Overview – program calls

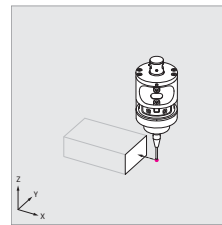|	
BLUM software	Quickstart
Article number	260605
Version	V4A
Machine control	Brother

ⓘ Incomplete excerpt – observe associated programming instructions!
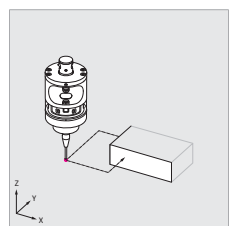
Determining the zero point

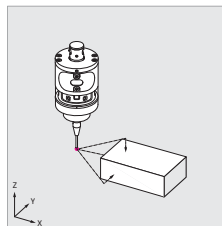**Correcting the zero point in rotation axis**

```
G65 P8705 W... A... B...
C...
```


Single point

```
G65 P8700 X... W...
G65 P8700 Y... W...
G65 P8700 Z... W...
```
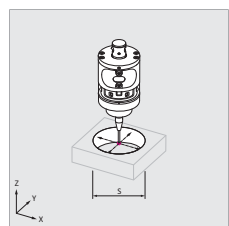

Corner in 2 axes

```
G65 P8700 X... Y... W...
G65 P8700 X... Z... W...
G65 P8700 Y... Z... W...
```
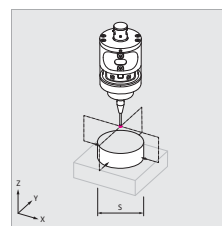

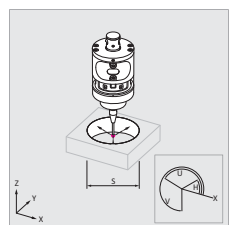
Corner in 3 axes

```
G65 P8700 X... Y... Z...
W...
```


Inside diameter

```
G65 P8700 S... W...
```
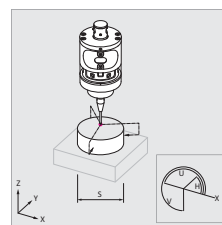

Outside diameter

```
G65 P8700 S... Z... W...
```
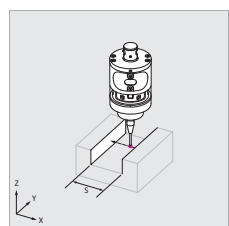

Inside diameter with 3 measuring points

```
G65 P8700 S... W... H...
U... V...
```
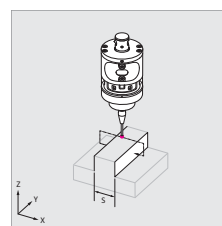

Outside diameter with 3 measuring points
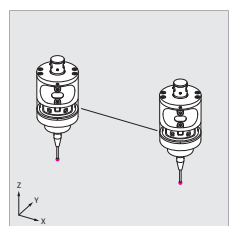
```
G65 P8700 S... W... Z...
H... U... V...
```


Inside width

```
G65 P8700 S... X1. W...
G65 P8700 S... Y1. W...
```
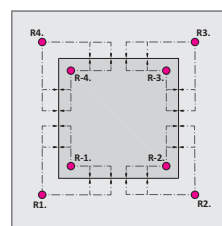

Outside width

```
G65 P8700 S... X1. Z...
W...
G65 P8700 S... Y1. Z...
W...
```

Additional functions

Protected Move

```
G65 P8703 A... X... Y...
Z...
```


Determine corner mark with 3/4 measuring points

```
G65 P8712 R... X... U...
Y... V...
```

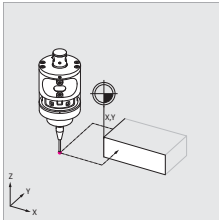## Measurement in production process

Results:

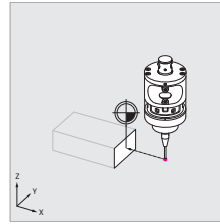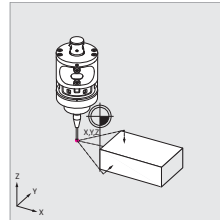|	
#100/#101/#102:	Position of middle mark/corner in X/Y/Z in the active workpiece coordinate system
#103/#104/#105:	Deviation in X/Y/Z from set value
#106	Dimension/diameter of contour
#107	Deviation from the set value

Single point

```
G65 P8700 A1. X...
G65 P8700 A1. Y...
G65 P8700 A1. Z...
```

Corner in 2 axes

```
G65 P8700 A1. X... Y...
G65 P8700 A1. X... Z...
G65 P8700 A1. Y... Z...
```

Corner in 3 axes

```
G65 P8700 A1. X... Y...
Z...
```

Inside diameter

```
G65 P8700 A1. S...
```
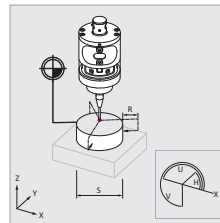
Outside diameter
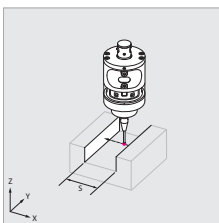
```
G65 P8700 A1. S... Z...
```

Inside diameter with 3 measuring points

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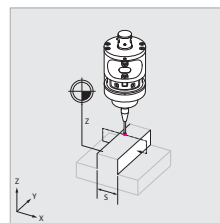
Outside diameter with 3 measuring points

```
G65 P8700 A1. S... Z...
H... U... V...
```

Inside width

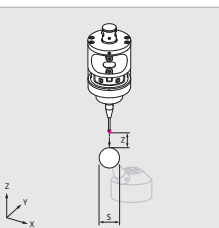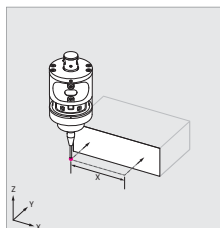```
G65 P8700 A1. S... X1.
G65 P8700 A1. S... Y1.
```

### Outside width

```
G65 P8700 A1. S... X1. Z...
G65 P8700 A1. S... Y1. Z...
```

Sphere diameter
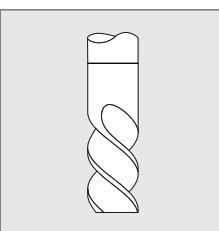
```
G65 P8700 S... Z... U-1.
```

Measure angle with 8715
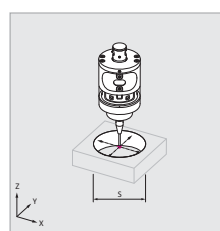
```
G65 P8715 X...
G65 P8715 Y...
```

Additional functions

Tool correction/process adaptation

```
G65 P8706 E... T... U...
I... J... K...
```

Tolerance check with 8707

```
G65 P8707 T... U... I...
J...
```