

## Reporting on features and updates

In addition to creating probe routines, Productivity+™ Active Editor Pro can also create reports on inspected features and the updates you have performed on your machine, i.e. tool and WCS updates. This module covers the steps required to create a report.

The report function can create either a D-print statement in your program to send data via RS232 to a printer/comms package, or write to a file location on the controller (subject to capability).

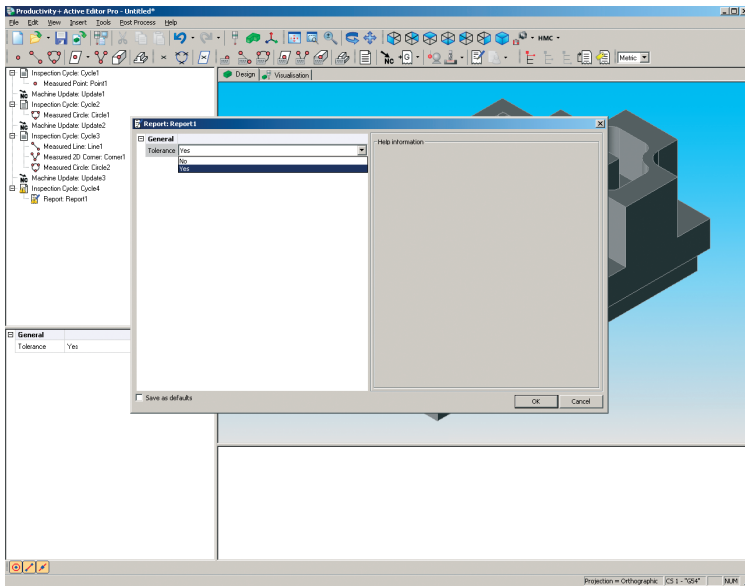
Having complete this module you will be able to:

- Create an inspection report
- Create an update report

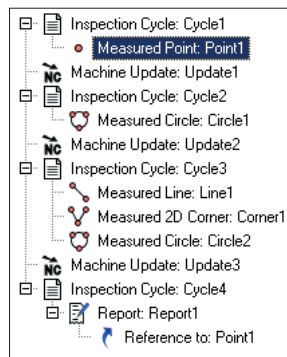
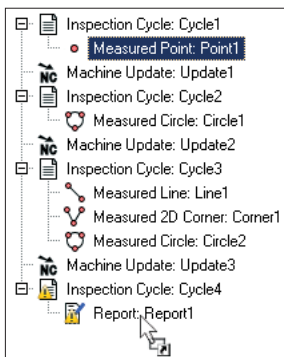


Open a Productivity+™ Active Editor Pro session that contains a few different features and updates.

Select the Reporting icon.



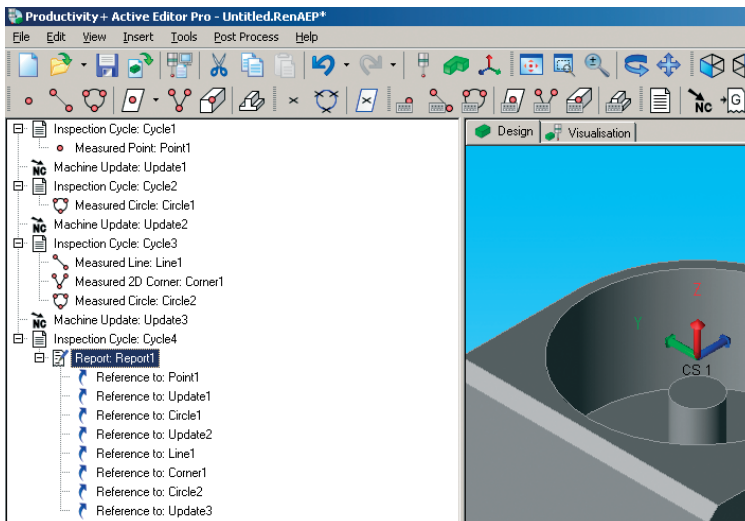
This adds a new Inspection Cycle containing a Report element to your process tree, and opens a Report dialog box with an option to include tolerances within the report



Determine which features and updates within the process tree you wish to report on.

Drag and drop these features onto the newly created Report:Report1 element. When the cursor changes to a square box containing an arrow, release the mouse button.

(The Report element will indicate an error (warning triangle) until it contains at least one feature to report on.)



In the example on the left all features and updates have been selected for reporting.

Once posted and run on your machine with your component, a report will be generated detailing the selected features and updates.

```
PROGRAM START PGS
PROGRAM NAME O1900
VERSION 18
DATE 2010 8 2
TIME 14 26 52
```

REPORT RPT

REPORT1

	NOM	ACT	DEV	LOWER	UPPER	IN TOL
MEASURED POINT MPT						
POINT1						
POSITION X	-101.0940	-101.0945	-0.00050	-0.0500	0.0500	YES
POSITION Y	-60.0000	-60.0145	-0.01450	-0.0500	0.0500	YES
POSITION Z	-15.0180	-15.0170	0.00152	-0.0500	0.0500	YES

	NOM	ACT	DEV	LOWER	UPPER	IN TOL
MEASURED CIRCLE MCL						
CIRCLE1						
CENTRE X	0.0000	-0.0066	-0.0066	-0.1250	0.1250	YES
CENTRE Y	0.0000	-0.0021	-0.0021	-0.1250	0.1250	YES
CENTRE Z	0.0000	0.0000	0.0000			
DIAMETER	20.0000	20.0072	0.0072	-0.0500	0.0500	YES

UPDATE1

```
WCS UPDATE WUP
  UPDATESET      UPDATE
  WCSTOUPDATE    G54
  REFERENCEWCS   G54
  FEATURE         POINT2
  POSITION X       0.0000
  POSITION Y       0.0000
  POSITION Z       0.0000
```

MACHINE UPDATE UPD

```
UPDATE2
WCS SET FROM FEATURE WSF
  UPDATESET      SET FROM FEATURE
  WCSTOUPDATE    G55
  REFERENCEWCS   G54
  FEATURE         POINT2
  POSITION X       47.0790
  POSITION Y       - 75.3780
  POSITION Z       -194.5140
```

```
PROGRAM END PGE
PROGRAM NAME O1900
DATE 2010 8 2
TIME 14 31 14
```

Report structure will vary slightly depending on controller type, but all contain a header and footer to indicate when the program starts and ends.

Reports are split by report elements with each report and feature being indicated by type (e.g. REPORT, MEASURED CIRCLE), type code (e.g. RPT, MCL), followed by the feature name from the program structure tree (e.g. REPORT1, CIRCLE1).

Machine update elements are reported in a similar way.

A sample report containing measured feature and machine update elements is shown on the left.

The following table lists the type codes for the varying features and elements that may be displayed by reports.

Element/feature type	Code	Sub-type	Sub-type code
PROGRAM START	PGS		
PROGRAM END	PGE		
REPORT	RPT		
MEASURED POINT	MPT		
MEASURED LINE	MLN		
MEASURED PLANE	MPL		
MEASURED WEB OR POCKET	MWP		
MEASURED CIRCLE	MCL		
MEASURED 2D CORNER	MC2		
MEASURED 3D CORNER	MC3		
CONSTRUCT POINT	CPT		
CONSTRUCT CIRCLE	CCL		
CONSTRUCT PLANE	CPL		
MACHINE UPDATE	UPD		
		TOOL DIAMETER UPDATE	TDU
		TOOL LENGTH UPDATE	TLU
		WCS UPDATE	WUP
		WCS SET MANUAL	WSM
		WCS SET FROM FEATURE	WSF
		ROTATION UPDATE	RUP
		MACHINE VARIABLE SET	MVS
		MACHINE VARIABLE UPDATE	MVU
CUSTOM MACRO	CMA		

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