

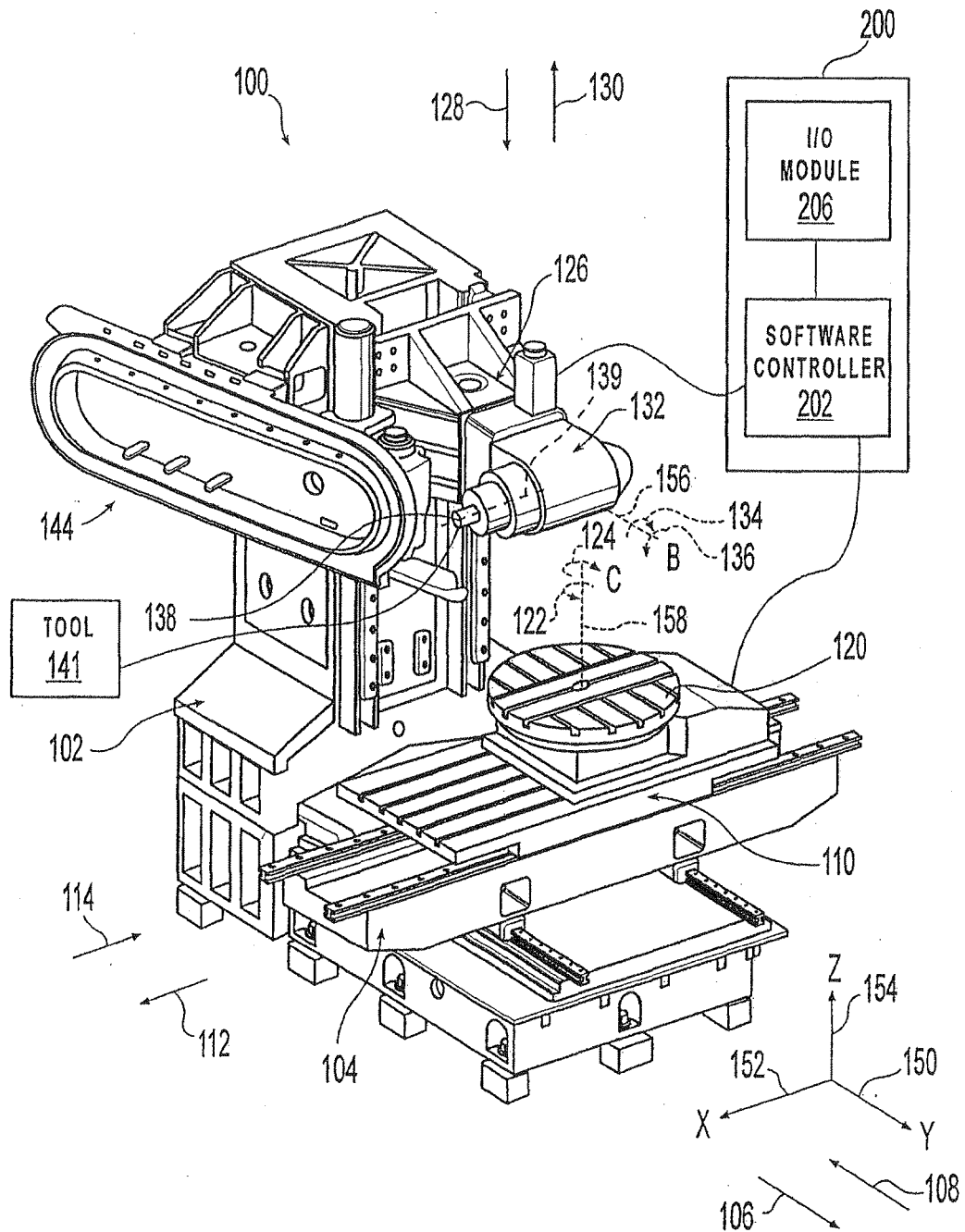


Fig. 1

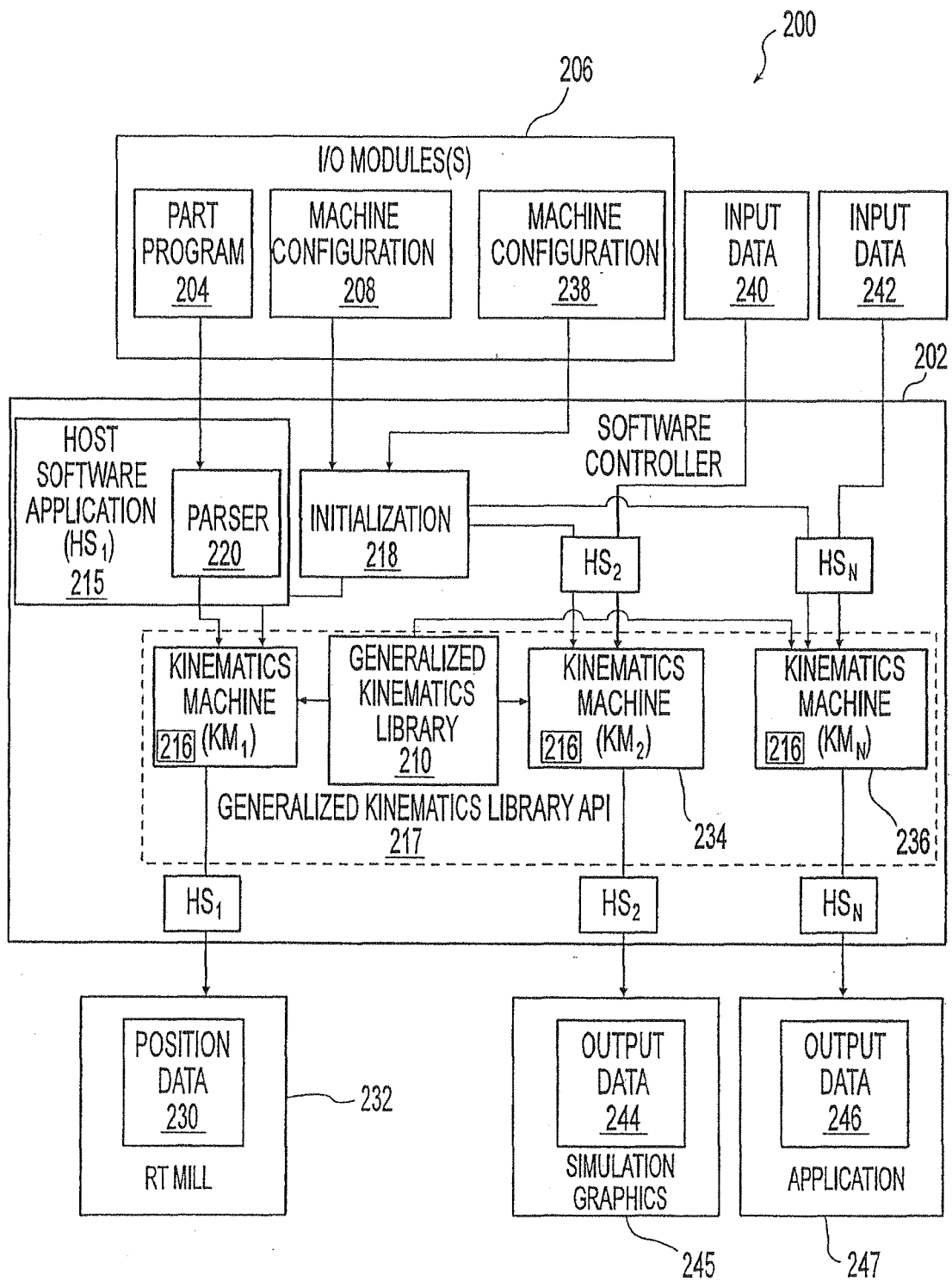


Fig. 2

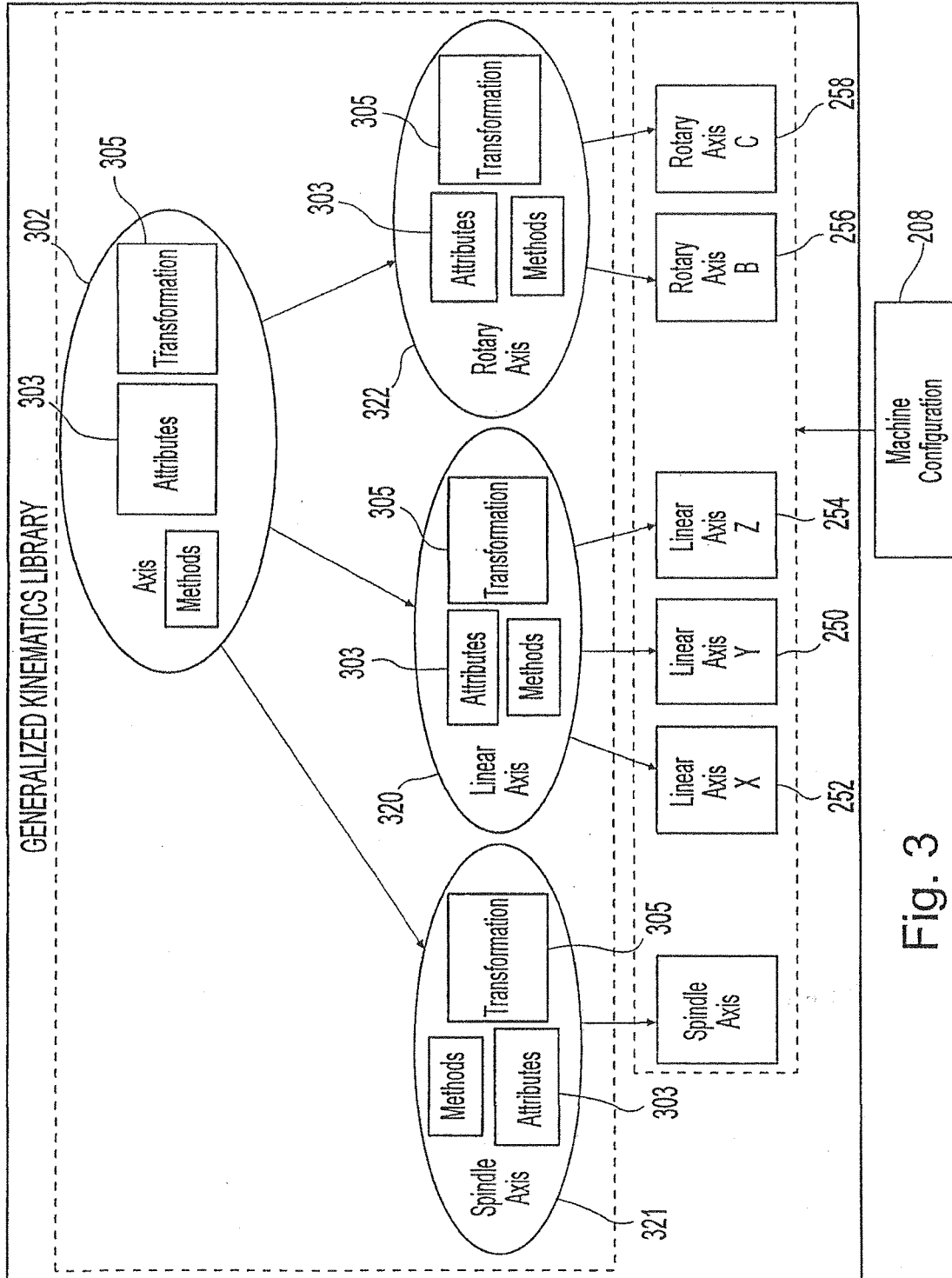


Fig. 3

INTEGRATOR SUPPORT SERVICES
CNC CONFIGURATION PARAMETERS
C AXIS

328

GENERAL	ENCODER	LIMIT SW	CENTERLINE
ROTARY CONFIGURATION TYPE 330 FULL ROTARY ▾			
MAXIMUM RPM 33.3			
CALIBRATION HOME POSITION 59.556 DEG 332			

FULL 360 DEGREE ROTARY F1
 TILT ROTARY F2
 F3
 F4

Fig. 4A

INTEGRATOR SUPPORT SERVICES
CNC CONFIGURATION PARAMETERS
C AXIS

328

GENERAL	ENCODER	LIMIT SW	CENTERLINE
ROTARY CENTERLINE X 726.819 336			
ROTARY CENTERLINE Y 300.969 338			
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 ▾				FULL 360 DEGREE ROTARY F1 TILT ROTARY F2 F3 F4
MAXIMUM RPM 332 50.0				
CALIBRATION HOME POSITION 340 -51.356 DEG				
MINUS DIRECTION TRAVEL LIMIT 340 -92.000 DEG				
PLUS DIRECTION TRAVEL LIMIT 342 92.000 DEG				

344

Fig. 5A

INTEGRATOR SUPPORT SERVICES
CNC CONFIGURATION PARAMETERS
B AXIS

328

GENERAL	ENCODER	LIMIT SW	CENTERLINE	
ROTARY CENTERLINE X 50.035 346				F1 F2 F3 F4
ROTARY CENTERLINE Z 242.156 348				
ENABLE CENTERLINE AUTOCALC? YES ▾				

Fig. 5B

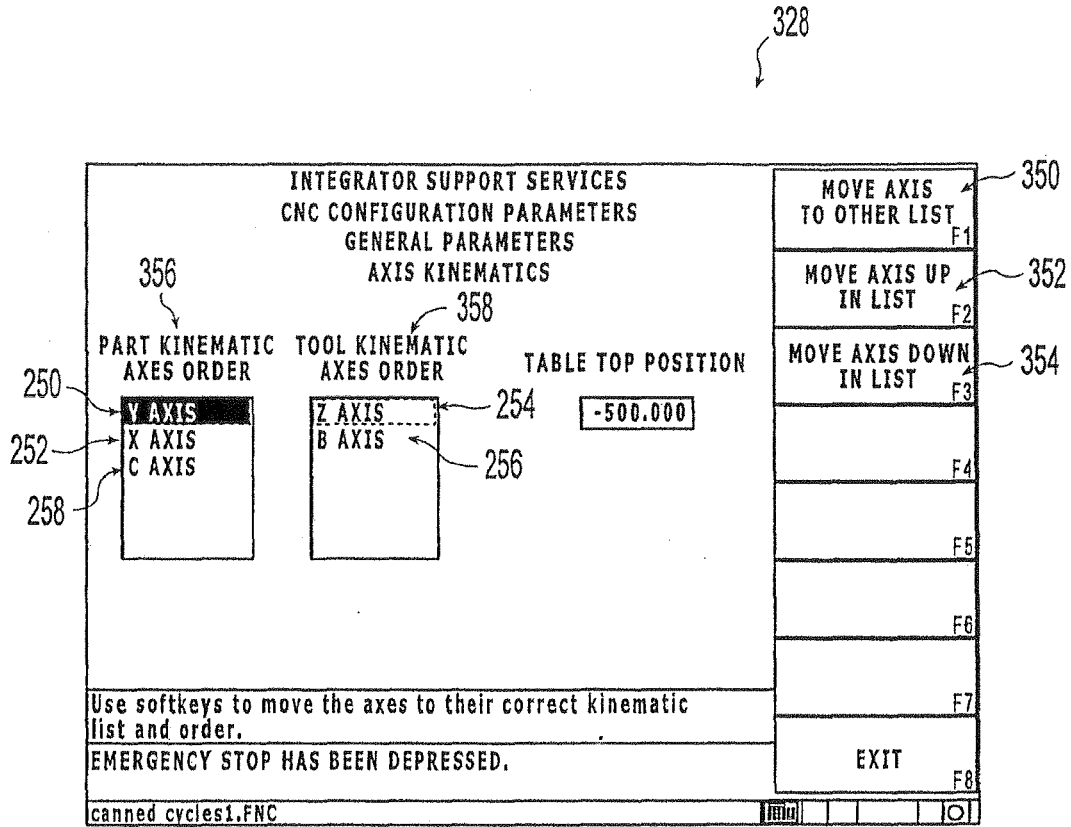


Fig. 6

TOOL MATRIX STACK

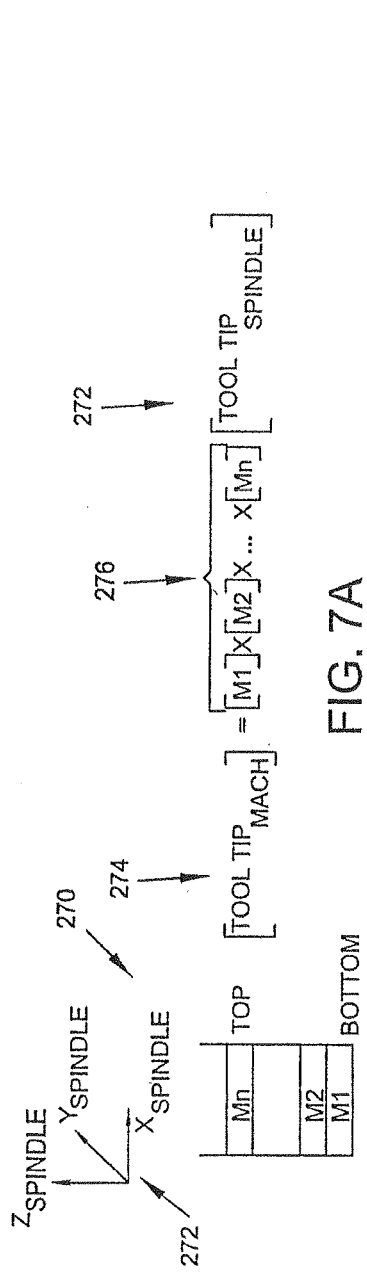


FIG. 7A

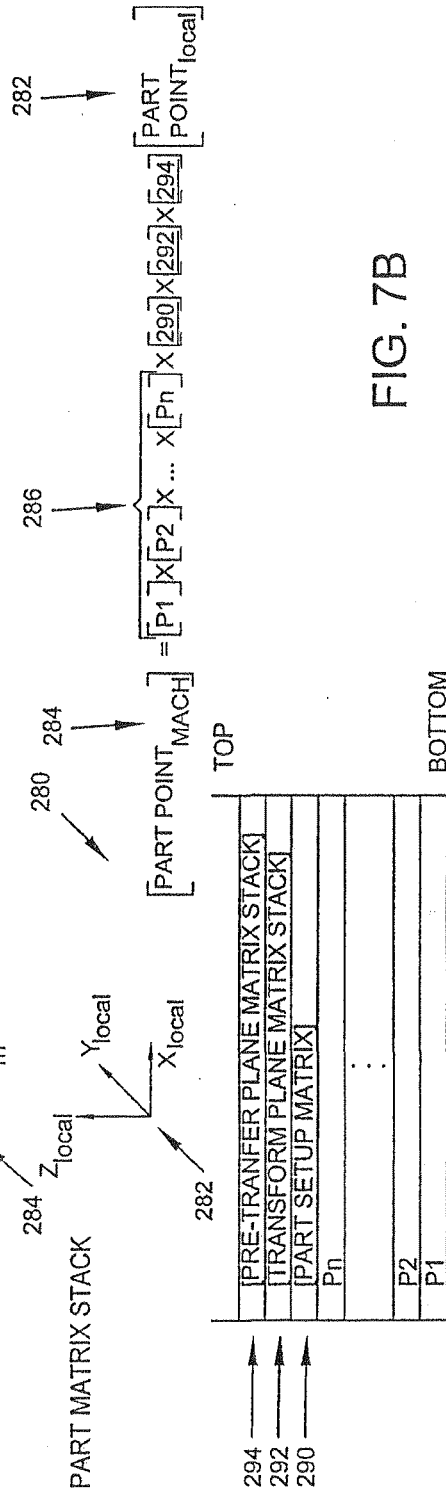


FIG. 7B

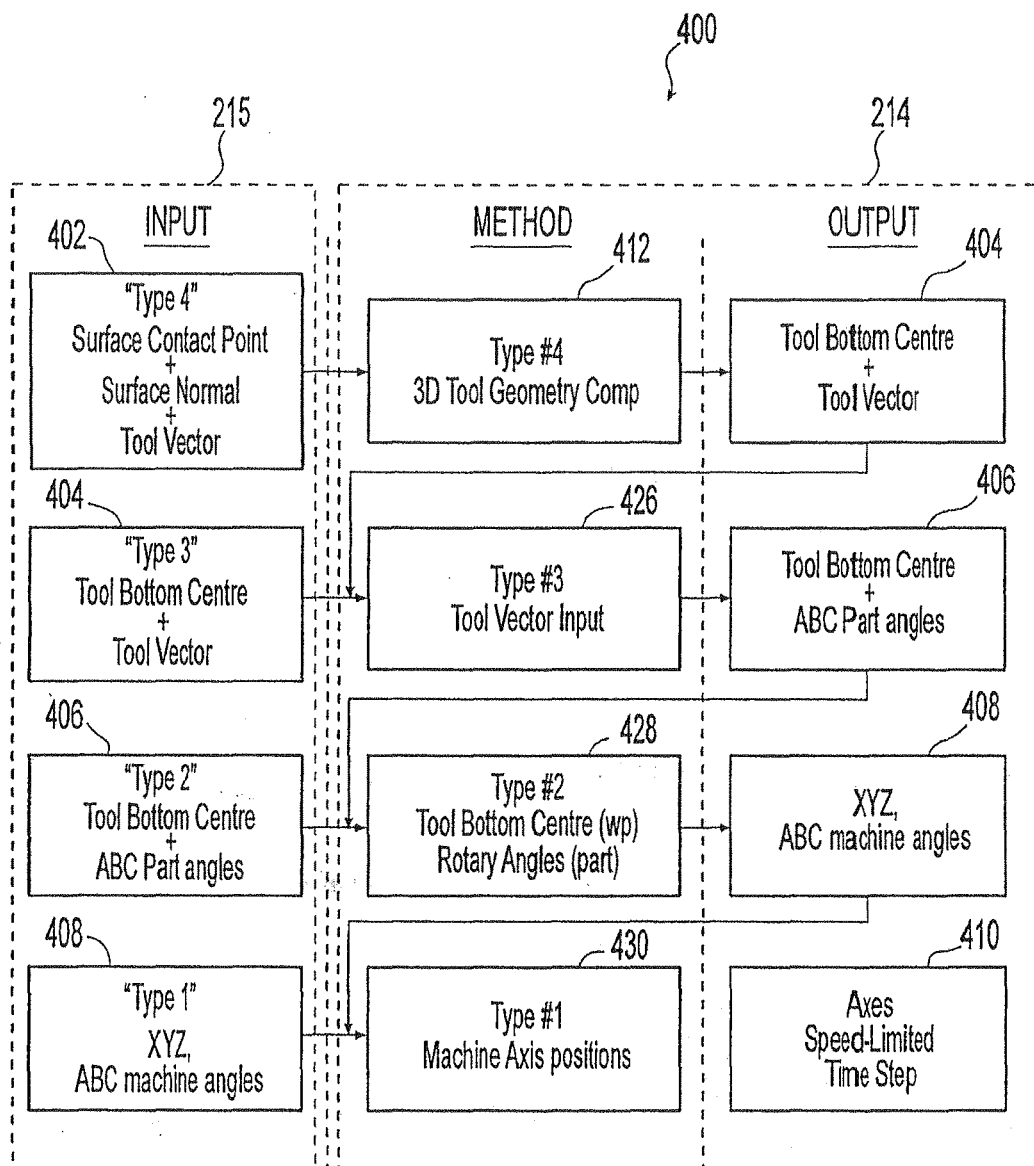
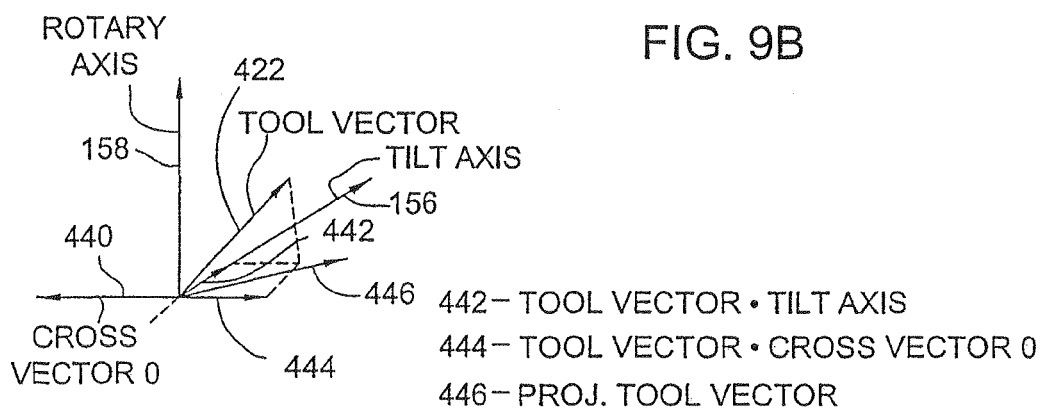
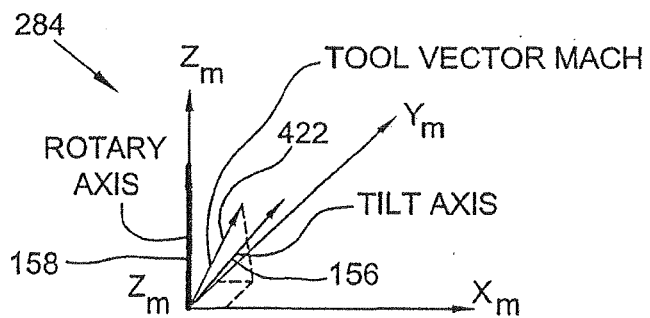
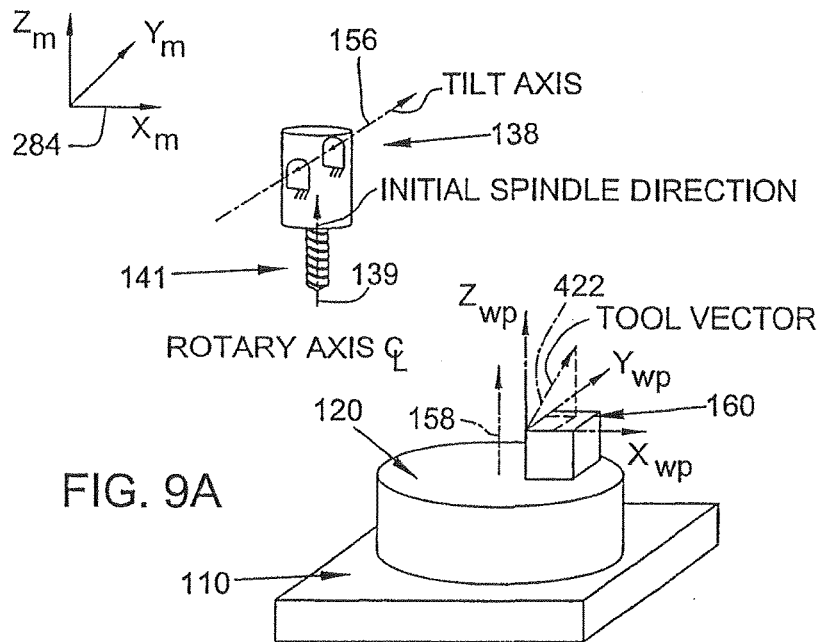
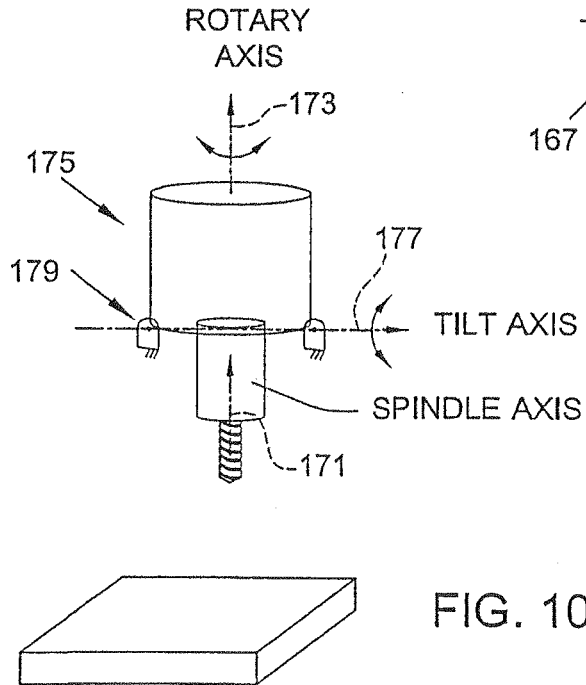
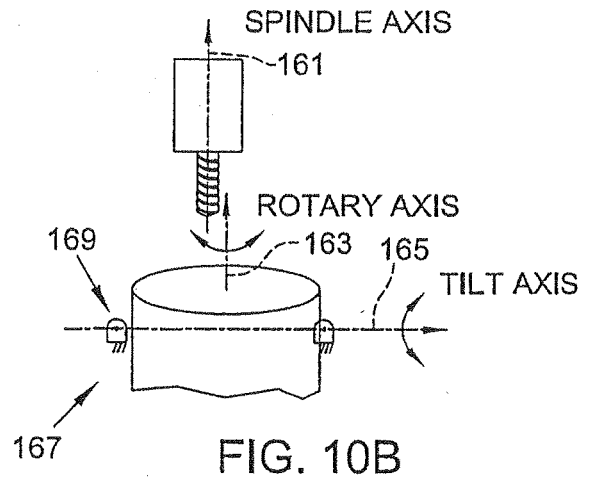
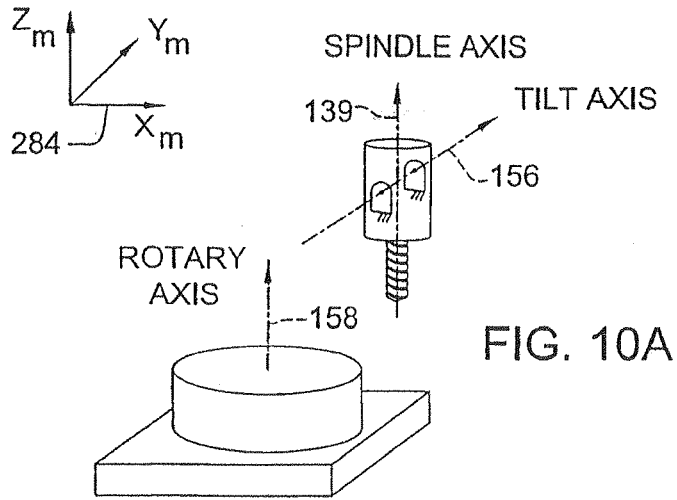


Fig. 8





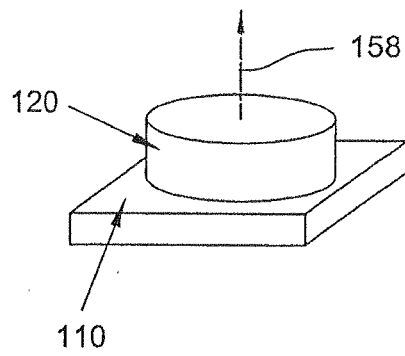
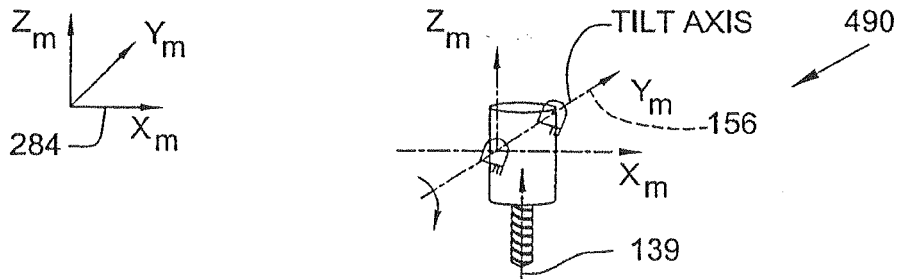


FIG. 11A

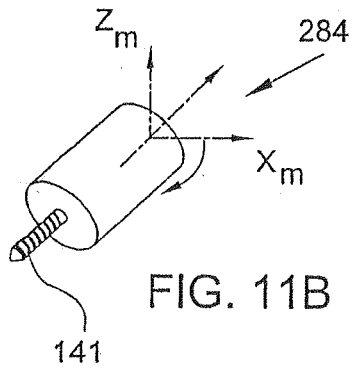


FIG. 11B

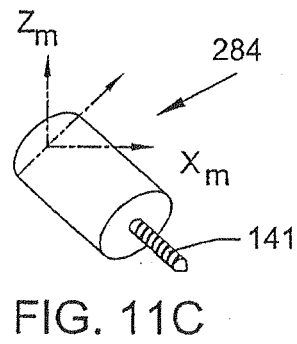
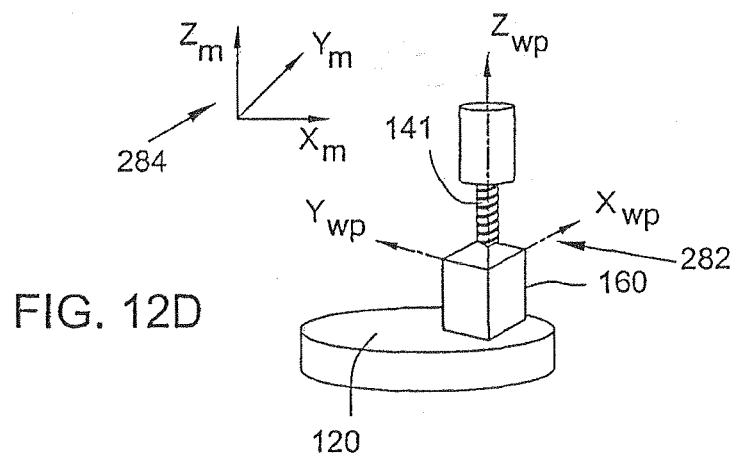
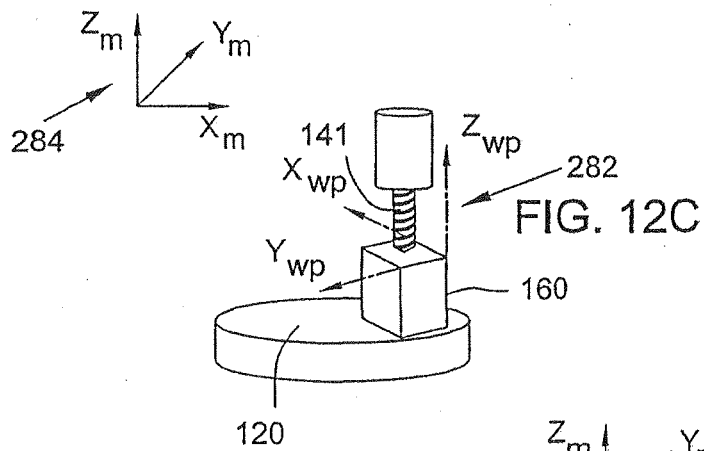
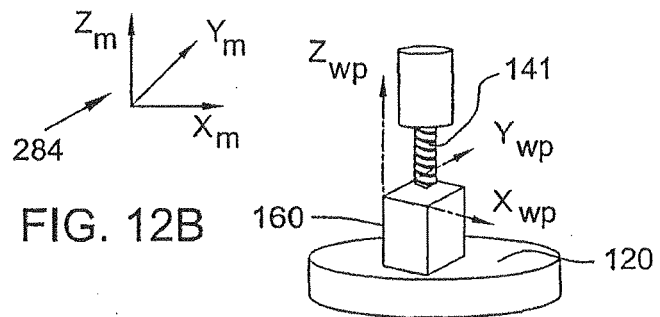
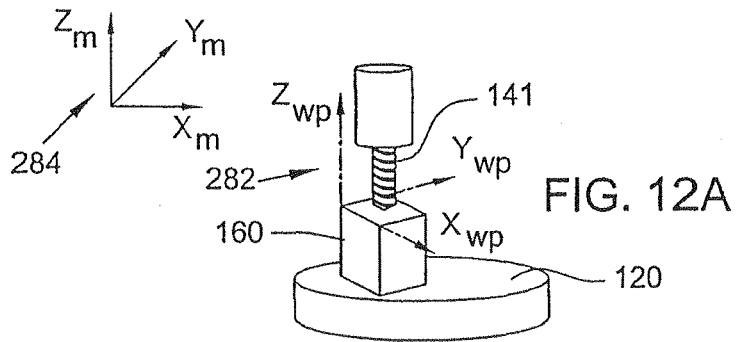
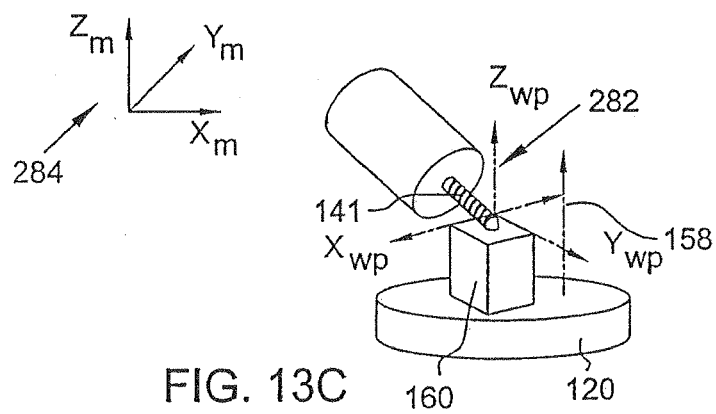
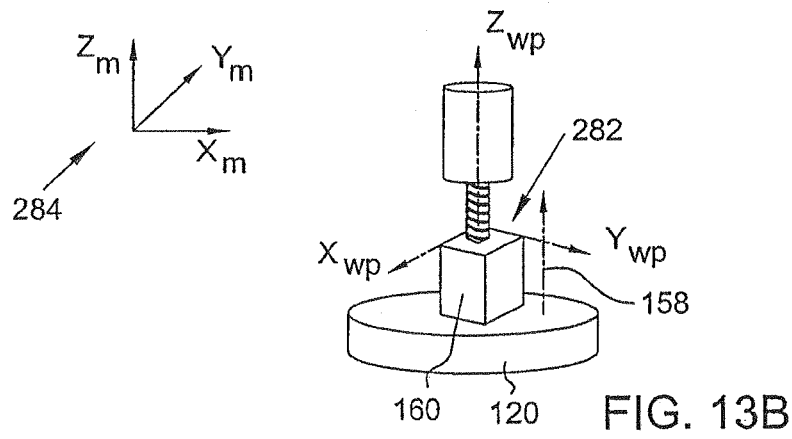
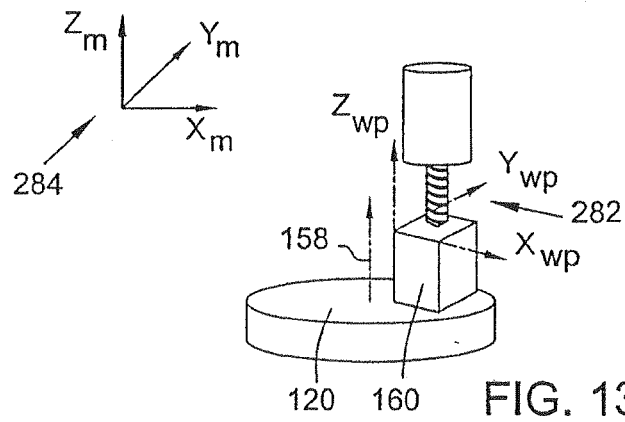


FIG. 11C





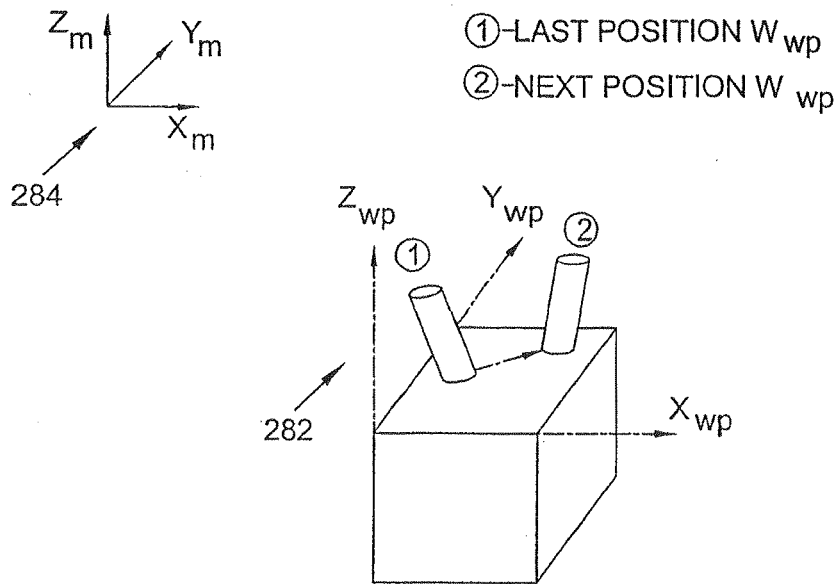


FIG. 14A

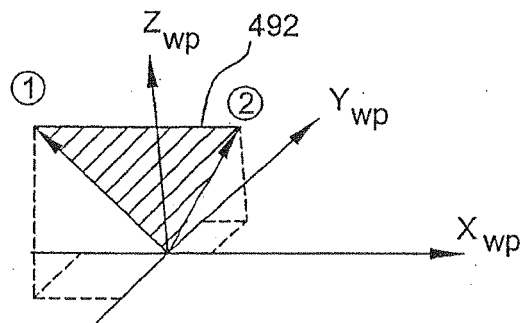


FIG. 14B

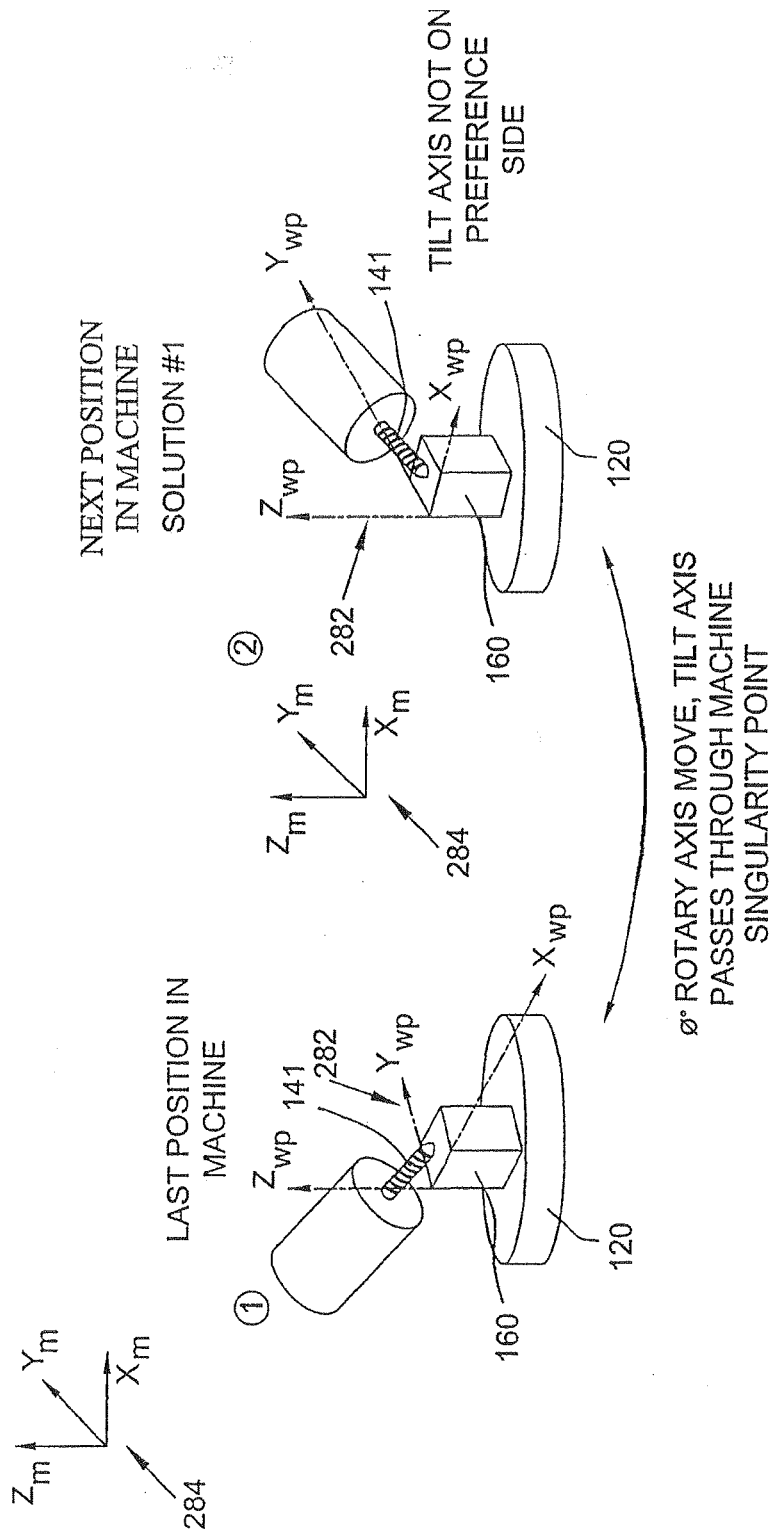


FIG. 14C

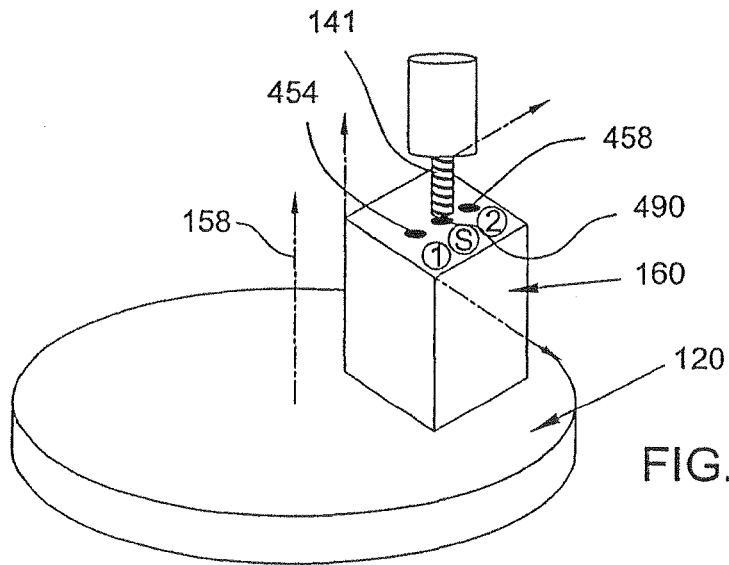


FIG. 15A

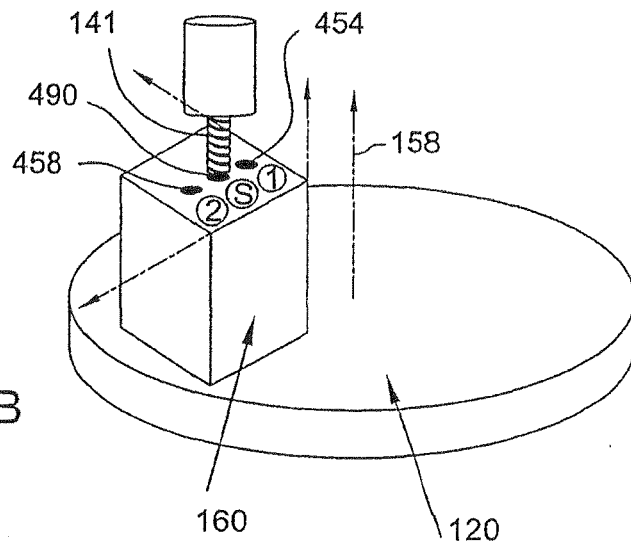


FIG. 15B

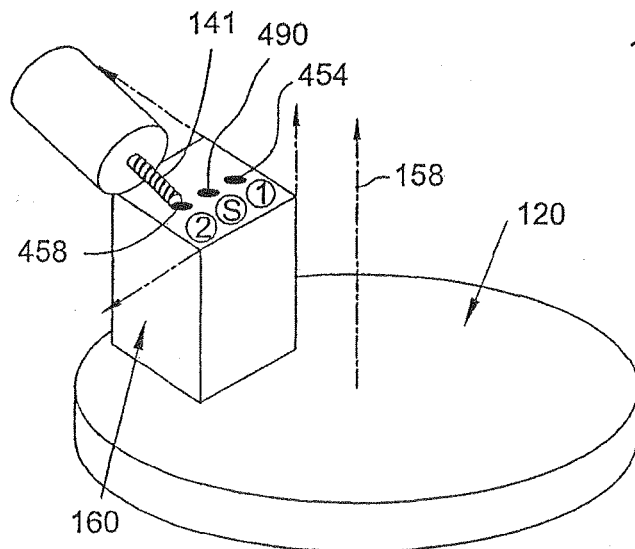
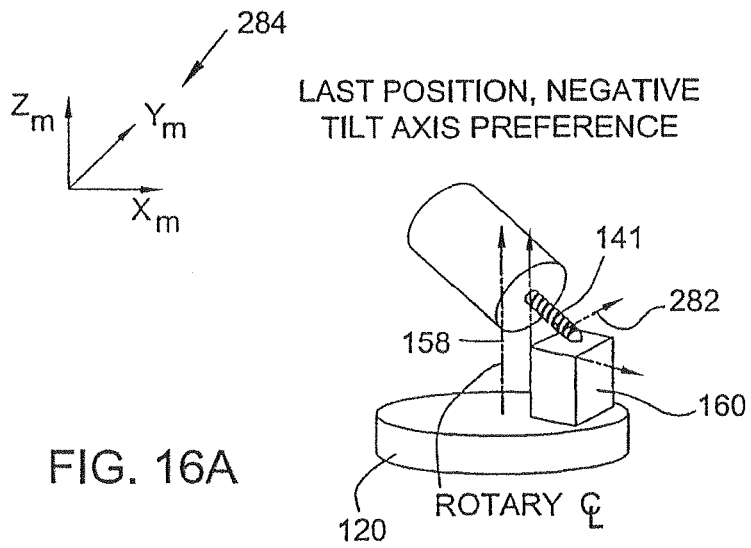
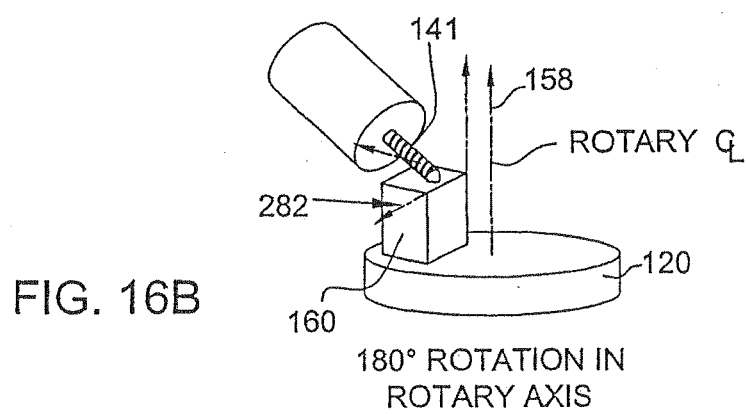
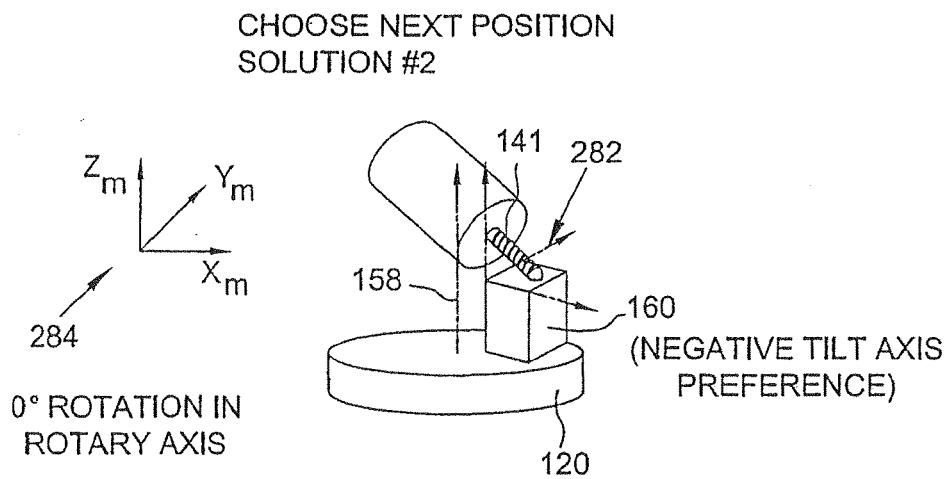
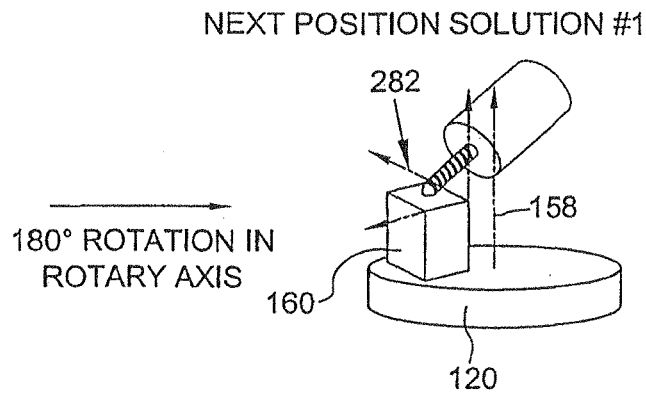
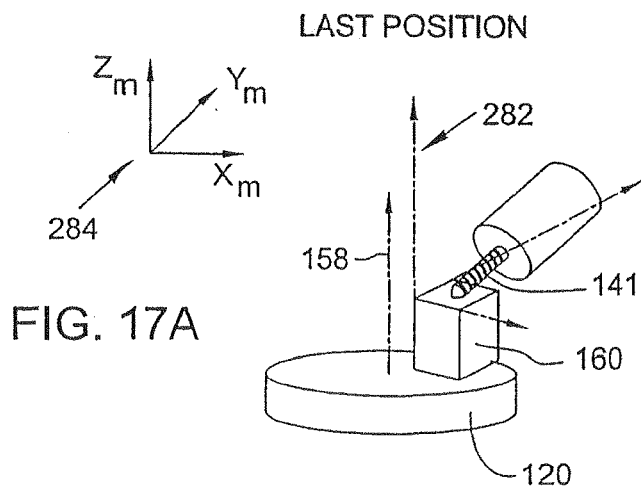


FIG. 15C



NEXT POSITION SOLUTION #1





LAST POSITION

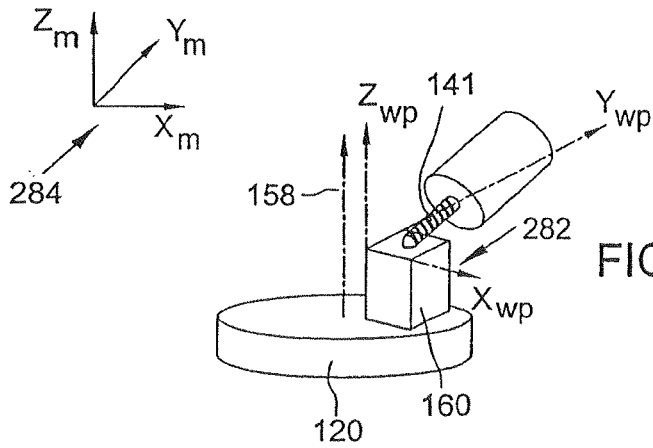


FIG. 18A

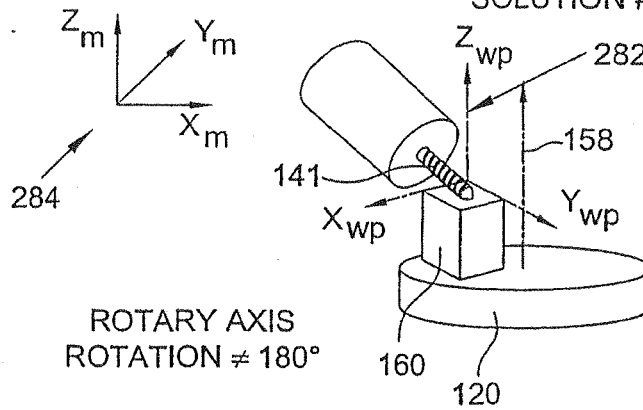
NEXT POSITION
SOLUTION #1 - INCORRECT SOLUTION

FIG. 18B

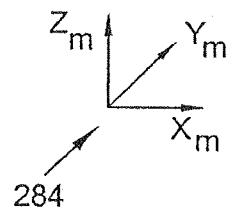
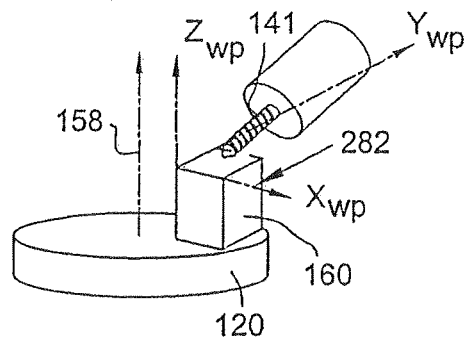
ROTARY AXIS
ROTATION $\neq 180^\circ$ 

FIG. 18C

CHOOSE SOLUTION #2



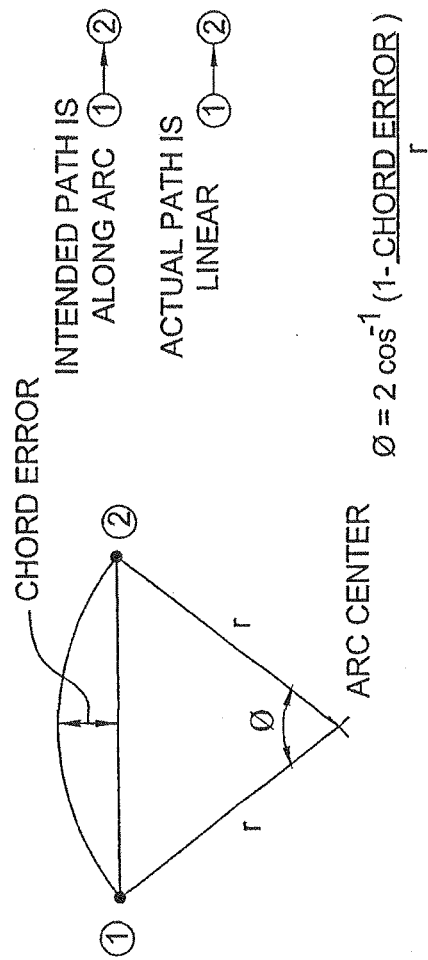


FIG. 19

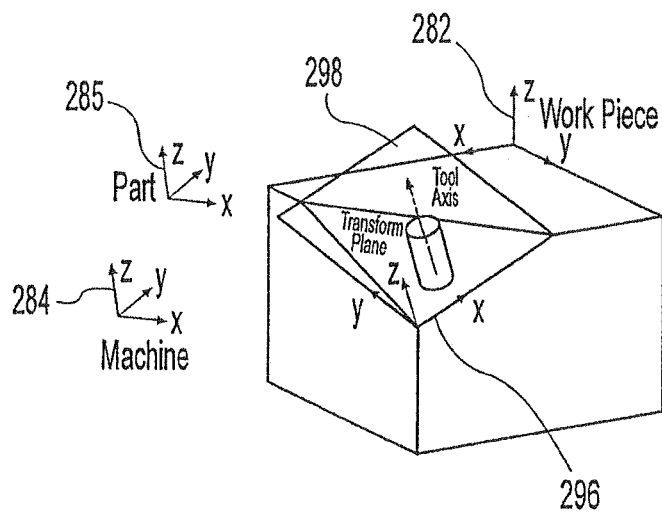


Fig. 20

LINEARIZATION TOLERANCES		
☐ ANGULAR STEP TOLERANCES	496	NEUTRAL F1
TILT AXIS TOLERANCE	498	POSITIVE F2
ROTARY AXIS TOLERANCE	0.0100	NEGATIVE F3
☒ ROTATION AXIS CHORD ERROR	501	F4
☐ TOOL VECTOR CHANGE TOLERANCE	0.250	F5
☒ TIME STEP TOLERANCE (MILLISECONDS)	503	F6
☒ ANSI ROTARY TABLE AXES	25.0	F7
TILT AXIS PREFERENCE	NEGATIVE	EXIT F8
ENABLE PATH PLANNING DMP FILES	NEUTRAL	
	POSITIVE	
	NEGATIVE	
Choose positive or negative for larger work volume. Choose neutral if no preference.		

Fig. 21

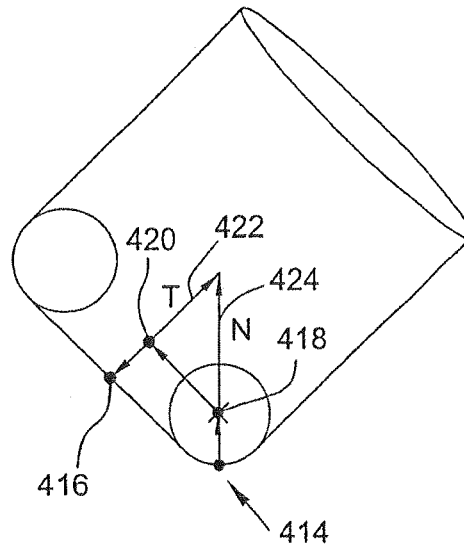


FIG. 22

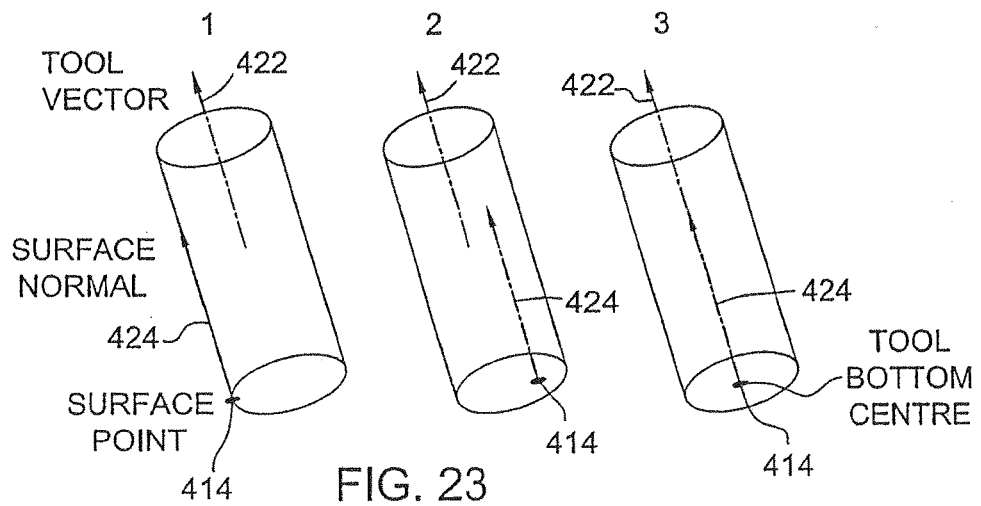


FIG. 23

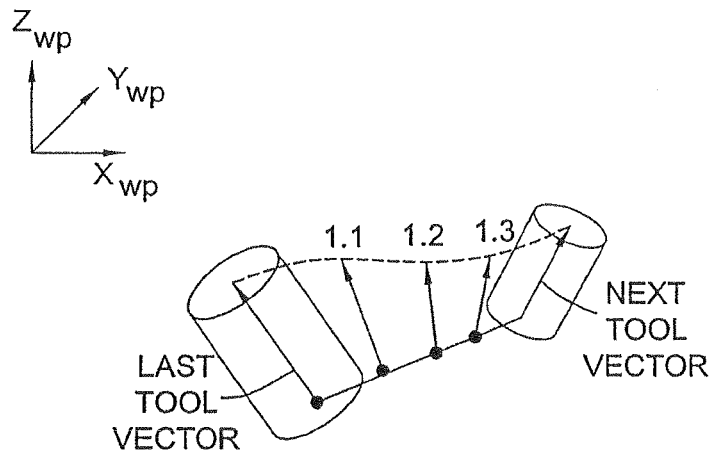


FIG. 24

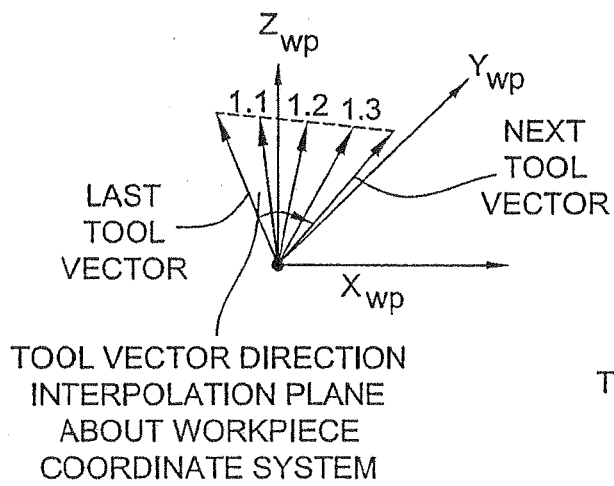


FIG. 25

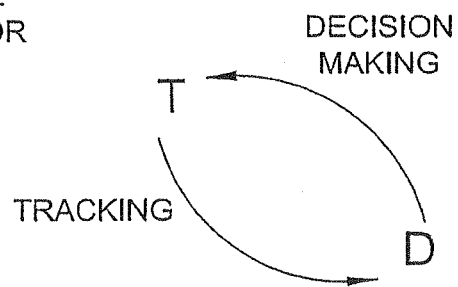
FIGURE 1
CORRESPONDENCE

FIG. 26