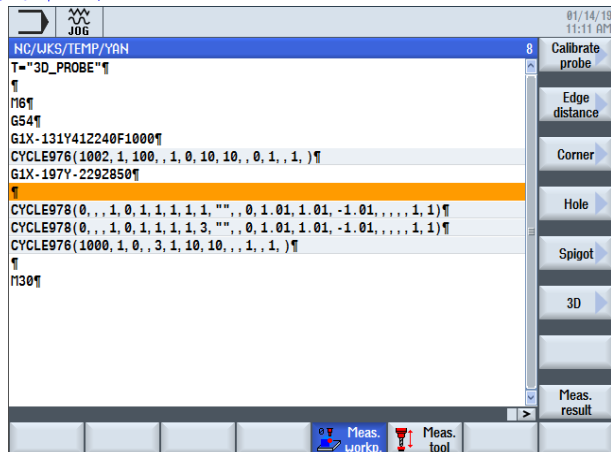


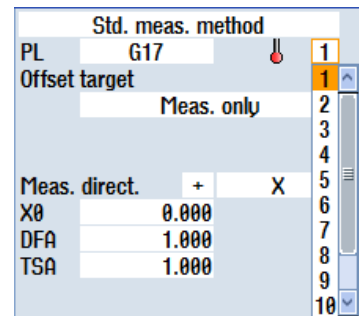
**Description:**

Setting for the input screen form, measuring cycles in automatic, workpiece measurement  
工件测量测量循环编程界面设置

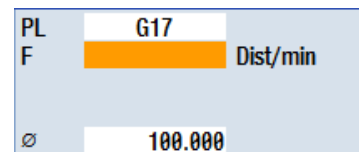
- Bit 1: Show selection of softkey 3D measurement**  
工件测量参数界面 ‘3D’ 测量软按键选择显示



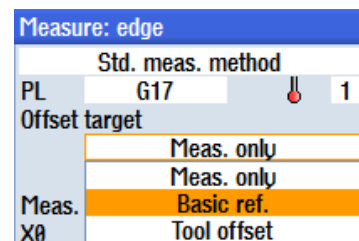
- Bit 3: Enable selection of probe calibration data field**  
工件探头校正数据组 (1...12) 选择使能



- Bit 4: Select Calibrate input measuring feed<sup>1)</sup>**  
工件探头校正界面测量进给率输入栏使能

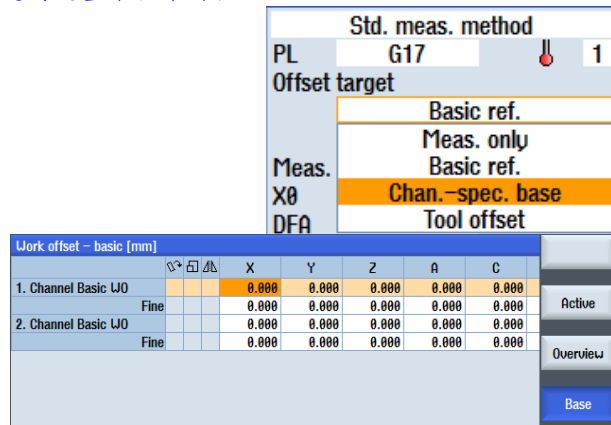


- Bit 6: Enable selection of WO compensation in basic frame (SETFRAME)**  
工件测量参数界面 ‘Offset target’ (偏置对象) 下拉菜单中 ‘Basic ref.’ (SETFRAME 基准框架) 选项使能



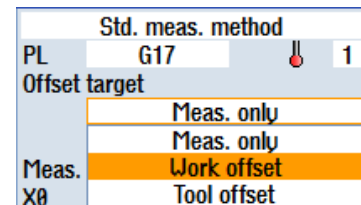
- Bit 7: Enable selection of WO compensation in channel-specific basic frame**

工件测量参数界面 ‘Offset target’（偏置对象）下拉菜单中 ‘Chan.-spec. base’（通道特定基准框架）选项使能，即在通道特定基本框架补偿误差

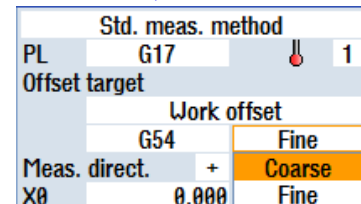


Bit 8: Enable selection of WO compensation in global basic frame  
在全局基准框架下 WO 补偿选择使能

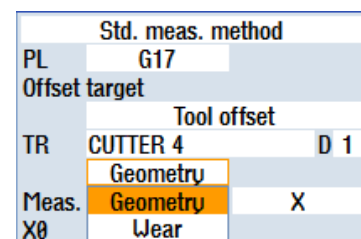
Bit 9: Enable selection of WO compensation in settable frame  
工件测量参数界面 ‘Offset target’（偏置对象）下拉菜单中 ‘Work offset’（工件偏置）选项使能



Bit 10: Enable selection of WO compensation coarse and fine  
当工件测量参数界面 ‘Offset target’（偏置对象）下拉菜单选中 ‘Work offset’ 或 ‘Basic ref.’ 或 ‘Chan.-spec. base’ 之后 ‘Coarse’（粗略）和 ‘Fine’（精细）选项使能



Bit 11: Select Tool offset Geometry and wear  
工件测量参数界面 ‘Offset target’（偏置对象）下拉菜单选中 ‘Tool offset’（刀具偏置）后的 ‘Geometry’（几何）和 ‘Wear’（磨损）选项使能，即选择工件测量误差在刀具几何尺寸中补偿，还是刀具磨损中补偿



Bit 12: Select Tool offset Not inverted and inverted  
工件测量参数界面 ‘Offset target’（偏置对象）下拉菜单选中 ‘Tool offset’（刀具偏置）后的 ‘Calculation’ 输入域 ‘Not inverter’（不取反）和 ‘Inverted’（取反）选项使能，即工件测量误差在刀具偏置的补偿是否取反

Offset target		
Tool offset		
TR	CUTTER 4	D 1
Wear		
Calculating		not inverted
Meas. direct.	+	not inverted
X0	0.000	Inverted

Bit 13: Select Tool offset L1, R or L1, L2, L3 R

工件测量参数界面‘Offset target’（偏置对象）下拉菜单选中‘Tool offset’（刀具偏置）后的‘Automatically’（自动）、‘Leng.L1’（长度1）、‘Leng.L2’（长度2）、‘Leng.L3’（长度3）或‘Radius’（半径）选项使能，即选择工件测量误差在刀具偏置具体哪个参数项补偿

Offset target		
Tool offset		
TR	CUTTER 4	D 1
Geometry		
Calculating		automatically
Meas. direct.	+	autom...cally
X0	0.000	Leng. L1
DFA	1.000	Leng. L2
TSA	1.000	Leng. L3
		Radius

Bit 14: Select Tool offset Work offset (\_TZL)

工件测量参数界面‘Offset target’（偏置对象）下拉菜单选中‘Tool offset’（刀具偏置）后的‘TZL’（刀具补偿公差，对应于最大意外尺寸偏差量）输入域使能，即工件测量误差刀具偏置补偿的公差，小于此公差属于正常加工误差，不进行刀具偏置补偿

Offset target		
Tool offset		
TR	CUTTER 4	D 1
Geometry		
Calculating		automatically
Meas. direct.	+	not inverted
X0	0.000	X
DFA	1.000	
TSA	1.000	
Dim. toler.		Yes
TUL	1.010	
TLL	-1.010	
TZL	0.000	

Bit 15: Select Tool offset Dimensional difference check (\_TDIF)

工件测量参数界面‘Offset target’（偏置对象）下拉菜单选中‘Tool offset’（刀具偏置）后的‘TDIF’（尺寸差监控公差范围）输入域使能，即在工件测量误差刀具偏置补偿中，当测量误差大于此公差时不进行刀具偏置补偿，并显示报警信息

Offset target		
Tool offset		
TR	CUTTER 4	D 1
Meas. direct.	+	X
X0	0.000	
DFA	1.000	
TSA	1.000	
Dim. toler.		Yes
TDIF	1.010	
TUL	1.010	
TLL	-1.010	

Bit 16: Select Workpiece measurement with spindle reversal

工件测量中‘3D probe w/ spindle ch/over’即手册中‘3D probe with spindle reversal’测量方式选择使能

Std. meas. method
Std. meas. method
3D probe w. spindle ch/over
Align 3D probe

**Bit 17:** Select Align workpiece probe in switching direction  
 工件测量中 ‘Align 3D probe’ 测量方式（在触发方向校正 3D 探头）选择使能

**Bit 18:** Select Number of measurements (\_NMSP)  
 工件测量中 ‘Meas.-ments’ 测量触碰次数 (\_NMSP) 选择

Meas.-ments	1
	1
	2
	3
	4
	5
	6
	7
	8
	9

**Bit 19:** Select Offset with averaging (\_TMV)<sup>1)</sup>  
 工件测量参数界面 ‘Offset target’（偏置对象）下拉菜单选中 ‘Tool offset’（刀具偏置）且 ‘Data set ave. value’（均值数据组）后的 ‘TMV’（计算平均值的偏置范围）输入域使能

Offset target		
Tool offset		
TR	CUTTER 4	D 1
Geometry		
		automatically
Calculating		not inverted
Meas. direct.	+	X
X0	0.000	
DFA	1.000	
TSA	1.000	
TUL	1.010	
TLL	-1.010	
TZL	0.000	
Data set ave. value		3
TMU	0.340	
FW	1.000	

**Bit 20:** Select Empirical values (\_EVNUM)  
 工件测量参数界面 ‘Offset target’（偏置对象）下拉菜单选中 ‘Tool offset’（刀具偏置）后的 ‘Data set emp. val’（经验值数据组）选择使能，适用于不符合偏差变化趋势的恒定偏差补偿

Offset target		
Tool offset		
TR	CUTTER 4	D 1
Meas. direct.		
	+	X
X0	0.000	
DFA	1.000	
TSA	1.000	
Dim. toler.		Yes
TUL	1.010	
TLL	-1.010	
Data set emp. val.		3

**Bit 21:** Select Additive setup offset  
 选择附加设置偏置

**Bit 22:** Select Calibrate to unknown or known center point  
 工件测量探头半径校正界面的 ‘Start p. in ring cen’（起点在中心点）选择使能适，即未知或已知中心点校正选择，一般具备定向功能的主轴可选择未知中心点校正

PL	G17
Start p. in ring cen	No
∅	100.000

**Bit 24: Select Calibrate with/without positional deviation**

工件测量探头半径校正界面的 ‘Det. pos. deviation’ (位置偏差监控) 选择使能


PL	G17
Det. pos.deviation	Yes
∅	100.000
DFA	10.000
TSA	10.000

**Bit 25: Select zero offset when measuring the angularity of the spindle**

当测量主轴角度时零点偏置使能

**Bit 26: Tool offset select not enabled**

工件测量参数界面 ‘Offset target’ (偏置对象) 下拉菜单中 ‘Tool offset’ (刀具偏置) 选项禁用

Std. meas. method	
PL	G17  1
Offset target	
	Meas. only
	Meas. only Work offset
Meas.	Tool offset
X0	0.000
DFA	1.000
TSA	1.000

**Bit 27: Select tolerance of linear vectors with kinematics measurement**

通过运动学测量选择线性矢量的公差

If WO compensation bit 6..10 is not selected, then offer "Measure only".

如果涉及 WO 补偿的位 6..10 均未置位时, 工件测量界面仅提供 ‘Meas. only’ 选项

If WO compensation bit 6..10 is selected, then always also offer compensation in active WO in the input screen

如果涉及 WO 补偿的位 6..10 置位时, 工件测量输入界面总提供 active WO (有效工件偏置) 补偿

For averaging, display the following parameters: \_K \_TMV, \_EVNUM

平均值计算, 以下参数: \_K \_TMV, \_EVNUM

**1) Input measuring feed applies to Automatic and JOG**

输入的进给率应用于自动和 JOG 方式