

for use with

MarCom Professional v.5.2

Mahr

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Quick Reference Sheet

This page is included for those people who wish to install and use MarCom with minimal instructions. Complete details follow.

Setting up MarCom for RS-232 Output

- 1. In MarCom, set up an Emulation or Interface box activating as COM3
- 2. Add your wireless gages and connect to them via RF.
- 3. For each gage, choose to transfer to Virtual Interface Box and choose the COM3 box you set in step 1.
- 4. Optionally specify a port number (channel in QC-Gage).
- 5. In QC-Gage, create your spec plan and link to COM3 (either in the spec plan or through Global Gages use Mahr Wireless (MarCom) gage script).
- 6. When creating features, link to the appropriate gage, set the channel and optionally set the units.

Setting Up MarCom for RS-232 Output

Introduction

All Mahr wireless gages communicate with built in wireless, communicate through a USB receiver to the PC. You must install MarCom Professional to receive the communications and pass it along to other software packages. This document will walk you through the steps to set up MarCom to output to a virtual COM port so that QC-Gage can receive the data from the gage.

NOTE: You must install MarCom Professional in order to use a virtual COM port (RS-232) communication with QC-Gage as MarCom Standard does not have this functionality. As of Summer 2017, MarCom Professional is now a free software product available for download on Mahr's website.

Setting Up Virtual COM Port

Once you have installed MarCom Professional, it should launch itself and appear on screen as follows:



- 1. Open the settings by double clicking on the Mahr logo.
- In the main settings screen, choose Emulation of Interface Box from the Settings menu.



3. In the Virtual Interface Box settings window, check the **Active** checkbox to the right of the first row. Click **OK** to save changes.

NOTE: You can activate as many COM ports as you would like and link different gages to different COM ports. In this example, we are only activating the first COM port.

Virtual Interface Box					×
	Interface	Type of Interface Box		Foots	witch
Virtual Interface Box 1	СОМ З ~	Mux50 Mahr-Box 🗸 🗸	Active	-	~
Virtual Interface Box 2	COM 4	Mux50 Mahr-Box 🗸 🗸	Active	-	~
Virtual Interface Box 3	COM 5 ~	Mux50 Mahr-Box v	Active	-	~
Virtual Interface Box 4	COM 6 ~	Mux50 Mahr-Box v	Active	-	~
				<u>O</u> k	<u>C</u> ancel

Add RF Devices

1. Select Measuring Instruments > Add RF Device > i-stick.

NOTE: Depending on the device you are adding, you may choose e-stick or FM2. In our case, we are adding a standard caliper.

 Program	Measuring Instruments	Settings ?
Reset Mea	surement Cycle	cription
Previous Next Edit Request Va	lue	linent, Data Cable
Add RF-De	evice >	i-Stick
Delete RF- Delete All	Device RF- <mark>D</mark> evices	e-Stick FM2
Refresh		

- 2. In the Parameters screen, choose the instrument to install from the Instrument drop down list and optionally name it with the Description field.
- 3. In the Transfer to area, choose Virtual Interface Box from the drop down list and choose the virtual COM port you just created above. You can also optionally choose a port number at the bottom. This will be viewed as a channel number by QC-Gage. If left blank, MarCom will send zero.

CO Description my caliper -RF1 Device No. d 01 Data Request via Keypad F2 Zero None Transfer to Virtual Interface Box Virtual Interface Box 1: COM 3 / Mux50 Mahr-Box	 Ibj4 		~	al 16EWRi	Mart	Instrument	// lect
Data Request via Keypad V F2 V Zero None V Transfer to Virtual Interface Box V Settings of Interface Box I: COM 3 / Mux50 Mahr-Box V				liper	my c d 01 001	Description Device No.	
Zero None Transfer to Settings of Interface Box Virtual Interface Box I: COM 3 / Mux50 Mahr-Box Virtual Interface Box Virtual Interface Bo	~		~ F2		Keypad	est via	ita Reque
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	C) 	r-Box	erface Box Mux50 Mał	Virtual In 1: COM 3) of Interface Box terface Box	ansfer to ettings o irtual Int
Select port number		4	3 7	2 6	1 X 5	rt number	elect poi

4. When finished, setting up the gage, click the Connect button in the top left corner of the screen. The connect button will flash yellow, connect with your gage and eventually flash green when connected.

Note]
(())	Connect RF-Device	
	Close	

5. Once connected, you're ready to use the gage in QC-Gage. Click **OK** to close the parameters window.

Setting up QC-Gage Global Gage/Spec Plan

- 1. In QC-Gage, set up a global gage via **Tools > Global Gages**. Click the green plus sign to add a new global gage.
- 2. In the Gage Setup screen, choose COM Port (serial) at the top, name your gage and fill out the COM port settings below according to the following:

Gage Script: Mahr Wireless (MarCom)

COM Port: COM3 Baud: 9600 Bits: 8 Parity: None Stop bits: 1

Select **OK** to save changes.

iput Type	COM Port (Serial)		
riendly Name	my caliper		
Feature Defaults			
Units	Precision	4 7	Channel NONE
Dimension Source		Extra Info	
COM Port Settings			
COM Port Settings Default Gage Script	Mahr Wireless (MarC	iom)	
COM Port Settings Default Gage Script COM Port	Mahr Wireless (MarC COM3	iom)	-) - î
COM Port Settings Default Gage Script COM Port Baud Rate	Mahr Wireless (MarC COM3 9600	iom) T Bits per Byte T Stop Bits	*) * 🗃 8 1
Default Gage Script COM Port Baud Rate Parity	Mahr Wireless (MarC COM3 9600 None	iom) P Bits per Byte Comp Bits P Flow Control	8 1 Software (xon/xoff
COM Port Settings – Default Gage Script COM Port Baud Rate Parity <u>Reset to default</u>	Mahr Wireless (MarC COM3 9600 None	iom) Bits per Byte Stop Bits Flow Control RT3	8 1 Software (xon/xoff
COM Port Settings Default Gage Script COM Port Baud Rate Parity Reset to default No open connection	Mahr Wireless (MarC COM3 9600 None	om) v Bits per Byte v Stop Bits v Flow Control	8 1 Software (xon/xoff
COM Port Settings Default Gage Script COM Port Baud Rate Parity Reset to default No open connection Test Connection	Mahr Wireless (MarC COM3 9600 None Close Port	om) Bits per Byte Stop Bits Flow Control COM port of	8 1 Software (xon/xoff DTR
COM Port Settings Default Gage Script COM Port Baud Rate Parity Reset to default No open connection Test Connection Gage Data Received	Mahr Wireless (MarC COM3 9600 None Close Port 1 MW +000, 1655 inc	iom) Bits per Byte	B Software (xon/xof DTR spened.

3. Create your spec plan in QC-Gage. When specifying the features, choose the global gage you created to link the feature source.

Channel: If choosing to enforce channel number, choose it from the drop down list. If not, choose NONE.

Units: The Mahr Wireless gage script populates the units field with either "mm" or "inch" based on the setting from the gage. If you choose to enforce this in your spec plan, type it in the Units field. Otherwise, leave the field blank.

		asaremente	
ure: OD			
ture Info Picture and Inst	ructions		
Details (1)			
Feature Label			
Feature Source my c	aliper (COM3 - Mahr Wireless (MarCom))	2
	verride Gage Geript	Tolerance Type	Bilateral
Gage Script	Hill Air Gage	Nominal	2
Channel Number NON	E	7 Plus Tolerance	0.01
Dimension Source			
Extra Info		Minus Tolerance	-0.01
Extra hilo		Precision	4 7
		Units	Inch
Pass/Fail Properties			
Allow N/A Value	Hee Default Value	Default Value	
	ore bendiat value		13
Advanced		Moneyromoute to	innero (Dofrydt 0)
Calculation] [.		
Clear Value on Send	Gage Prep Com	mand Save Inj	out Buffer for Next Feature
Send this feature to QC-	CALC	Display	this feature in light gray color
Required		Data Tri	gger Required

4. Finished.