Using LMI Gocators

with LEonard





Software Version 22.11.1.1

**LEonard Software by Lecky Engineering, LLC**

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| **Document Version** | **Date** | **Major Additions** |
| 21.11.4.0 | 11/04/2021 | Initial user interface and device management system, Java interpreter |
| 22.04.1.0 | 04/01/2022 | Universal Robot interface and grinding system, LEScript support |
| 22.08.1.0 | 08/15/2022 | LMI Gocator interface and demonstration |
| 22.11.1.0 | 11/14/2022 | Python support, screen sizing and display management |
| 22.11.1.1 | 11/25/2022 | Documentation fixes, small code cleanup and reorganization |

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# Overview

LEonard provides a custom interface for the LMI Gocator product line.

The interface is currently in use with and heavily tested with the Gocator 3200 Series Snapshot cameras.

For more information on these powerful systems, see the company website at [lmi3d.com](https://lmi3d.com/) or see product-specific information at [lmi3d.com/series/gocator-3210/](https://lmi3d.com/series/gocator-3210/).

# Basic Ethernet Connection

The Gocator and the computer running LEonard must have an Ethernet interface capable of communication. At Lecky Engineering, our test machine is on 192.168.0.252/24 and our Gocator is on 192.168.0.3/24.

You should be able to browse directly to the Gocator to verify communication.

Graphical user interface, text, application

Description automatically generated

# The LEonard Interface

To communicate with the Gocator, the **Devices** list in LEonard needs an entry for the Gocator. The default devices include two properly setup entries for a Gocator- you will just need to verify and adjust your IP address appropriately.

Graphical user interface, application

Description automatically generated

Figure Device Entries for LMI Gocator

It is important to use the gocator CallBack as well as the displayed TxSuffix and RxTerminator.

The Gocator job that you wish to be loaded can be included in the Jobfile field of the device entry.

Connection is initiated by selecting the desired row and pressing **Connect**. In addition, if you have selected **Auto Connect On Load** for your device file, the connection will be started automatically when LEonard starts.

LEonard always starts a Gocator-style connection with a set of commands:

stop

clearalignment

loadjob <jobFile>

start

Upon successful connection, the Connected field should check itself and the Gocator Status annunciators should appear on the Run tab.

## Additions to the Run Tab for Gocator

Special status annunciators appear when a Gocator is in communication with LEonard. These are shown below.

Diagram

Description automatically generated with low confidence

Figure Gocator Status Annunciators

**Gocator OK:** Is the connection with the Gocator (a special version of TcpClient) healthy?

**Gocator Ready:** Green only if gocator\_ready == True.

NOTE:

On gocator\_trigger(…), gocator\_ready is set to False.

The Gocator must send gocator\_ready=True at the end of processing!

## Using the Accelerator

It is common to use PC-based acceleration with the Gocator to accelerate processing speed.

The Accelerator software is downloaded from the LMI website. Ours is at:

"C:\Users\nedlecky\Desktop\Gocator 3210\14405-6.1.32.12\_SOFTWARE\_GO\_Utilities\Emulator and Accelerator\bin\win64\GoAccelerator.exe"

When this software is running, and started, you will see the dialog below. Sometimes it takes a few attempts to get the connection initiated.

Graphical user interface, application

Description automatically generated

Figure LMI Gocator Accelerator in Operation

For native connection to the Gocator, we would use 192.168.0.3:8190 to connect straight to the Gocator. To use the accelerators, this becomes localIP:8190. In our case, that would be 192.168.0.252:8190.

To browse to the Gocator for monitoring and programming while using the accelerator, just browse to localhost:8080

# Your Gocator Job

The LEonard interface to Gocator is simple. The gocator\_trigger(int pre\_delay\_ms) command sends the “trigger” command to the Gocator which runs whatever job you have loaded.

When the trigger is sent, LEonard clears a variable called gocator\_ready.

Your Gocator job must send gocator\_ready=True as its final output. This is how LEonard knows that processing is complete!

The example Gocator job LEonardRoot/3rdParty/Gocator is called LeonardHolefinder.job.

It measures hole sizes, angles, and locations for both countersunk and thru holes.

It does this using the Surface Countersunk Hole, Surface Hole, and Surface Plane tools as shown below.

Your job could use any Gocator tools!

Graphical user interface

Description automatically generated

Figure LEonardHolefinder.job Tools

After running your inspection, you need to send results back to LEonard, followed by that all-important gocator\_ready=True.

Here’s how LEonardHolefinder.job does it:

A screenshot of a computer

Description automatically generated

Figure Output from the Gocator job to LEonard

The detail on the data format field is as follows:

gc\_decision=%decision[100]

gh\_decision=%decision[200]

gc\_offset\_x=%value[100]

gc\_offset\_y=%value[101]

gc\_offset\_z=%value[102]

gc\_outer\_radius=%value[103]

gc\_depth=%value[104]

gc\_bevel\_radius=%value[105]

gc\_bevel\_angle=%value[106]

gc\_xangle=%value[107]

gc\_yangle=%value[108]

gc\_cb\_depth=%value[109]

gc\_axis\_tilt=%value[110]

gc\_axis\_orient=%value[111]

gh\_offset\_x=%value[200]

gh\_offset\_y=%value[201]

gh\_offset\_z=%value[202]

gh\_radius=%value[203]

gp\_xangle=%value[300]

gp\_yangle=%value[301]

gp\_z\_offset=%value[302]

gp\_std\_dev=%value[303]

gocator\_ready=True

DON’T FORGET THAT LAST LINE!

LEonard will assume the Gocator is still crunching data until it receives that. That will also trigger the Gocator Ready annunciator to go back to green.

That’s it! You can send as many results back as you like, and they will be received and remembered by LEonard.

These variables are stored in the LEonard LEScript variable set as well as the variable lists in Java and Python.

The variable assignment statements are passed to Java and Python exactly as received, so the automatic typing rules implemented in those languages will automatically happen. The received values will be integers or floats as assumed in Python, for example.

# Using the Results in LEonard

LEonard includes a hard-coded gocator\_adjust function that automatically moves a UR robot to try to drive offsets and angles to 0. This code makes assumptions about orientation, scale, and offset that might not be what you need, however.

Look at the example Python alignment, which is entirely user-modifiable, in LEonardRoot/Code/Lib/leGocatorSupport.py to see how custom functions can be used to feed robot motion commands back as a result of measurements.

Look at the examples in LEonardRoot/Code/Examples/Gocator to see how these functions are used.

# LElib.LMI Library for LMI Gocator

Here is the complete documentation for each of the Gocator-specific internal and Python-based calls available in LEonard.

Many example programs using the snapshot camera for alignment are in LEonardRoot/Code/Examples/Gocator.

To learn how to connect, configure, and setup programs for use on the Gocator with LEonard, consult the ***LMI Gocator QuickStart for LEonard*** manual.

## LElib.LMI.gocator

These are Gocator support commands built-in to LEonard. As they are not user-modifiable, they should only be used in existing applications.

Lecky Engineering provides a Python library for LEonard that duplicates these capabilities in user-modifiable Python code.

These are discussed after the built-in functions here.

#### gocator\_send(string message)

Sends the command message to the currently selected LMI Gocator. Non-blocking.

#### gocator\_trigger(int pre\_delay\_ms)

Sends the command trigger to the currently selected LMI Gocator. Delays for pre\_delay\_ms milliseconds prior to sending the trigger to allow specification of robot mechanical settling time.

#### gocator\_adjust(int version)

This is a built-in fixed adjustment routine in LEonard for hole aligning using the LMI Gocator and a UR robot. It has been used for several applications but is replaced by the new Python version that is user modifiable.

This is a hardcoded adjustment that assumes the use of counterbore, thru hole, and plane tools returning the following variables from the Gocator. The example Gocator job used for testing is at LEonardRoot/3rdParty/Gocator/LEonardHolefinder.job.

**Counterbore Tool**

gc\_decision 0 if counterbore tool succeeded

gc\_offset\_x Misalignment in X in microns

gc\_offset\_y Misalignment in Y in microns

gc\_offset\_z Misalignment in Z in microns

gc\_xangle Misalignment angle in X in deg/1000

gc\_yangle Misalignment angle in Y in deg/1000

Also Included (Unused in examples)

gc\_outer\_radius Misalignment angle in Y in deg/1000

gc\_depth Misalignment angle in Y in deg/1000

gc\_bevel\_radius Misalignment angle in Y in deg/1000

gc\_bevel\_angle Misalignment angle in Y in deg/1000

**Hole Tool**

gh\_decision 0 if thru hole tool succeeded

gh\_offset\_x Misalignment in X in microns

gh\_offset\_y Misalignment in Y in microns

gh\_offset\_z Misalignment in Z in microns

**Plane Tool**

gp\_xangle Misalignment angle in X in deg/1000

gp\_yangle Misalignment angle in Y in deg/1000

#### gocator\_write\_data(string filename, string tag\_name)

This built in fixed routine write the standard Gocator alignment variables to a file. The CSV file created has a timestamp, an optional tag name, and a copy of all the variables returned by the standard Gocator application.

Example file with the returned results in it as built by example program LEonardRoot/Code/Examples/Gocator/10p Static Repeatability.txt

timestamp,gocator\_ID,gc\_decision,gc\_offset\_x,gc\_offset\_y,gc\_offset\_z,gc\_outer\_radius,gc\_depth,dc\_bevel\_radius,gc\_bevel\_angle,gc\_xangle,gc\_yangle,gc\_cb\_depth,gc\_axis\_tilt,gc\_axis\_orient,gh\_decision,gh\_offset\_x,gh\_offset\_y,gh\_offset\_z,gh\_radius,gp\_xangle,gp\_yangle,gp\_z\_offset,gp\_std\_dev

,,,in,in,in,in,in,in,deg,deg,deg,in,deg,deg,,in,in,in,in,deg,deg,in,in

2022-11-06 14:30:56,static\_pose,0,-0.0448,0.2962,-0.0272,0.2635,3.1,0.7,100.5,0.9,-0.2,0.0000,2.9,99.2,0,-0.0439,0.2826,-0.0363,0.1331,-0.1,0.0,-0.0385,0.0220

2022-11-06 14:47:53,static\_pose,0,-0.0447,0.2961,-0.0272,0.2636,3.1,0.7,100.5,0.9,-0.2,0.0000,2.8,99.2,0,-0.0439,0.2827,-0.0363,0.1332,-0.1,0.0,-0.0386,0.0222

2022-11-06 14:47:56,static\_pose,0,-0.0447,0.2964,-0.0273,0.2635,3.1,0.7,100.5,0.9,-0.2,0.0000,2.9,99.6,0,-0.0432,0.2823,-0.0365,0.1335,-0.1,0.0,-0.0387,0.0226

## Python Library for Gocator

Lecky Engineering provides a Python library for LEonard that duplicates the built-in functions in user-modifiable Python code.

Load the commands into your sequence and switch into Python processing to use them:

exec\_python(Lib/leGocatorSupport.py)

using\_python()

These commands are:

start\_operation()

end\_operation()

adjust\_alignment()

offset\_to\_probe()

write\_results()

Many example programs using the snapshot camera for alignment are in LEonardRoot/Code/Examples/Gocator.

#### start\_operation()

Just performs a movement to cp\_origin, a previously taught LEonard position assumed to be the start position and orientation of the part to be inspected. We tell the robot that this is part(0,0,0,0,0,0).

def start\_operation():

move\_linear('cp\_origin')

movel\_rel\_set\_part\_origin\_here()

#### end\_operation()

Just moves back to the cp\_origin home position.

def end\_operation():

move\_linear('cp\_origin')

#### adjust\_alignment(int version)

Identical in performance to gocator\_adjust. Feel free to copy and modify!

#### offset\_to\_probe()

A demo routine that simply moves the robot in part coordinates the distance assumed from the Gocator 0,0,0 to the tip of the tool.

def offset\_to\_probe():

movel\_incr\_part(-0.0235,0,0.165,0,0,0)

#### write\_results(string filename, string tag\_name)

Identical in performance to gocator\_write\_data. Feel free to copy and modify!

**How Does Adjust Alignment Work?**

Here’s the code. In this version, we’re really just trying to drive all Gocator positions to 0,0,0,0,0,0.

Translation movements in x,y,z are done in tool coordinates.

Rotations are done in Leonatrd Part coordinates, which means that if a spherical or cylindrical part has been specified, LEonard will follow the surface trajectory as part of it’s X,Y,Z movement.

The example programs assume a cylindrical part which is setup in LEonardRoot/Code/Examples/Gocator/00p Origin.txt:

# 00p Set Origin

exec\_python(Lib/leGocatorSupport.py)

using\_python()

start\_operation()

# Coupon is 762mm diam (32in)

coupon\_diameter = 762.0

le\_write\_sysvar('coupon\_diameter',str(coupon\_diameter))

# Force all speeds and accelerations to good inspection ones!

linear\_speed = 100

linear\_accel = 100

joint\_speed = 20

joint\_accel = 10

blend\_radius = 2

set\_linear\_speed(linear\_speed)

set\_linear\_accel(linear\_accel)

set\_joint\_speed(joint\_speed)

set\_joint\_accel(joint\_accel)

set\_blend\_radius(blend\_radius)

grind\_trial\_speed(linear\_speed)

grind\_linear\_accel(linear\_accel)

grind\_max\_blend\_radius(blend\_radius)

select\_tool('gocator3210')

set\_part\_geometry('CYLINDER',coupon\_diameter)

end\_operation()

For reference, the exact Python code for the adjustment function is as follows:

# adjust\_alignment.py

# LMI Gocator Interface Code for LEonard

# Lecky Engineering LLC

# Author: Ned Lecky

# Description: Moves the robot to drive the offsets from Gocator to 0

#

# This version:

# Implements 4 versions of alignment- see code below

#

# Customize as needed for your application

# Moves robot to (hopefully!) drive alignment values to zero

# Version:

# 1: only adjusts translation

# 2: only adjusts rotation

# 3: adjusts in translation first, pauses 1S, and then does rotation

# 4: adjusts all 5 axes simultaneously but 3D calcs are not spot-on

def adjust\_alignment(version):

le\_print('adjust\_alignment starting...')

dx = 0.0

dy = 0.0

dz = 0.0

drx = 0.0

dry = 0.0

# Assumes using counterbore and thruhole tools. Uses counterbore if result, else tries thruhole

# NOTE: dz and drx are negated below to match sensor/robot alignment!

if gc\_decision == '0':

le\_print('Using counterbore')

dx = float(gc\_offset\_x) / 1e6

dy = float(gc\_offset\_y) / 1e6

dz = -float(gc\_offset\_z) / 1e6

drx = -float(gc\_xangle) / 1e3

dry = float(gc\_yangle) / 1e3

elif gh\_decision == '0':

le\_print('Using thruhole')

dx = float(gh\_offset\_x) / 1e6

dy = float(gh\_offset\_y) / 1e6

dz = -float(gh\_offset\_z) / 1e6

drx = -float(gp\_xangle) / 1e3

dry = float(gp\_yangle) / 1e3

else:

le\_print('No result found')

return

abs\_dx = abs(dx)

abs\_dy = abs(dy)

abs\_dz = abs(dz)

abs\_drx = abs(drx)

abs\_dry = abs(dry)

drx\_rad = math.radians(drx)

dry\_rad = math.radians(dry)

if version == 1:

le\_print('Version 1 Translation Only')

if abs\_dx > 0.020 or abs\_dy > 0.020 or abs\_dz > 0.020:

le\_print('Excessive gocator\_adjust (' + str(dx) + ',' + str(dy) + ',' + str(dz) + ',0,0,0)')

else:

movel\_incr\_part(dx,dy,dz,0,0,0)

elif version == 2:

le\_print('Version 2 Rotation Only')

if abs\_drx > 15 or abs\_dry > 15:

le\_print('Excessive gocator\_adjust (0,0,0,' + str(drx) + ',' + str(dry) + ',0)')

else:

movel\_incr\_tool(0,0,0,drx\_rad,dry\_rad,0)

elif version == 3:

le\_print('Version 3 translate, Pause 1sec, Rotate')

if abs\_dx > 0.020 or abs\_dy > 0.020 or abs\_dz > 0.020 or abs\_drx > 15 or abs\_dry > 15:

le\_print('Excessive gocator\_adjust (' + str(dx) + ',' + str(dy) + ',' + str(dz) + ',' + str(drx\_rad) +',' + str(dry\_rad) + ',0)')

else:

movel\_incr\_part(dx,dy,dz,0,0,0)

time.sleep(1)

movel\_incr\_tool(0,0,0,drx\_rad,dry\_rad,0)

elif version == 4:

le\_print('Version 4 All 5 axes at once- not quite accurate!')

if abs\_dx > 0.020 or abs\_dy > 0.020 or abs\_dz > 0.020 or abs\_drx > 15 or abs\_dry > 15:

le\_print('Excessive gocator\_adjust (' + str(dx) + ',' + str(dy) + ',' + str(dz) + ',' + str(drx) +',' + str(dry) + ',0)')

else:

movel\_incr\_tool(dx,dy,dz,drx\_rad,dry\_rad,0)

le\_print('adjust\_alignment complete')

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