

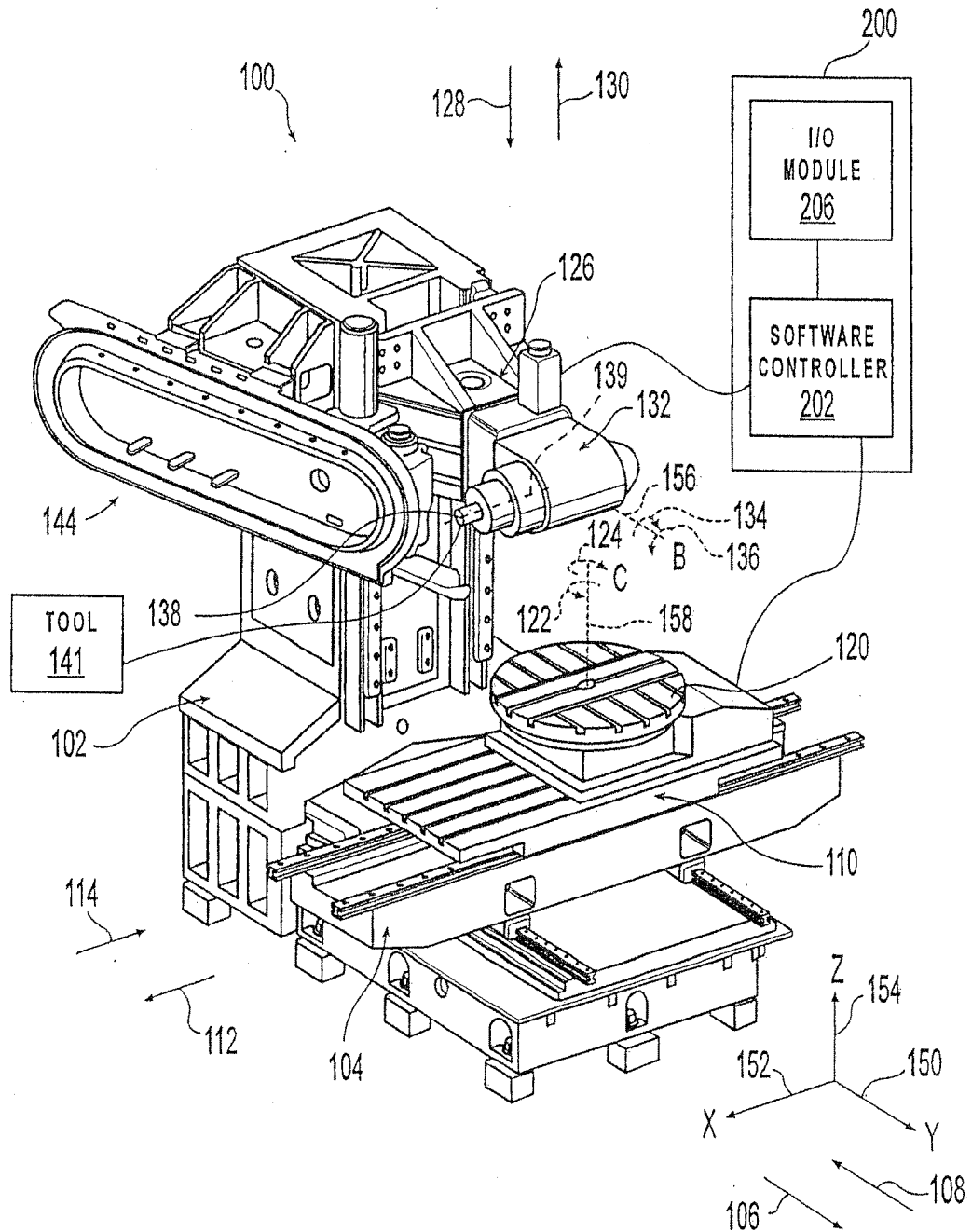


Fig. 1

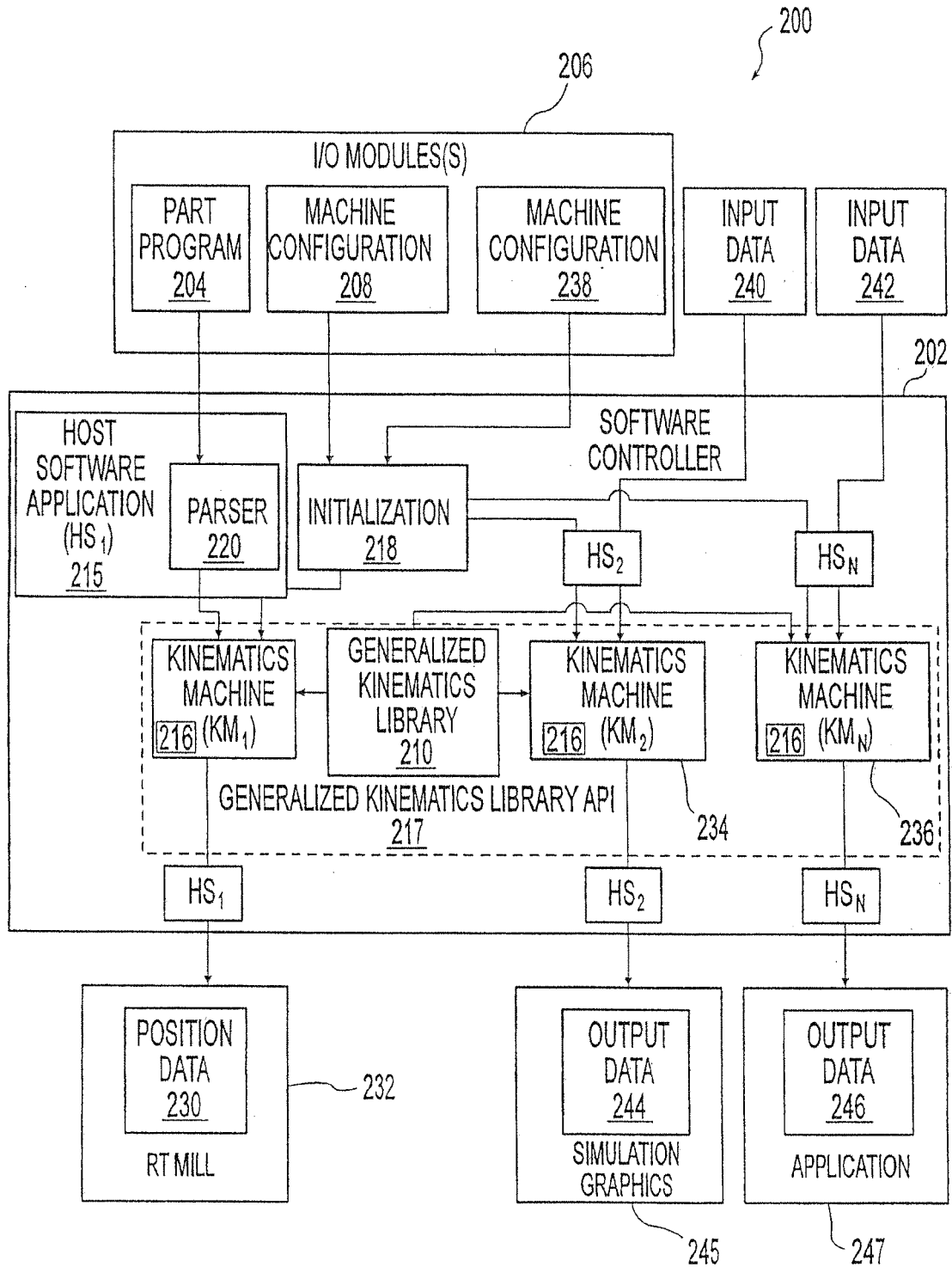


Fig. 2

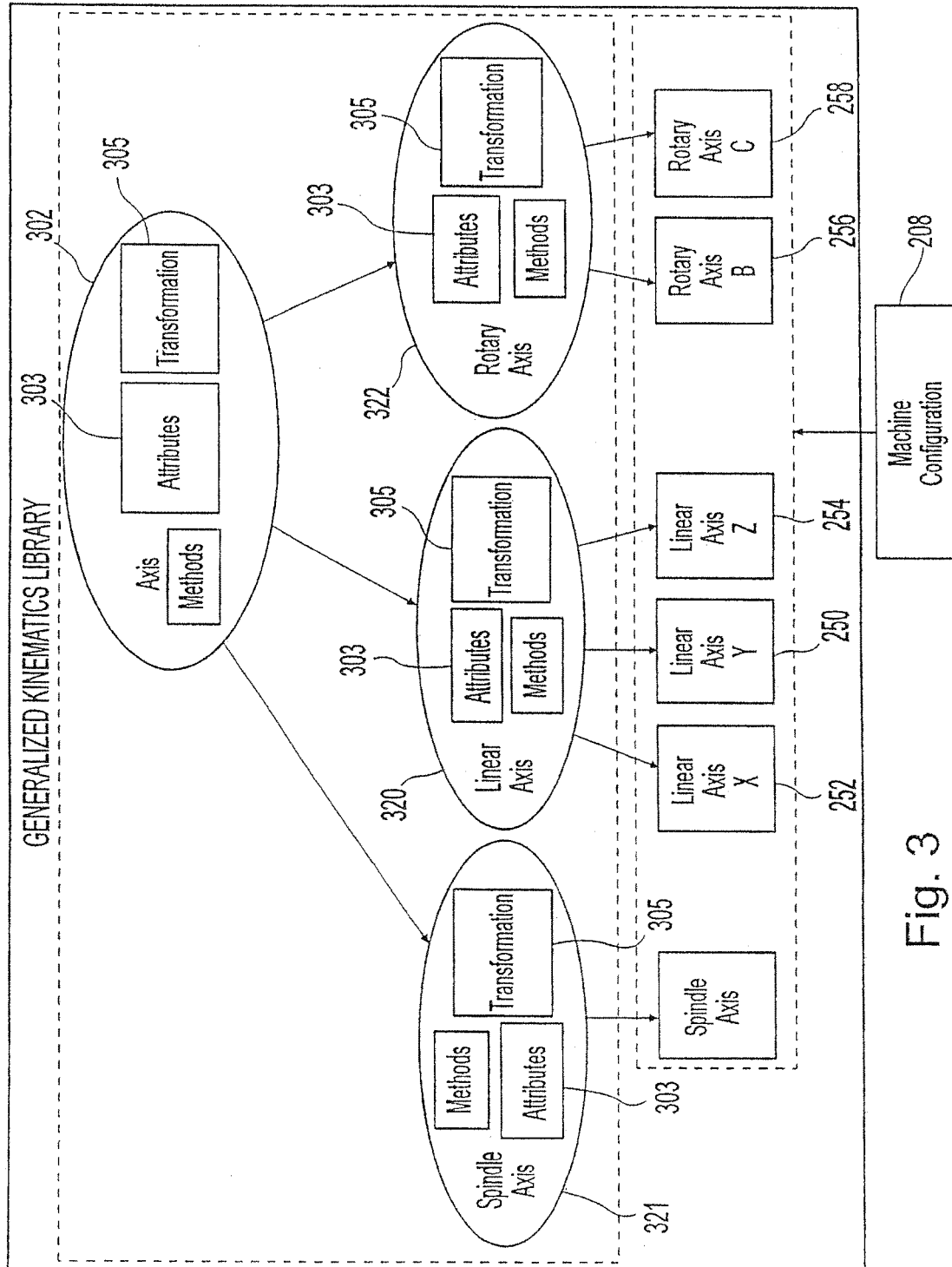


Fig. 3

328

INTEGRATOR SUPPORT SERVICES CNC CONFIGURATION PARAMETERS C AXIS			
GENERAL	ENCODER	LIMIT SW	CENTERLINE
ROTARY CONFIGURATION TYPE 330 FULL ROTARY 332 MAXIMUM RPM 33.3 CALIBRATION HOME POSITION 334 59.556 DEG			

FULL 360 DEGREE ROTARY	F1
TILT ROTARY	F2
	F3
	F4

Fig. 4A

328

INTEGRATOR SUPPORT SERVICES CNC CONFIGURATION PARAMETERS C AXIS			
GENERAL	ENCODER	LIMIT SW	CENTERLINE
ROTARY CENTERLINE X 336 726.819 ROTARY CENTERLINE Y 338 300.969 ENABLE CENTERLINE AUTOCALC? YES			

	F1
	F2
	F3
	F4

Fig. 4B

INTEGRATOR SUPPORT SERVICES
CNC CONFIGURATION PARAMETERS
B AXIS

328

GENERAL	ENCODER	LIMIT SW	CENTERLINE
ROTARY CONFIGURATION TYPE	330	TILT ROTARY	
MAXIMUM RPM	332	50.0	
CALIBRATION HOME POSITION	340	-51.356 DEG	
MINUS DIRECTION TRAVEL LIMIT	342	-92.000 DEG	
PLUS DIRECTION TRAVEL LIMIT	344	92.000 DEG	

FULL 360 DEGREE ROTARY
F1
TILT ROTARY
F2
F3
F4

Fig. 5A

INTEGRATOR SUPPORT SERVICES
CNC CONFIGURATION PARAMETERS
B AXIS

328

GENERAL	ENCODER	LIMIT SW	CENTERLINE
ROTARY CENTERLINE X	50.035 346		
ROTARY CENTERLINE Z	242.156 348		
ENABLE CENTERLINE AUTOCALC?	YES		

F1
F2
F3
F4

Fig. 5B

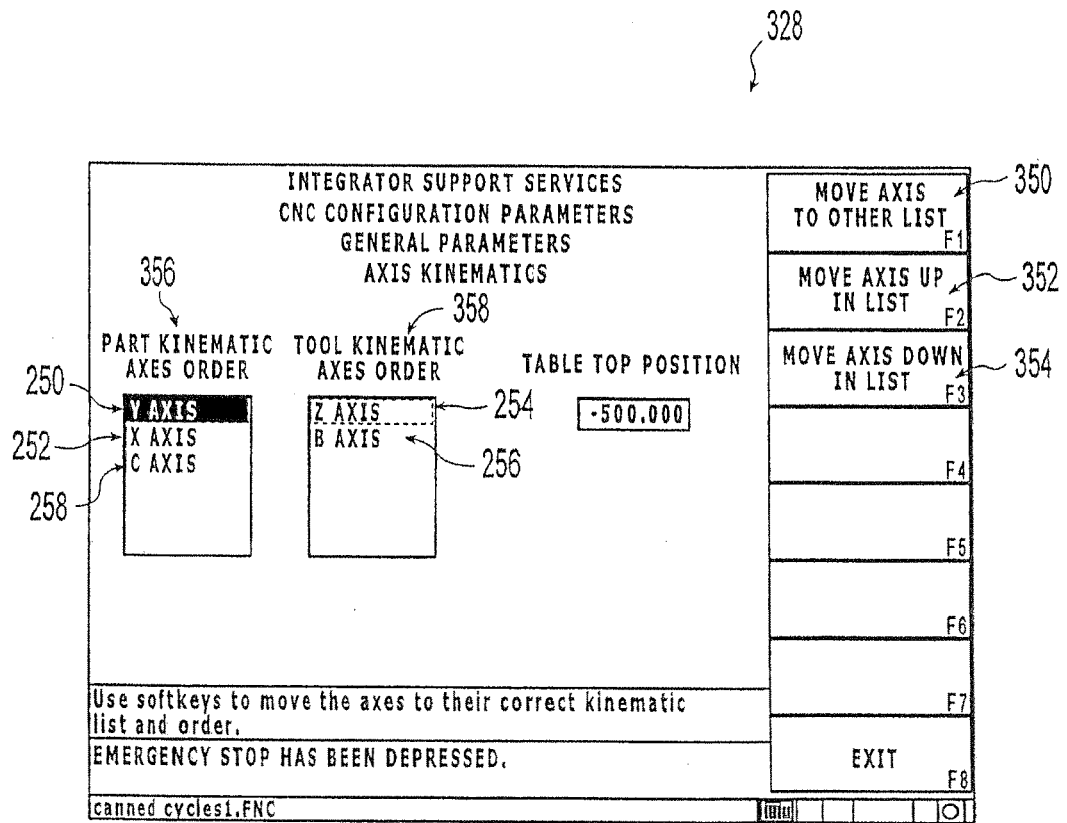
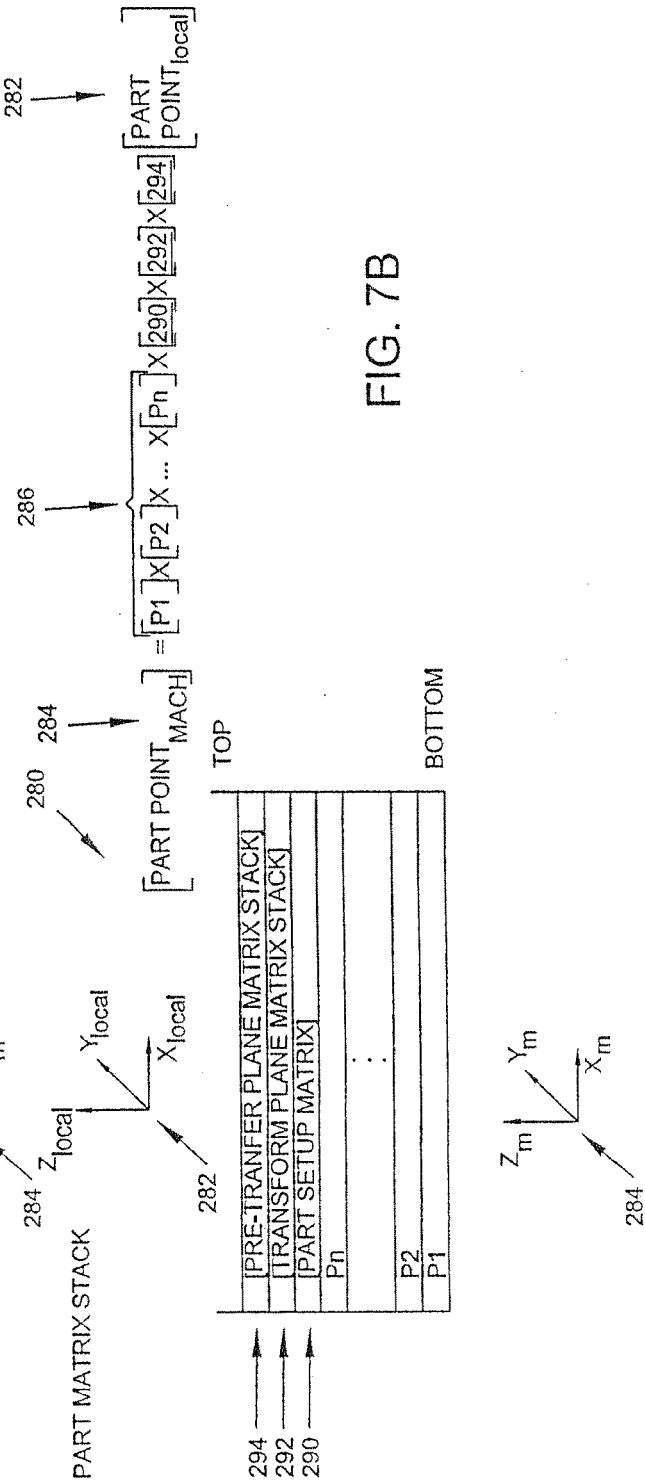
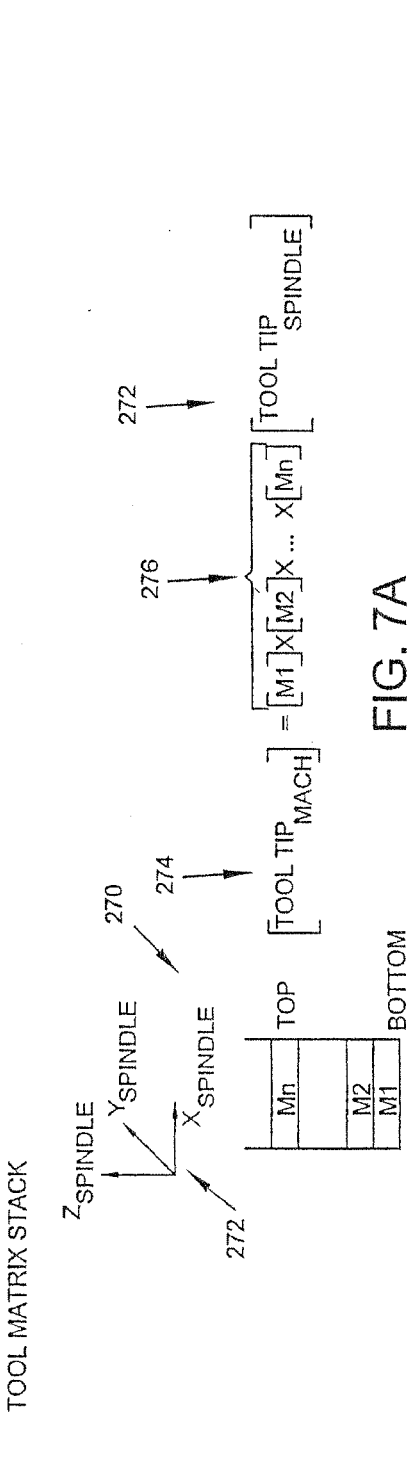


Fig. 6



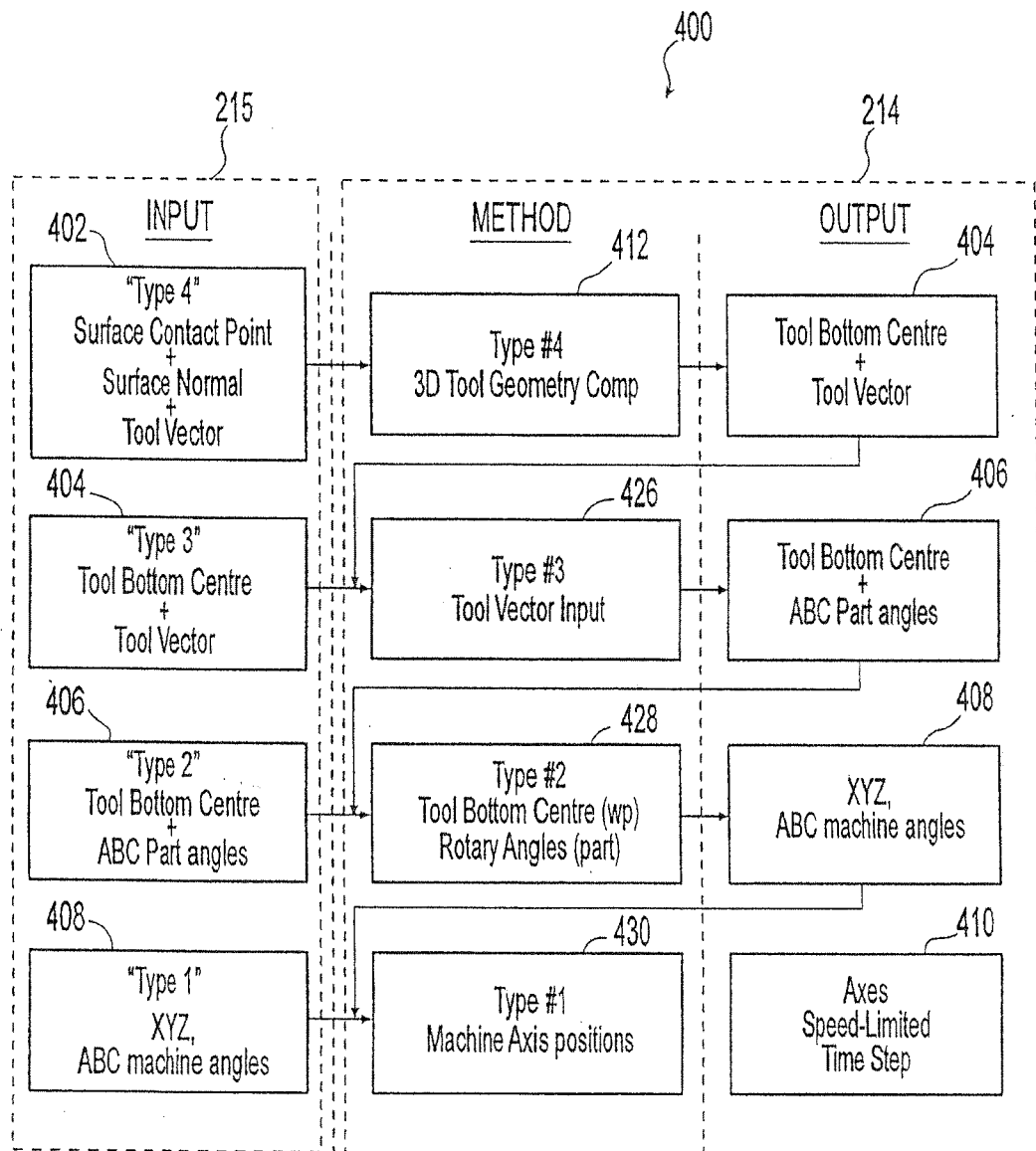
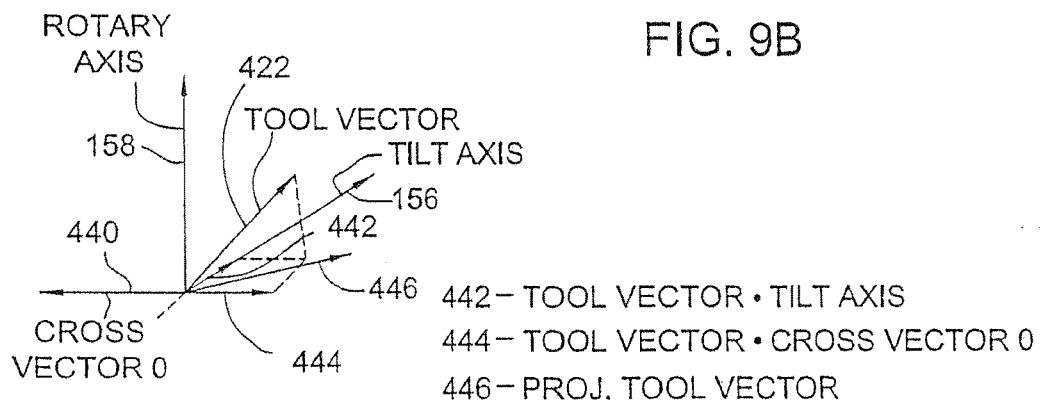
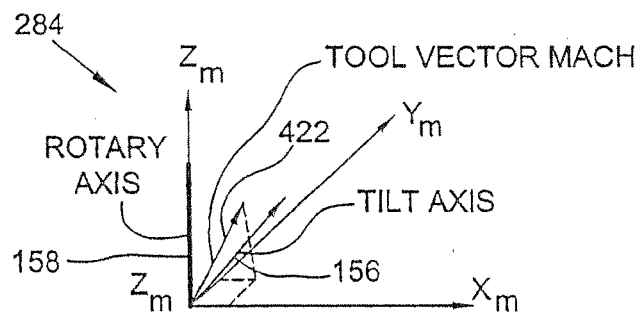
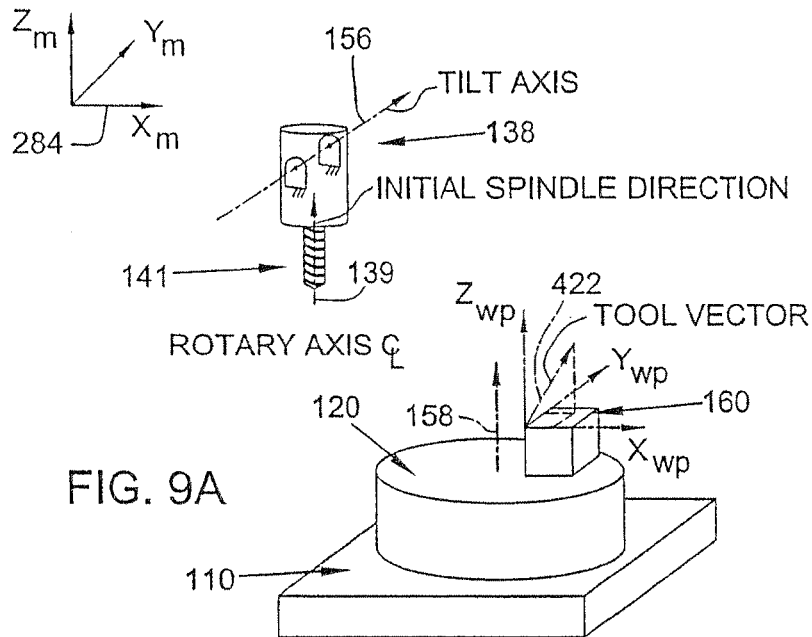
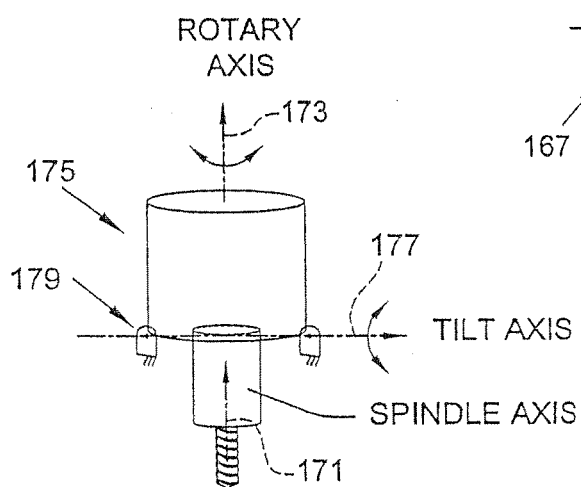
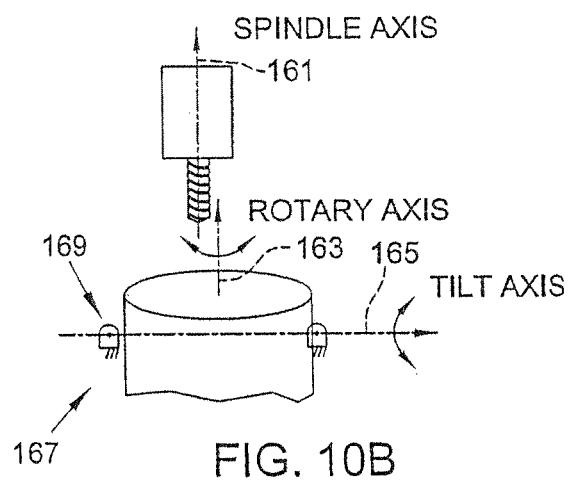
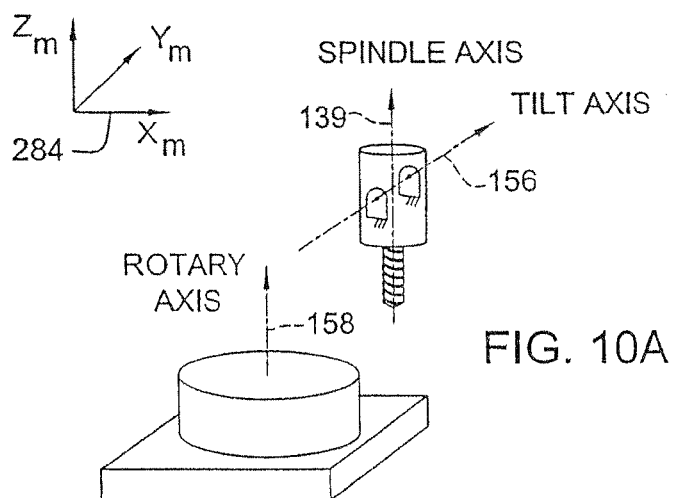


Fig. 8



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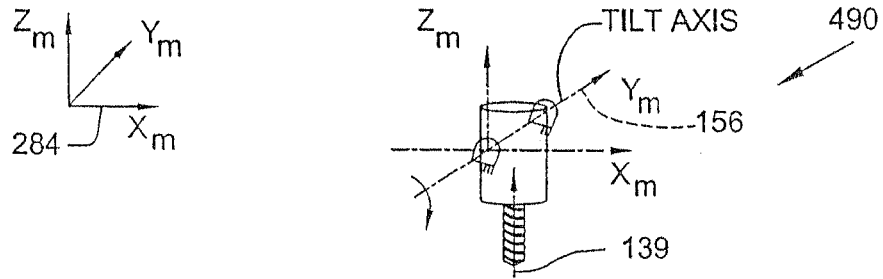


FIG. 11A

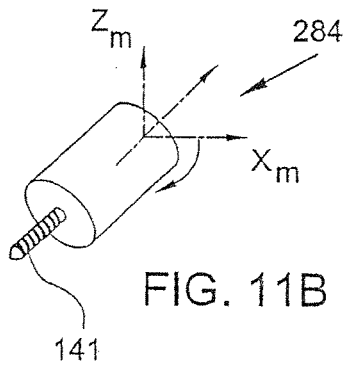


FIG. 11B

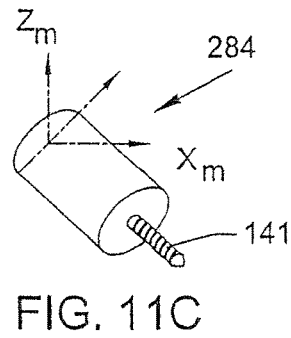
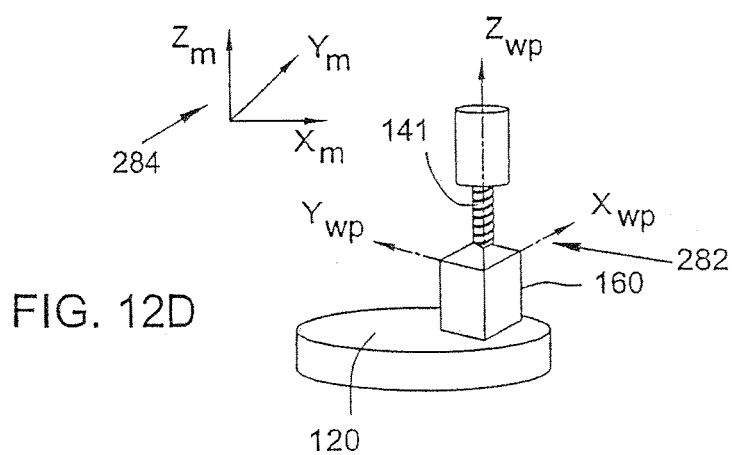
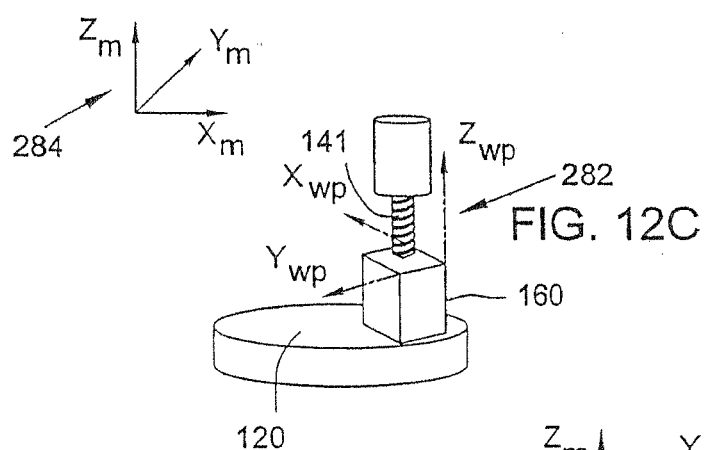
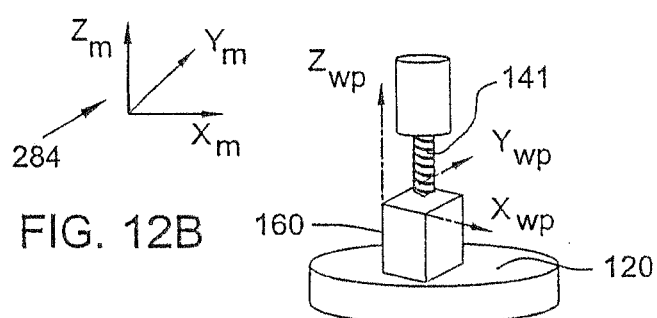
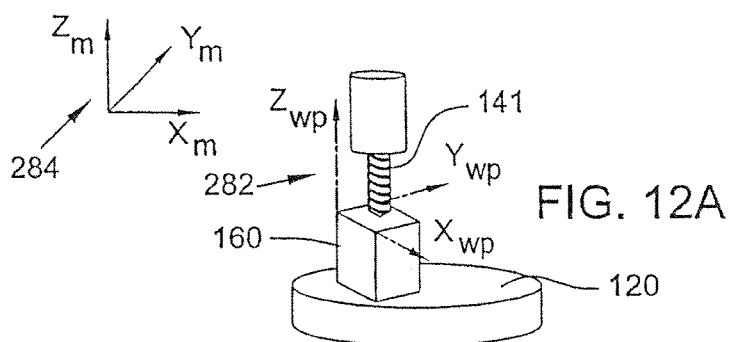
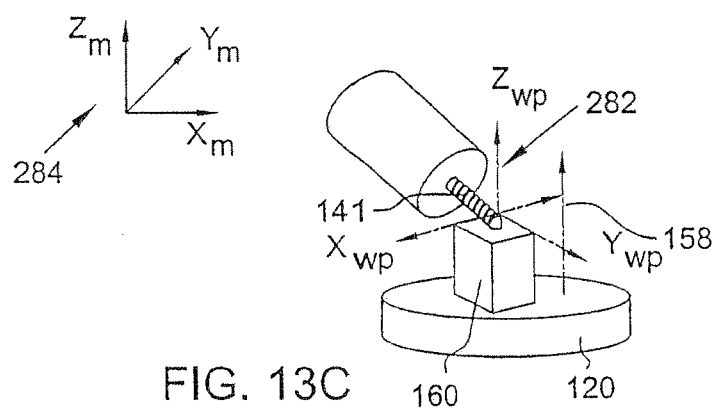
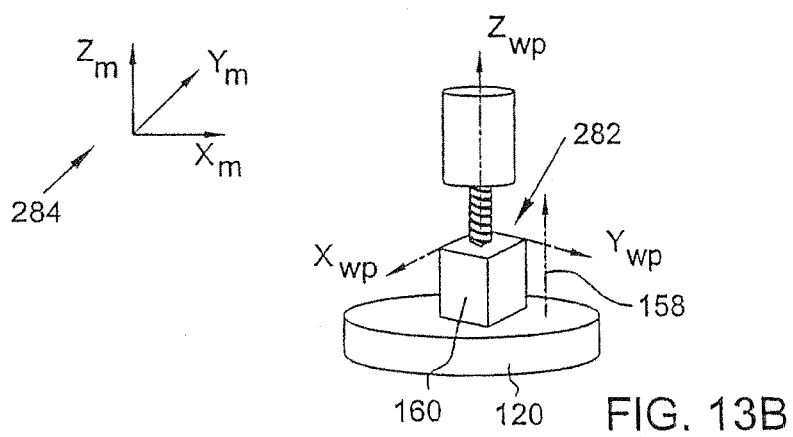
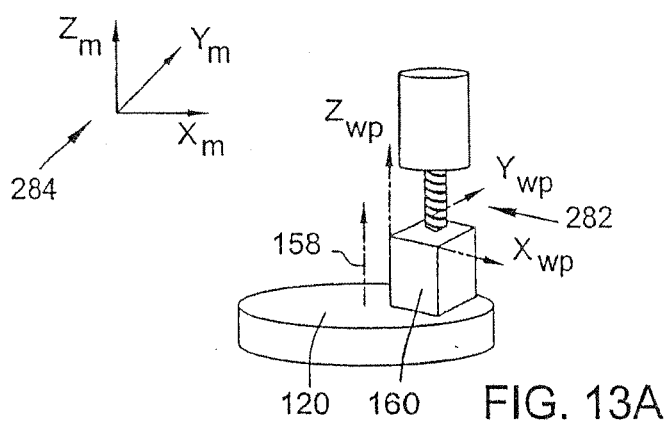


FIG. 11C

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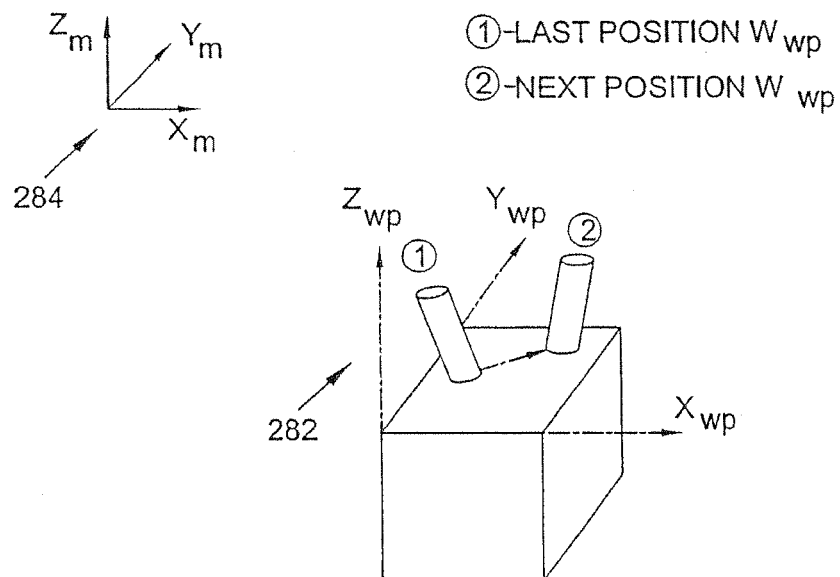


FIG. 14A

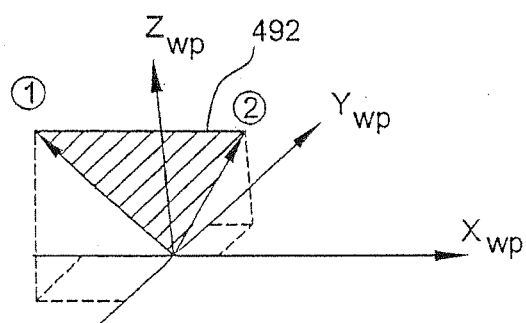
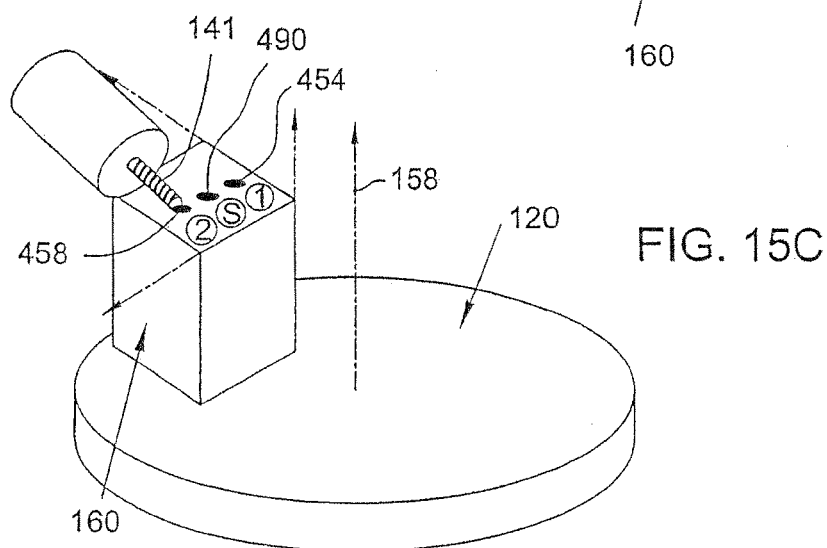
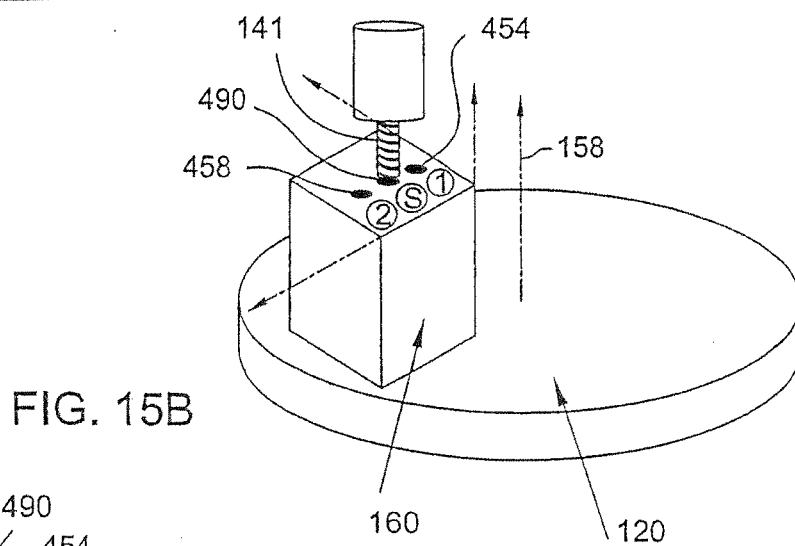
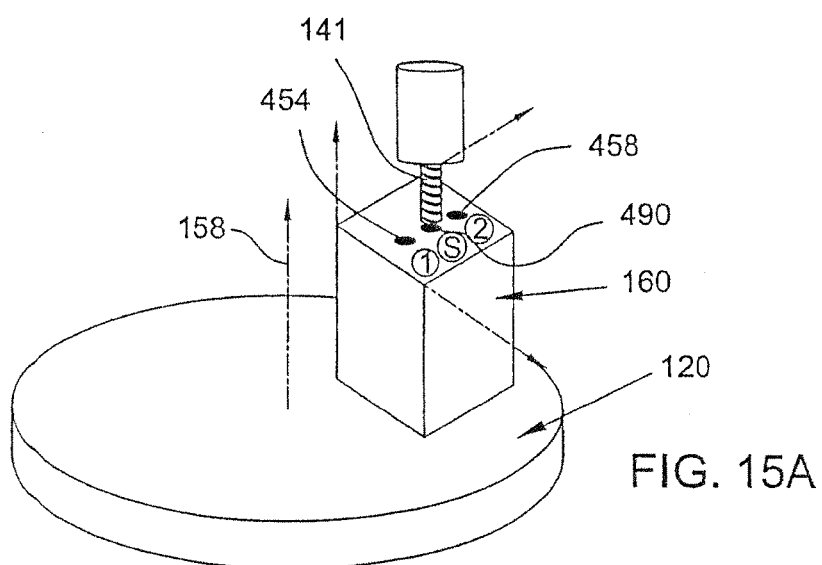
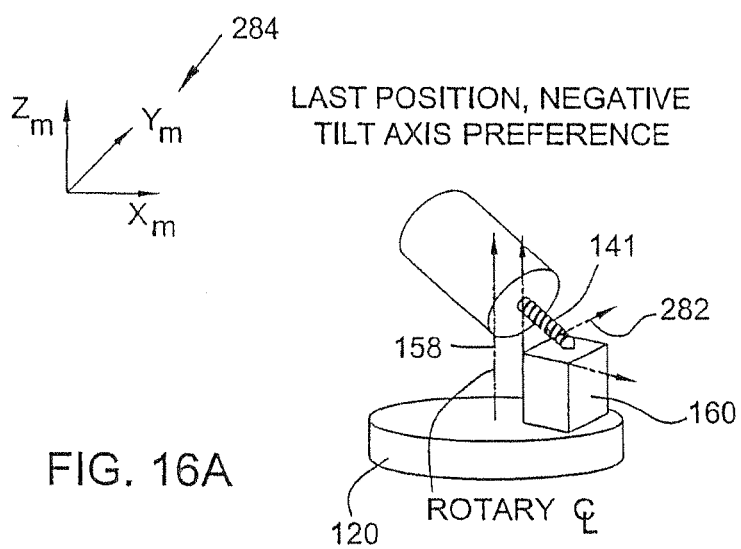


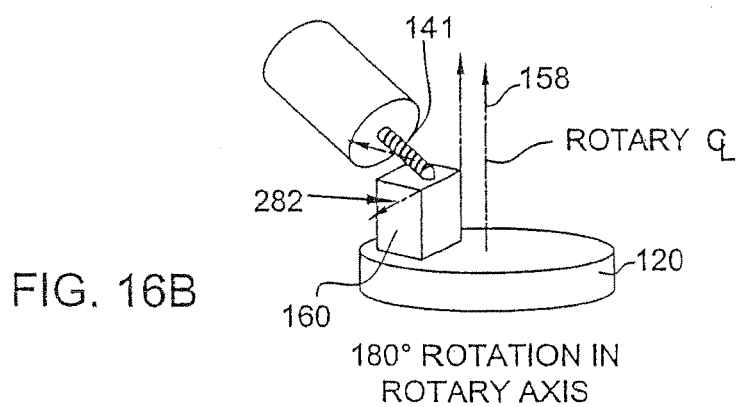
FIG. 14B

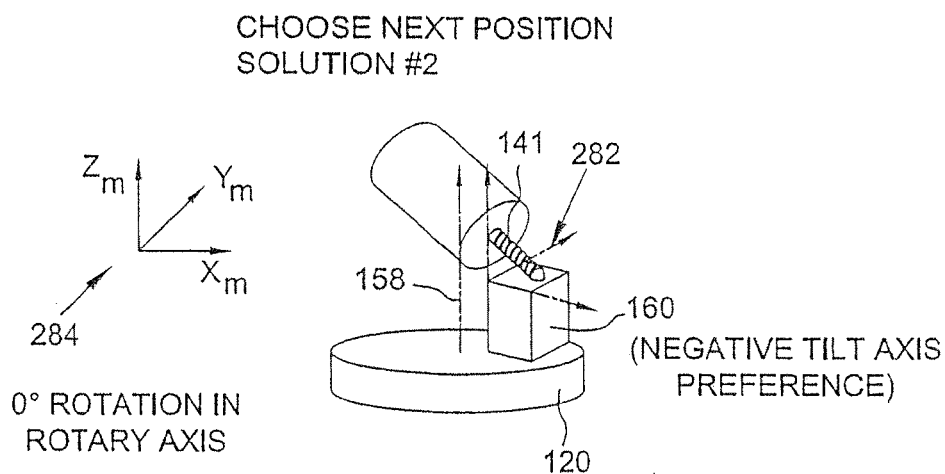
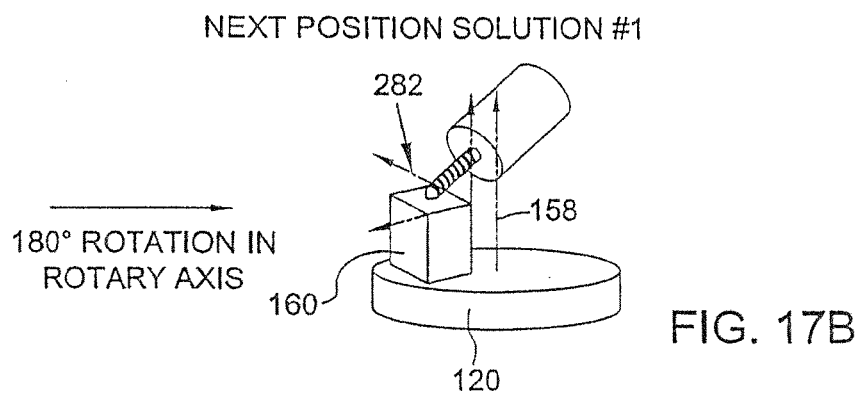
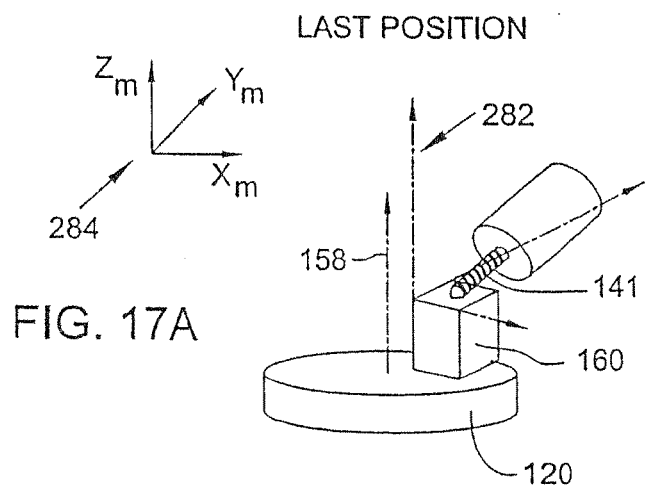
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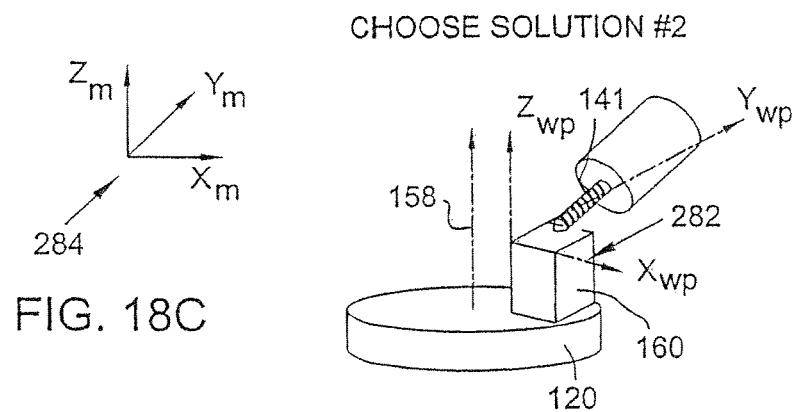
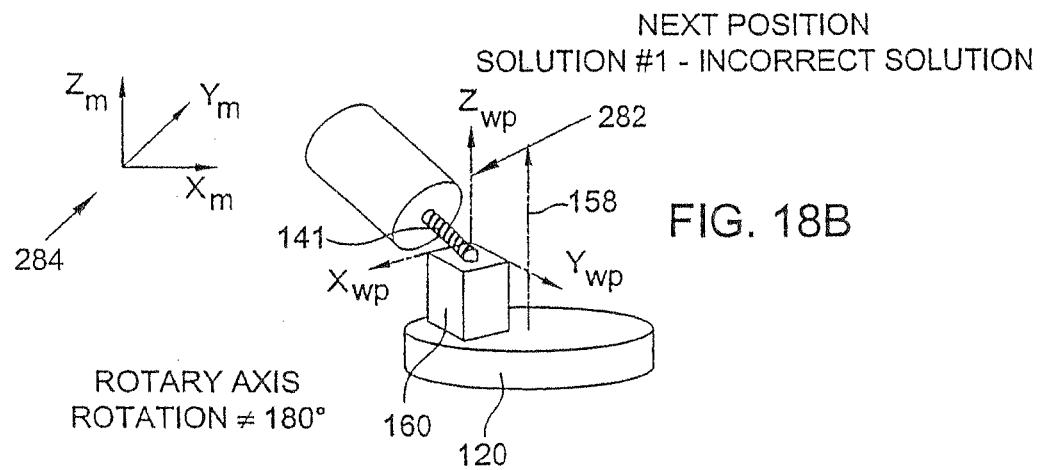
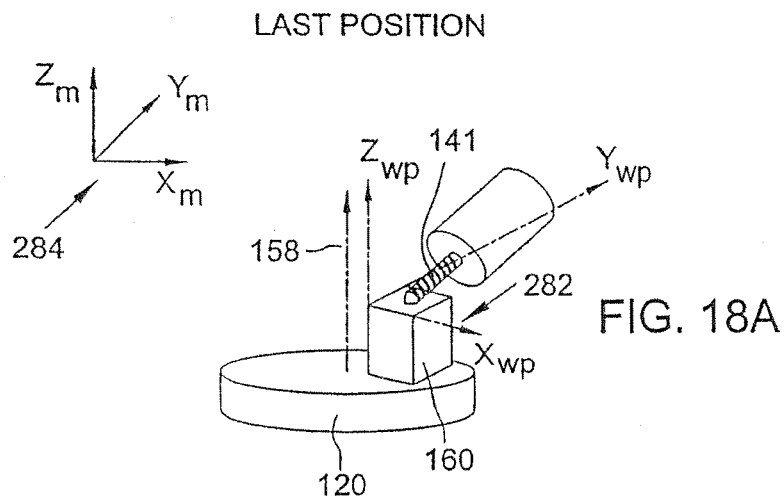




NEXT POSITION SOLUTION #1







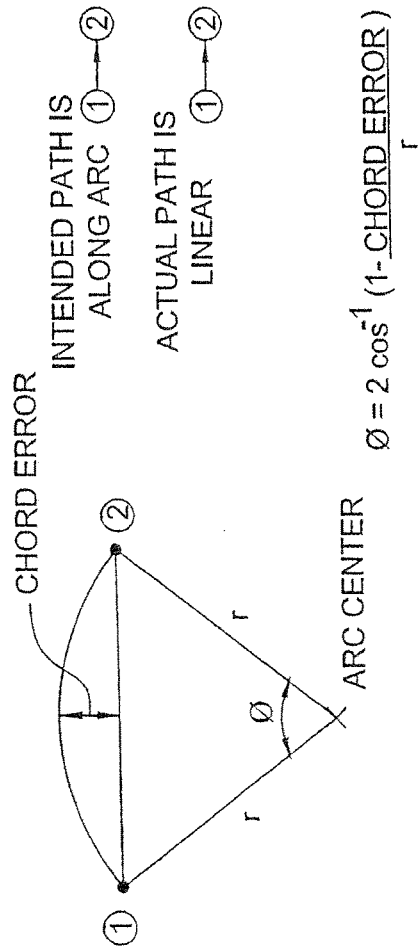


FIG. 19

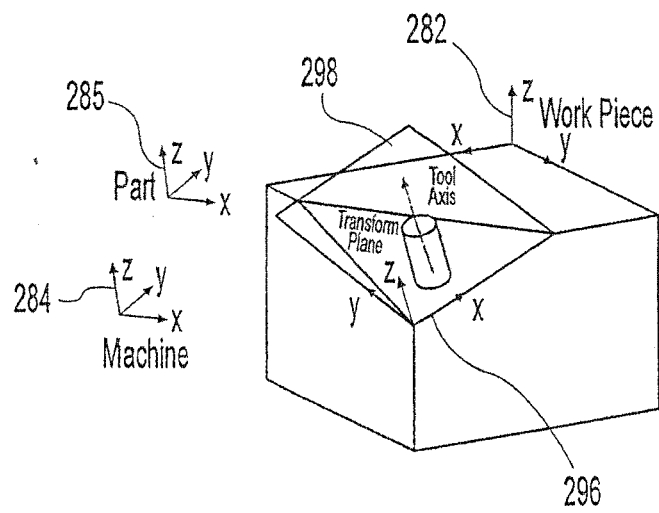


Fig. 20

LINEARIZATION TOLERANCES

☐ ANGULAR STEP TOLERANCES
 TILT AXIS TOLERANCE
 ROTARY AXIS TOLERANCE
☒ ROTATION AXIS CHORD ERROR

☐ TOOL VECTOR CHANGE TOLERANCE
☒ TIME STEP TOLERANCE (MILLISECONDS)

☒ ANSI ROTARY TABLE AXES

 TILT AXIS PREFERENCE
 ENABLE PATH PLANNING DMP FILES

 Choose positive or negative for larger work volume.
 Choose neutral if no preference.

496

0.100

498

0.100

501

0.250

503

25.0

NEGATIVE

NEUTRAL

POSITIVE

NEGATIVE

NEUTRAL	F1
POSITIVE	F2
NEGATIVE	F3
	F4
	F5
	F6
	F7
EXIT	F8

494

482

Fig. 21

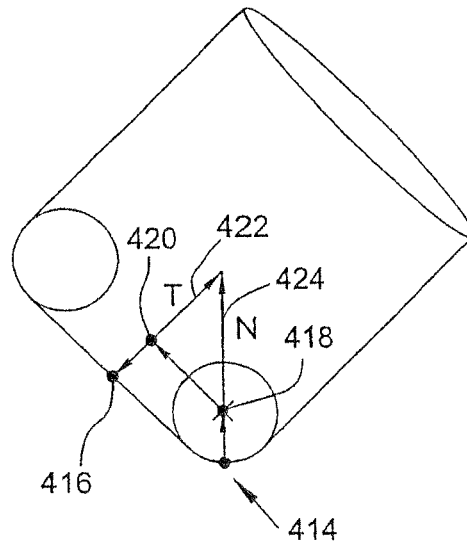


FIG. 22

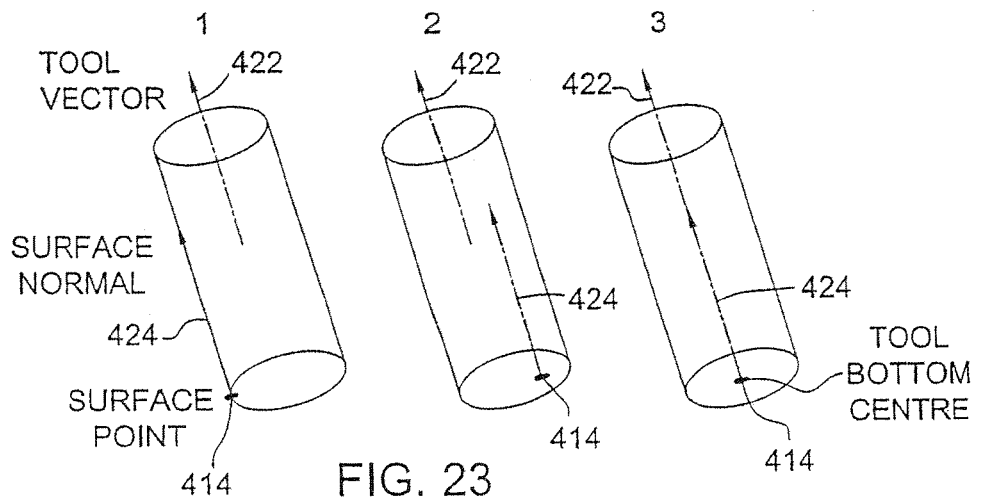


FIG. 23

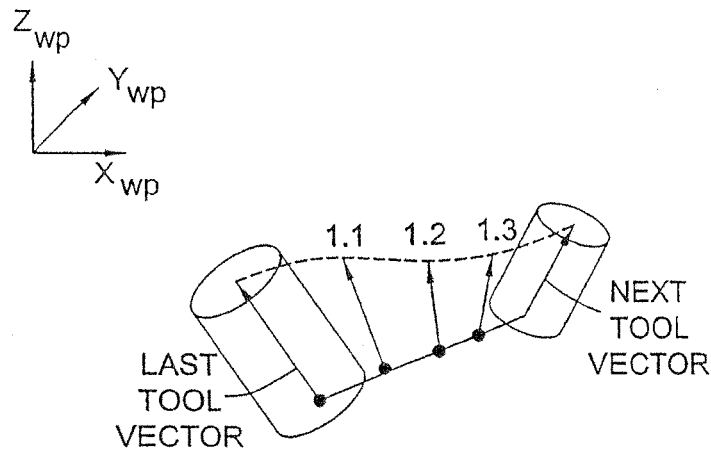


FIG. 24

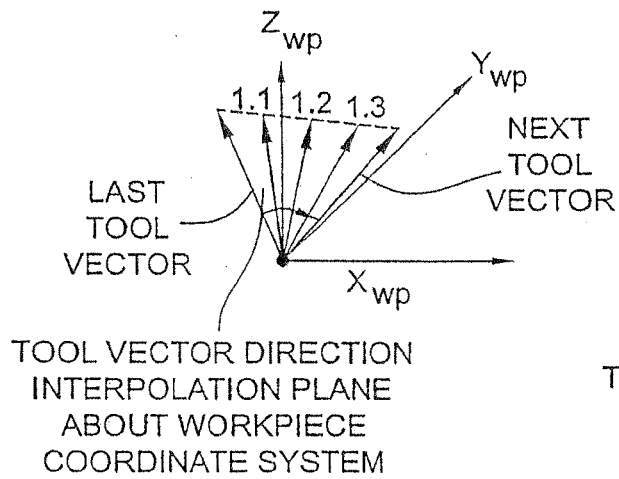


FIG. 25

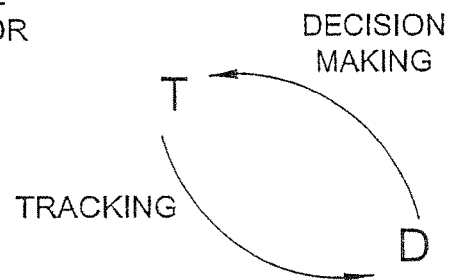


FIGURE 1
CORRESPONDENCE

FIG. 26