

Step 5 Verification of Setup

- a. Press the green START button to run the TOOL_LEN program.
- b. Select the tool number from the list of measurable tools and press the SPACE bar.
- c. Press   to measure the tool.

Compare the daylight value found with the Length Sensor with the value found manually. If there is a great difference between the daylight values, then either the difference was calculated incorrectly or the SET SWITCHSPOIL value should be negative instead of positive or vice versa or the incorrect tool was selected to be measured.

Step 6 Measure remaining Tools

Measure all tools.

- a. Press the green START button to run the TOOL_LEN program.
- b. Select the tool number(s) for the installed tools from the list of measurable tools and press the SPACE bar.
- c. Press   to measure the tool.

Quicksheet

1. Load the TOOL_LEN program.
 - a. Change the SET SWITCHSPOIL variable to zero (0) in the M999 Macro.
2. Measure the same tool's DAYLIGHT VALUE manually to the spoilboard.
3. Measure a tool with the sensor.
4. Calculate the difference between Daylight Value to the sensor and the spoilboard.
5. Update the SET SWITCHSPOIL variable in the M999 macro.
6. Measure the tool and compare the measured Daylight Value to the one manually obtained from the spoilboard.
7. Measure all remaining tools with the sensor.