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Writing probe values into the datum table would result in incorrect entries. Page 25. HEIDENHAIN iTNC 530. 13. 2.2 Calibration 13.2. Viewing Calibration Results When performing calibration, you must set the zero point and set the direction of travel. The direction of movement is set using the parameter and allows calibration to be carried out even if the position of the measuring head and the probe do not match. To set the direction of movement, use the parameter. It has two options: and .

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