

# VTube-LASER Quick Start Guide for ROMER Absolute Arms

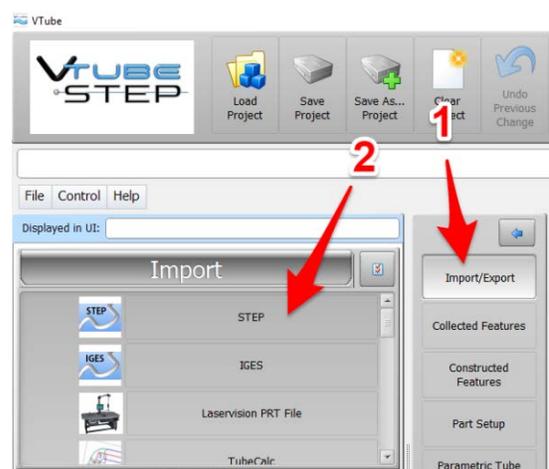
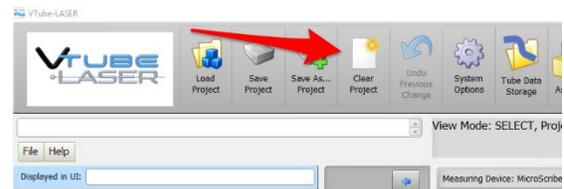
This guide shows how to import a STEP file and then MEASURE and qualify demo tube 4 using a ROMER Absolute Arm.



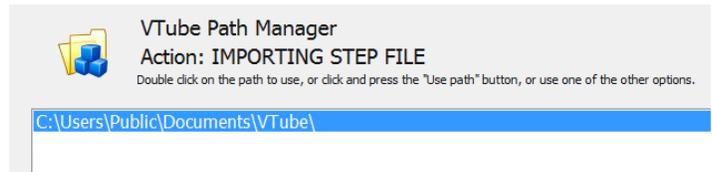
The steps in this workflow are from version 2.9.3 with the ROMER RDS version 4 or higher.

VTube-LASER always starts in the LASER mode window.

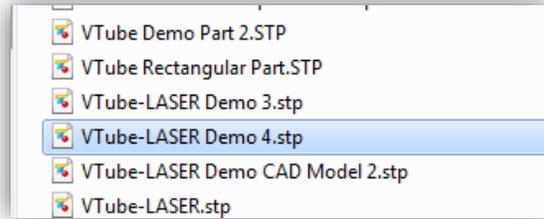
1. If VTube has a tube showing in the viewport, then press the **Clear Project** button in the tool bar on the top of the VTube-LASER window.
2. On the far-right side of the toolbar, press SWITCH TO STEP MODE button. This will allow switch you to the window that allows you to import solid models into VTube.
3. You are now in the VTube-STEP Window. Press the **Import/Export** button in the Navigation Pane, then press the **Import STEP** button in the Import menu.



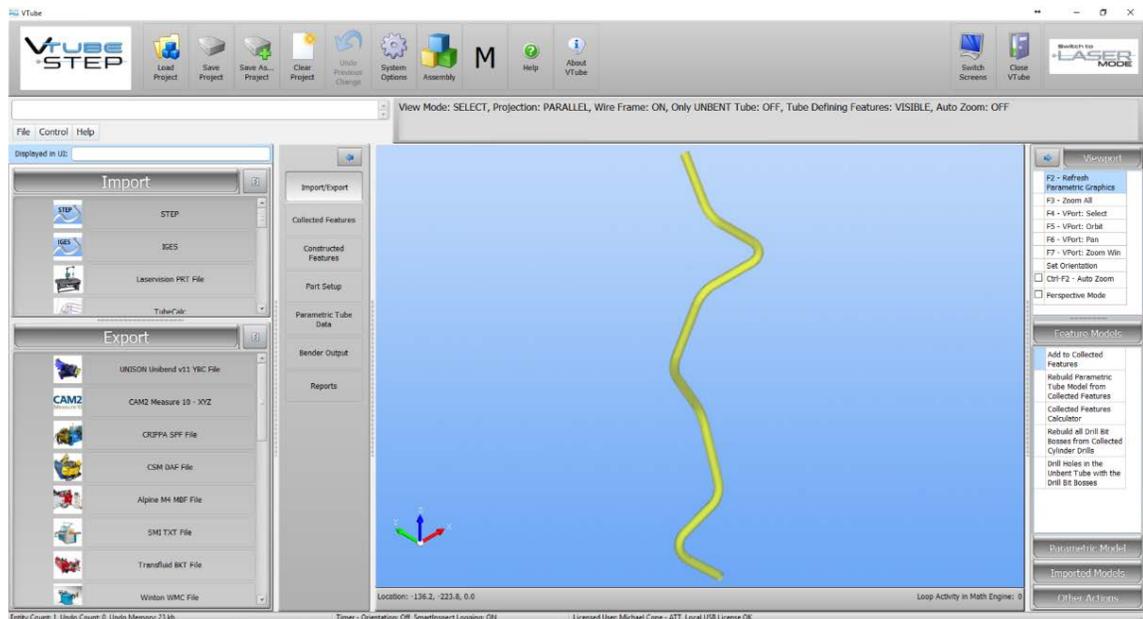
4. Double click on the VTube path in the Path Manager.



Find **VTube-LASER Demo 4.stp** file and load it into VTube-STEP.

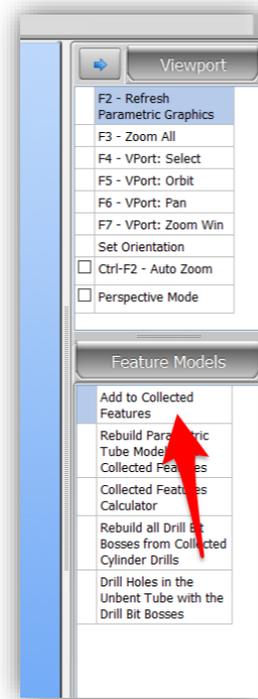


5. The screen will appear something like this after the model is imported:



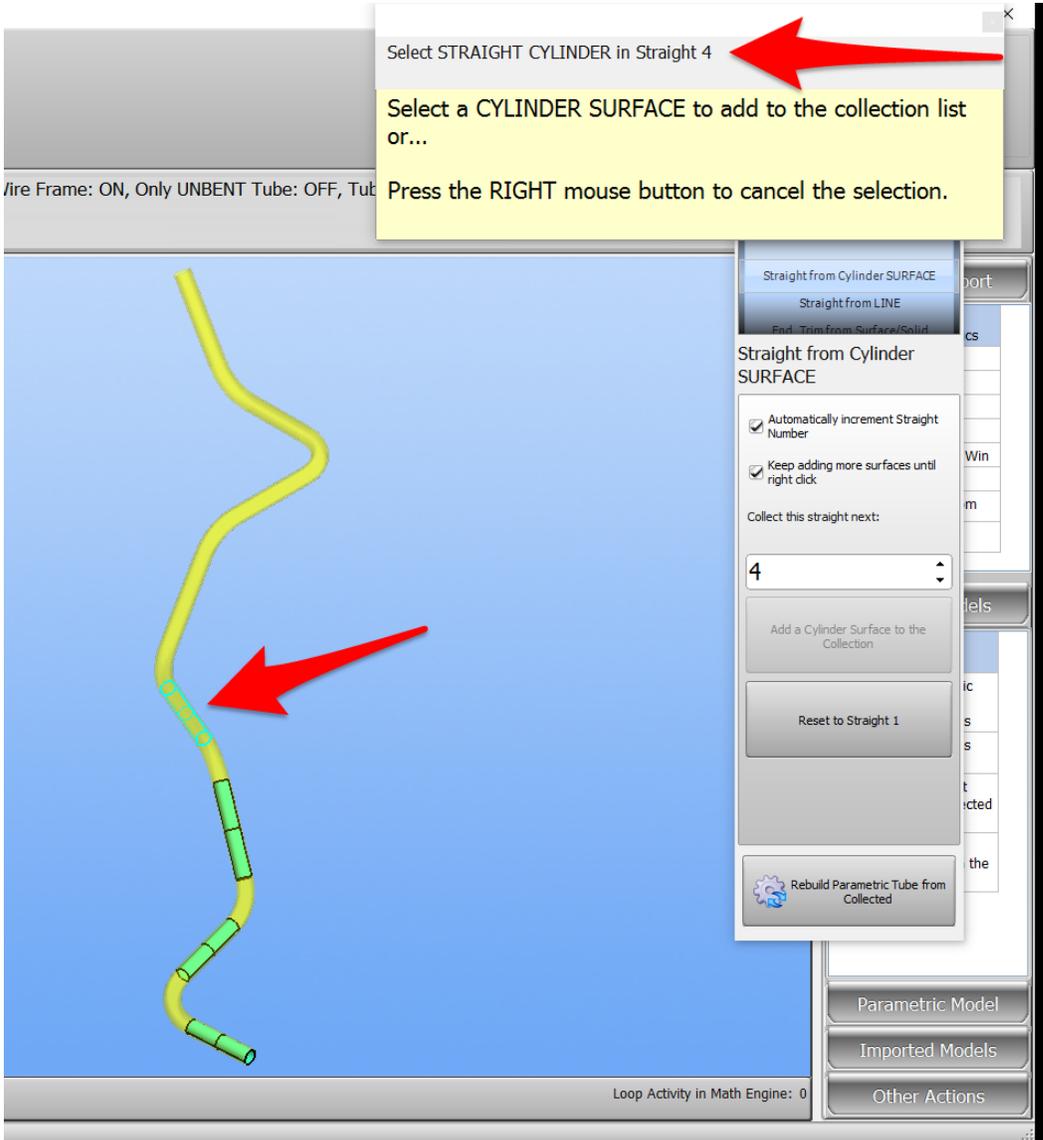
6. Press the **Add to Collect Features** on the right side of the screen in the Feature Models menu.
7. Check on both the checkboxes in the **Straight from Cylinder SURFACE** option.
8. Press **Add a Cylinder Surface to the Collection** button.

Note that with the **Keep adding more surfaces** option enabled, VTube will continue to press the “Add Cylinder Surface to the Collection” button automatically after every straight surface selection.



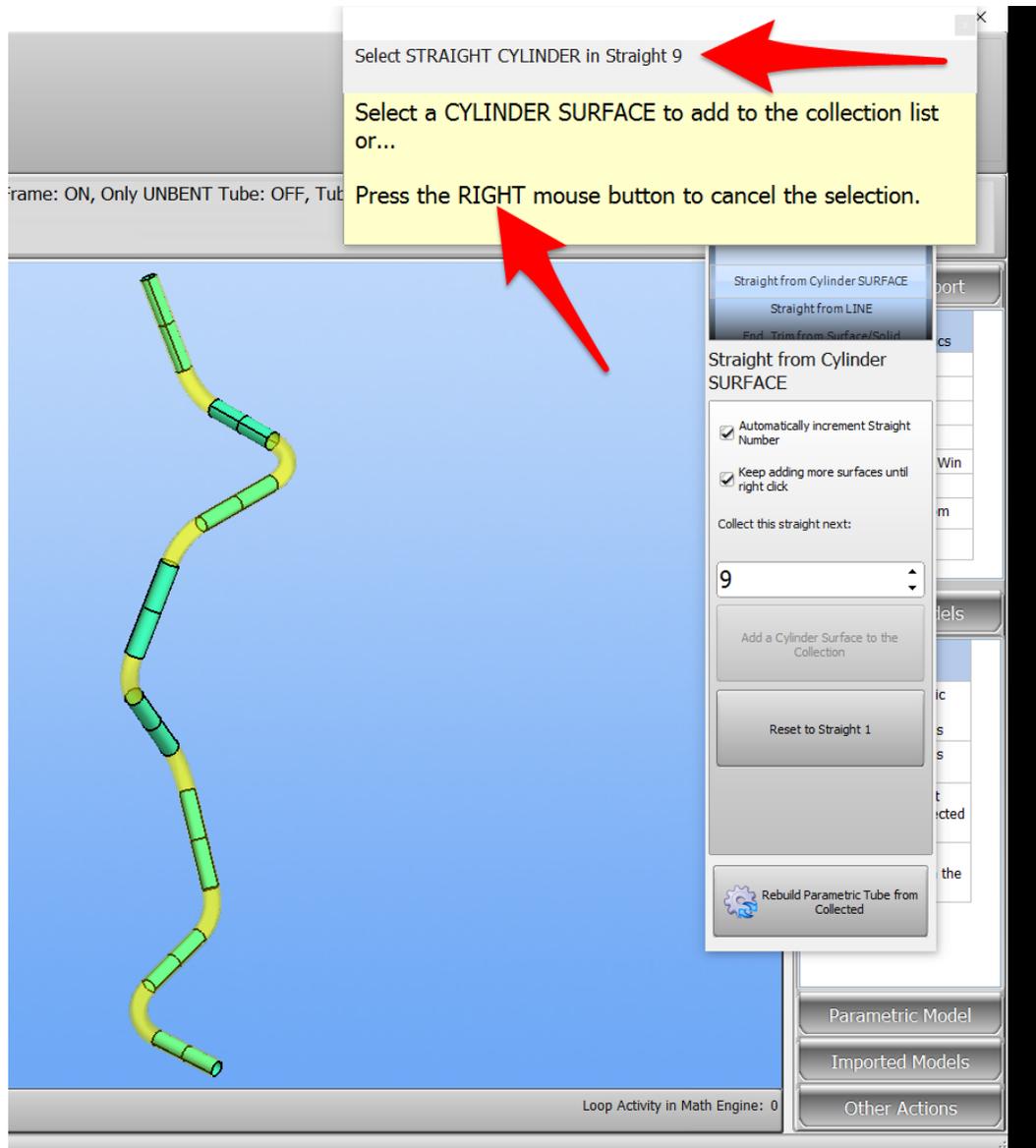
9. Select the surfaces of the tube straights in order. We recommend that you choose the shorter of the two end straights as the first straight.

Follow the instructions in the yellow guide box.



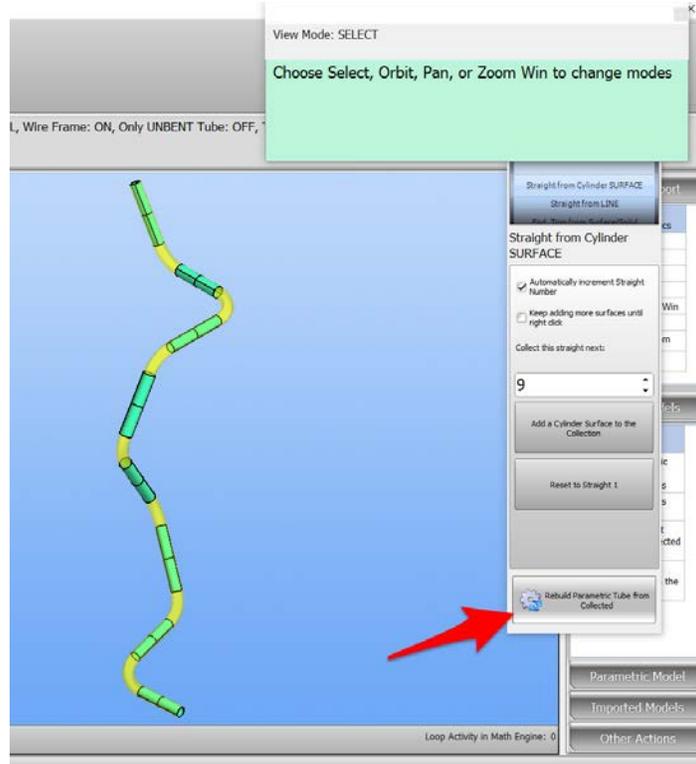
- It is acceptable to collect both outer diameter surfaces and inner wall surfaces in any straight. If you collect a variety of both, then VTube will calculate the wall thickness as well as the diameter.

When you have selected all the straights, VTube will continue to ask for straight 9. There is no straight 9 in this part, so stop the collection process by RIGHT clicking the mouse on the viewport.

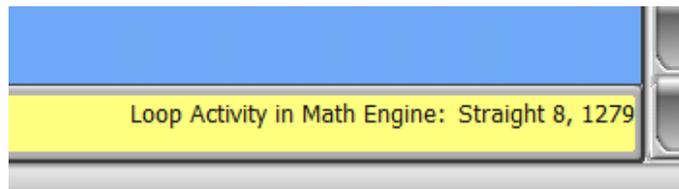


- The CAD mouse mode will change to SELECT mode, which means that the process of adding to the collection is stopped.

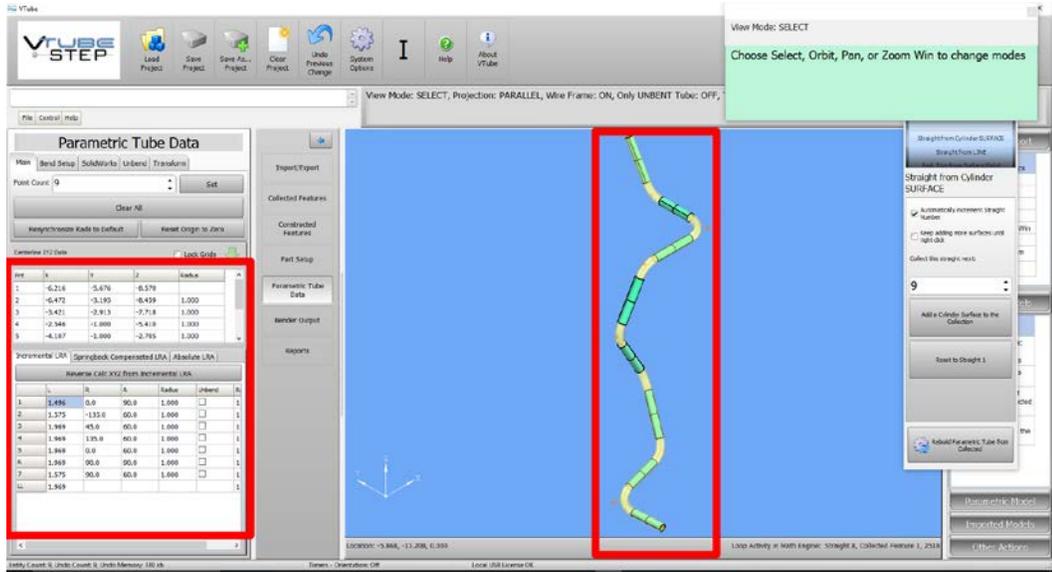
12. Click on **Rebuild Parametric Tube from Collected** at the bottom of the Collect control.



13. In the lower right corner of the viewport, you will see the math engine work its way through the straights to solve for the centerline end and intersection point positions.



- When the calculation is complete, you will see new XYZ data in the Tube Data menu. You will also see a white tube superimpose on the imported model.



- Click on the **Part Setup** menu in the navigation pane to see how VTube automatically calculated what it could determine from the model.

During the calculation, VTube calculated...

- The **diameter** (row 16)
- If you selected an inner wall in the collection, the **wall thickness** (row 19)
- The **cut length** (row 25)
- The **default radius** (row 26).

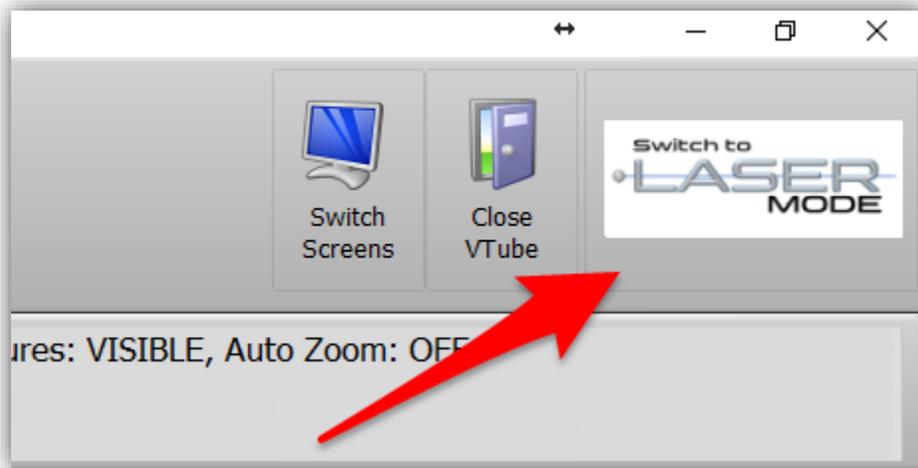
Row	Parameter	Value	Unit
14	Date/Time	1/21/2016 7:22:05 PM	
15	Diameter Profile Setup	Cylinder	
16	Diameter	0.375	inches
17	A-End Diameter	0.375	inches
18	B-End Diameter	0.375	inches
19	Wall	0.032	inches
20	Rec Width 1	1.000	inches
21	Rec Width 2	0.500	inches
22	Rec Wall	0.059	inches
23	Rec Fillet Radius	0.125	inches
24	Rec Angle	0.0	deg
25	Cut Length	24.775	inches
26	Default Radius	1.000	inches

16. The import and calculation of the master data is complete.

The **Tube Data in VTube-STEP** will become the **Master Data in VTube-LASER** automatically. The Master Data is used to tell us if we have a good part after measurement.

Press the LASER button in the upper right corner to change to LASER mode. The LASER window is the only one that connects to the ROMER arm.

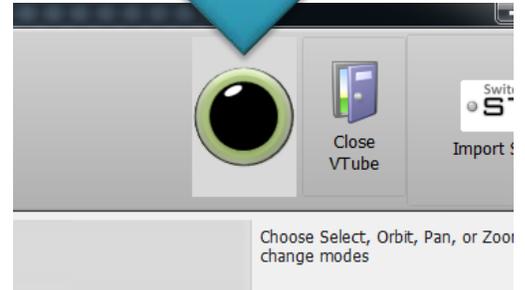
When you press this button, VTube-STEP will automatically close any control and guide windows.



## Measuring and Qualifying the Tube Shape

Follow these steps to setup to measure the tube:

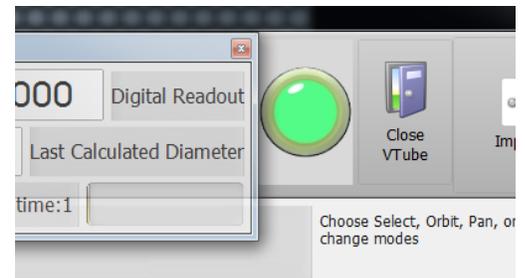
1. If the arm is not connected to VTube-LASER, then **click on the black LED** in the upper right corner.



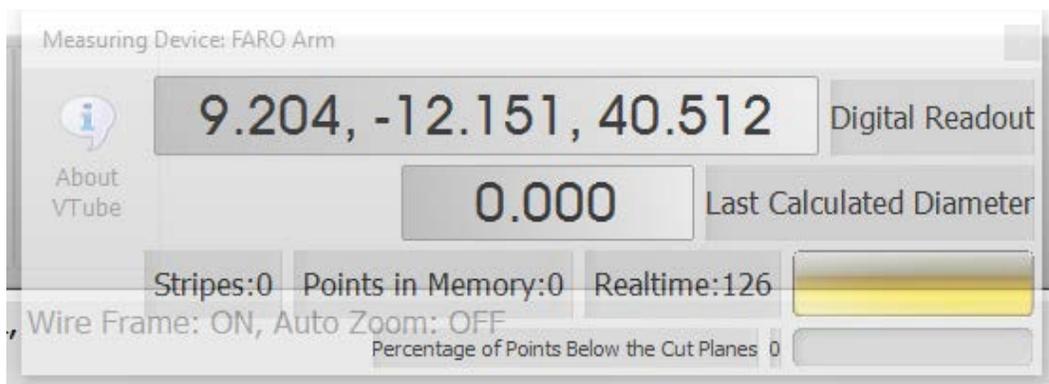
When the connection to the arm is active, the LED turns green, you will hear a connection sound, and the transparent DRO (Digital Readout) window will appear.

2. Pull the arm away from its resting position and watch the values in the DRO (Digital Readout) move.

If the laser scanner is on, then you can point the scanner about 6 to 8 inches from any object, and you will see XYZ data change in the DRO.

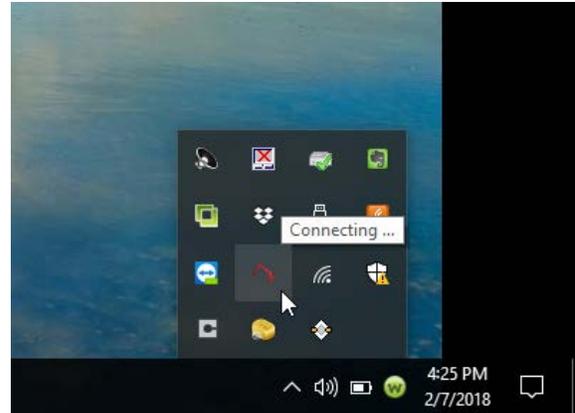


This is the **DRO (Digital Readout)**:

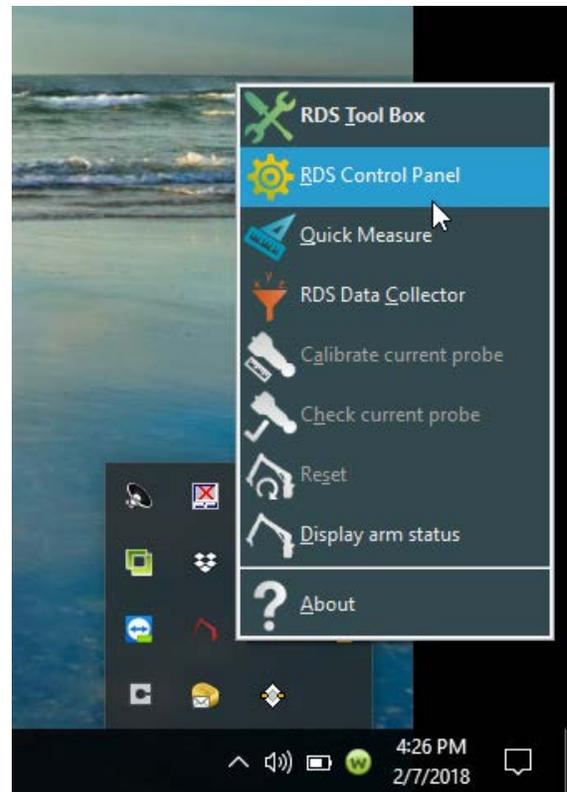


If the laser is not on, then you will see the XYZ data changing whenever you move the arm. In this mode, the data will represent the **center of the ball probe**.

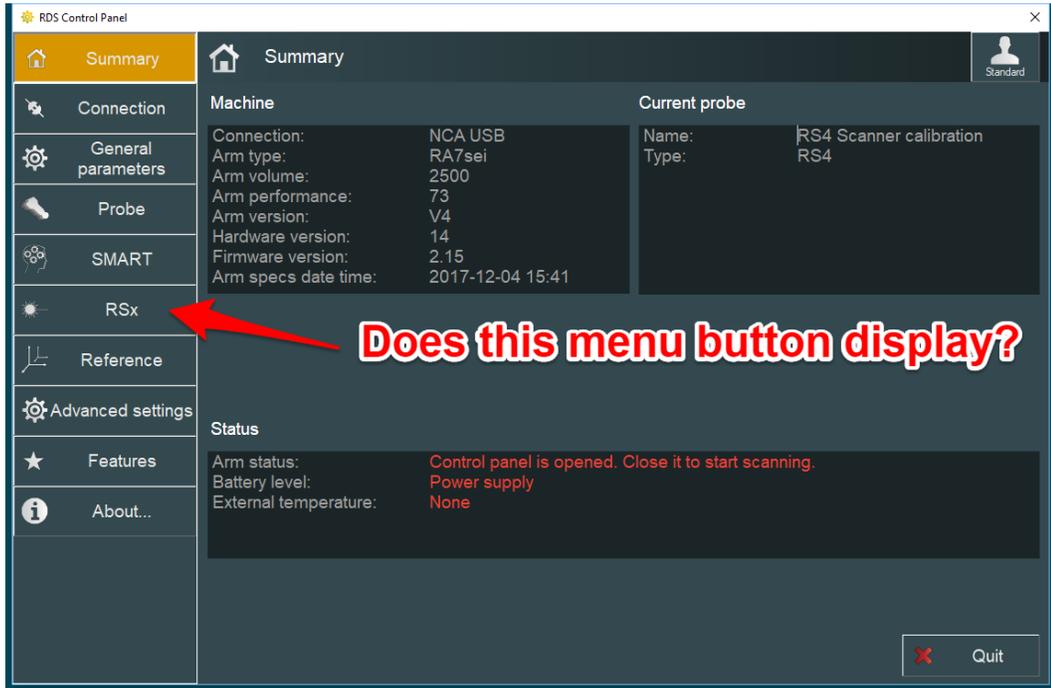
3. If you plan on using the laser scanner (rather than the ball probe), then enter the RDS Control Panel. In the system tool tray, find the measuring center icon:



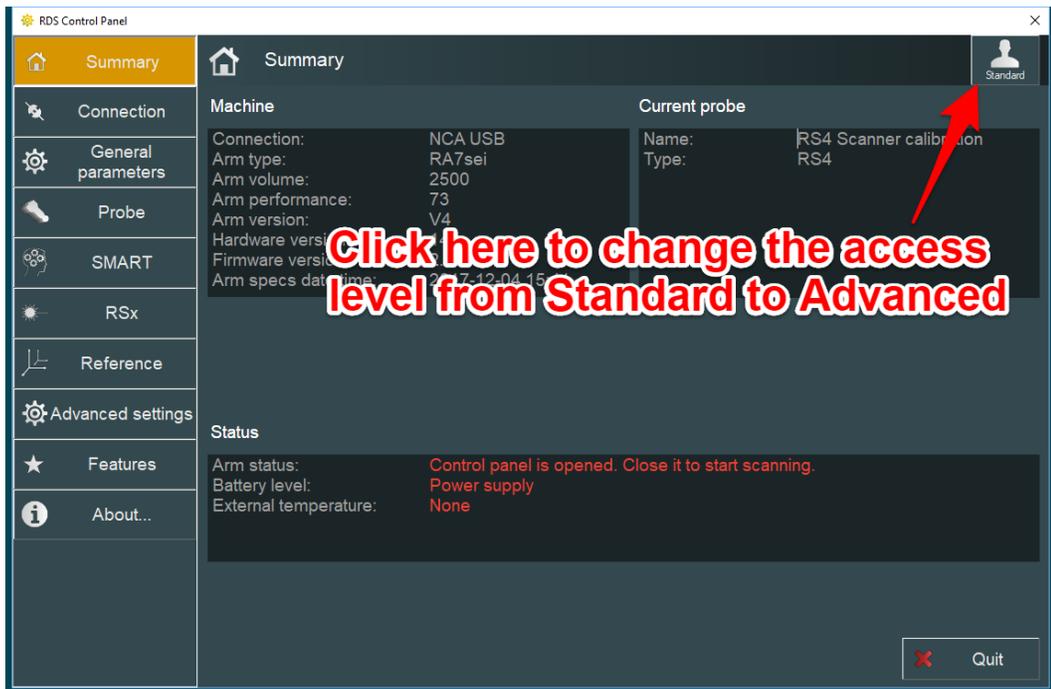
4. Right mouse click on the icon, then left mouse click on the RDS Control Panel.



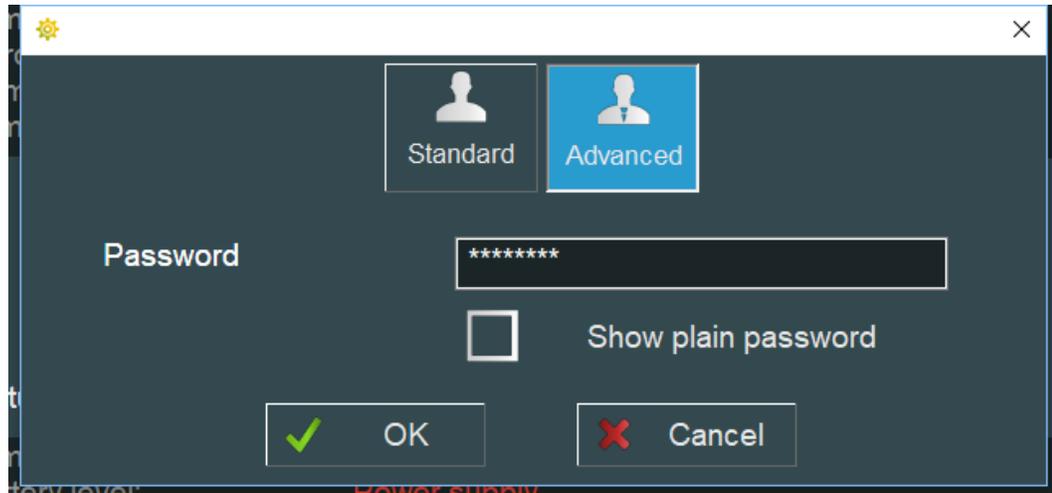
5. If the RSx menu button does not display, then switch the scanner on using the sliding switch on the ROMER integrated scanner.



6. If the access level is **Standard** (see the upper right corner), then click on the access level button.

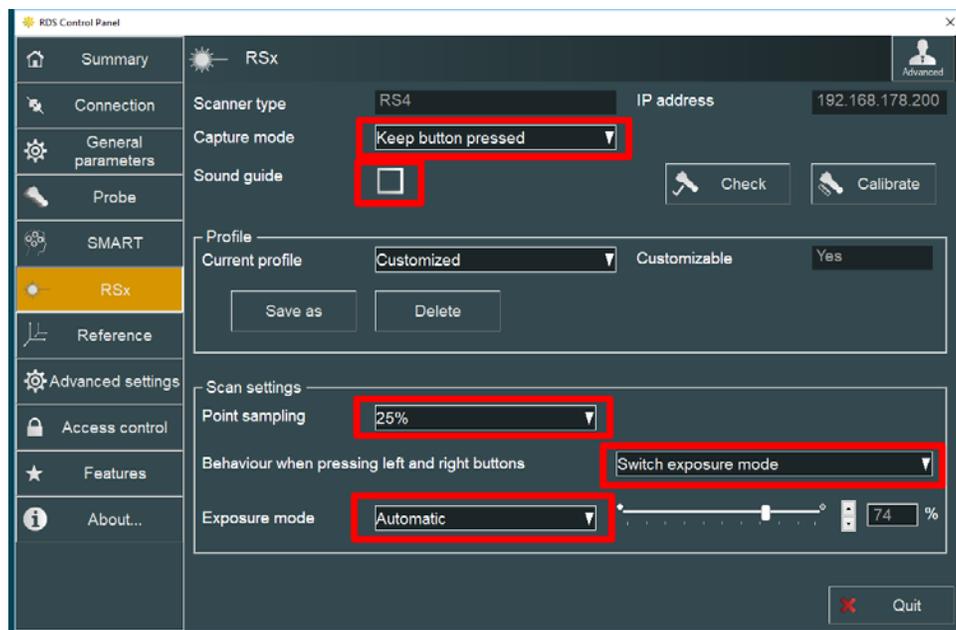


7. Type the password “Advanced” and then set the access level to Advanced by clicking on the **Advanced** button.



This access level will allow you to change the RSx scanner settings in the RDS Control Panel.

8. After you make the change, enter the RSx menu by clicking on the RSx button on the left. If you're not sure what the settings should be, then we recommend that you set them this way:

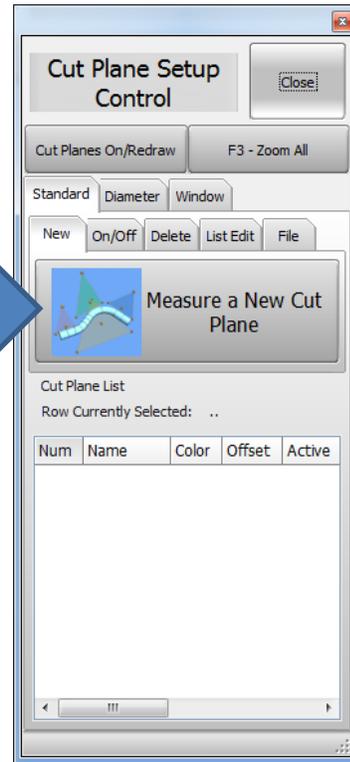
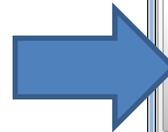


9. Press the Quit button to exit the RDS Control Panel.
10. Setup CUT PLANES if you are measuring the part on a table surface. Cut Planes will remove any laser points beyond the measured plane.

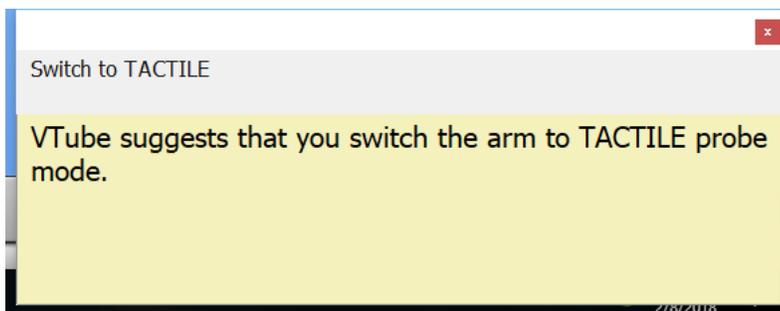
Click on the **Cut Plane icon** at the bottom of the navigate pane.



11. Press the **Measure a New Cut Plane** button in the NEW tab.



VTube-LASER will suggest that you set the scanner switch on the arm to TACTILE probe mode with this guide box:



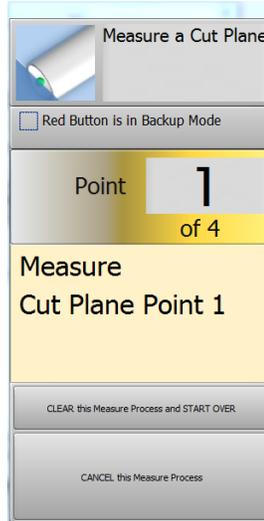


12. **Press the GREEN button for all four points.**

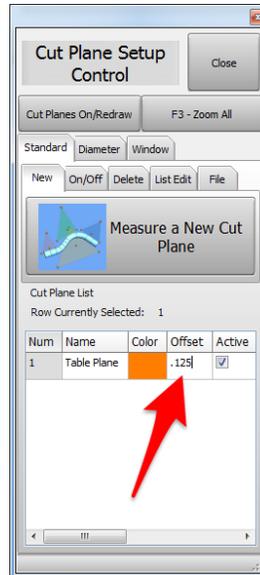
Take the first three points on the plane of the table surface using the GREEN button.

Take the last point is at least 1 millimeter above the table also with the GREEN button.

**(Do not push the red button in this operation.)**



13. The **Active** label in the Cut Planes icon will now show "1".



14. Enter an **offset** for the new cut plane of up to half of the diameter of the tube.

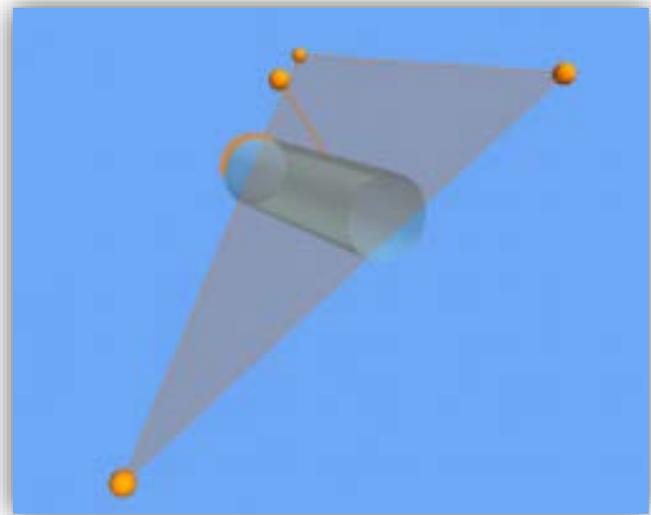
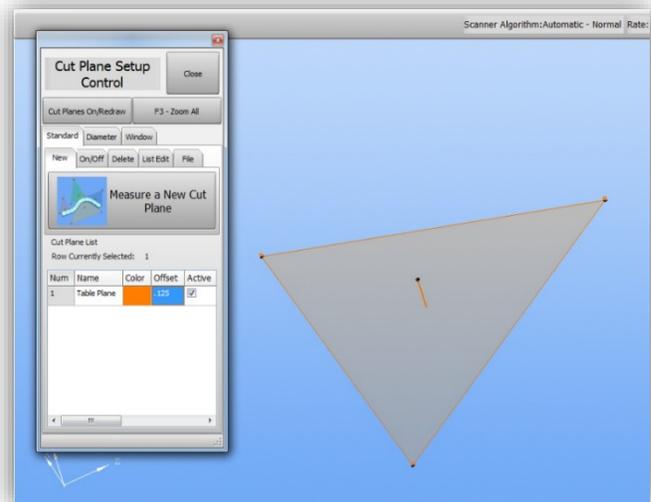
An offset is important, or the scanner may pickup surface outliers. The greater the offset, the less chance of outliers.

For most tables, we recommend 0.125" or 3 mm as a starting point. Some surfaces will require a larger value.

Enter the offset, then press the **Enter button** to allow the value to be entered into memory.

## 15. Important Things About Cut Planes

- a. Cut Planes are always stored until you delete or change them – even if you shut VTube-LASER down.
- b. Cut Planes are only used for laser scans. They are **IGNORED** when using the ball probe.
- c. Make changes to the Cut Plane at any time during any other measurement.
- d. You can add as many cut planes as you want.
- e. You can activate or deactivate the cut planes any time. Each cut plane has its own active switch and offset value.
- f. If you move the arm relative to the table, then you will need to remeasure the cut planes – or the cut plane will be in the wrong place relative to the table.



16. Next, let's cover the

## DCP - Diameter Cut Plane

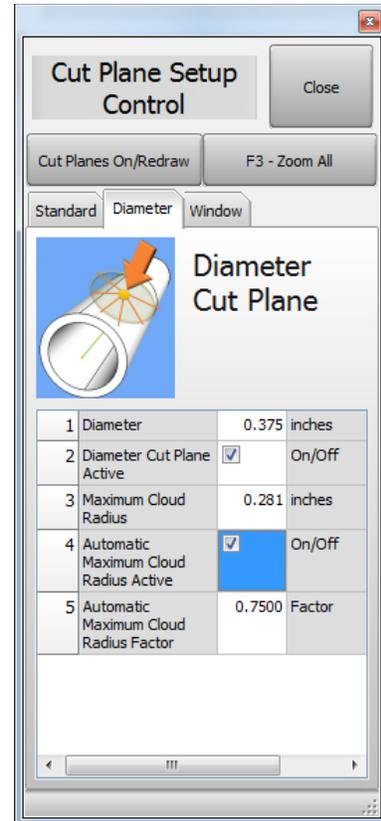
It is powerful – and yet it is easy to understand and use.

The DCP feature will find the top diameter and remove all other objects behind the first diameter (closest to the probe) that it finds. Because it does this, DCP can not only remove unwanted objects from the scanner, it can also remove outliers or flyers that enter the data.

When in AUTO MODE, DCP relies on the nominal diameter to know how big the Cloud Radius should be – so it is important to have the diameter set to the actual value before you measure using the DCP command.

If you turn DCP on, and also enable the **Automatic Maximum Cloud Radius** feature, then be careful to enter the actual nominal DIAMETER, and the Cloud Radius FACTOR in row 5 should be anywhere from 0.75 to 1.0 in normal situations.

With this setup, VTube will find the first (nearest) surface point it encounters, then keep any surface point within a distance of 0.281" from that first point.



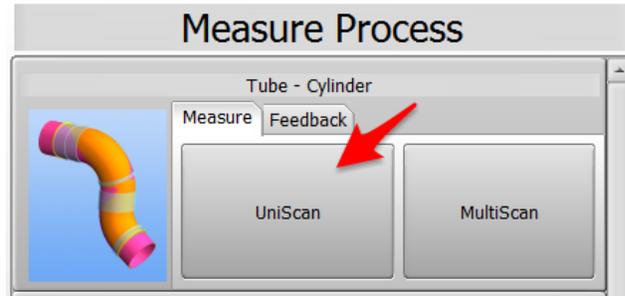
Here are three Important notes about DCP:

- a. DCP only works when the scanner is active - **not the ball probe** - because it requires multiple points per scanned line to work.
- b. DCP only applies to **cylinder scans** and **bend profile scans**. **It does not have any effect on END scans.**
- c. **DCP values are not remembered persistently across all projects like regular Cut Planes.** The DCP setting can be different for every project, unlike the Cut Plane settings which will carry across to other projects.

17. Go to the Navigation Pane and press

## MEASURE PROCESS

menu and find the Tube - Cylinder panel at the top of the choices on the left side of the screen. Press the **UniScan**.



**UNISCAN versus MULTISCAN Note:** We are going to use the **UNISCAN** method to measure tubes. The UNISCAN motion feels like spray-painting the tube with laser stripes. When you press the green button, then VTube takes in the laser stripes. You can release the green button to pause scanning to move over obstacles. During scanning, when you release the green button, new scanned points will draw on the screen.

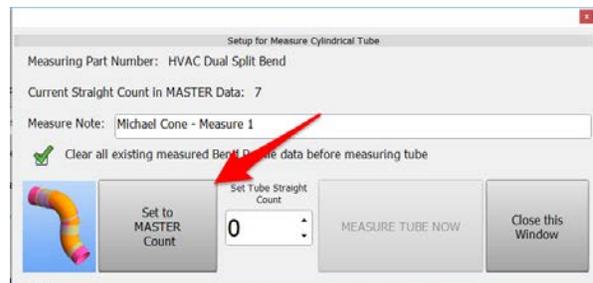
There is another method called **MULTISCAN** that is ideal for for situations where the straights are bowed or curved. In MULTISCAN, you aim near the first tangent, then hold the arm still, then press and hold the green button until you hear the scan complete sound. Then you do the same at the other end of the straight.

**For most measurements, we recommend UNISCAN**, because this mode takes in much more data and is able to give operators better assurance that the scan is good. For example, using DCF – Dual Cylinder Fit, UNISCAN can reduce uncertainty significantly because it takes many more surface points than MULTISCAN, then uses this to your advantage.

18. Press

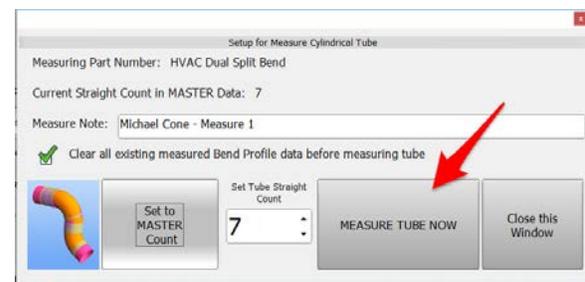
## Set to MASTER Count

button.

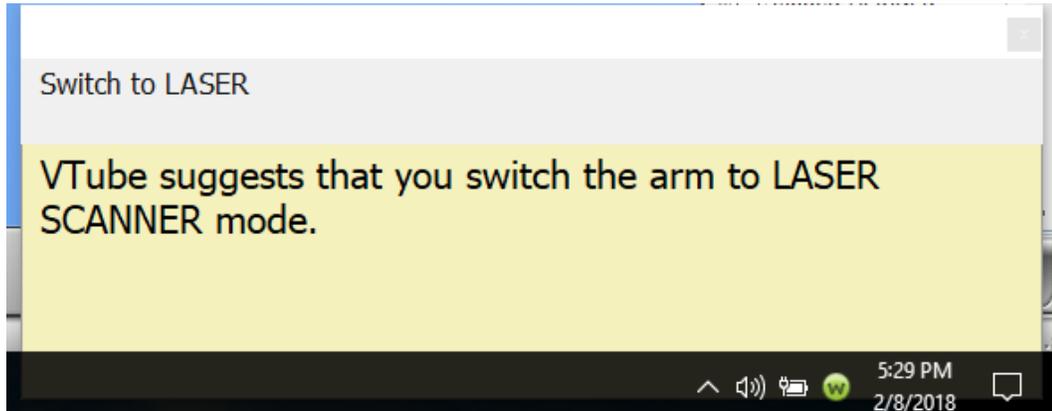


19. Press

## MEASURE TUBE NOW.



If the scanner switch is still in ball probe mode, then VTube-LASER will suggest that you switch it to LASER SCANNER mode (if you are using the default setup).



20. Measure the part following the instructions in the guide box like the one shown here. The yellow box tells you the current step.

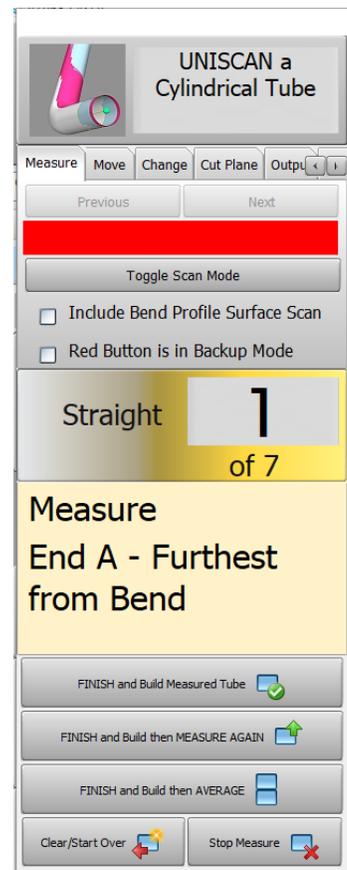
If VTube is setup to measure the ends with the ball probe, the red laser box will turn black. If you want to measure the end with the laser, then just press the **Toggle LASER** button.

**At this point, the trainer will show you the exact technique to use for scanning the ends and the staights.** If you are learning without the help of a trainer, then it's important to see at least one of these two videos in the knowledgebase first:

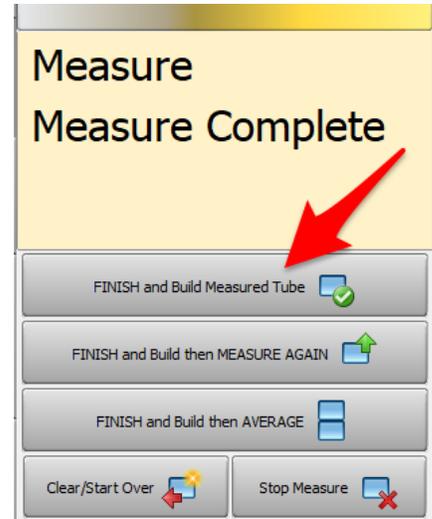
[http://www.advancedtubular.wiki/index.php/VTube-LASER\\_Videos\\_for\\_HEXAGON\\_ROMER](http://www.advancedtubular.wiki/index.php/VTube-LASER_Videos_for_HEXAGON_ROMER)

## Video 2: "Scanning Speed Test on Two Types of Tube"

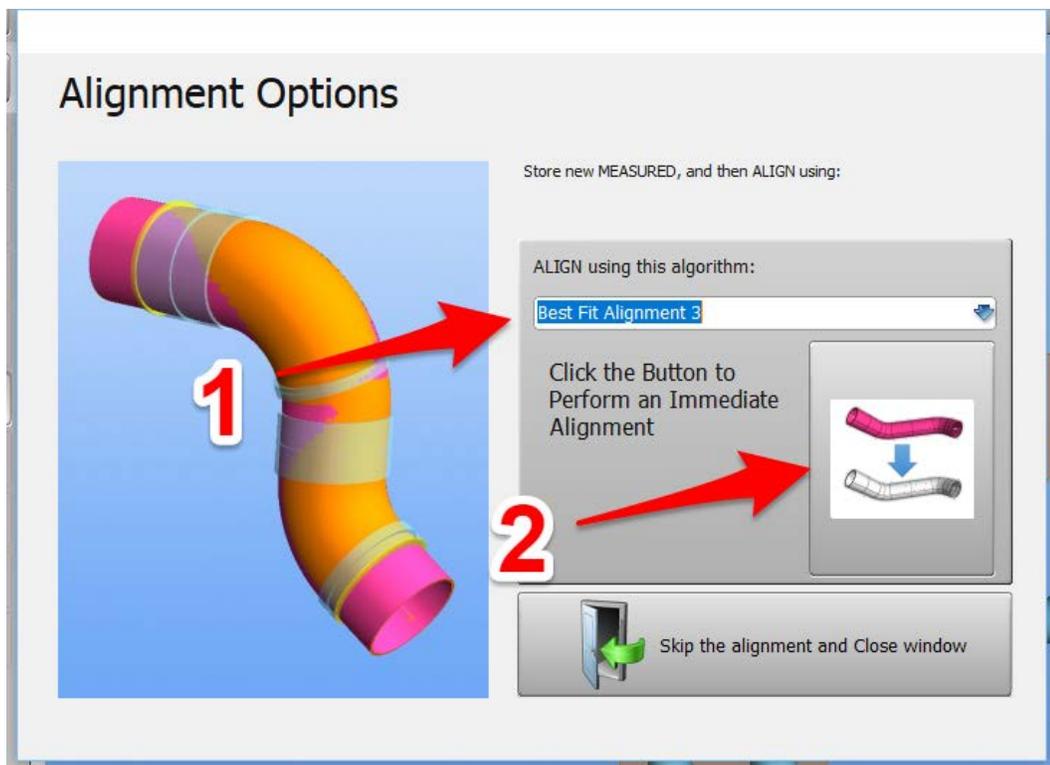
Knowledgebase Videos for VTube-LASER are in this web page:  
[http://www.advancedtubular.wiki/index.pp/VTube-LASER\\_Videos](http://www.advancedtubular.wiki/index.pp/VTube-LASER_Videos)



21. After measuring End B, press the **Finish and Apply** button.

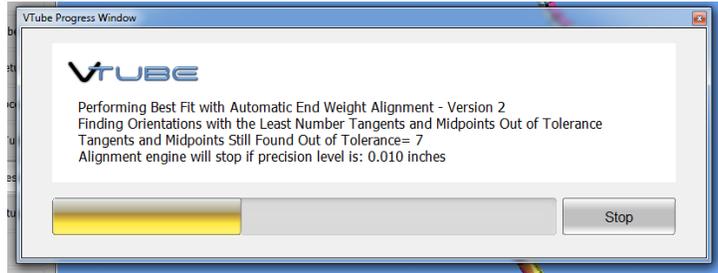


22. Change the **alignment type to #3** and then press the **Alignment button** with the image of the two tubes.



23. VTube will align the measured part to the master part. It will show a progress bar as it is doing the alignment.

For the demo tube, don't be surprised if you see a lot RED cells in the Inspection Data menu. This tutorial is designed to show you how to determine if a part is out of profile deviation – and then how to correct that situation. (The out of tolerance condition is expected.)



- You will see **Inspection Data** menu display on the left with color-coded deviations. End length and tangent point deviations are always shown here.

The **Tangents** deviation grid qualifies the profile of the straights as a virtual gauge. Tangents are where the straights meet the bends. For example, the **T2 dev, row 1** cell shows the deviation where the first straight meets the first bend on the centerline.

Note that **T1-1** and **T2-8** cells in this grid are really trimmed end points (not tangent points).

The end lengths are qualified at the top of the menu. The default profile tolerance can be set at the very top.

### Inspection Data

Recalculate Best Fit - Automatic End Weight Adjustment 2

Main Setup | End Lengths | General Setup | Alignment | Envelope

Default Tolerance:  inches

Trim A	+Tol A	-Tol A	Trim B	+Tol B	-Tol B	Angle A	Tol A	Ar
0.012	0.039	0.039	0.006	0.039	0.039	0.5793	1.0000	1.

Tangents | Intersection | Aligned Model | Out-of-round

	T1 dev	T1 tol	MP dev	MP tol	T2 dev	T2 tol
1	0.043	0.039	0.035	0.039	0.028	0.039
2	0.016	0.039	0.003	0.039	0.012	0.039
3	0.039	0.039	0.038	0.039	0.038	0.039
4	0.031	0.039	0.015	0.039	0.007	0.039
5	0.014	0.039	0.013	0.039	0.013	0.039
6	0.009	0.039	0.009	0.039	0.026	0.039
7	0.041	0.039	0.039	0.039	0.042	0.039
8	0.039	0.039	0.022	0.039	0.017	0.039

## CORRECTING BENDERS with COMMUNICATIONS

This next section works through how to communicate with the bender. This is only an example correction communication. It simulates the Benderlink feature to teach the principles of communications to benders.

To make communications work (and not just simulate), the Benderlink feature must be setup by an experienced technician. The Benderlink setup steps are not covered in this document because it's too complex to be covered here.

1. Press **Bender Setup** to show the Bender Setup screen (for communicating with the bender).
2. Press **(1) Setup This Window** on the right side.
3. Press **(2) COPY Master LRA to Setup LRA**. (Press the Continue in the Confirmation dialog if it appears.)
4. If the cut length is zero, then press **(3) Set Cut Length From MASTER Calculation**.



This will fill the starting values into the bender setup like this:

Part Number: VTube-LASER Demo 3  
 Diameter: 0.375 inches  
 Wall: 0 inches  
 Cut Length: 0 inches

Automatic Springback Damping: 3.000 (degrees)  
 Automatic Correction Damping: IS NOT PRESENT

	Length	Adjust	SE Adjust	NEW Len	Rotation	Adjust	Invert	NEW Rot	Angle	Adjust	SE Adjust	NEW Ang	Radius
1	1.525	0.001	0.0000	1.525	0.0	0.0	<input type="checkbox"/>	0.0	89.9	-0.1	0.0000	89.9	1.000
2	1.601	-0.025	0.0000	1.589	-134.6	-0.5	<input type="checkbox"/>	-134.9	59.9	-0.1	0.0000	59.8	1.000
3	2.197	-0.008	0.0000	2.193	44.7	0.7	<input type="checkbox"/>	45.0	59.7	-0.1	0.0000	59.6	1.000
4	2.217	-0.009	0.0000	2.213	134.6	0.6	<input type="checkbox"/>	134.9	59.9	-0.3	0.0000	59.8	1.000
5	2.219	-0.071	0.0000	2.183	0.2	0.4	<input type="checkbox"/>	0.4	59.9	0.0	0.0000	59.9	1.000
6	2.117	-0.012	0.0000	2.111	90.3	0.6	<input type="checkbox"/>	90.6	89.5	0.9	0.0000	90.0	1.000
7	1.634	-0.053	0.0000	1.607	89.6	0.5	<input type="checkbox"/>	89.9	60.0	0.1	0.0000	60.0	1.000
8	2.866	-0.019	0.0000	2.857			<input type="checkbox"/>				0.0000		1.000

The BLUE columns represent bender data before correction. The ORANGE

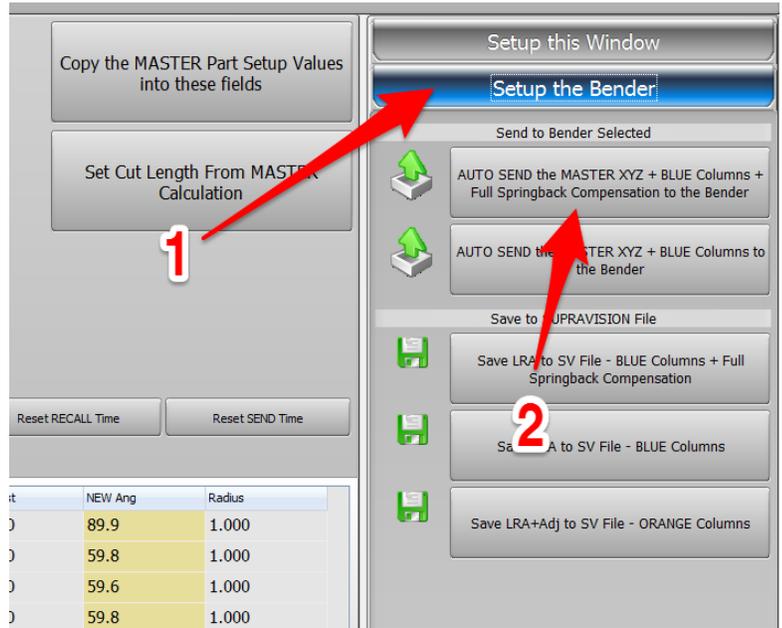
columns represent corrected data to be sent to the bender. The columns in between the BLUE and ORANGE columns are ADJUSTMENT columns.

This BLUE and the GREY cells can be manually adjusted for total control by the operator over the corrections being sent to the bender.

5. Press **(1) Setup the Bender** button.

6. Press **(2) AUTO SEND the MASTER...** button.

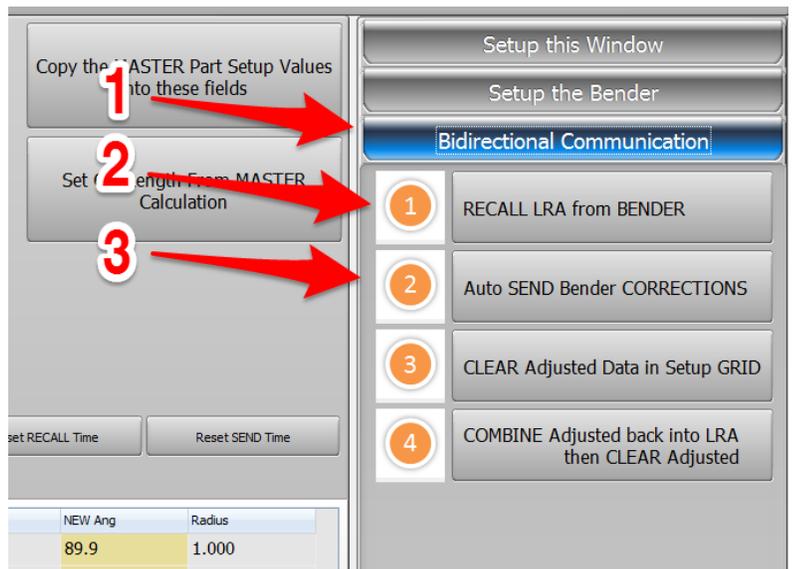
If VTube-LASER was connected to a bender, then **this would have transferred new setup data to the bender.**



7. Press the **(1) Bidirectional Communication** button on the right bottom side.

This sequence of button presses is how VTube can RECALL and SEND data for corrections loops to benders. VTube can communicate with up to 100 benders.

8. Press **Exit to LASER** on the top right corner of this window.



## CORRECTIONS REPORT EXAMPLE

You may not have a connection to the bender. That's ok, because you can still get to the correction data using printed reports.

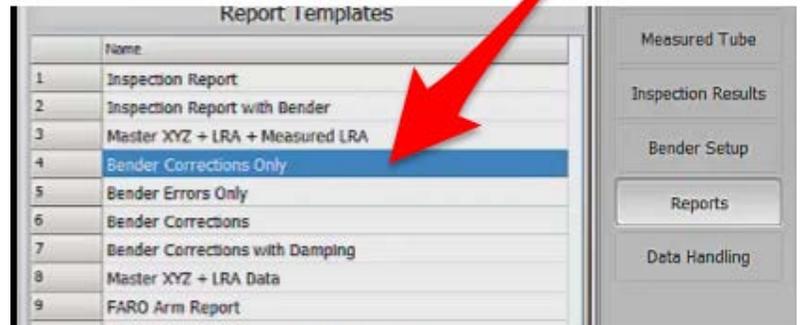
Click on **Reports** in the navigation pane.

Double-click on the **Bender Corrections Only** template cell in row 4.

If the tube image is not the same as the image in the main screen, then press **Refresh Image** at the top of the screen.

You can also tell VTube to always automatically refresh the image by putting a check in the **Automatic Image Refresh** switch at the top.

This is the end of the Quick Start Guide.



**Part Setup**

Date: 8/1/2017 1:08:01 PM  
 Part Number: VTube-LASER Demo 4  
 Unit: Inches

**Bender Adjustments**  
 Add this data to the bender data to correct the shape of the tube

Bend	Length	Rotation	Angle
1	-0.018	0.0	0.5
2	-0.029	-0.9	0.5
3	-0.231	0.5	0.7
4	-0.266	-0.2	0.3
5	-0.267	0.1	0.6
6	-0.140	-0.8	1.1
7	-0.081	0.7	0.6