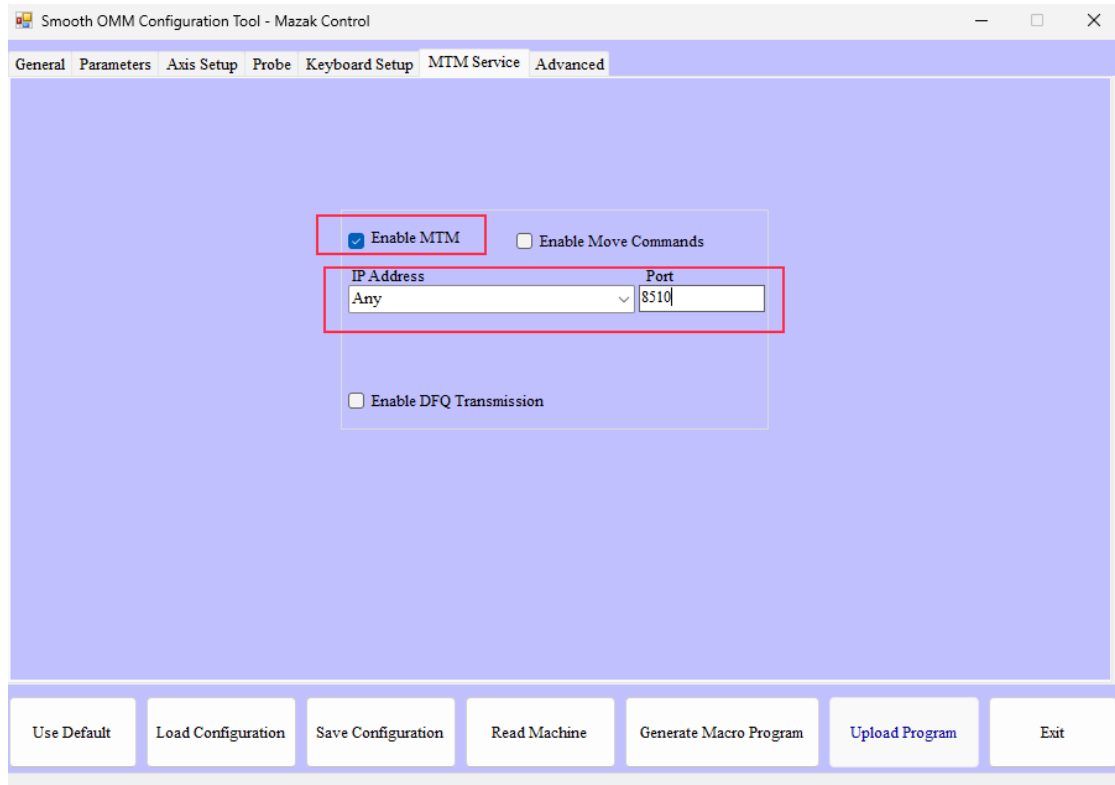


MTM NET TEST TOOL OPERATING MANNUAL

1 Connect

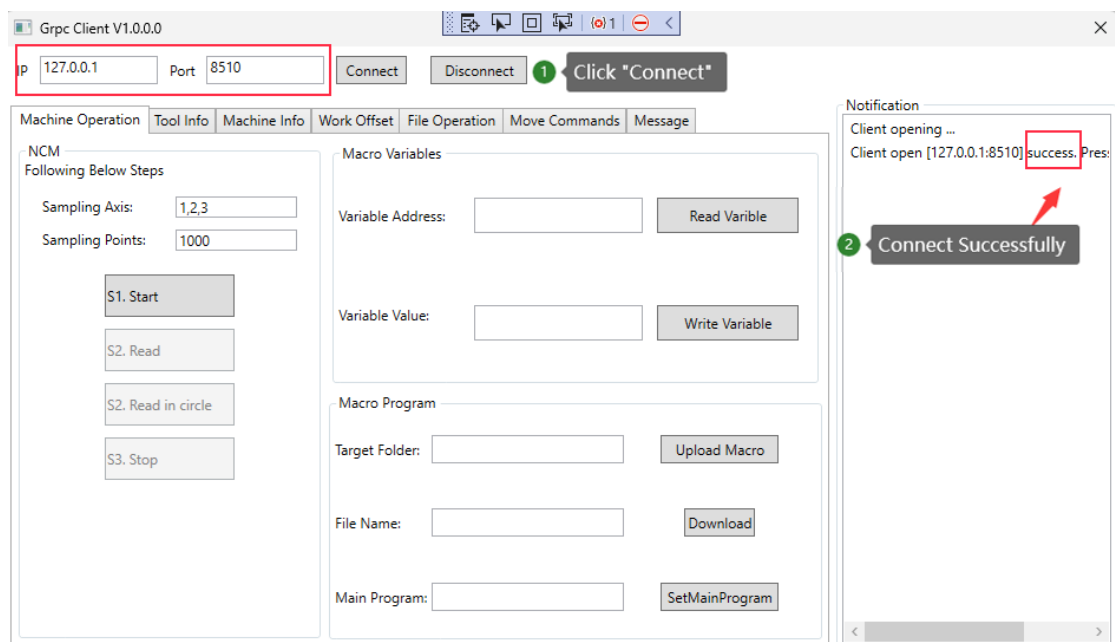
1.1 Configure MTM NET and Enable MTM NET



1.2 Run Smooth OMM

1.3 Run MTM Net Test tool to check

1.4 Connect First



2 Work Offset

2.1 Get Active Work Offset

Please click “GetActiveWorkOffset” button, then you will get active work offset related information.

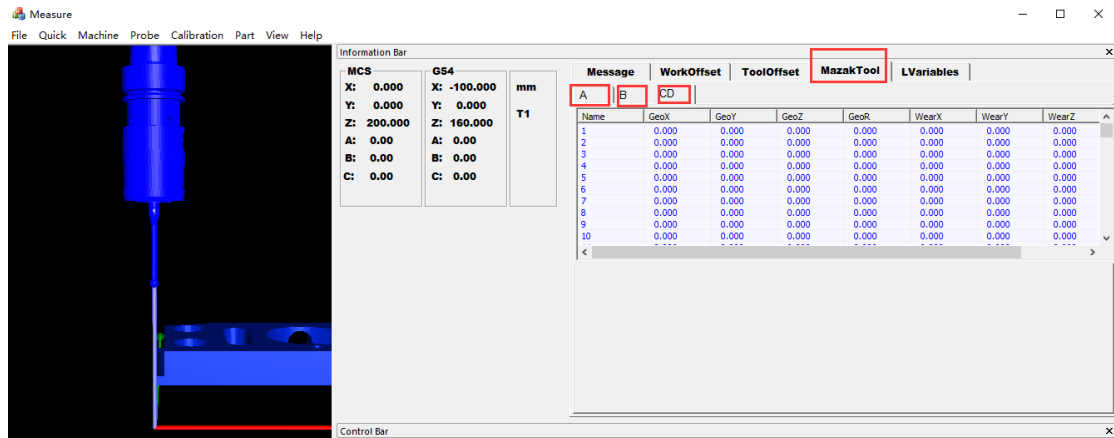
The screenshot shows the 'Grpc Client V1.0.0.0' window. At the top, there are fields for 'IP' (127.0.0.1) and 'Port' (8510), with 'Connect' and 'Disconnect' buttons. Below this is a tabbed interface with 'Machine Operation', 'Tool Info', 'Machine Info', 'Work Offset', 'File Operation', 'Move Commands', and 'Message'. The 'Work Offset' tab is active, displaying a list of input fields for work offset parameters: Workoffset Number (G58), X (-15), Y (-15.001), Z (31.995), A (#), B (0), C (255.08), U (#), V (#), and W (#). To the right of these fields are three buttons: 'GetActiveWorkOffset' (highlighted with a red box), 'GetWorkOffset', and 'UpdateWorkOffset'. A 'Notification' panel is visible on the far right.

2.2 Get Work Offset

Please input work offset number , then click “GetWorkOffset” button, you can get the work offset information you wanted.

The screenshot shows the 'Grpc Client V1.0.0.0' window. The 'Work Offset' tab is active. The 'Workoffset Number' field is now set to 'G59'. The 'X' field is set to '-85.0', 'Y' to '-49.999', 'Z' to '54.996', 'A' to '0.001', 'B' to '0.0', 'C' to '0.0', 'U' to '0.0', 'V' to '0.0', and 'W' to '0.0'. The 'GetWorkOffset' button is highlighted with a green circle and a red arrow pointing to it from the right. Another red arrow points to the 'Workoffset Number' field from the right. The 'GetActiveWorkOffset' and 'UpdateWorkOffset' buttons are also visible. The 'Notification' panel is on the right.

Measure							
File Quick Machine Probe Calibration Part View Help							
Information Bar							
MCS		G55		Message	WorkOffset	ToolOffset	MazakEIATool
K: -30.000	X: -30.000	mm		Name	X	Y	Z
I: -10.000	Y: -10.000	T1		G54	-145.000	-5.000	54.130
Z: 300.000	Z: 245.869			G55	0.000	0.000	54.131
A: 0.00	A: 0.00			G56	0.000	0.000	0.000
B: 0.00	B: 0.00			G57	0.000	0.000	64.934
C: 0.00	C: 0.00			G58	-15.000	-15.001	31.995
				G59	-85.000	-49.999	54.996
				G54.1P1	0.000	0.000	0.000
				G54.1P2	0.000	0.000	0.000
				G54.1P3	0.000	0.000	0.000
				G54.1P4	0.000	0.000	54.130
				G54.1P5	0.000	0.000	54.130
				G54.1P6	0.000	0.000	54.130
				G54.1P7	0.000	0.000	54.130
				G54.1P8	0.000	0.000	54.130
				G54.1P9	0.000	0.000	54.130
				G54.1P10	0.000	0.000	54.130
				G54.1P11	0.000	0.000	54.130
				G54.1P12	0.000	0.000	54.130
				G54.1P13	0.000	0.000	54.130
				G54.1P14	0.000	0.000	54.130
				G54.1P15	0.000	0.000	54.130
				G54.1P16	0.000	0.000	54.130
				G54.1P17	0.000	0.000	54.130
				G54.1P18	0.000	0.000	54.130
				G54.1P19	0.000	0.000	54.130
				G54.1P20	0.000	0.000	54.130
				G54.1P21	0.000	0.000	54.130
				G54.1P22	0.000	0.000	54.130
				G54.1P23	0.000	0.000	54.130
				G54.1P24	0.000	0.000	54.130
				G54.1P25	0.000	0.000	54.130
				G54.1P26	0.000	0.000	54.130
				G54.1P27	0.000	0.000	54.130
				G54.1P28	0.000	0.000	54.130
				G54.1P29	0.000	0.000	54.130
				G54.1P30	0.000	0.000	54.130
				G54.1P31	0.000	0.000	54.130
				G54.1P32	0.000	0.000	54.130
				G54.1P33	0.000	0.000	54.130
				G54.1P34	0.000	0.000	54.130
				G54.1P35	0.000	0.000	54.130
				G54.1P36	0.000	0.000	54.130
				G54.1P37	0.000	0.000	54.130
				G54.1P38	0.000	0.000	54.130
				G54.1P39	0.000	0.000	54.130
				G54.1P40	0.000	0.000	54.130
				G54.1P41	0.000	0.000	54.130
				G54.1P42	0.000	0.000	54.130
				G54.1P43	0.000	0.000	54.130
				G54.1P44	0.000	0.000	54.130
				G54.1P45	0.000	0.000	54.130
				G54.1P46	0.000	0.000	54.130
				G54.1P47	0.000	0.000	54.130
				G54.1P48	0.000	0.000	54.130
				G54.1P49	0.000	0.000	54.130
				G54.1P50	0.000	0.000	54.130
				G54.1P51	0.000	0.000	54.130
				G54.1P52	0.000	0.000	54.130
				G54.1P53	0.000	0.000	54.130
				G54.1P54	0.000	0.000	54.130
				G54.1P55	0.000	0.000	54.130
				G54.1P56	0.000	0.000	54.130
				G54.1P57	0.000	0.000	54.130
				G54.1P58	0.000	0.000	54.130
				G54.1P59	0.000	0.000	54.130
				G54.1P60	0.000	0.000	54.130
				G54.1P61	0.000	0.000	54.130
				G54.1P62	0.000	0.000	54.130
				G54.1P63	0.000	0.000	54.130
				G54.1P64	0.000	0.000	54.130
				G54.1P65	0.000	0.000	54.130
				G54.1P66	0.000	0.000	54.130
				G54.1P67	0.000	0.000	54.130
				G54.1P68	0.000	0.000	54.130
				G54.1P69	0.000	0.000	54.130
				G54.1P70	0.000	0.000	54.130
				G54.1P71	0.000	0.000	54.130
				G54.1P72	0.000	0.000	54.130
				G54.1P73	0.000	0.000	54.130
				G54.1P74	0.000	0.000	54.130
				G54.1P75	0.000	0.000	54.130
				G54.1P76	0.000	0.000	54.130
				G54.1P77	0.000	0.000	54.130
				G54.1P78	0.000	0.000	54.130
				G54.1P79	0.000	0.000	54.130
				G54.1P80	0.000	0.000	54.130
				G54.1P81	0.000	0.000	54.130
				G54.1P82	0.000	0.000	54.130
				G54.1P83	0.000	0.000	54.130
				G54.1P84	0.000	0.000	54.130
				G54.1P85	0.000	0.000	54.130
				G54.1P86	0.000	0.000	54.130
				G54.1P87	0.000	0.000	54.130
				G54.1P88	0.000	0.000	54.130
				G54.1P89	0.000	0.000	54.130
				G54.1P90	0.000	0.000	54.130
				G54.1P91	0.000	0.000	54.130
				G54.1P92	0.000	0.000	54.130
				G54.1P93	0.000	0.000	54.130
				G54.1P94	0.000	0.000	54.130
				G54.1P95	0.000	0.000	54.130
				G54.1P96	0.000	0.000	54.130
				G54.1P97	0.000	0.000	54.130
				G54.1P98	0.000	0.000	54.130
				G54.1P99	0.000	0.000	54.130
				G54.1P100	0.000	0.000	54.130
				G54.1P101	0.000	0.000	54.130
				G54.1P102	0.000	0.000	54.130
				G54.1P103	0.000	0.000	54.130
				G54.1P104	0.000	0.000	54.130
				G54.1P105	0.000	0.000	54.130
				G54.1P106	0.000	0.000	54.130
				G54.1P107	0.000	0.000	54.130
				G54.1P108	0.000	0.000	54.130
				G54.1P109	0.000	0.000	54.130
				G54.1P110	0.000	0.000	54.130
				G54.1P111	0.000	0.000	54.130
				G54.1P112	0.000	0.000	54.130
				G54.1P113	0.000	0.000	54.130
				G54.1P114	0.000	0.000	54.130
				G54.1P115	0.000	0.000	54.130
				G54.1P116	0.000	0.000	54.130
				G54.1P117	0.000	0.000	54.130
				G54.1P118	0.000	0.000	54.130
				G54.1P119	0.000	0.000	54.130
				G54.1P120	0.000	0.000	54.130
				G54.1P121	0.000	0.000	54.130
				G54.1P122	0.000	0.000	54.130
				G54.1P123	0.000	0.000	54.130
				G54.1P124	0.000	0.000	54.130
				G54.1P125	0.000	0.000	54.130
				G54.1P126	0.000	0.000	54.130
				G54.1P127	0.000	0.000	54.130
				G54.1P128	0.000	0.000	54.130
				G54.1P129	0.000	0.000	54.130
				G54.1P130	0.000	0.000	54.130
				G54.1P131	0.000	0.000	54.130
				G54.1P132	0.000	0.000	54.130
				G54.1P133	0.000	0.000	54.130
				G54.1P134	0.000	0.000	54.130
				G54.1P135	0.000	0.000	54.130
				G54.1P136	0.000	0.000	54.130
				G54.1P137	0.000	0.000	54.130
				G54.1P138	0.000	0.000	54.130
				G54.1P139	0.000	0.000	54.130
				G54.1P140	0.000	0.000	54.130
				G54.1P141	0.000	0.000	54.130
				G54.1P142	0.000	0.000	54.130
				G54.1P143	0.000	0.000	54.130
				G54.1P144	0.000	0.000	54.130
				G54.1P145	0.000	0.000	54.130
				G54.1P146	0.000	0.000	54.130
				G54.1P147	0.000	0.000	54.130
				G54.1P148	0.000	0.000	54.130
				G54.1P149	0.000	0.000	54.130
				G54.1P150	0.000	0.000	54.130
				G54.1P151	0.000	0.000	54.130
				G54.1P152	0.000	0.000	54.130
				G54.1P153	0.000	0.000	54.130
				G54.1P154	0.000	0.000	54.130
				G54.1P155	0.000	0.000	54.130
				G54.1P156	0.000	0.000	54.130
				G54.1P157	0.000	0.000	54.130
				G54.1P158	0.000	0.000	54.130
				G54.1P159	0.000	0.000	54.130
				G54.1P160	0.000	0.000	54.130
				G54.1P161	0.000	0.000	54.130
				G54.1P162	0.000	0.000	54.130
				G54.1P163	0.000	0.000	54.130
				G54.1P164	0.000	0.000	54.130
				G54.1P165	0.000	0.000	54.130
				G54.1P166	0.000	0.000	54.130
				G54.1P167	0.000	0.000	54.130
				G54.1P168	0.000	0.000	54.130
				G54.1P169	0.000	0.000	54.130
				G54.1P170	0.000	0.000	54.130
				G54.1P171	0.000	0.000	54.130
				G54.1P172	0.000	0.000	54.130
				G54.1P173	0.000	0.000	54.130
				G54.1P174	0.000	0.000	54.130
				G54.1P175	0.000	0.000	54.130
				G54.1P176	0.000	0.000	54.130

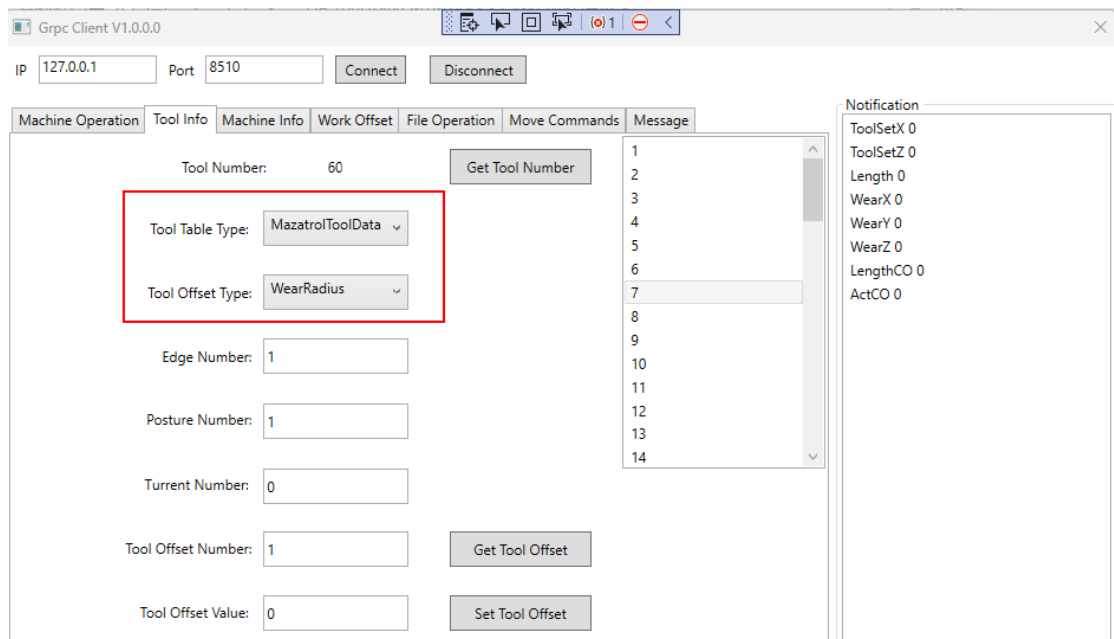


3.2 Test Mazak EIA Tool

Please select Tool Table Type and Tool Offset Type ,then you click “Get Tool Number”.

You can input Tool Offset Number, then click “Get Tool Offset” button .

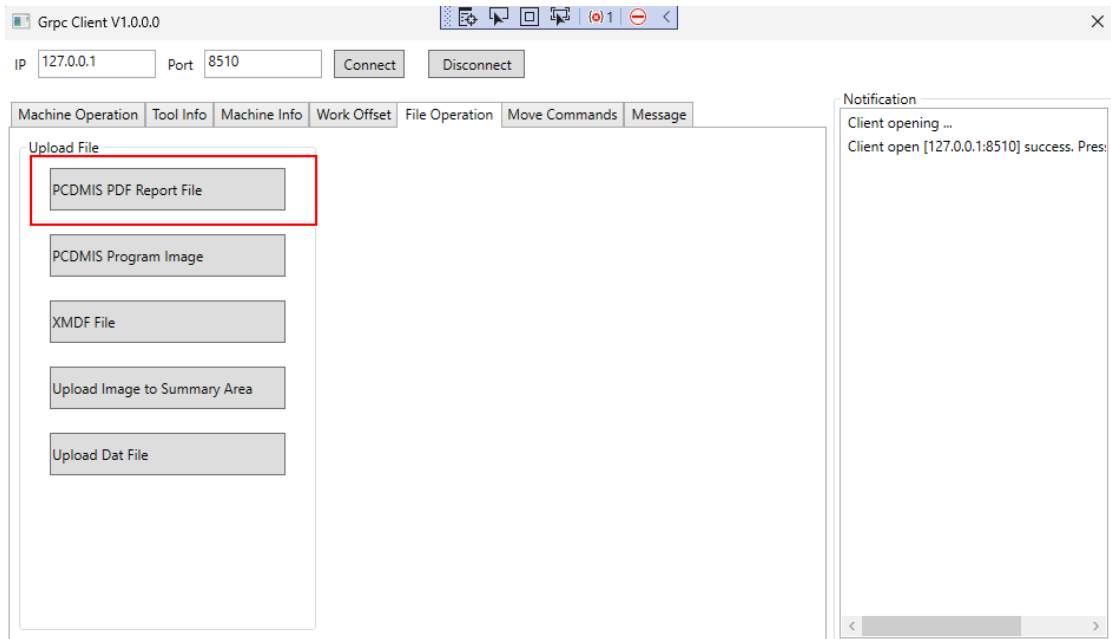
You can input Tool Offset Value then click “Set Tool Offset” button.



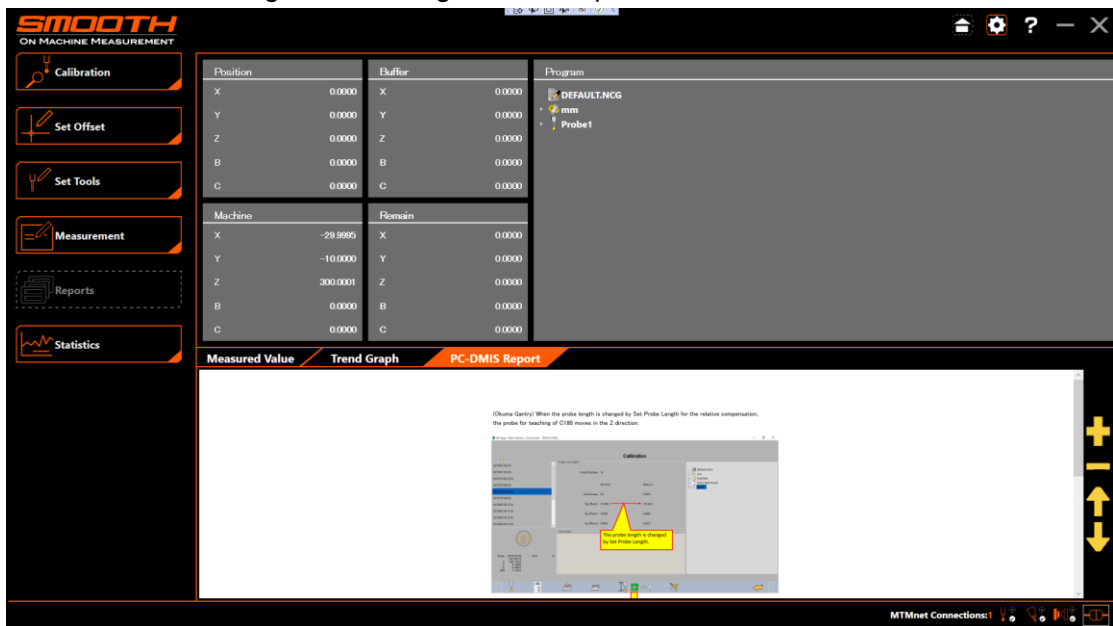
4 File Operation

4.1 Upload PDF

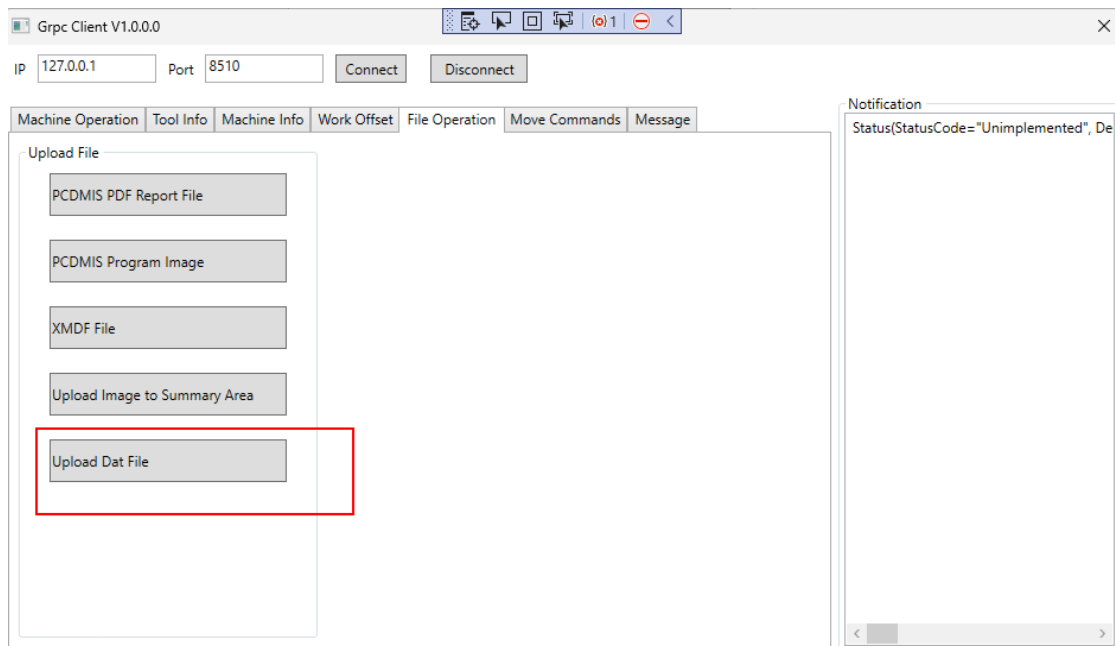
You can click “PCDMIS PDF Report File” button to upload pdf file.



4.2 PDF will be changed in NC-Gage with the uploaded one.



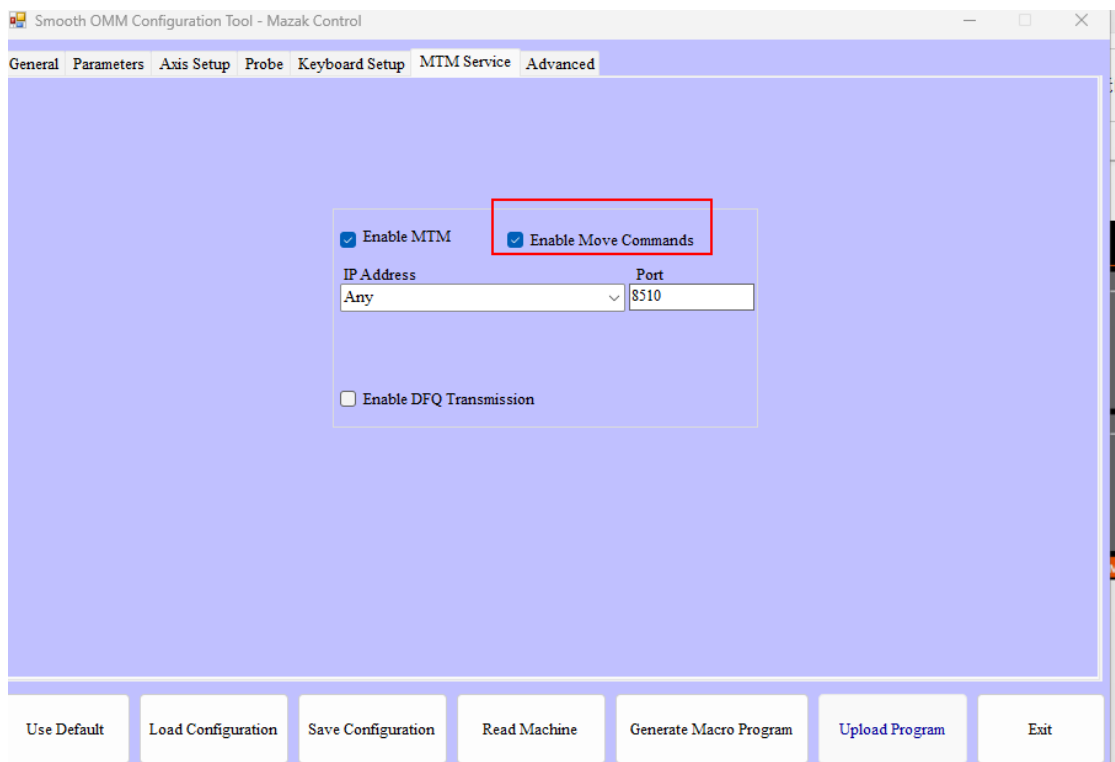
4.3 After pressing "Upload Dat File" and selecting a Dat file, Smooth OMM will restart and the Dat file will be replaced with the selected Dat file.



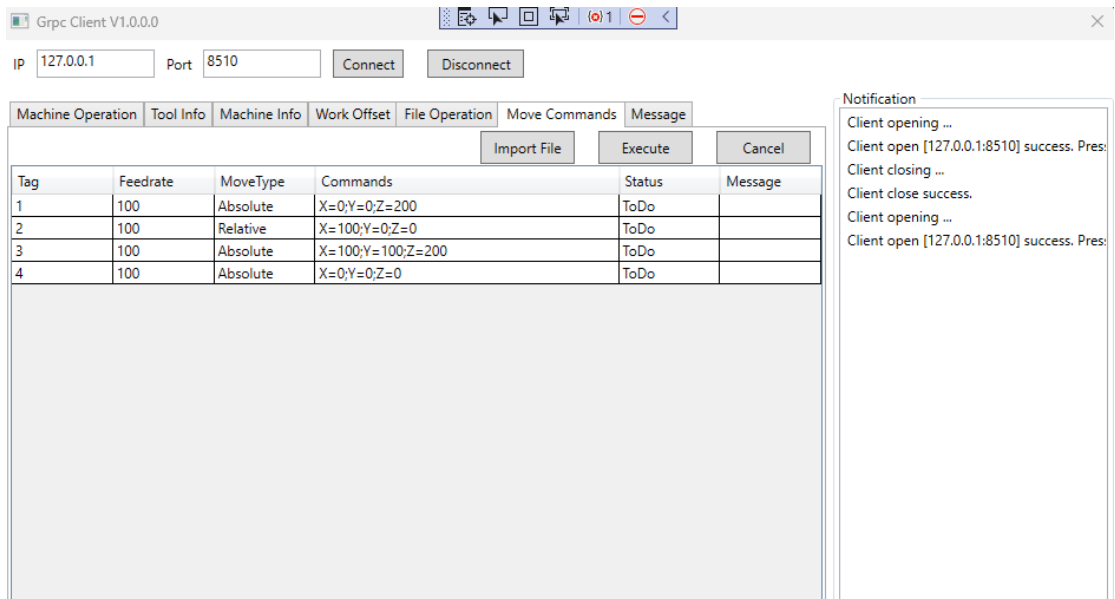
4.4 You can also upload other type files

5 Move commands

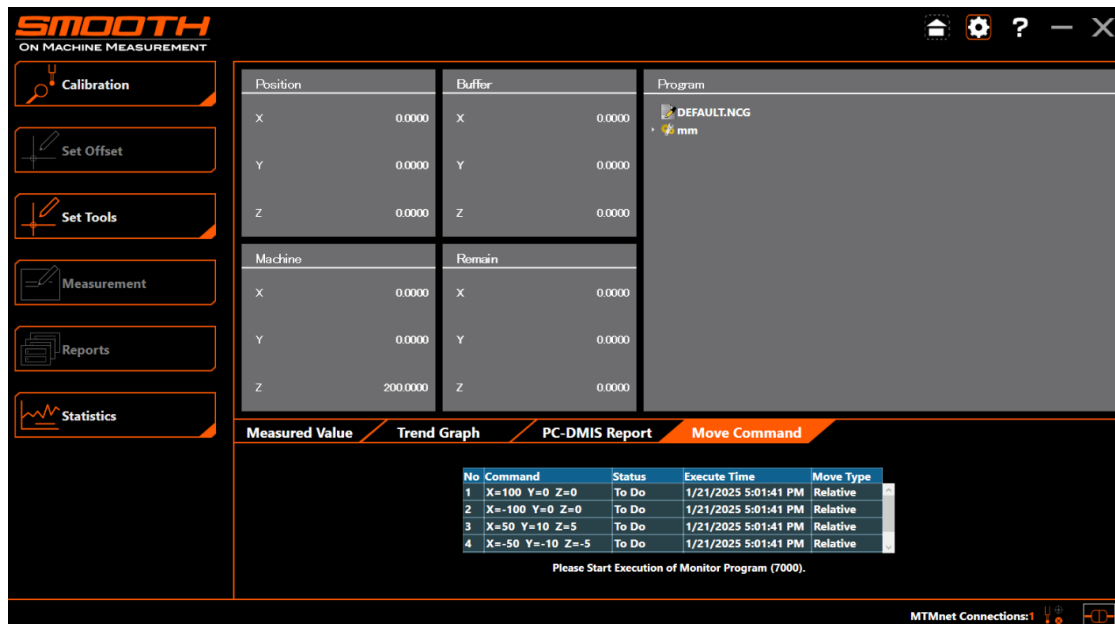
5.1 Enable move commands in the configure tool screen



5.2 You can import file or use current data, then click “Execute” button.

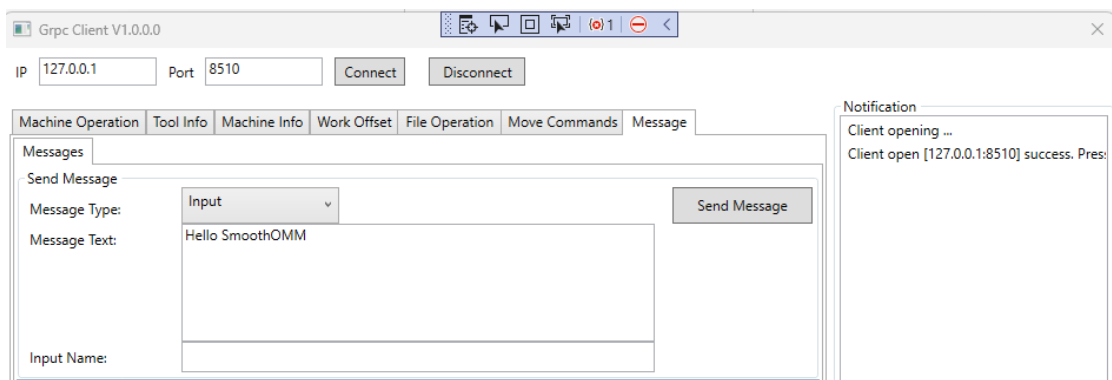


5.2 You can see move commands in Smooth OMM screen

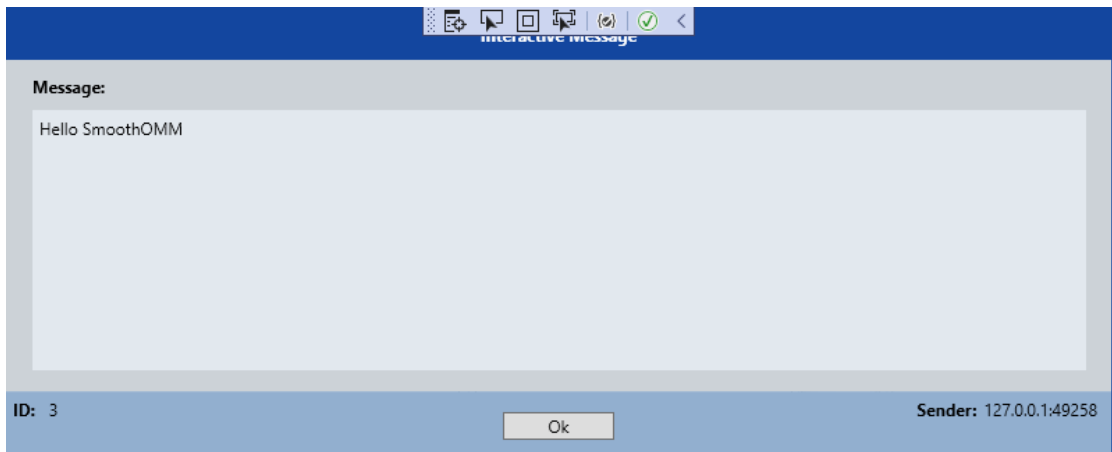


6 Message

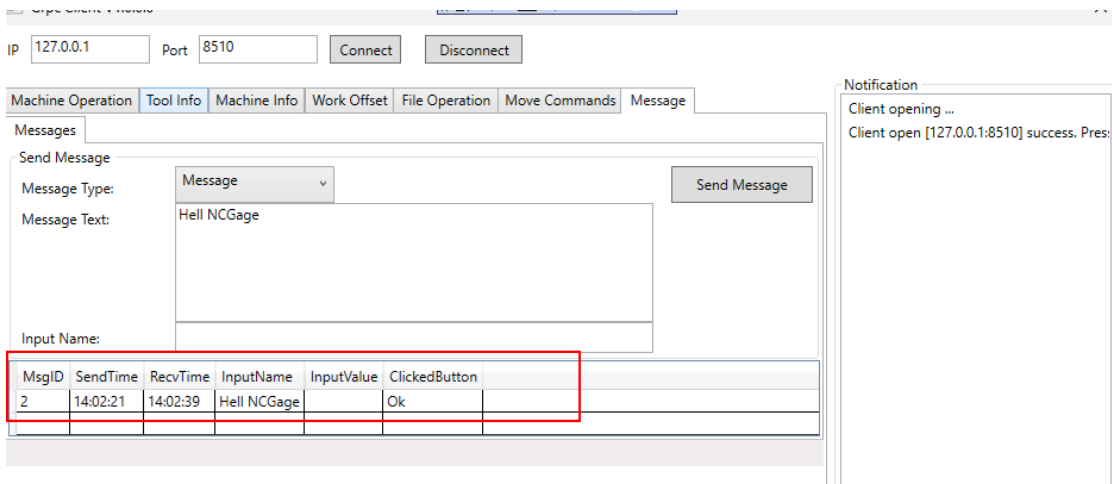
6.1 Please select "Message" Type, input Message Text, click "Send Message" button



6.2 You can see popup information screen in SmoothOMM



6.3 If you click “Ok” button, you can see Ok in the following table.



6.4 You can choose other Message Types to test.