



# CNC PROBING Recorder

*SURF YOUR DATA*



# MARPOSS

## Description

The Marpo PROBING Recorder is an automatic measurement, report and process control acquisition system for statistically analysing measurement results using touch probes. It offers a direct interface with the machine via an Ethernet connection and using CN communication protocols (FOCAS2 libraries for FANUC CNCs and an OPC UA Server for SIEMENS CNCs). Designed to analyse production processes, it allows prompt corrective action to be taken in order to avoid the useless production of low quality workpieces. CNC PROBING Recorder has been developed to work in Microsoft Excel® environment.

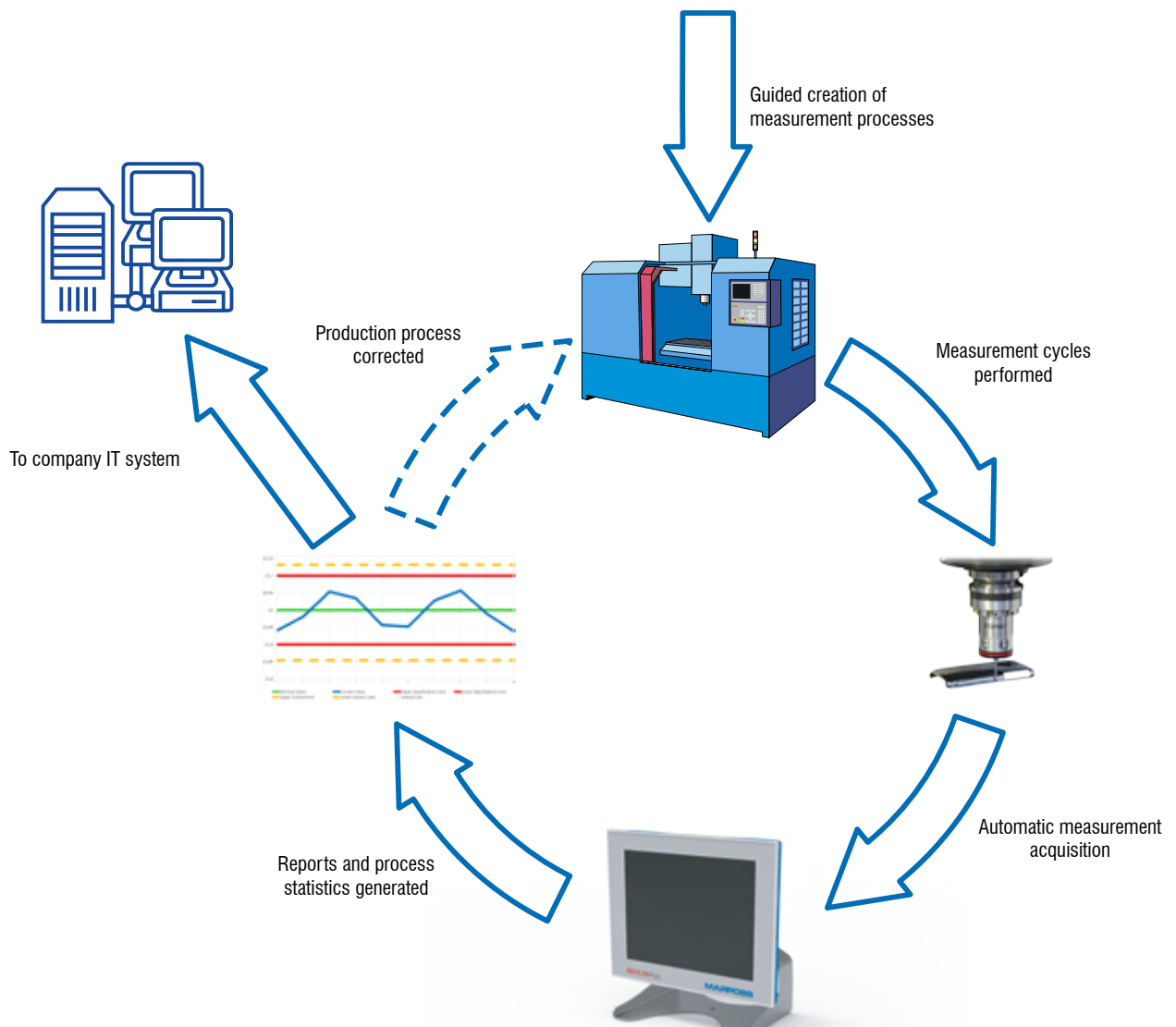
It is compatible with the following CNCs:

- FANUC
- Siemens

## Benefits

- Guided creation of measurement processes
- Automatic result extraction
- Process statistics
- Graphic result reports that are intuitive and easy to consult
- Colour-based identification for a rapid analysis of good and reject items

# CNC PROBING Recorder



## Guided creation of measurement processes

The interface includes a 'Processes and Data Info' section with fields for 'Number of processes' (set to 2) and 'Number of digits after decimal point' (set to 4). It also features buttons for 'Define Processes', 'Delete All Processes', 'Reset Collected Measurements', and 'Generate NC file'. A 'Process Input' dialog box is open, showing 'Commons Data' (Batch Quantity: 2, Sample Quantity: 5, Number of processes: 2) and 'Process Data' (ID: 1, Process Name: Alcega, Nominal Value: 22, Upper Limit: 0.1, Lower Limit: 0.1). It also includes fields for 'Marpos SW' (AFS SW/AF) and 'Output Macro' (115), and a 'Measurement Cycle' dropdown set to 'Automatic Stock Measurement'.

Once the type of machine it is operating on has been chosen, the CNC PROBING Recorder will select the set of available workpiece measurement cycles. When the number of measurement processes to run has been defined, data will begin to be entered via the edit masks. The parameters to enter include, the measurement's nominal value, its tolerance margins, the type of cycle and the desired result. The CNC PROBING Recorder will then automatically suggest the name/number of the program to be activated in the cutting programme on which the data collection cycle will be run.

## Automatic measurement acquisition

Process ID	Batch	Sample	Current Value	Nominal Value	Upper Limit	Lower Limit	Result	Date	Time
1	1	1	21.9407181	22	0.1	0.1	OK	10/12/2018	16:27:08
1	1	2	21.98171136	22	0.1	0.1	OK	10/12/2018	16:27:08
1	1	3	22.0536398	22	0.1	0.1	OK	10/12/2018	16:27:08
1	1	4	22.03483667	22	0.1	0.1	OK	10/12/2018	16:27:08
1	1	5	21.95710741	22	0.1	0.1	OK	10/12/2018	16:27:08
2	1	1	29.8407181	30	0.05	0.05	Not OK	10/12/2018	16:27:08
2	1	2							
2	1	3							
2	1	4							
2	1	5							
2	2	1	29.95193084	30	0.05	0.05	OK	11/12/2018	09:40:06
2	2	2	30.02906312	30	0.05	0.05	OK	11/12/2018	09:40:06
2	2	3	30.05672672	30	0.05	0.05	Not OK	11/12/2018	09:40:06
2	2	4	29.88943724	30	0.05	0.05	OK	11/12/2018	09:40:06
2	2	5	29.94001465	30	0.05	0.05	Not OK	11/12/2018	09:40:06

Once the machine connection has been launched, at the end of the production of each workpiece and when the measurement processes have been completed, the CNC PROBING Recorder will automatically enter the results in the cells corresponding to the workpiece number, the batch number and the number of the process currently in progress, thereby creating a report showing the trends of the individual measurements over time.



## Reports and statistics



At the end of production, the data collected can be saved automatically and exported in Q-DAS format so it can be processed in the future using software for statistical calculations. The data can be recalled at any time and a report can be generated for the workpiece or the type of measurement, including statistical data. For more detailed analyses the results can be exported in Q\_DAS format and processed using special software

## Options available

- Software version for PC: (FANUC/SIEMENS)
- Software and Hardware: Merlin Plus p/n

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D6C10600G0 - Edition 03/2019 - Specifications are subject to modifications  
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