LC15Dx
High accuracy with high resolution
New possibilities
without compromise
The LC15Dx is a viable alternative to a tactile probe for an increasing number of high precision CMM applications. Manufacturers gain a better appreciation of the dimensional quality of their products without compromising on cycle times. A wider variety of parts, geometry and materials can be measured more effectively, including many parts too small or fragile for a touch probe.

**BENEFITS**

**Closing the accuracy gap**
Thanks to the latest laser scanner technology the LC15Dx is closing the gap between laser scanner and tactile probe accuracy. In tests comparable to ISO 10360-2 MPE and ISO 10360-5 MPEAL the LC15Dx achieved the accuracy associated with using a CMM and tactile probe. However, unlike a tactile probe, the LC15Dx uses non-contact 3D laser triangulation to measure the surface directly and eliminate probe compensation errors. The uncertainty and delay caused when a laser scanner is used before it has reached operating temperature, has been eliminated by a thermal stabilizer mounted inside the scanner body.

**Versatile scanning without the hassle**
Nikon’s unique ESP3 technology intelligently adapts the laser settings for each measured point in real-time. A wider range and mix of surface materials, finishes, colors and transitions can be measured more efficiently without user interaction, manual tuning and part spraying, including small and fragile parts. Unwanted reflections are neutralised by an advanced software filter while changes in ambient light are absorbed by a high grade daylight filter.

**Better appreciation of product quality**
Global Compare provides a complete 3D visualization of dimensional quality. The entire part is checked to the CAD model and any areas of concern are immediately highlighted using Color Mapping. Further investigation and analysis is possible using fly-outs, sections and a library of Geometric Dimensioning and Tolerancing (GD&T). Inspection reports can be as simple or complex as required with follow-on reports fully automated.
SOFTWARE

Intuitive software for every application
A selection of popular software packages for part-to-CAD and feature inspection are available for the LC15Dx, including FOCUS and CAMIO.

Key features include:

- CAD programming
- Best-fit alignment
- Part to CAD comparison
- Feature inspection
- Blade analysis
- Color reporting
- Multi-sensor CMM
- Offline programming
- Point cloud management
- GD&T library
- Teach & Learn programming
- Full simulation

Intuitive programming and offline simulation reduces preparation time

Blade section analysis combined with full 3D comparison

3D visualization of dimensional quality

**Fully integrated**
Laser signal routed via probe interface

**Status LEDs**
Laser diagnostics and status

**Range finder**
User guide for manual operation

**High quality Nikon lens**
Improves accuracy and data quality

**Eye safe laser**
Class 2 visible light laser

**Feature inspection**
Feature measurement and GD&T library

**Sections and profiles**
2D section and profile analysis

**CAD comparison**
Direct comparison of measured part to CAD

**Best-fit alignment**
Best-Fit alignment of measured part to CAD

**Point cloud management**
Trim and filter point clouds

**CAD export**
Reverse Engineering and data storage

CLOSING THE GAP WITH TACTILE PROBE ACCURACY
Enhance the capability of your current CMM

Retrofitting your current CMM with an LC15Dx is a cost effective solution. The retrofit integrates with the existing CMM controller hardware and compatible probe system to provide a versatile multi-sensor CMM offering both non-contact and touch probe inspection.

LC15Dx retrofit kits are available for the following CMM controller systems.

- Aberlink
- Deva
- Coord3
- Dukin
- LK
- Hexagon DEA
- Hexagon Brown & Sharpe
- Hexagon Sheffield
- Mitutoyo
- Mora
- Renishaw
- Wenzel
- Werth
- Zeiss

Contact Nikon for details on exact versions of the controllers.

Combine laser scanning with a tactile probe

In some cases a single sensor technology is insufficient for measuring all of the features. The LC15Dx can be combined with an optional tactile probe to create a versatile multi-sensor CMM. Depending on the application both technologies can be used independently or together in the same inspection program. Fully automatic sensor changing is possible with the addition of an optional change and storage rack which is mounted on the table of the CMM.

High precision parts and small geometry

The LC15Dx provides significant benefits for a wide variety of high precision parts and geometry, including small details, semi-rigid parts and the more demanding materials:

- Turbine blades
- Medical implants
- Precision moulding
- Eliminate probe tip compensation errors

PROCESS  PRODUCTION - R&D - REVERSE ENGINEERING

METHOD  MACHINED - MOULDED - STAMPED - CAST - FORGED

MATERIAL  METAL - PLASTIC - RUBBER - CLAY - CERAMIC - COMPOSITES

FINISH  MACHINE - POLISHED - PLATED - PAINT - MIXED COLORS

STRUCTURE  RIDGED - SOFT - FLEXIBLE - FRAGILE

FEATURE  SURFACE - GEOMETRIC FEATURE - PROFILE - SECTION
**SPECIFICATIONS**

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
</tr>
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<tbody>
<tr>
<td>Probing error (MPEₚ)¹</td>
<td>1.9 µm (0.000075&quot;)</td>
</tr>
<tr>
<td>Ball bar length (MPEₑ)²</td>
<td>A+4 µm +L/350 mm (A+0.00016 +L/13.78&quot;)</td>
</tr>
<tr>
<td>Multi-stylus test (MPEₐₙ)³</td>
<td>3.9 µm (0.00015&quot;)</td>
</tr>
<tr>
<td>ISO Probing form error ⁴</td>
<td>7 µm (0.00027&quot;)</td>
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<tr>
<td>ISO Probing size error all ⁵</td>
<td>15 µm (0.000591&quot;)</td>
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<tr>
<td>ISO Probing dispersion value ⁶</td>
<td>7.6 µm (0.000299&quot;)</td>
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<tr>
<td>ISO Cone angle ⁷</td>
<td>100°</td>
</tr>
<tr>
<td>Scanning speed (approx.)</td>
<td>70,000 points/sec</td>
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<tr>
<td>Resolution (point spacing)</td>
<td>22 µm (0.00087&quot;)</td>
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<tr>
<td>Points per line (approx.)</td>
<td>900</td>
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<tr>
<td>Measuring temperature range</td>
<td>18-22°C (64.4-71.6° F)</td>
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<tr>
<td>Operating temperature range</td>
<td>10-40°C (50-104° F)</td>
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<tr>
<td>Weight</td>
<td>370 g (0.82 lbs)</td>
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<tr>
<td>Ingress protection</td>
<td>IP30</td>
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<tr>
<td>Laser safety</td>
<td>Class 2</td>
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<tr>
<td>Enhanced Scanner Performance</td>
<td>ESP3</td>
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<tr>
<td>Daylight filter</td>
<td>Yes</td>
</tr>
<tr>
<td>Probe head compatibility</td>
<td>PH10M, PH10MQ, CW43, PHS</td>
</tr>
</tbody>
</table>

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All accuracy specifications valid for a CMM with an accuracy of 2µm + L/350 or better using manufacturer supplied test sphere

¹ Nikon Metrology test comparable to EN/ISO 10360-2 MPEₚ using 1σ sphere fit.
² Nikon Metrology test comparable to EN/ISO 10360-2 MPEₑ where A is equal to the CMM MPEₑ first term value.
³ Nikon Metrology test comparable to EN/ISO 10360-5 MPEₐₙ

Accuracy specifications according ISO 10360-8:2013:

⁴ PₚForm.Sph.1x25:Tr:ODS,MPE : “Maximum probing form error” using 25 representative points in translatory scanning mode
⁵ PₚSize.Sph.All:Tr:ODS,MPE : “Maximum probing size error using All” measured points in translatory scanning mode
⁶ PₚForm.Sph.D95%:Tr:ODS,MPE : “Maximum probing dispersion value” using 95% of the measured points in translatory scanning mode

![Laser Radiation Warning]

Laser radiation should not be directed into the beam or viewed directly with optical instruments.

Class 2 Laser Product

Max output = 4.8 mW & 8.0 µJ

660 & 635nm

IEC 60825-1 Edition 2.0 2007-03

Read instruction manual before use

Complies with 21 CFR 1040.10 and 1040.11, Laser Notice No. 50, dated June 24, 2007

Due to the diverging beam, viewing the laser output with optical instruments (for example, eye loupes, magnifiers, and microscopes) within a distance of 100 mm may pose an eye hazard.
LC15Dx
Closing the gap with touch probe accuracy