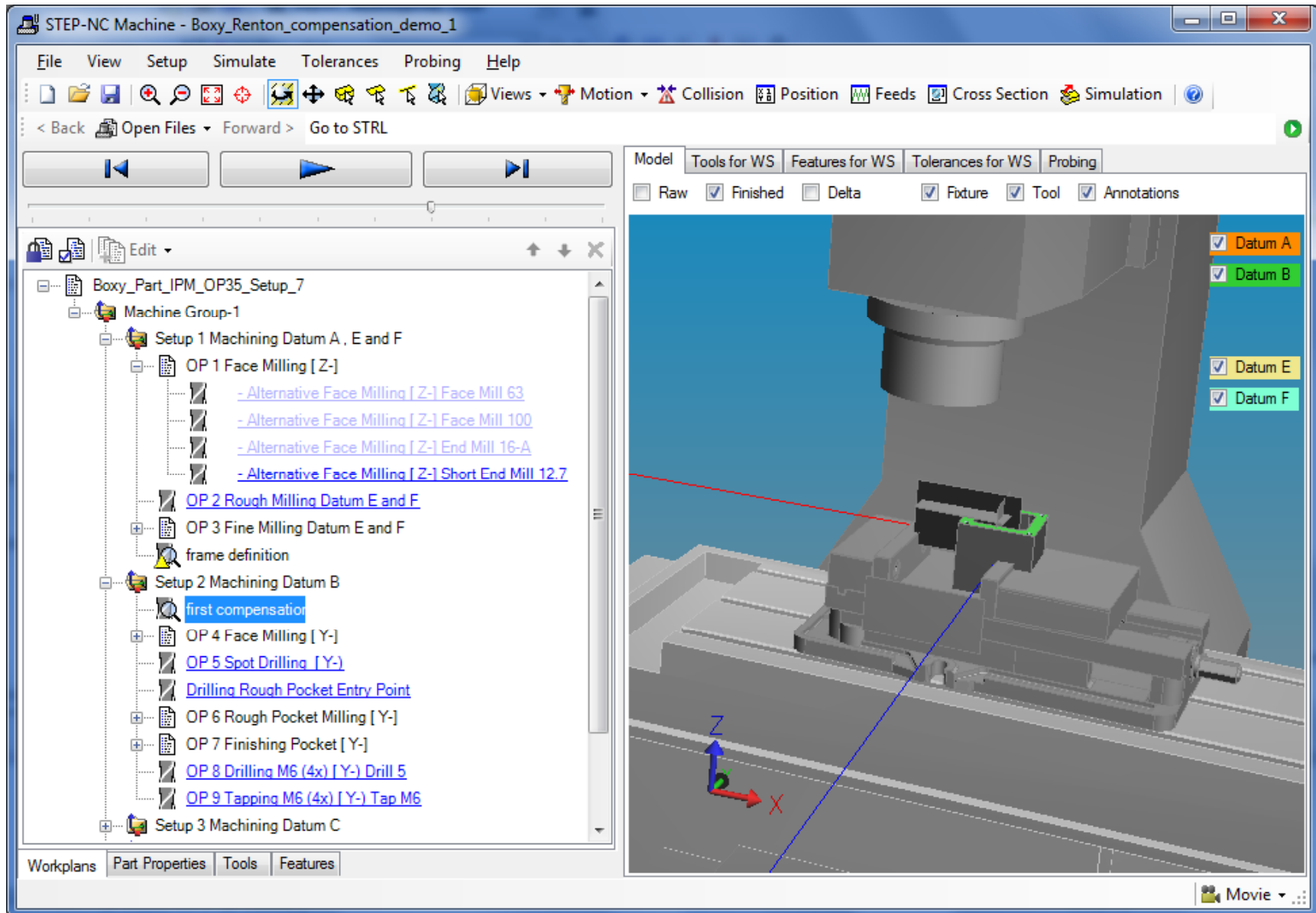
Both are now unapplied

STEP Tools, Inc.

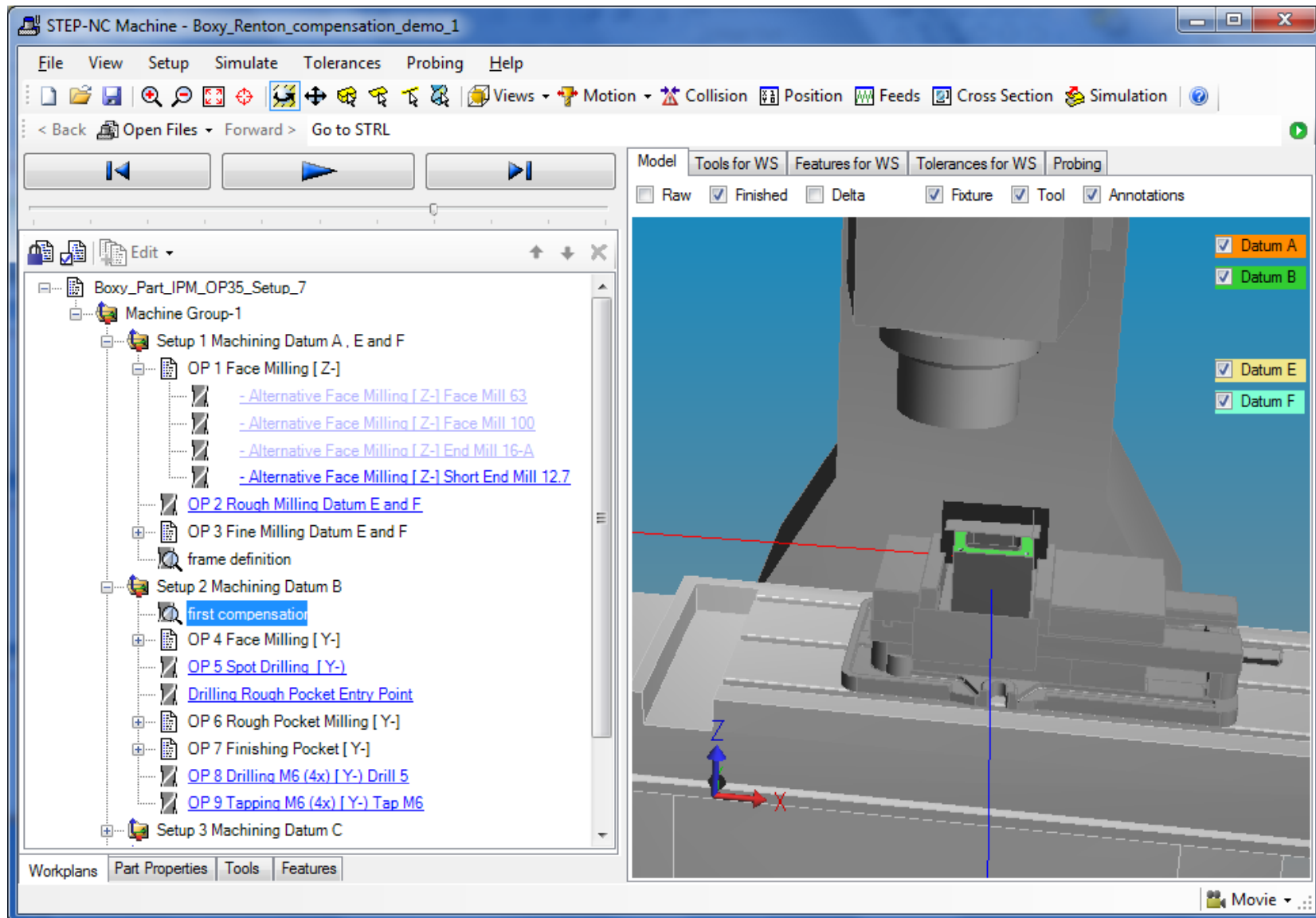


Compensation applied but not frame

STEP Tools, Inc.

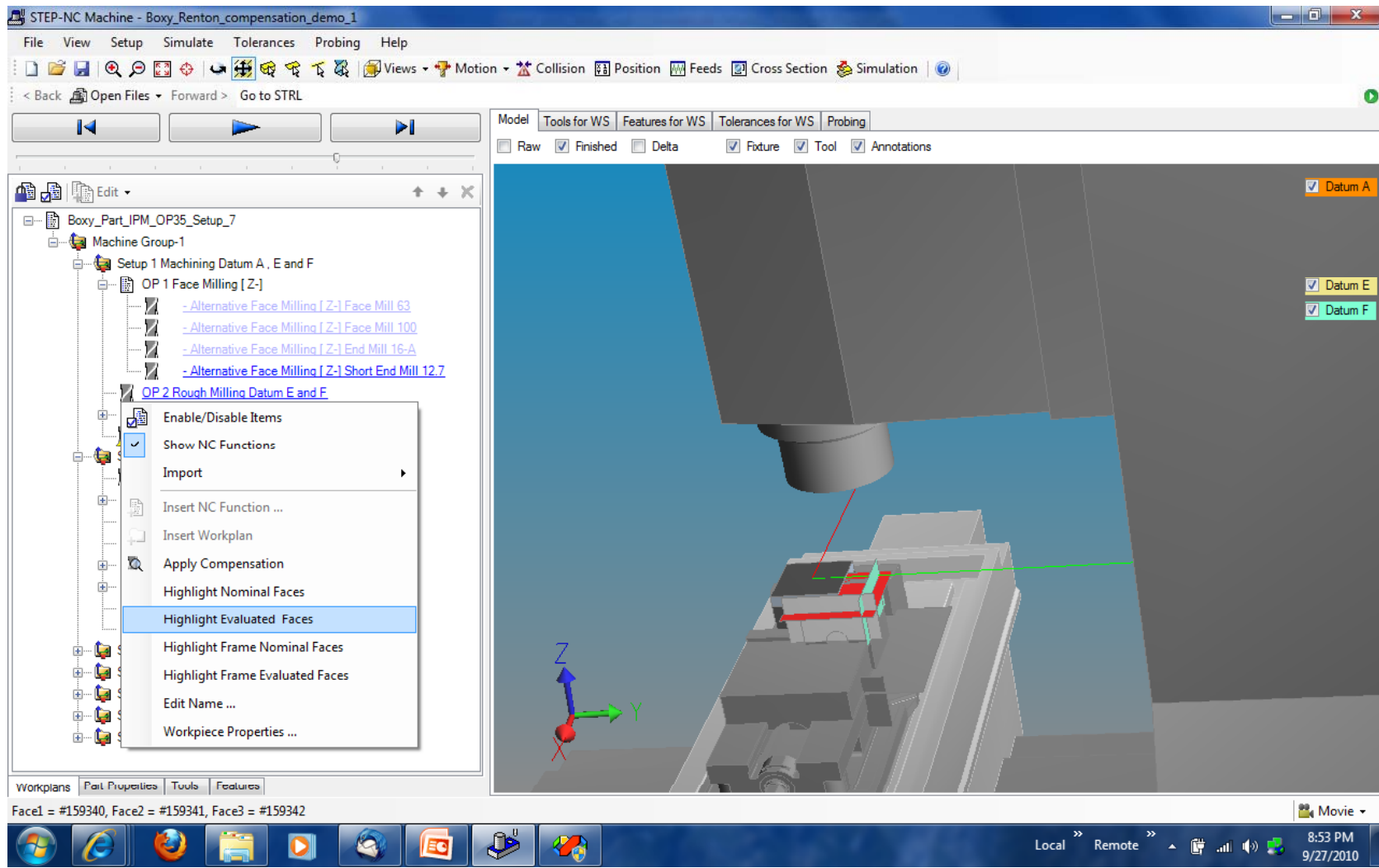


To fix: apply frame, unapply compensation **STEP Tools, Inc.** then apply compensation again



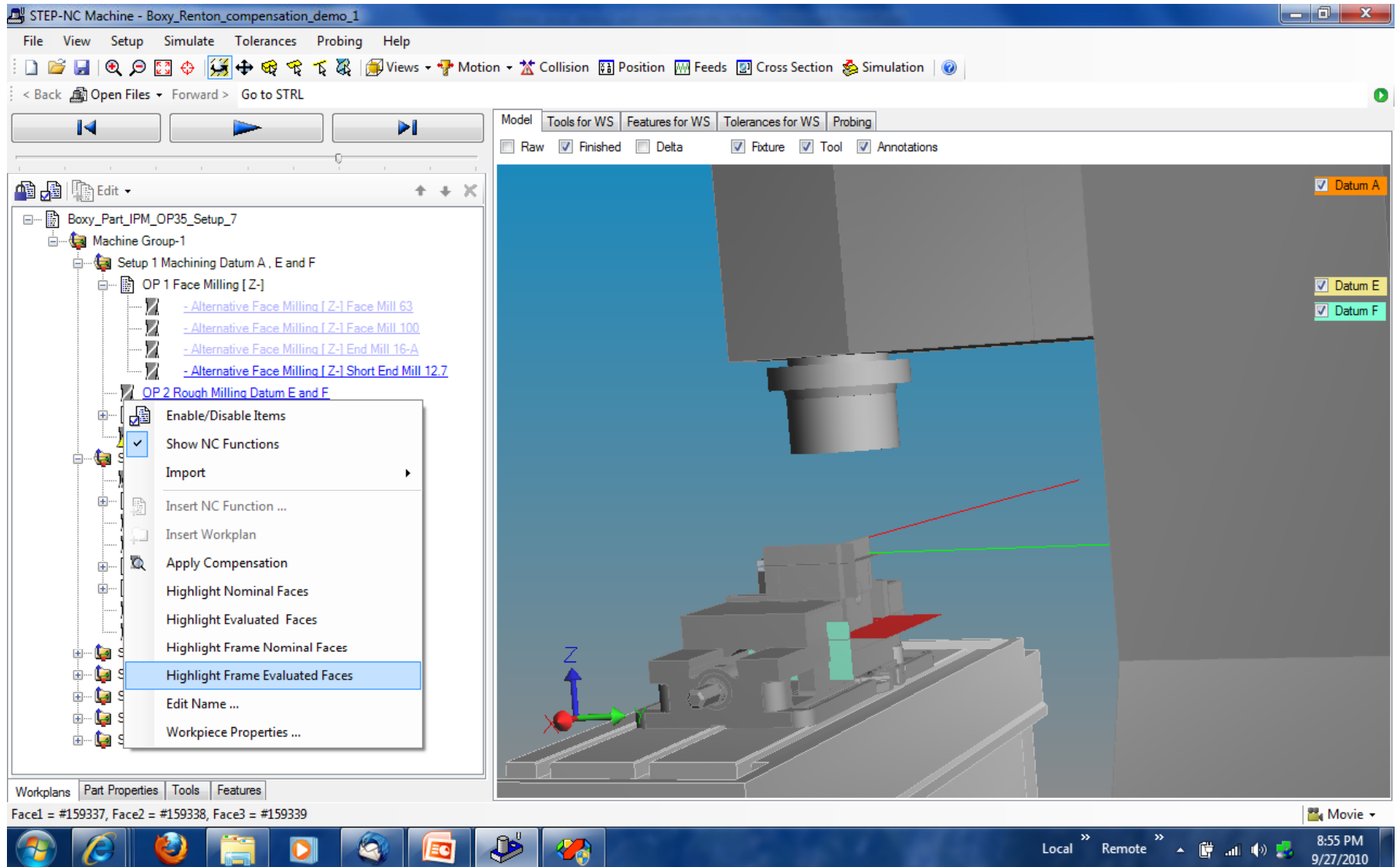
To see the measured faces (frame unapplied) STEP Tools, Inc.

Red first face, white second, light blue third



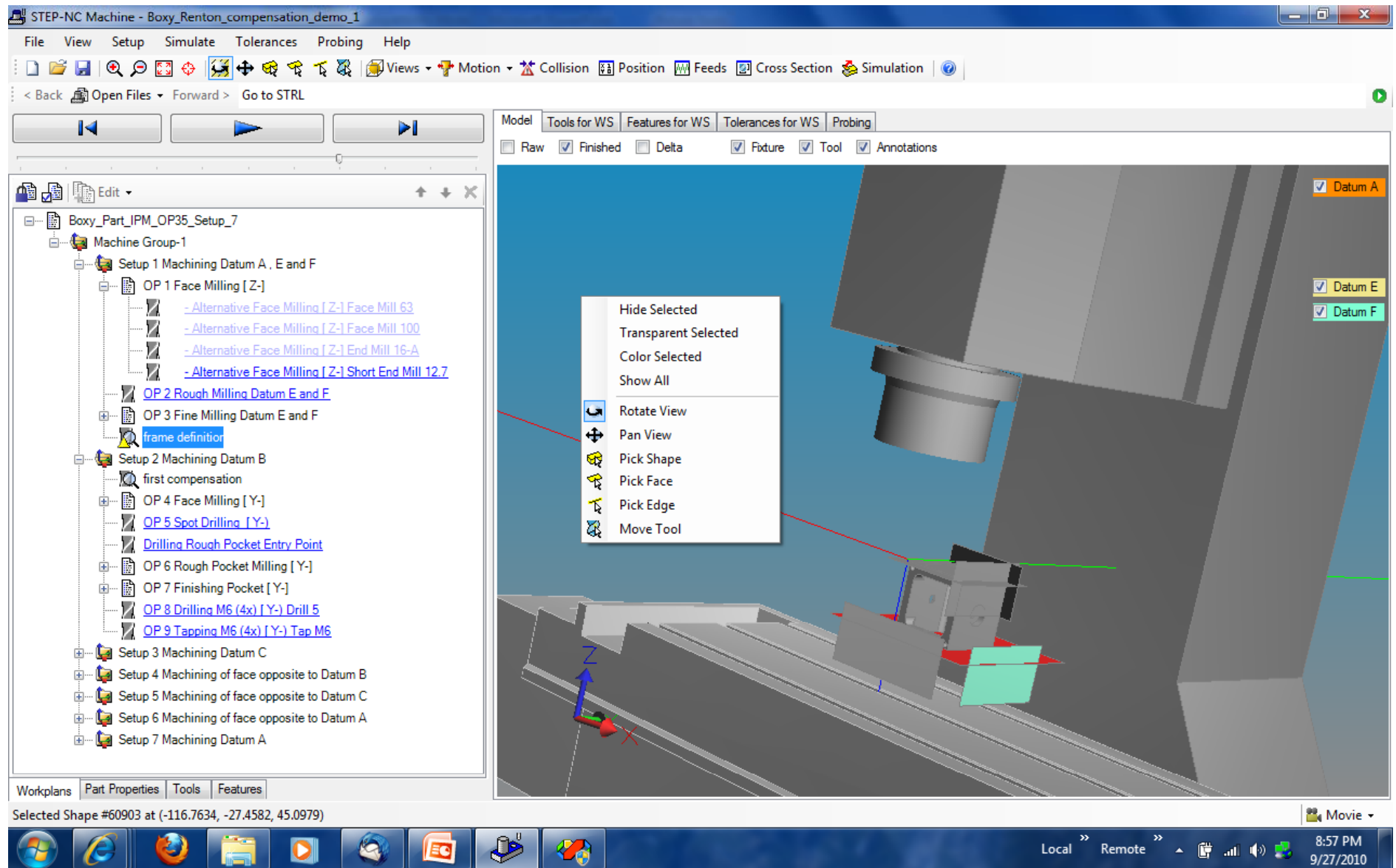
To see the machine tool faces

STEP Tools, Inc.



Right click to hide so can see better

STEP Tools, Inc.



To read measurements but not apply

STEP Tools, Inc.

