RDS-CAA Qualification and Programming Primer for Calypso version 5.2
The MasterProbe will have to be of type RDS-CAA in order to proceed with RDS-CAA qualification. The “Fitting Position” button should be visible.
If MasterProbe is not already of type RDS-CAA, drop down the “Mode” menu, choose “CFS qualification,” and proceed with locating Reference Sphere Position.
If MasterProbe is already of type RDS-CAA, select “Ref. Sphere position” and follow prompts. NOTE: If not already in A=0, B=0, be sure to drive the RDS clear of all obstacles.
When qualifying RDS-CAA, it is recommended that the Reference Sphere is oriented vertically.

Unscrew the reference sphere from rotating plate, loosen rotating plate and rotate 180 and reattach the reference sphere to the top threaded hole.
Be sure that the “Tilt” is set correctly. If the Reference Sphere is oriented vertically, “Tilt” should be set to 180. It matters not what Rotation angle is set. Take the first point in the direction of the stylus, as always.
After setting the Reference Sphere position, it is necessary to set the Fitting Position of the MasterProbe. In this process, the MasterProbe will automatically find the Reference Sphere position in all 12 orientations.
The progress of the Fitting Position is posted in the window. Status will indicate an OK status unless there has been a collision. Check that the Standard Deviation for MasterProbe is acceptable.
To create a new stylus system, attach the stylus system, select “Pick Up Stylus System.”
Choose “New”
Check the Probe type (RST, XDT, XXT TL3)

NOTE: XXT types TL1 and TL2 are not compatible with RDS-CAA qualification.
Enter the NAME and STYLUS NAME “1.” Check box for RDS-CAA

For qualification of individual positions, the box must remain unchecked.

This is the only place where qualification type (normal or RDS-CAA) may be set.
Select “Qualify stylus.” NOTE: If not already in A=0, B=0, be sure to drive the RDS clear of all obstacles. Take point in the direction of stylus shaft. Qualification of all 12 positions will be automatic.
Progress of qualification will be posted in the window.
To add a new stylus, select the “Add New Stylus” button. Enter Name “2.”
Select “Qualify Stylus,” Choose “Full Qualification.”
In the window, select each position, choosing “Show” for each. Be sure head is free for rotation.
If any position is not able to be qualified, choose “Alternative.” Click “Show” for the new angle.
Once all positions have been proofed for collisions, Click OK.
Progress will be posted in the window.
Once the Stylus System has been qualified with RDS-CAA, it may be used in measurement programs.
Create the measurement program as usual.
In The Features Settings Editor, navigate to Stylus System.
If not already assigned, select features and “Set to” the desired Stylus system.
If not already assigned, select features and “Set To” desired Stylus (“1” or “2”).
In the new menu, “RDS Angles” it is possible to set the angle for each feature, however this method is rather tedious and fraught with errors.
Instead, go to the Stylus Rotation window.
A CAD representation of the head, probe, and stylus appears. The current position is listed under “New Angle Position” A=0.0, B=0.0 indicates a “down” position.
A=-90°, B=90° indicates a “back” orientation
A=90°, B=90° indicates a “right” orientation
A=-90°, B=-90° indicates a “front” orientation
A=90°, B=-90° indicates a “left” orientation
Alternatively, the angle can be set by the orientation of a feature. Select the feature and select “To Feature.”
If the preview of the angle of the stylus is incorrect, select “Invert Position.”
Once satisfied with the angle, accept the angle.
To apply current angle to features, select the appropriate features and select “Apply Angle.”
Changes should be reflected in the Features Settings Editor.
Select orientation and apply for remaining features.
Changes should be verified in Features Settings Editor.