

PART NAME : 5186-1871

REV NUMBER : A

SER NUMBER :

STATS COUNT : 1

STARTUP =ALIGNMENT/START,RECALL:USE\_PART\_SETUP,LIST=YES

ALIGNMENT/END

MODE/MANUAL

MOVESPEED/ 150

FORMAT/TEXT,OPTIONS, ,HEADINGS,SYMBOLS, ;NOM,TOL,MEAS,DEV,OUTTOL, ,

TEMPCOMP/METHOD = AUTOMATIC,MATERIAL = Aluminium,CTE=23

,SET WARNING LIMIT = TRUE,MINIMUM = 18,MAXIMUM = 22

,PART SENSOR NUM=DEFAULT,X SCALE= 21.018,Y SCALE= 20.444,Z SCALE= 21.154,PART  
TEMP=20.428

LOADPROBE/1P5X20

TIP/T1A0B0, SHANKIJK=0, 0, 1, ANGLE=0

PLN1 =FEAT/CONTACT/PLANE/DEFAULT,CARTESIAN,NONE,LEAST\_SQR

THEO/<-47.964,4.574,100>,<0,0,1>

ACTL/<57.656,260.272,-361.919>,<0.001018,0.000958,0.999999>

TARG/<-47.964,4.574,100>,<0,0,1>

ANGLE VEC=<1,0,0>,SQUARE

SHOW FEATURE PARAMETERS=NO

SHOW CONTACT PARAMETERS=YES

NUMHITS=2,NUMROWS=2

SPACER=0

AVOIDANCE MOVE=BOTH,DISTANCE BEFORE=10,DISTANCE AFTER=10,DIRECTION=ALONG  
FEATURE VECTOR

USE BOUNDARY OFFSET=YES,OFFSET=1

SHOW HITS=NO

TIP/T1A90B-180, SHANKIJK=0, -1, 0, ANGLE=180

PLN2 =FEAT/CONTACT/PLANE/DEFAULT,CARTESIAN,NONE,LEAST\_SQR

THEO/<-21.536,-0.25,80.817>,<0,-1,0>

ACTL/<79.945,250.262,-377.874>,<-0.0108668,-0.9999407,-0.0006959>

TARG/<-21.536,-0.25,80.817>,<0,-1,0>

ANGLE VEC=<1,0,0>,SQUARE

SHOW FEATURE PARAMETERS=NO

SHOW CONTACT PARAMETERS=YES

NUMHITS=2,NUMROWS=2

SPACER=0

AVOIDANCE MOVE=BOTH,DISTANCE BEFORE=10,DISTANCE AFTER=10,DIRECTION=ALONG  
FEATURE VECTOR

USE BOUNDARY OFFSET=YES,OFFSET=1

SHOW HITS=NO

TIP/T1A90B-90, SHANKIJK=1, 0, 0, ANGLE=-90

PLN3 =FEAT/CONTACT/PLANE/DEFAULT,CARTESIAN,NONE,LEAST\_SQR

THEO/<79.5,75.125,74.409>,<1,0,0>

ACTL/<179.331,331.193,-382.722>,<0.9999325,-0.0116021,-0.0006129>

TARG/<79.5,75.125,74.409>,<1,0,0>

ANGLE VEC=<0,0,-1>,SQUARE

SHOW FEATURE PARAMETERS=NO

SHOW CONTACT PARAMETERS=YES

NUMHITS=2,NUMROWS=2

SPACER=0

AVOIDANCE MOVE=BOTH,DISTANCE BEFORE=10,DISTANCE AFTER=10,DIRECTION=ALONG  
FEATURE VECTOR

USE BOUNDARY OFFSET=YES,OFFSET=1

SHOW HITS=NO

A1 =ALIGNMENT/START,RECALL:STARTUP,LIST=YES

ALIGNMENT/LEVEL,ZPLUS,PLN1  
ALIGNMENT/TRANS,ZAXIS,PLN1  
ALIGNMENT/ROTATE,YMINUS,TO,PLN2,ABOUT,ZPLUS  
ALIGNMENT/TRANS,YAXIS,PLN2  
ALIGNMENT/TRANS,XAXIS,PLN3  
ALIGNMENT/END  
MODE/DCC  
TIP/T1A0B0, SHANKIJK=0, 0, 1, ANGLE=0  
PLNB =FEAT/CONTACT/PLANE/DEFAULT,CARTESIAN,NONE,LEAST\_SQR  
THEO/<-119.325,5.998,0>,<0,0,1>  
ACTL/<-119.326,5.998,0.02>,<-0.0574686,-0.0030986,0.9983425>  
TARG/<-119.325,5.998,0>,<0,0,1>  
ANGLE VEC=<1,0,0>,SQUARE  
SHOW FEATURE PARAMETERS=NO  
SHOW CONTACT PARAMETERS=YES  
NUMHITS=3,NUMROWS=3  
SPACER=0  
AVOIDANCE MOVE=BOTH,DISTANCE BEFORE=10,DISTANCE AFTER=10,DIRECTION=ALONG  
FEATURE VECTOR  
USE BOUNDARY OFFSET=NO  
SHOW HITS=NO  
TIP/T1A90B-180, SHANKIJK=0, -1, 0, ANGLE=180  
PLNC =FEAT/CONTACT/PLANE/DEFAULT,CARTESIAN,NONE,LEAST\_SQR  
THEO/<-102.235,0,-18.971>,<0,-1,0>  
ACTL/<-102.238,0.261,-18.969>,<0.0104534,-0.9999161,-0.0076472>  
TARG/<-102.235,0,-18.971>,<0,-1,0>  
ANGLE VEC=<1,0,0>,SQUARE  
SHOW FEATURE PARAMETERS=NO  
SHOW CONTACT PARAMETERS=YES

NUMHITS=3,NUMROWS=3  
SPACER=0  
AVOIDANCE MOVE=BOTH,DISTANCE BEFORE=10,DISTANCE AFTER=10,DIRECTION=ALONG  
FEATURE VECTOR  
USE BOUNDARY OFFSET=YES,OFFSET=1  
SHOW HITS=NO  
TIP/T1A90B-90, SHANKIJK=1, 0, 0, ANGLE=-90  
PLNA =FEAT/CONTACT/PLANE/DEFAULT,CARTESIAN,NONE,LEAST\_SQR  
THEO/<0,76.181,-24.598>,<1,0,0>  
ACTL/<-0.367,76.198,-24.601>,<0.9988973,-0.0460966,0.0089043>  
TARG/<0,76.181,-24.598>,<1,0,0>  
ANGLE VEC=<0,0,-1>,SQUARE  
SHOW FEATURE PARAMETERS=NO  
SHOW CONTACT PARAMETERS=YES  
NUMHITS=3,NUMROWS=3  
SPACER=0  
AVOIDANCE MOVE=BOTH,DISTANCE BEFORE=10,DISTANCE AFTER=10,DIRECTION=ALONG  
FEATURE VECTOR  
USE BOUNDARY OFFSET=YES,OFFSET=1  
SHOW HITS=NO  
A2 =ALIGNMENT/START,RECALL:STARTUP,LIST=YES  
ALIGNMENT/LEVEL,ZPLUS,PLNB  
ALIGNMENT/TRANS,ZAXIS,PLNB  
ALIGNMENT/ROTATE,YMINUS,TO,PLNC,ABOUT,ZPLUS  
ALIGNMENT/TRANS,YAXIS,PLNC  
ALIGNMENT/TRANS,XAXIS,PLNA  
ALIGNMENT/END