

# AUTOMATED START PROGRAMS

## WRITING AN AUTOMATED START PROGRAM

**Step # 1** Recall the Reference System (0,0 point) from the machine.



Recall Ref Sys

**Step #2** Move the Reference System to Features on the Stage Square.



Line 1 (*Line 1*)

(Hint: Use First Edge Tool / Long Search Windows / Have Tool Search from the Dark to the Light)



Line 2 (*Line 2*)



Point

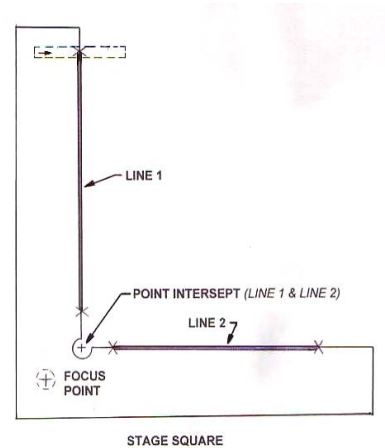


Intersect of Line 1 to Line 2 (*Point 3*)



Place a Focus Point Anywhere on the Top Surface of Square (*Point 4*)

(Hint: Zoom up to about 50% to avoid problems later)



Set your X,Y Origin to the Intersect Point



Set your Z Origin to Focus Point



Skew your X Axis to Line 2 (*System 5*)

**Step #3** Name the System fixt and store the program as START

Right Click on SYSTEM 5 > Select STORE > Select RENAME > Name the system - fixt

Click on the FILE menu > Select SAVE AS > Navigate to the desired location > Name the file START

**Step #4** Re-Calling as first step of any new program

Click on the FILE menu > Select NEW > Place your part on the stage nested into the Stage Square



Left Click on the RECALL icon > Select fixt (if fixt is not available, you need to run START.iwp)  
Write your program and save it

**Step #5** Running your program

If you have exited the InSpec software, you must re-run the START program.



Place your part on the stage nested into the Stage Square.

Click on the FILE menu > Select OPEN > Select your Program > Click on the RUN icon