

TL160 Digital Autocollimator Data Sheet (22 April 2013)

1.0 Introduction

The TL160 Optical Head is designed for use with the E3 Digital Controller. Together they form a stand alone high performance dual axis digital autocollimator. Outputs are taken from the E3 and include a color touch-screen display, analog outputs for each axis and an RS-232 serial output.

2.0 Manufacturer

Micro-Radian Instruments, 485 W. Horton Road, Bellingham, WA 98226 USA.

3.0 General Specifications

Beam diameter (nominal)	10 mm
Maximum recommended working distance	5,000 mm
Maximum calibrated measuring range (each axis)	± 600 arc-seconds (± 0.17 degrees)
RS-232 serial maximum measurement output rate (user-adjustable)	1000 readings-per-second
Analog maximum measurement output rate (user-adjustable)	4000 readings-per-second
Output resolution	0.01 arc-second
Output units (user-adjustable)	arc-seconds or micro-radians
Accuracy over entire measuring range (% of full scale)	>99.2%
Cross-coupling over entire measuring range (% of full scale)	<0.2%
Light source	red Laser
Power input requirements	90 - 264 VAC, 47 - 63 Hz, 10 Watt
Optical Head Weight	1.7 lbs
Operating temperature (calibrated)	20°C \pm 0.2°C
Operating/Storage temperature (maximum rated)	0°C to +52°C

4.0 Optical Head

The Optical Head is machined from a solid block of 6061 aluminum and black anodized inside and out. The part number and serial number are permanently engraved on the top surface.

5.0 E3 Digital Controller

The E3 Digital Controller has a color touch-screen LCD to display readings and enter operator commands. Displayed information includes Optical Head signal level, temperature, calibrated working distance, serial number, and the last calibration date. The electronics include digital signal processing and a full calibration covering the entire measuring range of the device. The time average of the data and data units are user-adjustable.

6.0 Optical Head Cable

The Optical Head cable is shielded twisted pair with a black PVC jacket that is nominally 6 feet long. The cable can optionally be made a different length and can be made vacuum compatible. Extension cables can also be provided.

7.0 Analog Output Specifications

Analog output measuring range	± 600 arc-seconds
Analog output resolution	0.018 arc-seconds
Analog scale factor (Azimuth and Elevation)	±2.4VDC for ± 600 arc-seconds
D/A converter	16-bit
D/A converter resolution	16 bit per ±2.4VDC
Output sampling rate (samples/second)	4000
Output connectors	BNC
Output load resistor for calibrated output	10 K ohm

8.0 RS-232 Output Specifications

Output rates (readings/second)	0.01, 0.1, 1, 10, 100, 500 (optionally 1000)
Baud Rate	115.2 Kbaud (optionally 230.4 Kbaud)
Output format	ASCII text, comma separated variable

The serial port outputs angle readings, data status, and head temperature in degrees Celsius. Data status is 1 if the angle readings are valid and 0 if invalid.

Output sequence for the 500 and 1000 samples/second settings

signed integer-only AZ data,signed integer-only EI data,status<carriage return>

For example:

+1234,-4321,1<carriage return>

Output sequence for 100, 10, 1, 0.1 and 0.01 samples/second settings

signed AZ data,signed EI data,status,signal level,head temperature<carriage return>

For example:

+1234.567,-7654.321,1,98,21.5<carriage return>

9.0 RS-232 Serial Port commands

9.1 The following commands can be sent via the serial port to the autocollimator. Command letters are case-sensitive and only the command letter should be sent. Sending an additional character such as carriage return or line feed or an undefined character will be interpreted as an E command and will terminate data transmission.

9.2 To request data from the autocollimator, use one of the following three commands:

<u>Command</u>	<u>Result</u>
A	One reply is sent immediately
B	One reply is sent after a delay of one Output Average period
C	Replies are sent continuously at the rate of the Output Average period

9.3 To change any of the user-adjustable settings, use the following commands. The user-adjustable settings in use at the time that the autocollimator is powered down will be the default settings when the autocollimator is next powered up.

<u>Command</u>	<u>Result</u>
E	Stop data transmission
F	Turn off Zero Offset
G	Turn on Zero Offset
H	Set data units to Arc-Seconds
I	Set data units to Micro-Radians
J	Turn off Head Data display
K	Turn on Head Data display
L	Set Display Average to 1 second
M	Set Display Average to 10 seconds
N	Set Display Average to 100 seconds
a	Set to output 500 (optionally 1000) samples/sec (output averaging of 0 second)
b	Set to output 500 (optionally 1000) samples/sec (output averaging of 0.001 second)
c	Set to output 100 samples/sec (output averaging of 0.01 second)
d	Set to output 10 samples/sec (output averaging of 0.1 second)
e	Set to output 1 sample/sec (output averaging of 1 second)
f	Set to output 0.1 sample/sec (output averaging of 10 seconds)
g	Set to output 0.01 sample/sec (output averaging of 100 seconds)

10.0 Modulation and Sampling

The optical head light source is modulated at 4 kHz and the autocollimator samples once per modulation cycle at all times regardless of the user-adjustable settings. This is one sample every 250 microseconds. The modulation source is built-in so no external modulation source is required.

For the digital output, the time period average (moving average) of this over sampled data is user adjustable. For example, the 1 sample/sec setting gives the moving average of the last 1 second of data with a delay of 250 microseconds. The maximum data rate from the serial port output is 500 (optionally 1000) samples/sec with a 250 microsecond delay.

The analog output is updated once per modulation cycle for output averaging settings of 0, 0.001, 0.01, and 0.1 second. For settings of 1, 10, or 100 seconds, the output is updated every 0.1 seconds.

The display is updated twice per second with user adjustable averaging settings of 1, 10, or 100 seconds. For example, if the display is set to 10 second averaging, the running average over the last 10 seconds is calculated and displayed every 500 milliseconds.

11.0 Calibration

The autocollimator uses DSP processing and all output data is fully calibrated. Errors in the detector are corrected using a 33x33 point look up table. The table is generated by comparing the autocollimator output to an angle standard calibrated by the Swiss Federal Institute of Metrology (METAS) in Wabern, Switzerland. Once the autocollimator is programmed with the look up table, verification scans are performed to confirm that the corrected outputs match the standard. Verification data and a certificate of traceability to METAS are included with the autocollimator.

The calibration is performed at $20^{\circ}\text{C} \pm 0.2^{\circ}\text{C}$ and with a 50mm, >98% reflective mirror. The mirror is flat to 1/10 wave. All calibration measurements are taken with the autocollimator in its 1 sample/sec setting.

12.0 Outline and Mounting (inches)

