Part Measurement Sensor

The Part Measurement Sensor is available on the Models 40, 42 and 53.

It is sometimes necessary to locate or measure a part either before or after it is machined. An example would be to measure a blank to check it is the proper size and thickness. To center French dovetails on the edge of a board, the exact thickness needs to be known. Another would be to locate a feature on the part other than the edge. This is used occasionally in the furniture business to center veneer patterns on tabletops. This is done by placing metal rings on the blanks precisely at the veneer lines and then locating the rings with the machine and adjusting the program to center on the veneer. The sensor is a very accurate three-axis switch. Programming the machine to advance until the switch is activated and the position information is then used later in the program uses it. It can measure in either X, Y or Z-axes. The option comes mounted on an air slide, which mounts on one of the piggyback positions. In order to properly utilize this option the user must make use of the Thermwood Advanced Function Language programming. To program in AFL the person must be an experienced computer programmer.

The sensor has a limited stroke and care must be taken in the programming not to exceed the travel of the sensor or to crash it as this will damage the sensor. As the sensor mounts in the piggyback position it may not have complete table coverage, check with Thermwood for exact coverages. As mentioned above, in order to properly utilize this option, an experienced programmer is necessary.

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