

# Calibration Measuring Probes - Novamatic 2000 CNC

Measuring probes must be re-calibrated after every change to machine or spindle data.

## Axis Measuring Probe Calibration

### **Procedure**

- Open the control menu (primary window) from Rotec.
- Activate the key F3 to calibrate the probe. A table appears which contains preset values. If the values X flange dimension, Y center and Z center are set at zero, replace these values with the standard values provided below.
- Enter the rest of the values for the measuring probe.
- F2 - save values

### **Note**

- The measuring probe is then calibrated. Repeat this sequence several times, until almost constant measurement results are achieved.
- After an interruption of the measuring probe calibration sequence and a return to home position with key F9, the last measuring probe data can be re-activated through activation of key F4, and the last work piece can be traced again.

	<b>Standard Measurement</b>	<b>1<sup>st</sup> Measurement</b>	<b>2<sup>nd</sup> Measurement</b>	<b>3<sup>rd</sup> Measurement</b>	<b>4<sup>th</sup> Measurement</b>
<b>X Flange Dimension</b>	-12.5812"				
<b>Y Center</b>	-1.8002"				
<b>Z Center</b>	-4.8156"				
<b>Test Mandrel Diameter</b>					
<b>Test Mandrel Length</b>					
<b>X Flange Dimension, L.</b>					
<b>Y Center, Left</b>					
<b>Z Center, Left</b>					
<b>Probe Point Diameter</b>	0.0787"				
<b>Probe Point Offset front</b>	0.0394"				
<b>Meas. Depth „Length..“</b>	0.5905"				
<b>Probe Width „Length..“</b>	0.2165"				
<b>Height Offset „Length..“</b>	0.0394"				
<b>Helix during measure</b>	80%				

# Calibration Measuring Probes - Novamatic 2000 CNC

## Grinding Wheel Measuring Probe Calibration

### **Procedure**

- Open the control menu (primary window) from Rotec.
- Activate the key F4 to calibrate the grinding wheel measuring probe. A table appears which contains preset values. If the values X flange dimension, Y center and Z center are set at zero, replace these values with the standard values provided below.
- Enter the rest of the values for the measuring probe.
- F2 - save values

### **Note**

- The measuring probe is then calibrated. Repeat this sequence several times, until almost constant measurement results are achieved.
- After an interruption of the measuring probe calibration sequence and a return to home position with key F9, the last measuring probe data can be re-activated through activation of key F4, and the last work piece can be traced again.

	<b>Standard Measurement</b>	<b>1<sup>st</sup> Measurement</b>	<b>2<sup>nd</sup> Measurement</b>	<b>3<sup>rd</sup> Measurement</b>	<b>4<sup>th</sup> Measurement</b>
<b>X Center</b>	-12.5590"				
<b>Y Center</b>	-1.7716"				
<b>Z Offset</b>	-4.2519"				
<b>Diameter Spindle Nose</b>	1.5748"				
<b>Length calibration bar</b>	1.3779"				
<b>Probe finger diameter</b>	0.1574"				
<b>Measuring Depth</b>	0.0591"				
<b>Probe backlash</b>	0"				
<b>Spindle-On time</b>	50				
<b>No. of meas. points</b>	5				