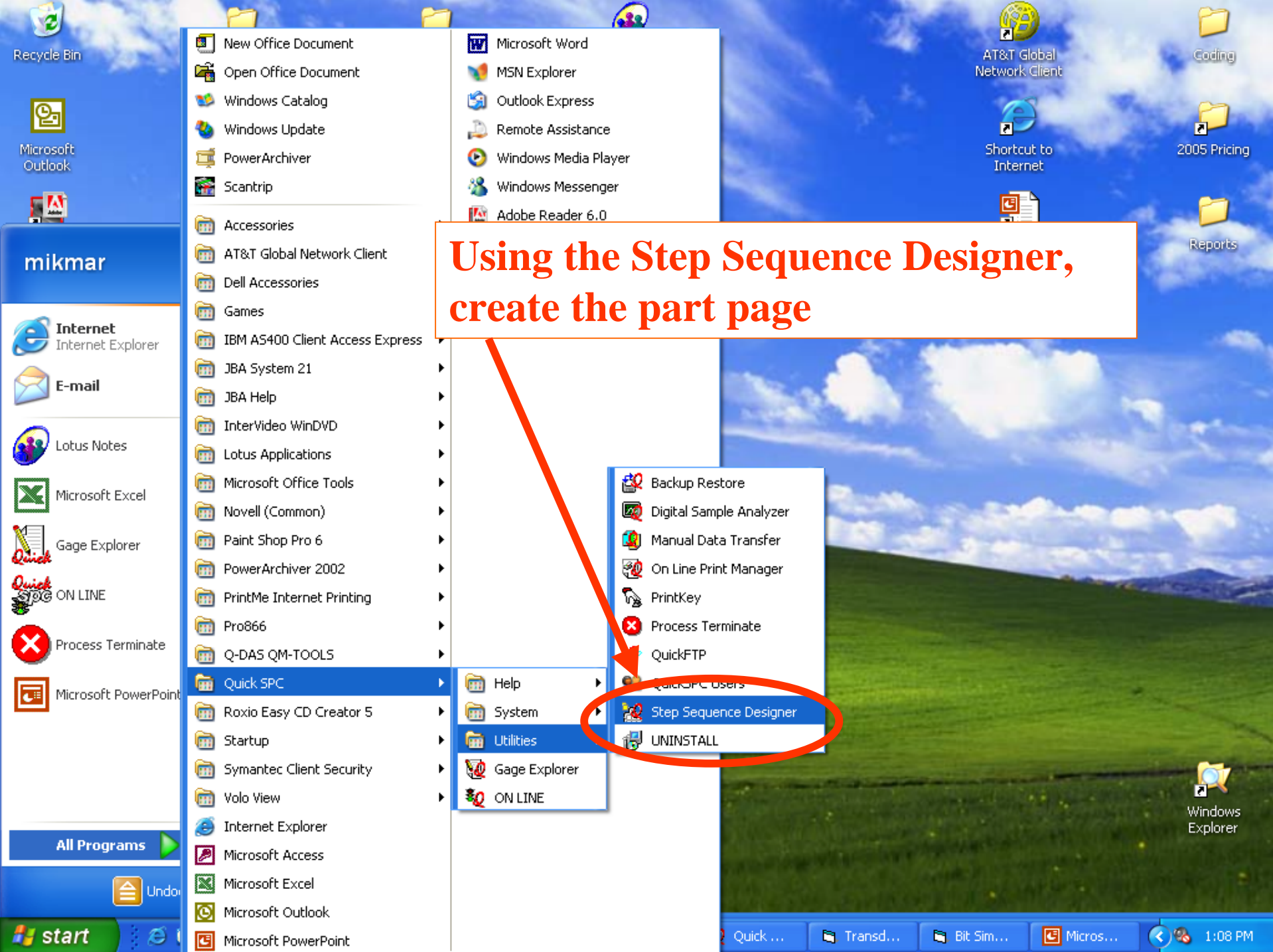


**MARPOSS**

# **HOW TO ADD A PART GRAPHIC TO A GAGING APPLICATION**

**Using the Step Sequence Designer,  
create the part page**



- Open...
- New
- Save...
- Save As...**
- Select Part Program...
- Exit

0.0

-100.0

↕

um

M1

P1	∅	Diameter1-12h
P3	∅	Diameter3-12h
P2	∅	Diameter2-12h

**Once you have completed designing the page, Select "File ...Save as.."**



New Page

**Save the File**

Save in: Frames

CylBlickManual.fpp	Opto.fpp	Snap-InitZero.fpp
CylBlickManualInit.fpp	Opto_15.fpp	Snap-Manual.fpp
CylSide8.fpp	Opto_J12.fpp	Snap-Meas1.fpp
CylSide9_1.fpp	Opto_J15.fpp	Snap-Meas2.fpp
CylSide9_2.fpp	Prompt_frame.fpp	Snap-Meas3.fpp
CylSideManual.fpp	Prompt_frame_15.fpp	Snap-Meas4.fpp
CylTop7_1.fpp	Prompt_frame_J12.fpp	Snap-Summ.fpp
CylTop7_2.fpp	Prompt_frame_J15.fpp	Snap-Zero.fpp
CylTop12.fpp	QuickS_Manual.fpp	Stator_InitMach.fpp
CylTop34.fpp	QuickS_Preel1.fpp	Stator_InitMeas.fpp
CylTop56.fpp	QuickS_Preel2.fpp	Stator_InitRough.fpp
CylTopManual.fpp	QuickS_PreelINF.fpp	Stator_Manual.fpp
gageC.fpp	QuickS_Sum.fpp	Stator_Meas.fpp
M1G1-Zero.fpp	QuickS_ZeroInit.fpp	Stator_Rough.fpp
M1G3-Zero.fpp	Snap-Engage.fpp	Stator_ZeroSum.fpp

File name: Demo Part Page

Save as type: Prompted Page (\*.fpp)

Save Cancel

**Give it a FPP name and Save**

# Close Step Sequence Designer and open “On-Line”

The screenshot shows the Windows XP Start menu. The 'All Programs' button is visible at the bottom left. The 'Step Sequence Designer' application is highlighted in blue. A sub-menu is open for 'Step Sequence Designer', showing the following items:

- IBM AS400 Client Access Express
- JBA System 21
- JBA Help
- InterVideo WinDVD
- Lotus Applications
- Microsoft Office Tools
- Novell (Common)
- Paint Shop Pro 6
- PowerArchiver 2002
- PrintMe Internet Printing
- Pro866
- Q-DAS QM-TOOLS
- Quick SPC** (highlighted)
  - Help
  - System
  - Utilities
  - Gage Explorer
  - ON LINE** (highlighted)
- Roxio Easy CD Creator 5
- Startup
- Symantec Client Security
- Volo View
- Internet Explorer
- Microsoft Access
- Microsoft Excel
- Microsoft Outlook
- Microsoft PowerPoint

The screenshot shows the Windows XP desktop with the Start menu open. The desktop background is the classic Windows XP 'Bliss' wallpaper. The taskbar at the bottom shows several open applications: Quick..., Transd..., Bit Sim..., and Micros... The system tray on the right shows the time as 1:39 PM. The Start menu is open, showing the 'Step Sequence Designer' application highlighted, with its sub-menu open and 'ON LINE' highlighted.

Dynamic Shaft		Quick Set Vertical		Reworkable	
M1	∅	2.2	DIAM-1	Good	
	μm		-32.5   0.0   32.5		
M2	∅	27.3	DIAM-2	Rework	
	μm		-8.0   0.0   8.0		
M3	∅	36.5	DIAM-3	Rework	
	μm		-8.0   0.0   8.0		
M4	∅	-14.8	DIAM-4	Good	
	μm		-43.5   0.0   43.5		
M5	∅	3.5	RunOut	Good	
	μm		0.0   50.0		
M6	∅	0.0	RunOut	Good	
	μm		0.0   20.0		
M7	∅	-3.5	RunOut	Good	
	μm		0.0   20.0		
M8	H	-1.6	DIST-1	Good	
	μm		-100.0   0.0   100.0		

**Change User to Administrator**

- 1
- 2
- 3
- 4
- 5
- 6
- 7
- 8
- 9
- 0

Prog Name **Dynamic Shaft** Mode **Manual** Status **OK** Step #  
User **Operator - Standard** 3/31/2005 1:44:38 PM Process Status: **In Control**

**Dynamic Shaft** **Quick Set Vertical** **Reworkable**

Metric	Symbol	Value	Feature	Status
M1	∅	7.1	DIAM-1	Good
	μm		-32.5   0.0   32.5	
M2	∅	31.6	DIAM-2	Rework
	μm		-8.0   0.0   8.0	
M3	∅	37.7	DIAM-3	Rework
M4	∅	-1.0		
	μm			
M5	∅			
	μm			
M6	∅			
	μm			
M7	∅			
	μm			
M8	H	-3.0		
	μm		-100.0   0.0   100.0	

**Login**

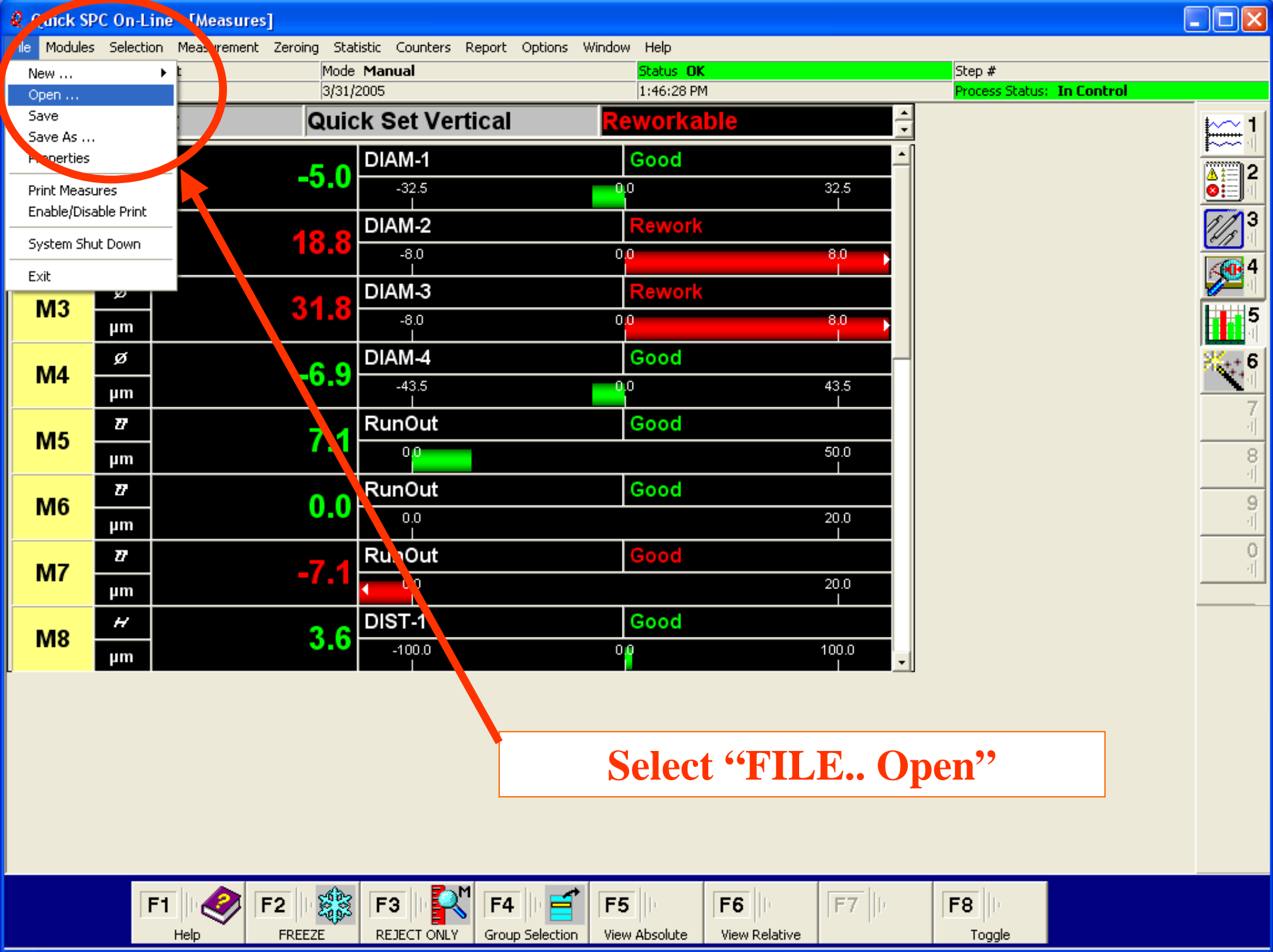
User Name: Administrator

Password: [ ]

MDI Mode:

OK Cancel

- 1 [Icon]
- 2 [Icon]
- 3 [Icon]
- 4 [Icon]
- 5 [Icon]
- 6 [Icon]
- 7 [Icon]
- 8 [Icon]
- 9 [Icon]
- 0 [Icon]



- New ...
- Open ...
- Save
- Save As ...
- Properties
- Print Measures
- Enable/Disable Print
- System Shut Down
- Exit

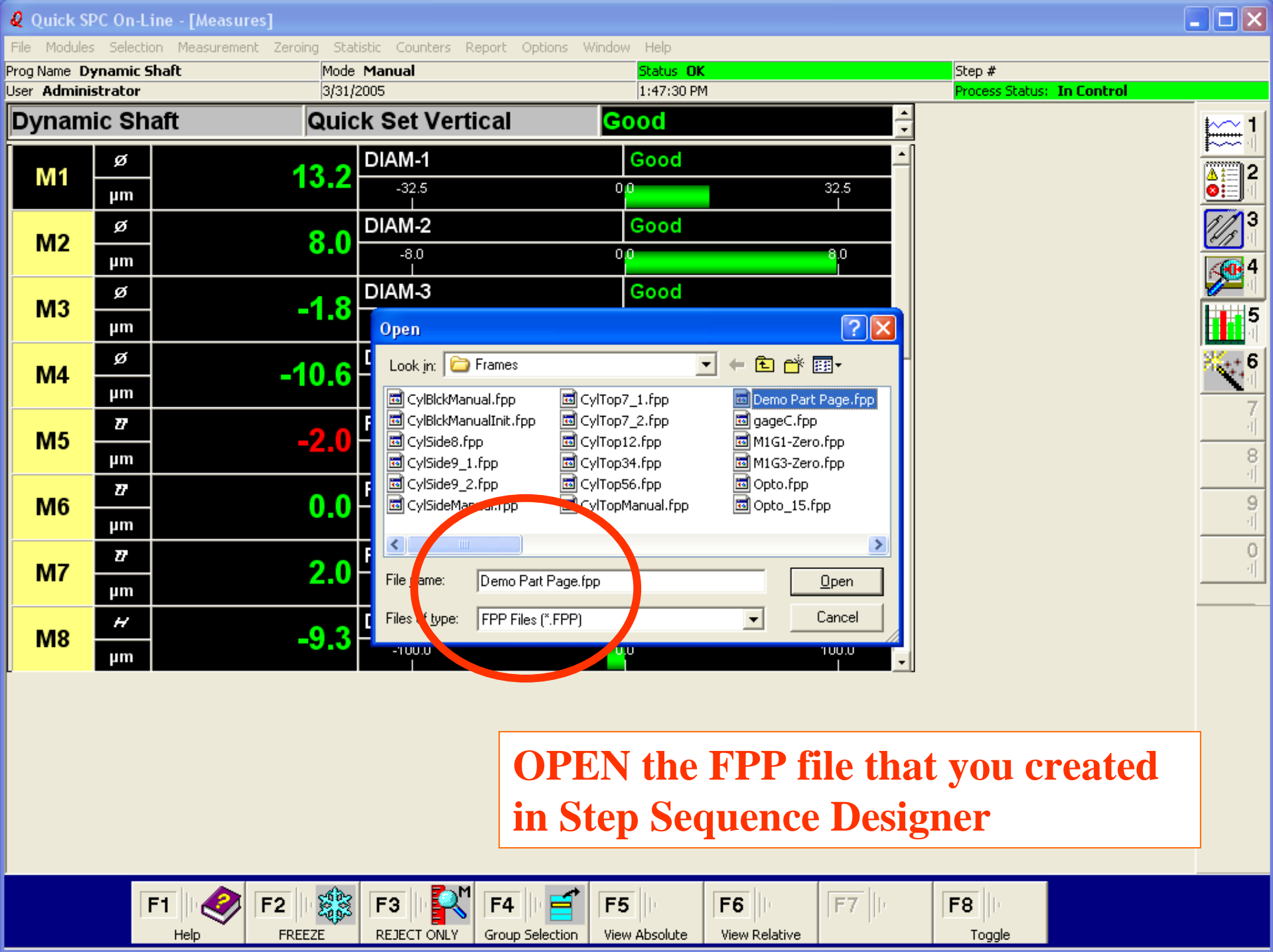
Mode **Manual** Status **OK** Step #  
3/31/2005 1:46:28 PM Process Status: **In Control**

**Quick Set Vertical Reworkable**

<b>M3</b>	μm	<b>-5.0</b>	DIAM-1	Good
			-32.5   0.0   32.5	
<b>M4</b>	μm	<b>18.8</b>	DIAM-2	Rework
			-8.0   0.0   8.0	
<b>M5</b>	μm	<b>31.8</b>	DIAM-3	Rework
			-8.0   0.0   8.0	
<b>M6</b>	μm	<b>-6.9</b>	DIAM-4	Good
			-43.5   0.0   43.5	
<b>M7</b>	μm	<b>7.1</b>	RunOut	Good
			0.0   50.0	
<b>M8</b>	μm	<b>0.0</b>	RunOut	Good
			0.0   20.0	
<b>M9</b>	μm	<b>-7.1</b>	RunOut	Good
			0.0   20.0	
<b>M10</b>	μm	<b>3.6</b>	DIST-1	Good
			-100.0   0.0   100.0	

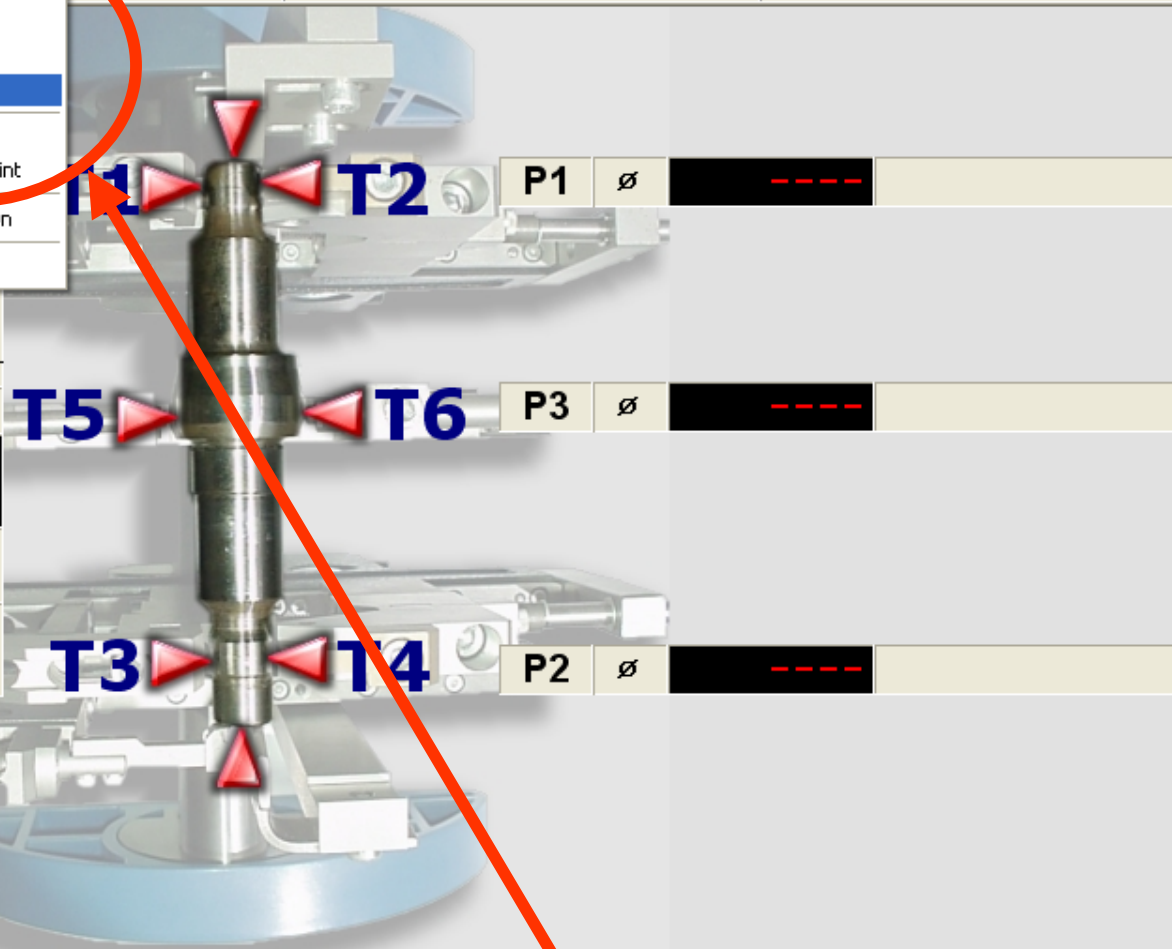
- 1
- 2
- 3
- 4
- 5
- 6
- 7
- 8
- 9
- 0

Select "FILE.. Open"



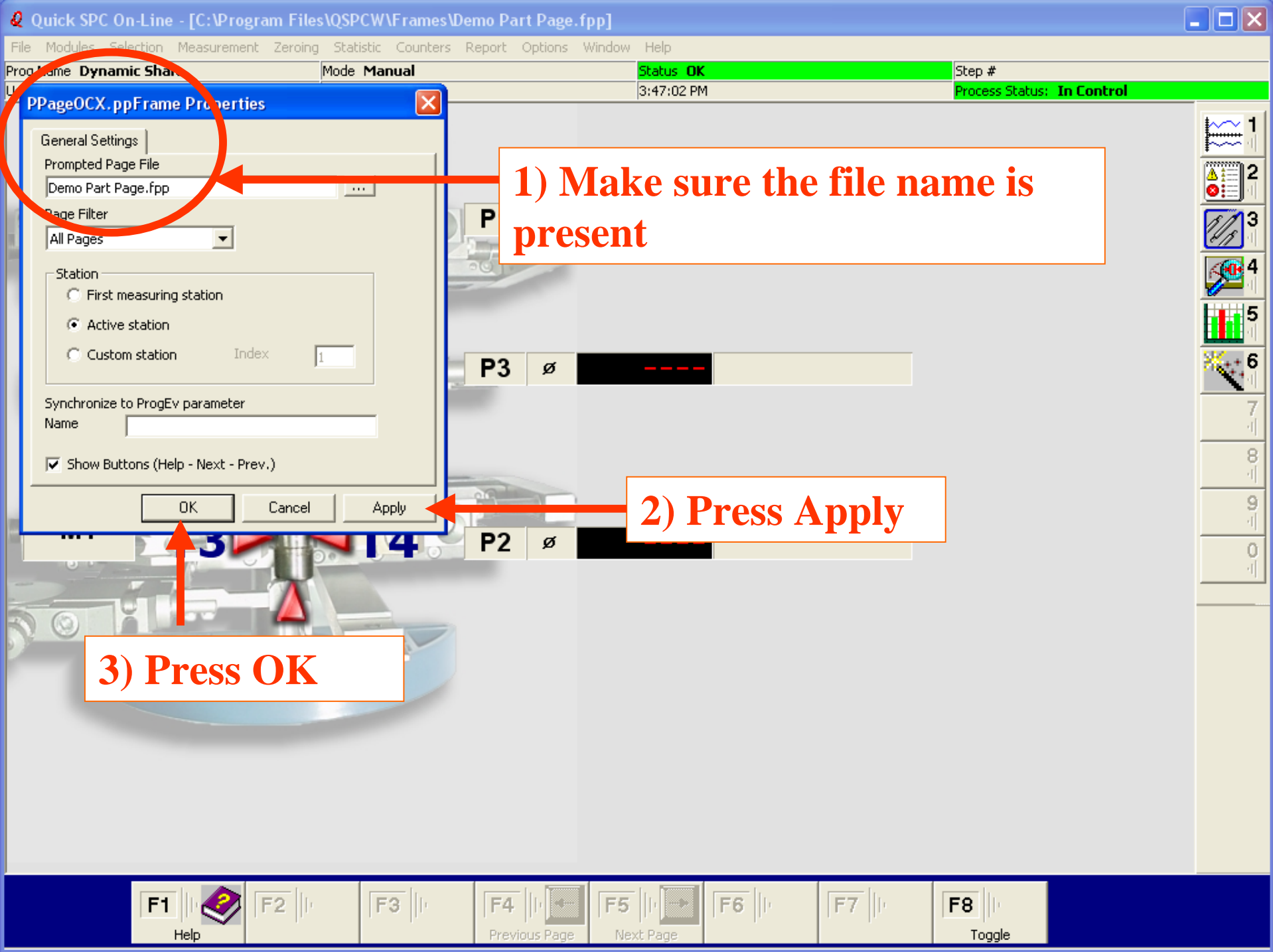
- New ...
- Open ...
- Save
- Save As ...
- Properties**
- Print Measures
- Enable/Disable Print
- System Shut Down
- Exit

-32.5  
↓  
**9.1**  
∅ μm  
M1



- 1 [Icon]
- 2 [Icon]
- 3 [Icon]
- 4 [Icon]
- 5 [Icon]
- 6 [Icon]
- 7 [Icon]
- 8 [Icon]
- 9 [Icon]
- 0 [Icon]

Select "FILE ...Properties"



**PPageOCX.ppFrame Properties**

General Settings

Prompted Page File  
Demo Part Page.fpp

Page Filter  
All Pages

Station  
 First measuring station  
 Active station  
 Custom station Index 1

Synchronize to ProgEv parameter  
Name

Show Buttons (Help - Next - Prev.)

OK Cancel Apply

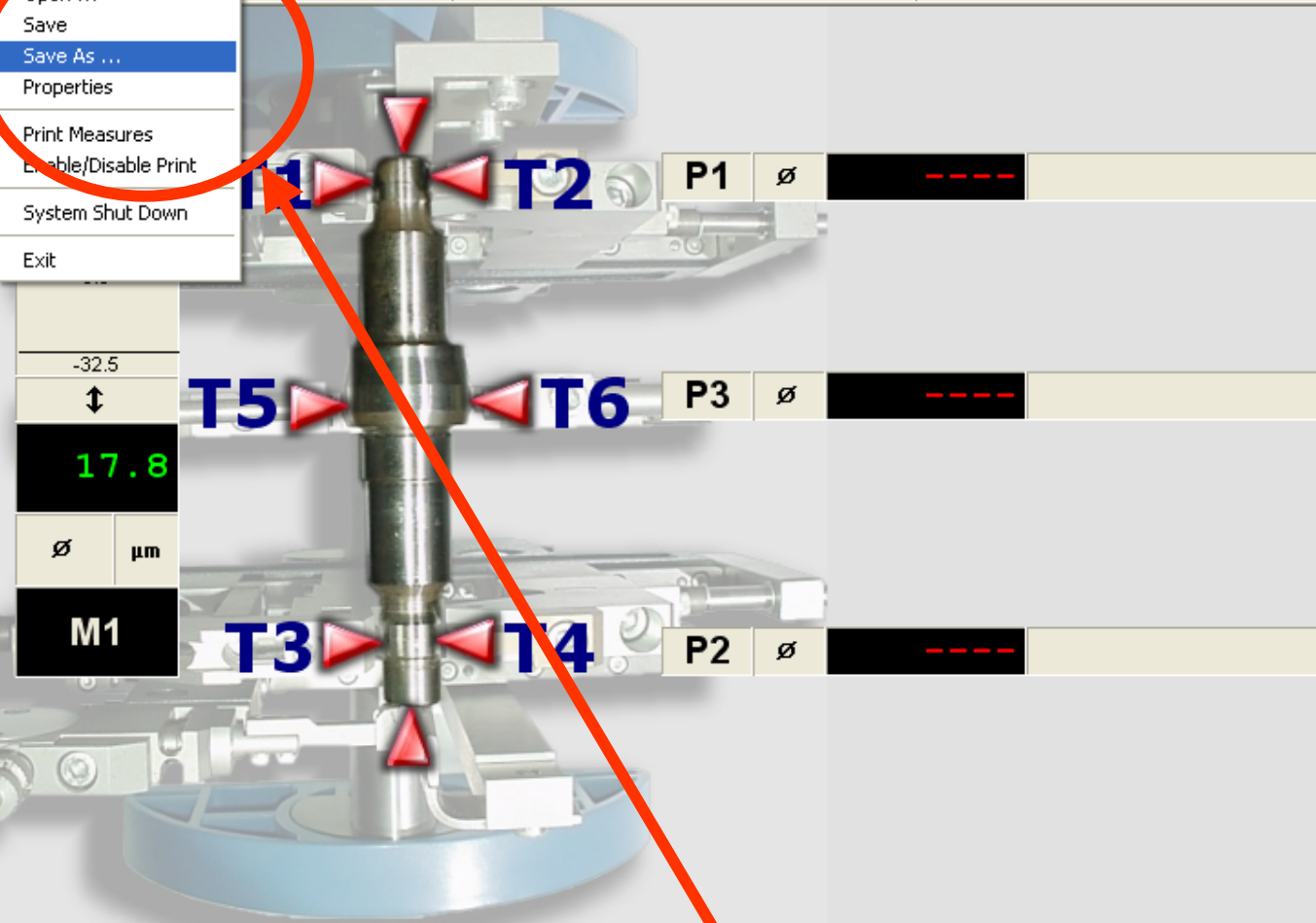
1) Make sure the file name is present

2) Press Apply

3) Press OK

- New ...
- Open ...
- Save
- Save As ...**
- Properties
- Print Measures
- Enable/Disable Print
- System Shut Down
- Exit

Mode <b>Manual</b>	Status <b>OK</b>	Step #
3/31/2005	1:48:15 PM	Process Status: <b>In Control</b>

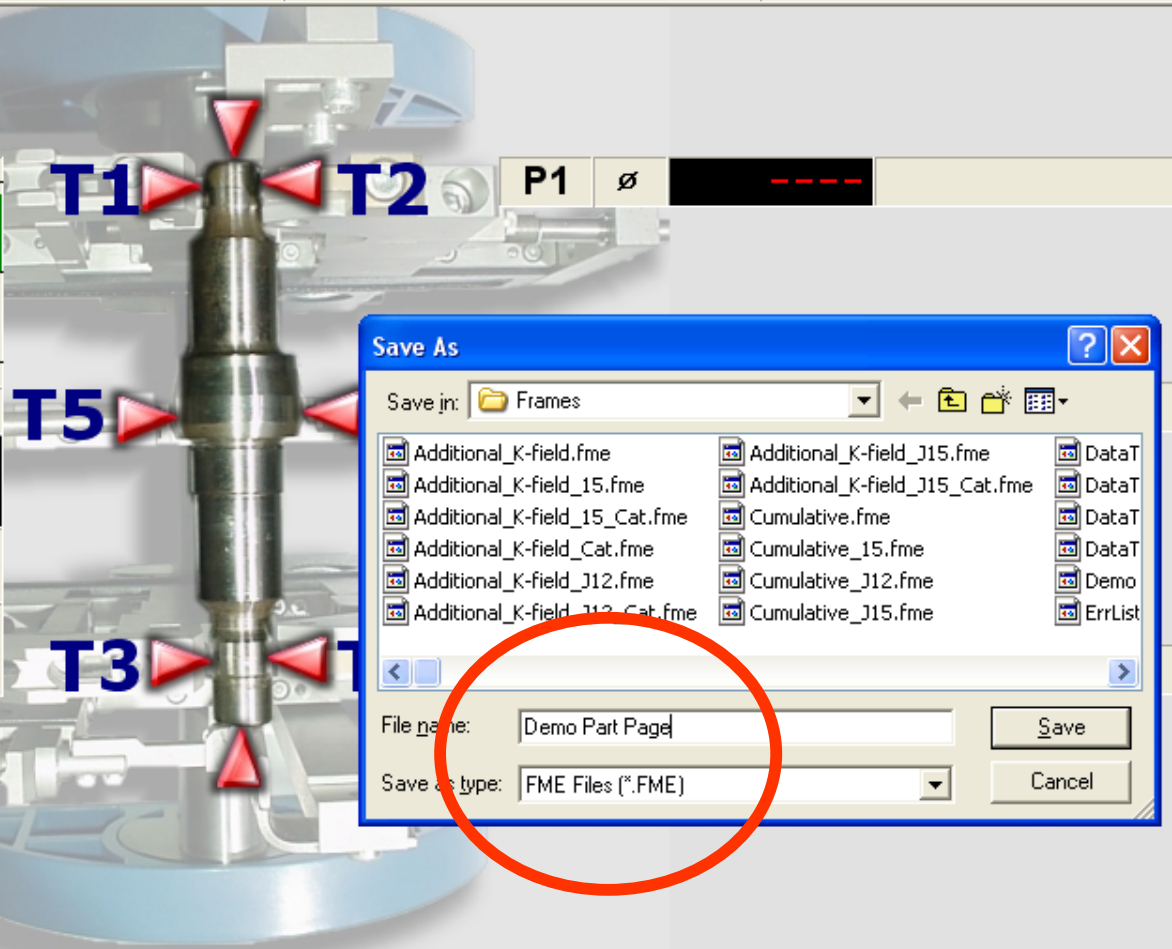


- 1
- 2
- 3
- 4
- 5
- 6
- 7
- 8
- 9
- 0

Select "FILE.. Save As"

File	Modules	Selection	Measurement	Zeroing	Statistic	Counters	Report	Options	Window	Help
Prog Name	<b>Dynamic Shaft</b>	Mode	<b>Manual</b>	Status	<b>OK</b>	Step #				
User	<b>Administrator</b>		3/31/2005		1:49:51 PM	Process Status:	<b>In Control</b>			

32.5  
0.0  
-32.5  
29.1  
∅ μm  
M1



1  
2  
3  
4  
5  
6  
7  
8  
9  
0

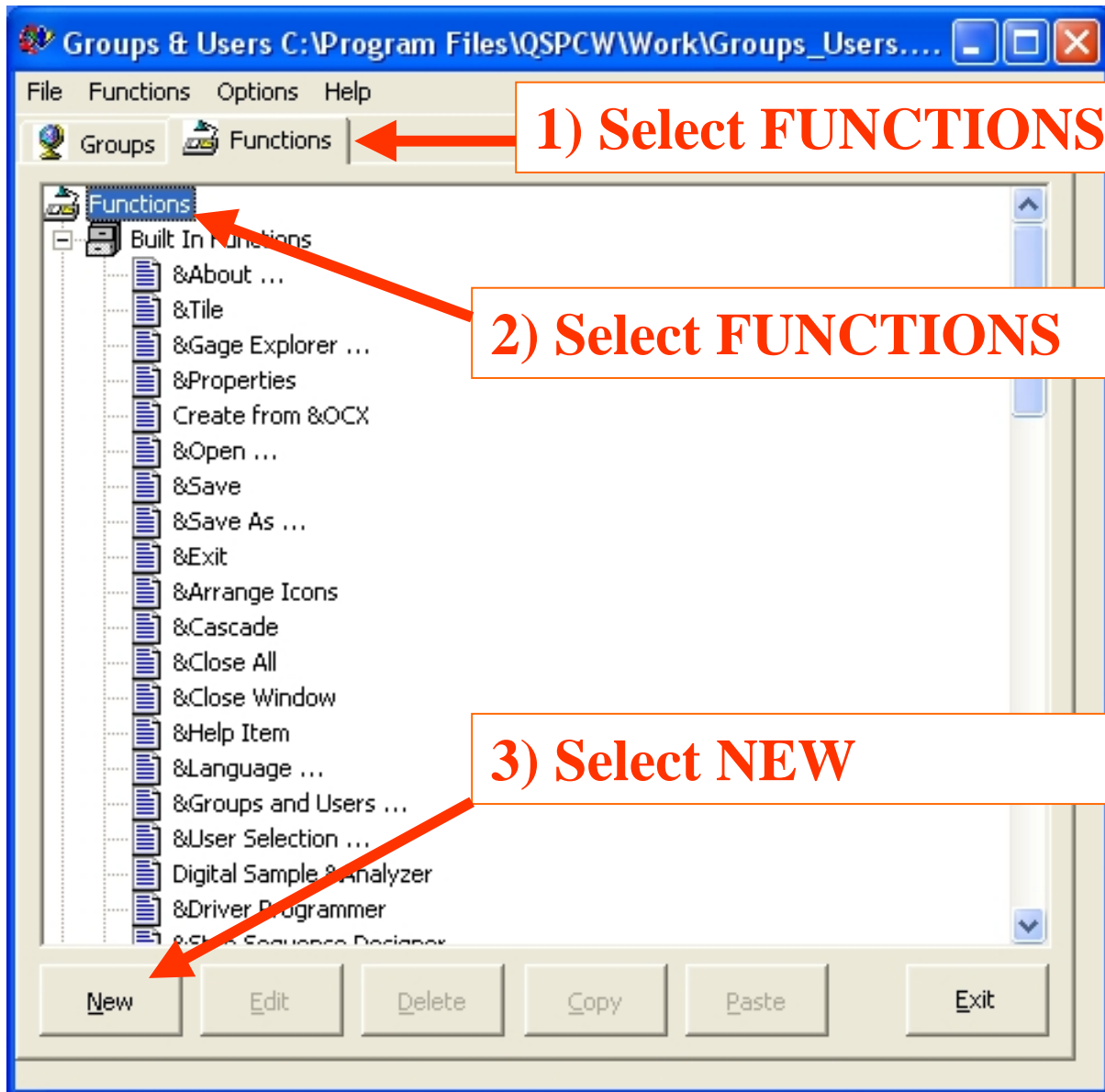
**Now save the file as an FME**

# Close On-Line and open GROUPS & USERS

The screenshot shows a Windows XP desktop with a Start menu open. The Start menu is expanded to show 'All Programs', which lists various applications. The 'ON LINE' application is highlighted. A sub-menu is open for 'ON LINE', showing options like 'Help', 'System', 'Utilities', 'Gage Explorer', and 'ON LINE'. The 'System' option is further expanded, showing 'Statistic Configuration', 'Driver Programmer', 'G.C. Configuration', 'Groups&Users', and 'System Configuration'. The 'Groups&Users' option is highlighted, indicating the next step in the process.

- IBM AS400 Client Access Express
- JBA System 21
- JBA Help
- InterVideo WinDVD
- Lotus Applications
- Microsoft Office Tools
- Novell (Common)
- Paint Shop Pro 6
- PowerArchiver 2002
- PrintMe Internet Printing
- Pro866
- Q-DAS QM-TOOLS
- Quick SPC**
- Roxio Easy CD Creator 5
- Startup
- Symantec Client Security
- Volo View
- Internet Explorer
- Microsoft Access
- Microsoft Excel
- Microsoft Outlook
- Microsoft PowerPoint

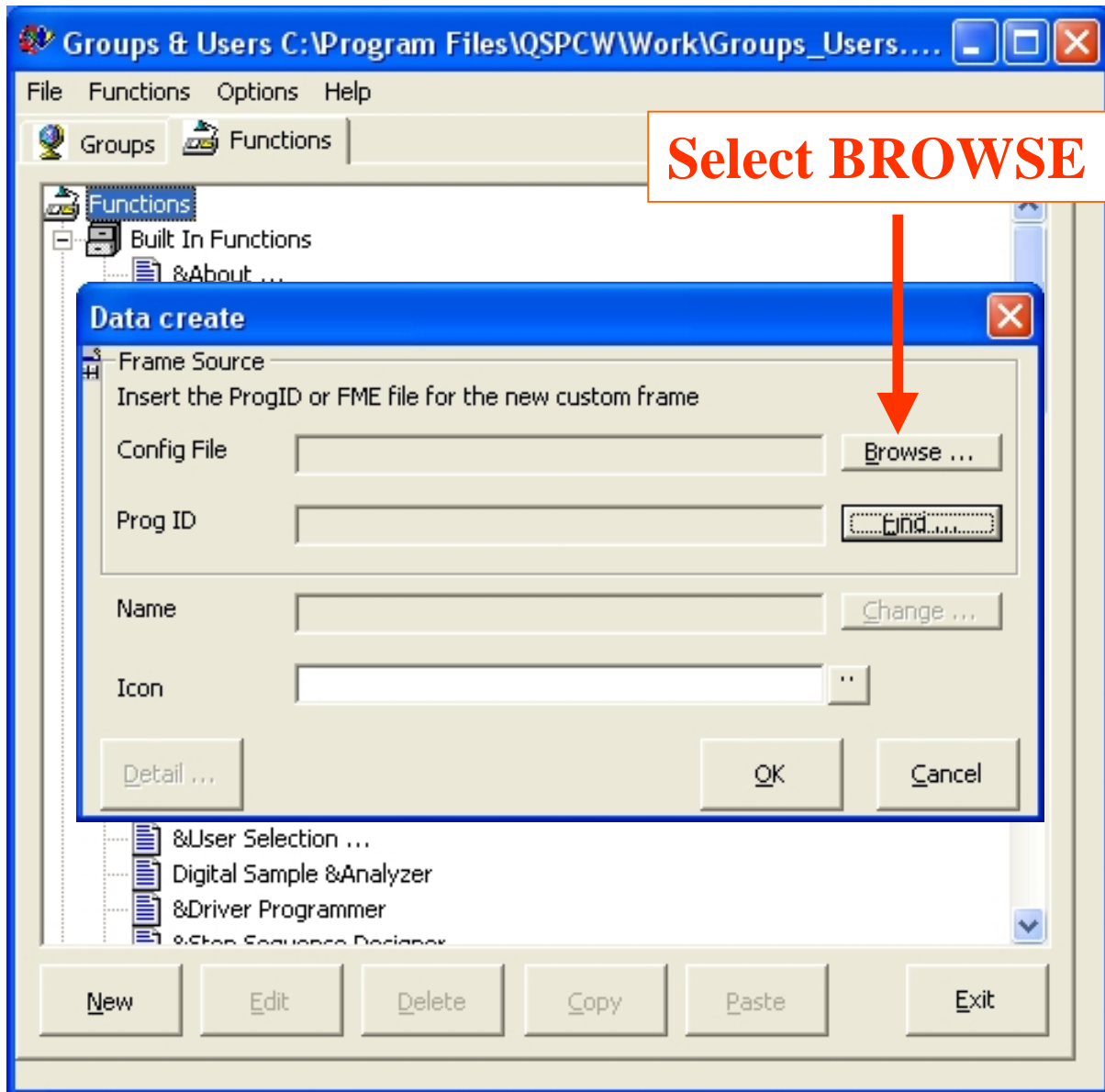
- Help
- System
  - Statistic Configuration
  - Driver Programmer
  - G.C. Configuration
  - Groups&Users**
  - System Configuration
- Utilities
- Gage Explorer
- ON LINE

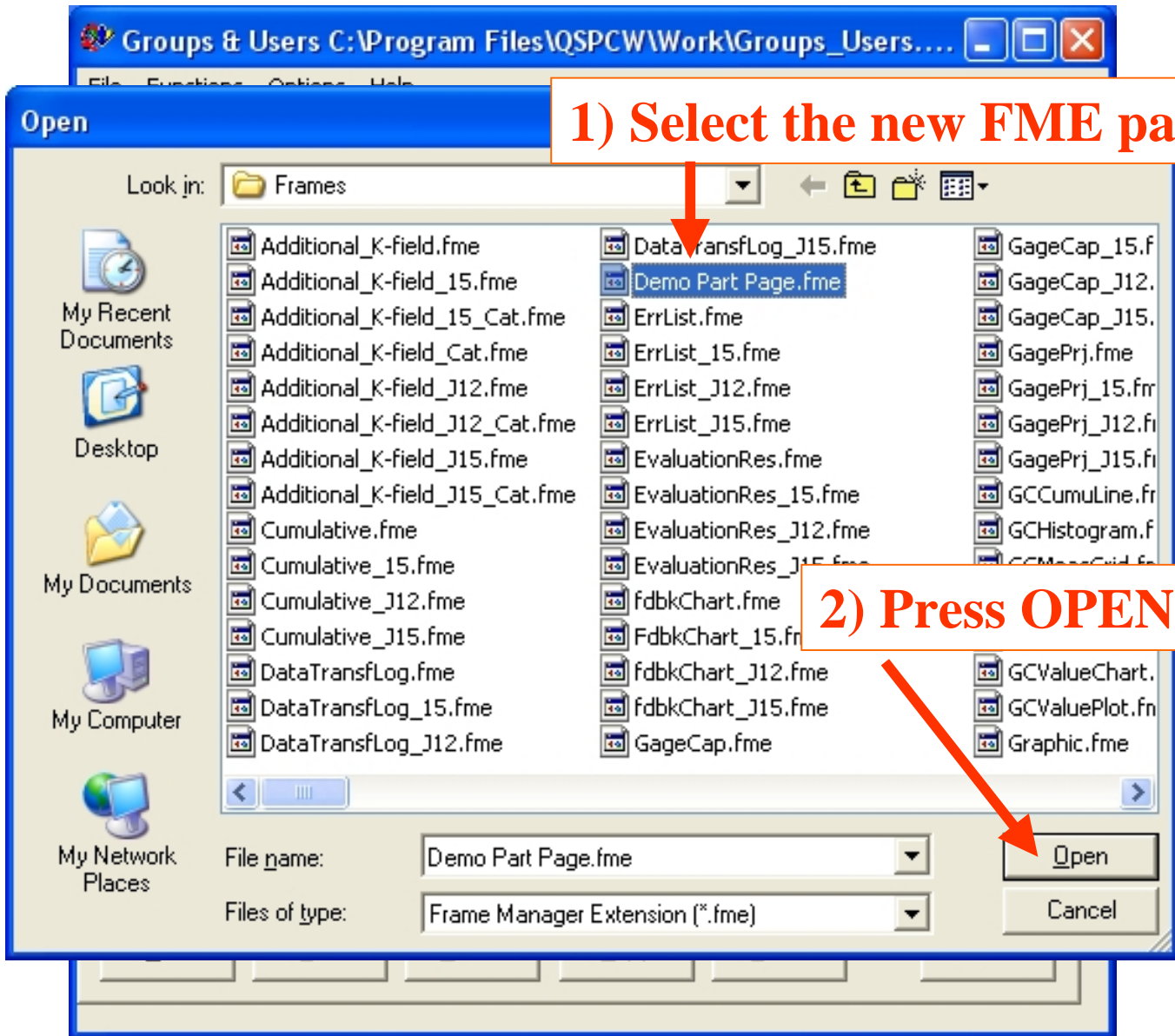


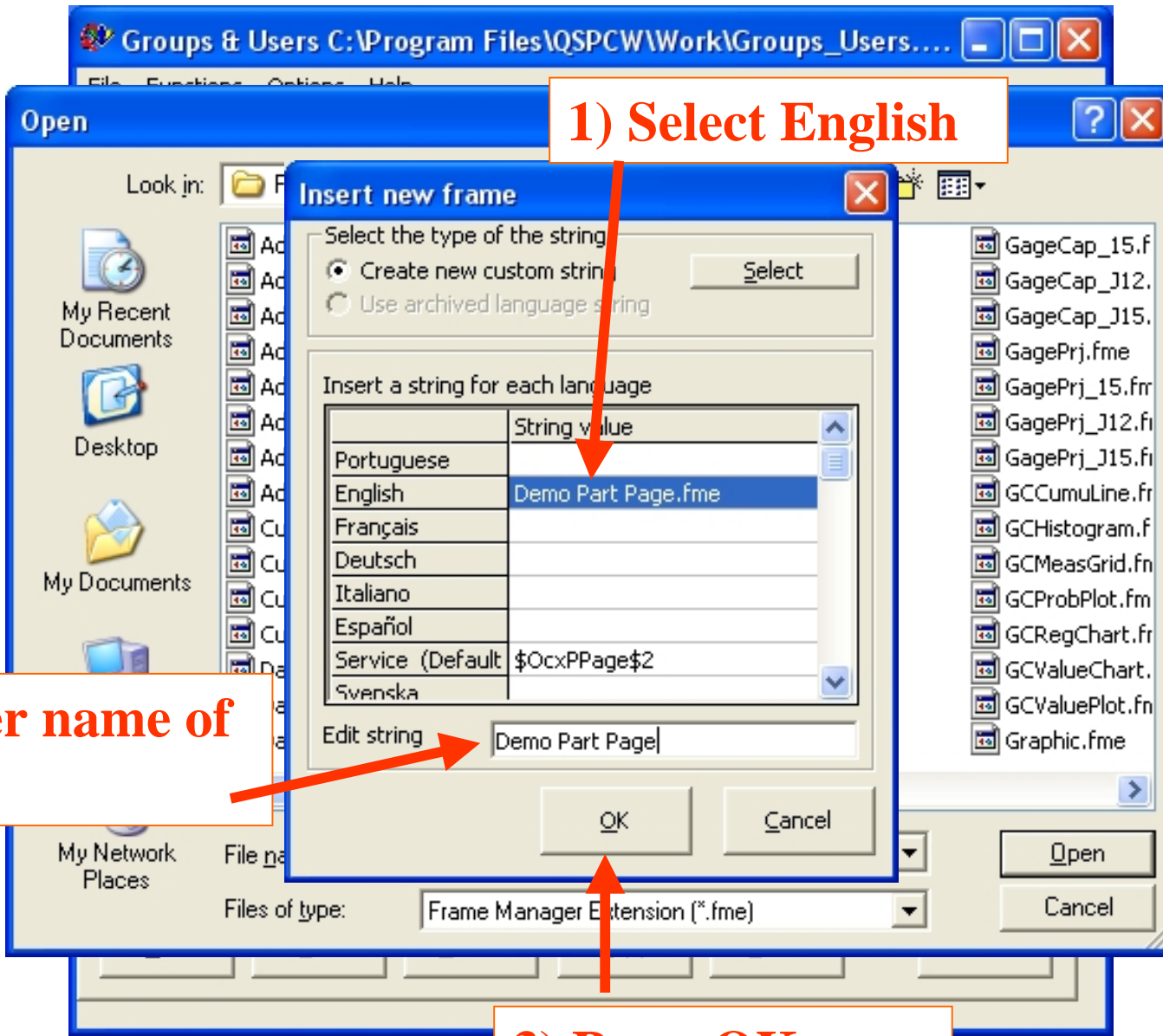
1) Select **FUNCTIONS** tab

2) Select **FUNCTIONS**

3) Select **NEW**



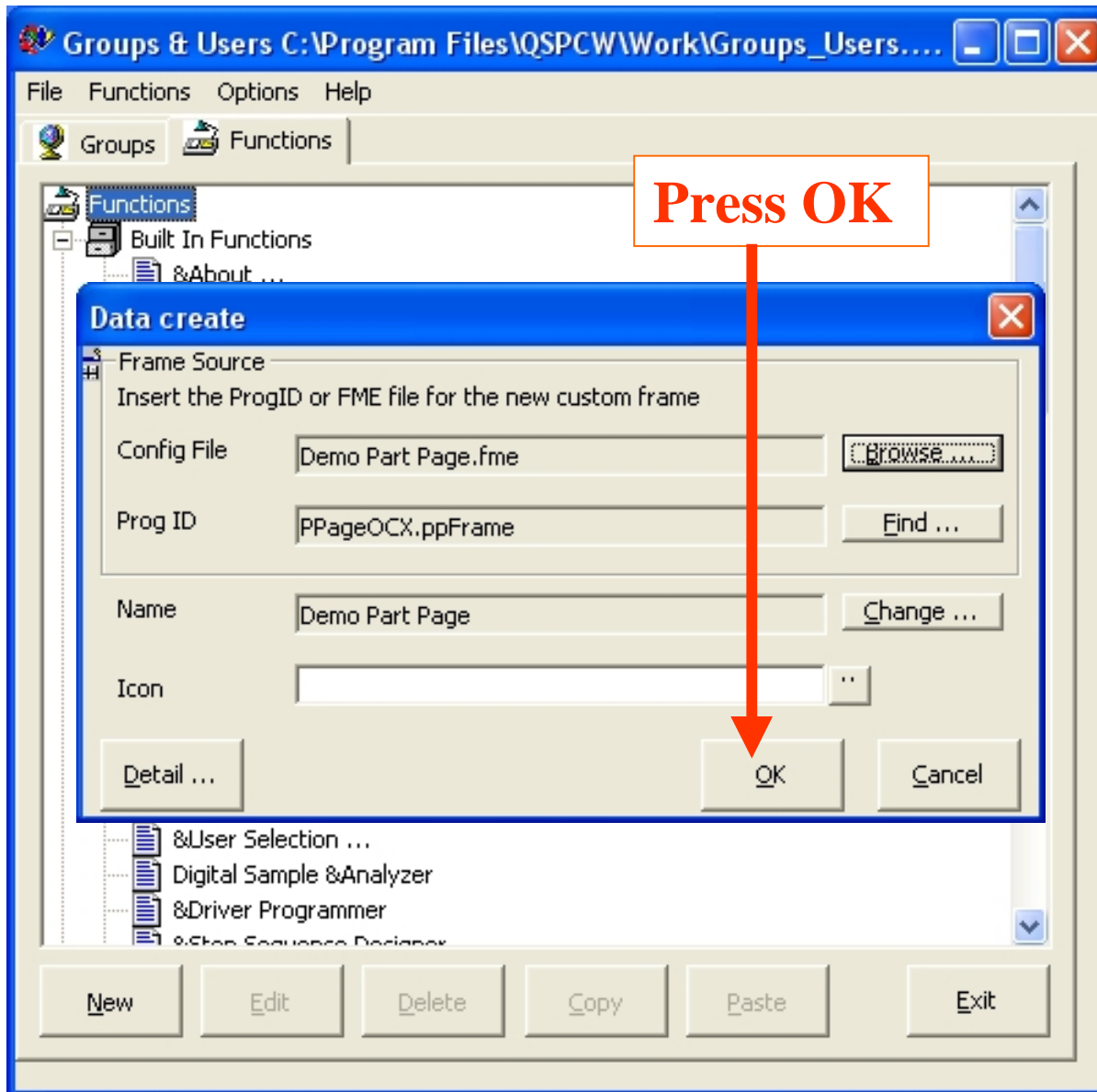


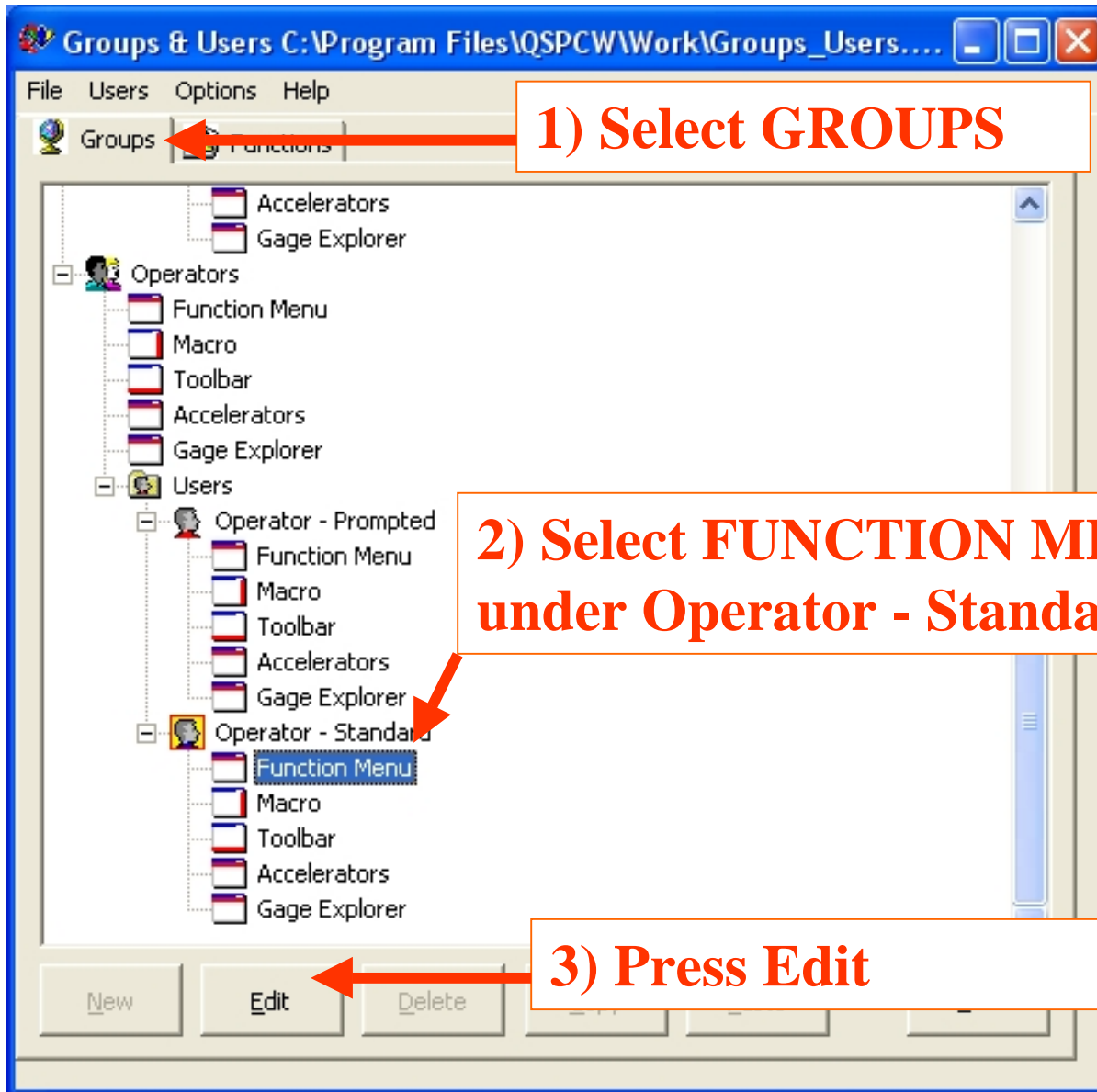


1) Select English

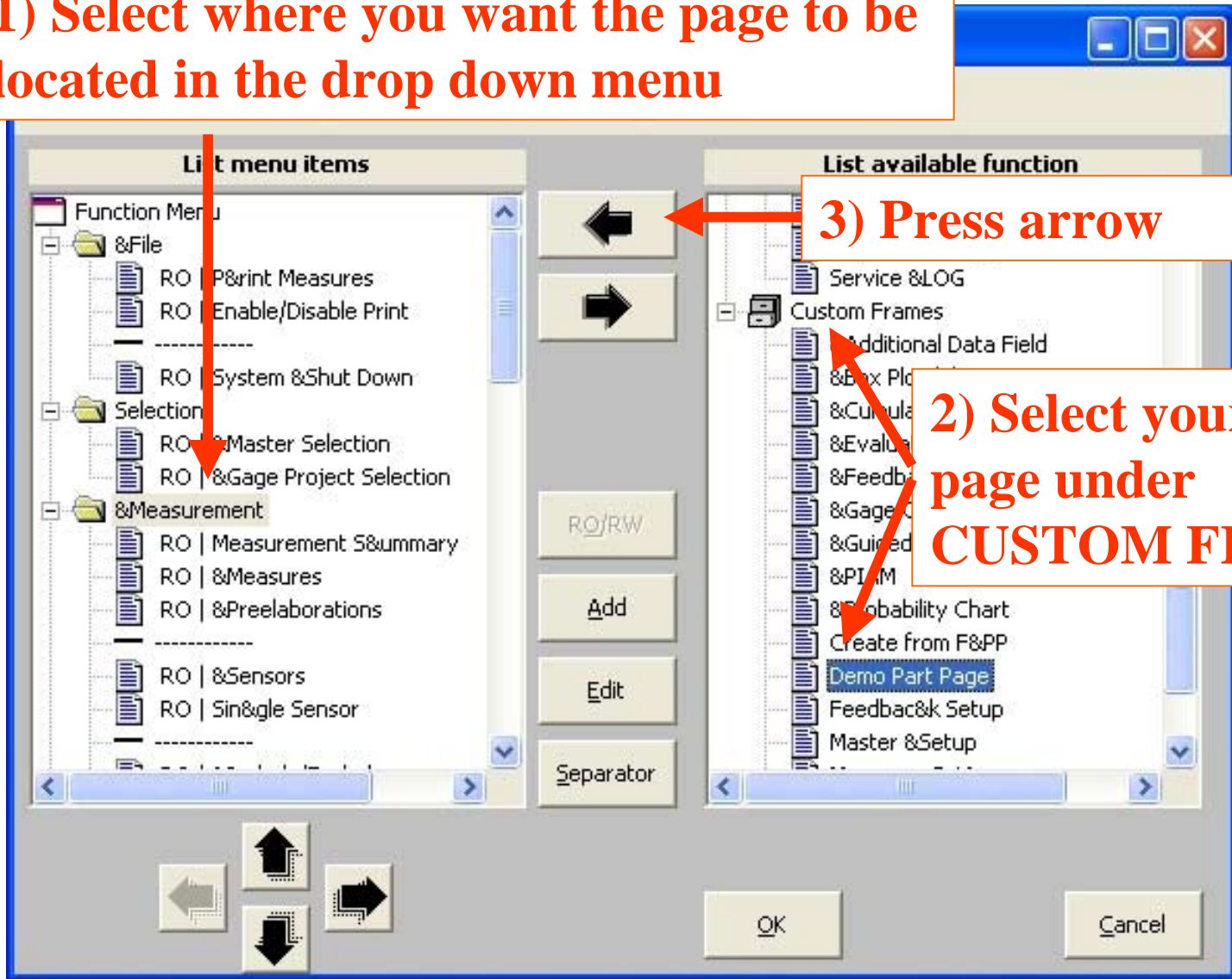
2) Enter name of Page

3) Press OK



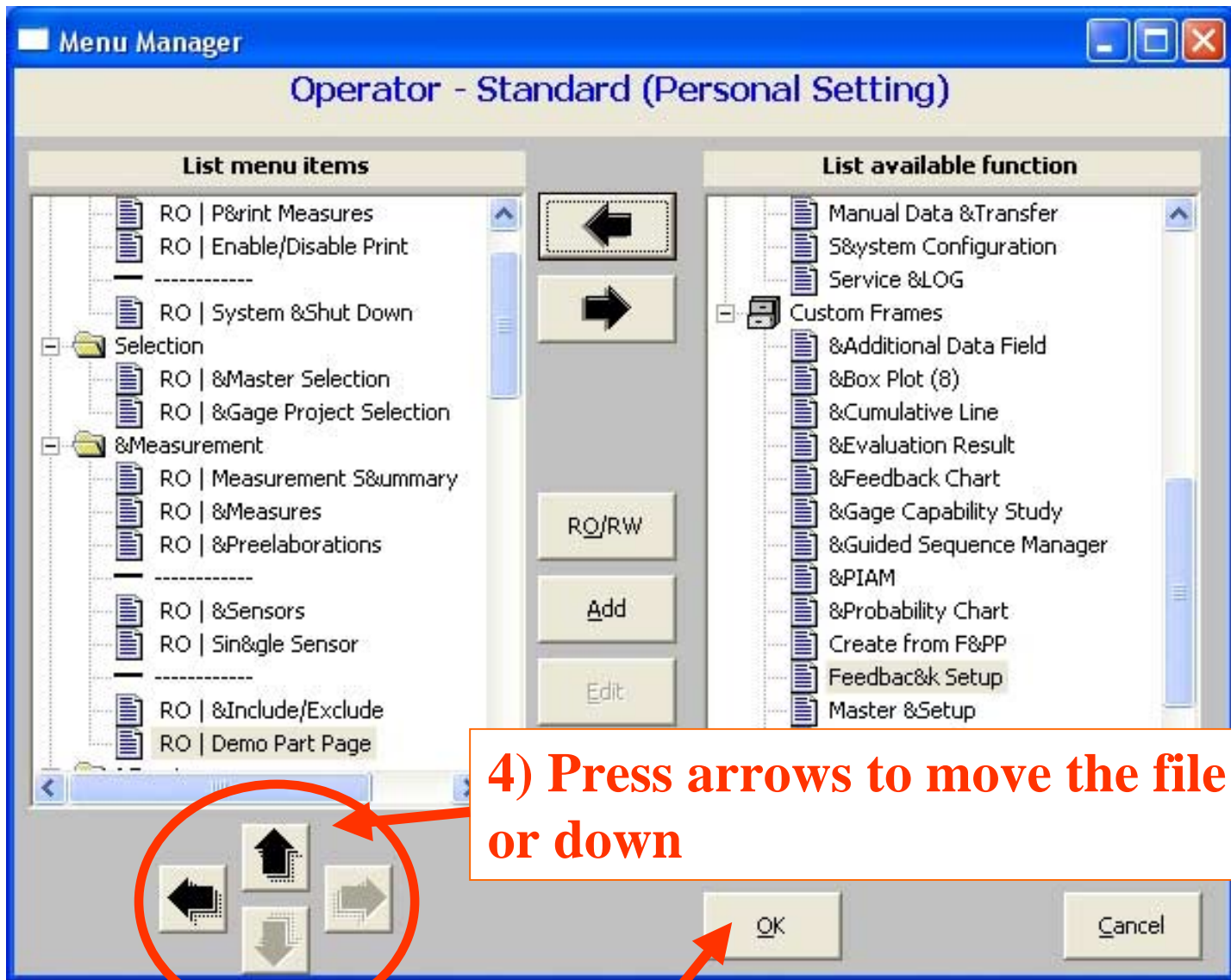


**1) Select where you want the page to be located in the drop down menu**



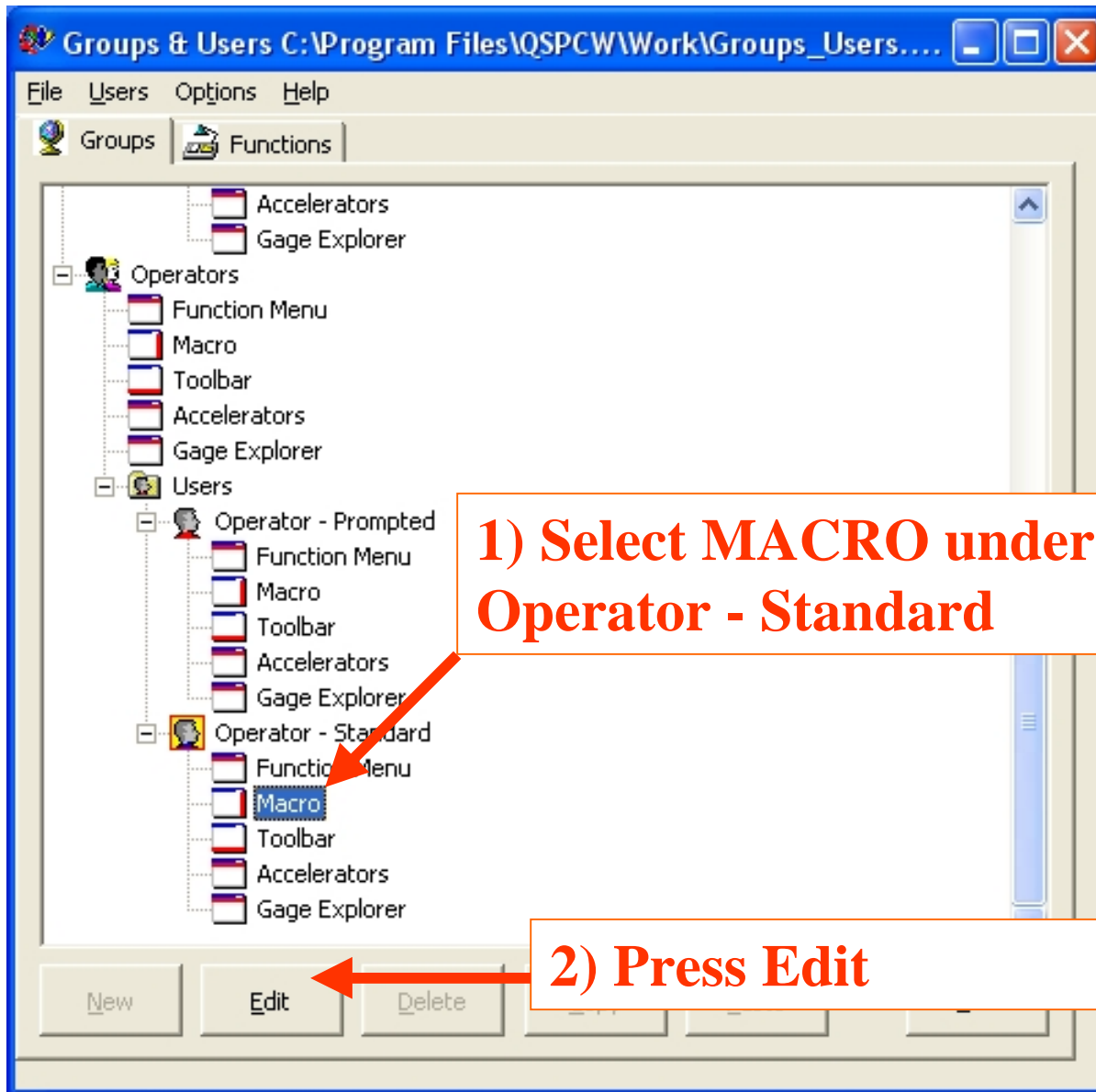
**3) Press arrow**

**2) Select your new page under CUSTOM FRAMES**



4) Press arrows to move the file up or down

5) Press OK



**1) Select MACRO under Operator - Standard**

**2) Press Edit**

