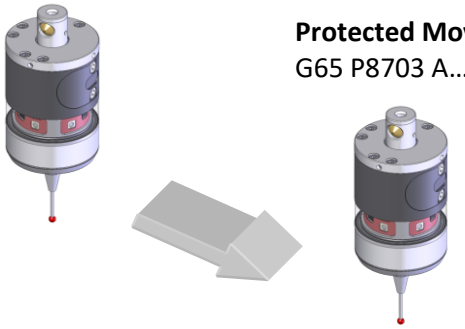
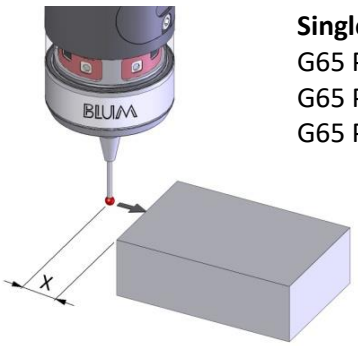
Quickstart 3 BROTHER – Workpiece referencing

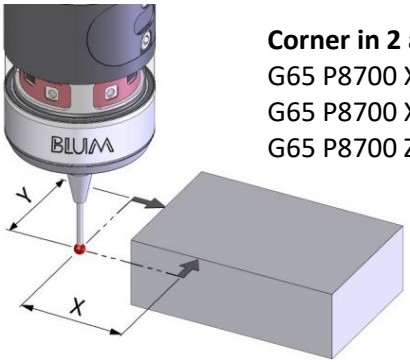
Protected Move
G65 P8703 A... X... Y... Z...



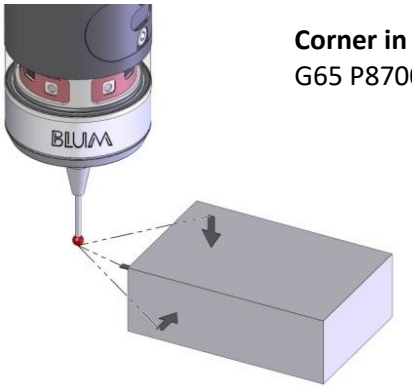
Single point
G65 P8700 X... W...
G65 P8700 Y... W...
G65 P8700 Z... W...



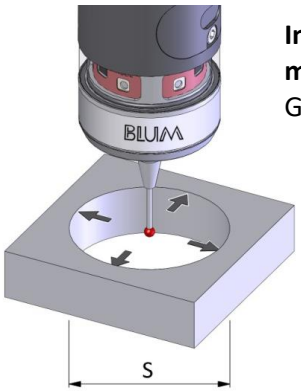
Corner in 2 axes
G65 P8700 X... Y... W...
G65 P8700 X... Z... W...
G65 P8700 Z... Y... W...



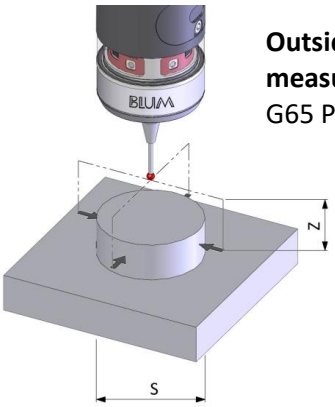
Corner in 3 axes
G65 P8700 X... Y... Z... W...



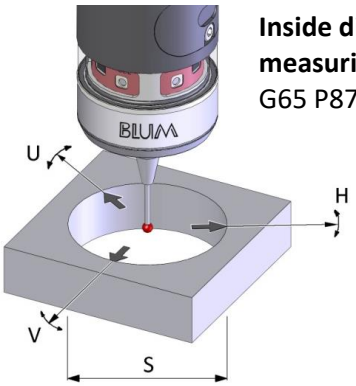
Inside diameter with 4 measuring points
G65 P8700 S... W...



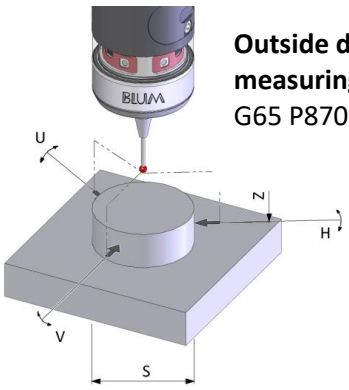
Outside diameter with 4 measuring points
G65 P8700 S... Z... W...



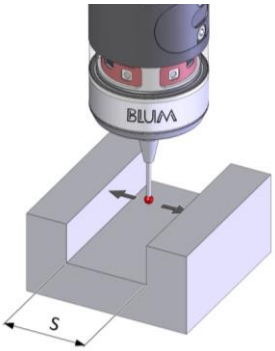
Inside diameter with 3 measuring points
G65 P8700 S... H.. U... V... W...



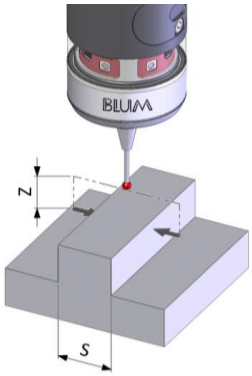
Outside diameter with 3 measuring points
G65 P8700 S... H.. U... V... Z... W...



Inside with
G65 P8700 S... X1. W...
G65 P8700 S... Y1. W...



Outside width
G65 P8700 S... X1. Z... W...
G65 P8700 S... Y1. Z... W...



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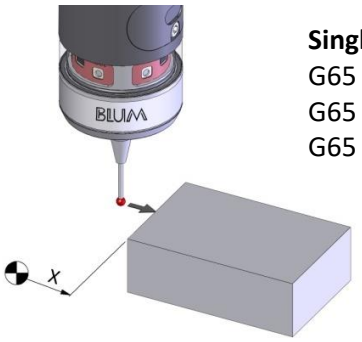
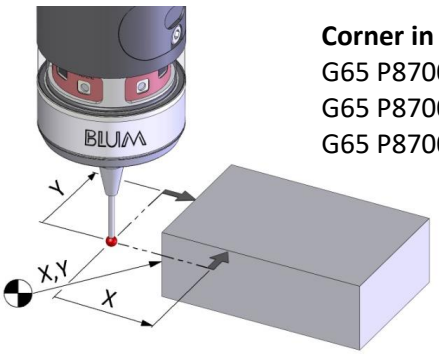
Quickstart 3 - Measurement

Results:

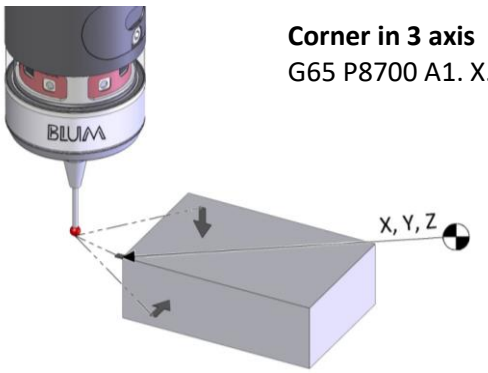
#100	X-position of the edge/center in the active WCS
#101	Y- position of the edge/center in the active WCS
#102	Z- position of the edge/center in the active WCS
#103	Deviation in X from the set value
#104	Deviation in Y from the set value
#105	Deviation in Z from the set value
#106	Diameter/result of the contour
#107	Deviation from the set value



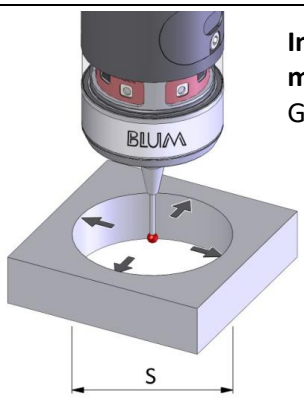
Single point
G65 P8700 A1. X...
G65 P8700 A1. Y...
G65 P8700 A1. Z...



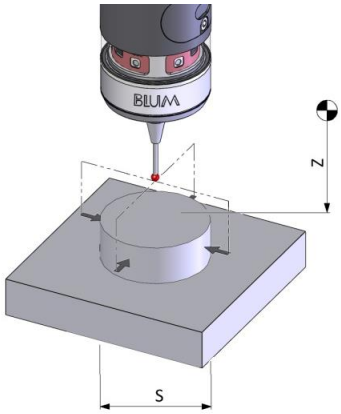
Corner in 2 axis
G65 P8700 A1. X... Y...
G65 P8700 A1. X... Z...
G65 P8700 A1. Z... Y...



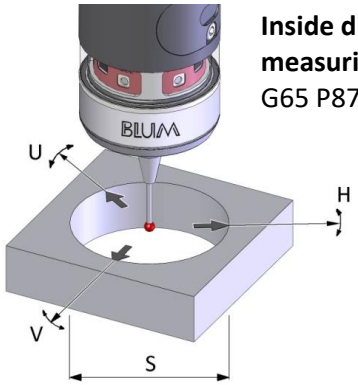
Corner in 3 axis
G65 P8700 A1. X... Y... Z...



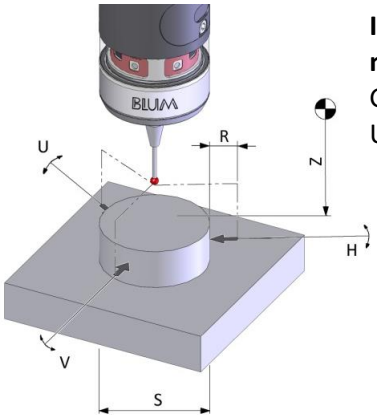
Inside diameter with 4 measuring points
G65 P8700 A1. S...



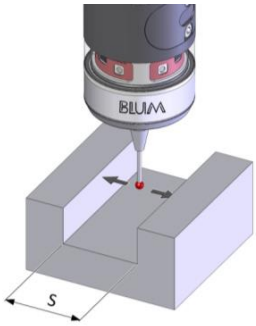
Inside diameter with 4 measuring points
G65 P8700 A1. S... Z...



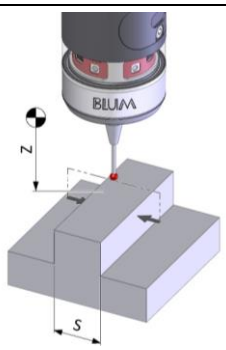
Inside diameter with 3 measuring points
G65 P8700 A1. S... H.. U... V...



Inside diameter with 3 measuring points
G65 P8700 A1. S... H..
U... V... Z...



Inside width
G65 P8700 A1. S... X1.
G65 P8700 A1. S... Y1.



Outside width
G65 P8700 A1. S... Z... X1.
G65 P8700 A1. S... Z... Y1.

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