

Novel calibration technique for hybrid structured-light three-dimensional measurement system

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Abstract. Hybrid structured-light measurement technique is used for form measurement of structured composite surfaces. A hybrid structured-light measurement system contains a phase measuring deflectometry (PMD) subsystem and a fringe projection profilometry (FPP) subsystem. Each subsystem measures specular surfaces and rough surfaces based on structured-light reflection and projection principle, respectively. Calibration's accuracy extremely effects data stitching precision between the subsystems. A novel calibration technique is explored for the hybrid structured-light system to complete reliable measurement accuracy. Calibration algorithms are developed based on designed calibration targets. Information of the calibration procedure are discussed and presented. Effectiveness of the proposed calibration technique has been conducted and verified through experiments by measuring structured composite samples. Experimental results demonstrate that the proposed technique can significantly improve data fusion accuracy of a hybrid structured-light measurement system.

1 Introduction

In-line surface measurement is an important section but still a challenge for precision and ultra-precision machining. Current widely used surface metrology techniques, such as coordinate measuring machine and stylus profilometer are hardly applied in in-line metrology due to their disadvantages of low measurement speed and large volume. By contrast, structured-light metrology techniques, such as fringe projection profilometry (FPP) [1-3] and phase measuring deflectometry (PMD) [4-6] have obvious benefits in fast speed, simple system configuration, and light weight. They are hot-topics in in-line surface form measurements but still have limited measurement ability affected by the reflective properties of the tested surfaces' materials. FPP reconstructs a measured surface's form data based on the scattered structured-light patterns on the surface. Therefore, it can only measure rough surfaces. PMD measures based on structured-light reflection and is only good at measuring specular surfaces.

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Hybrid structured-light technique [7-8] has been studied to increase the measurement ability of structured-light technique, which combining the advantages of FPP and PMD. FPP subsystem and PMD subsystem work independently. The reconstruction data from the subsystems can be fused together to generate a completed form of the measured surfaces. Thus, hybrid structured-light technique has obvious advantage in measuring more wider range of surfaces with different reflective characteristics. An accurate data fusion between the subsystems is essential to achieve high measurement accuracy of the hybrid structured-light technique. Martin et al. studied a method to calibrate the subsystems based on a special designed target for a good data fusion [9]. The designed target consists of several specular surfaces and rough surfaces and is difficult to be manufactured. In order to increase data fusion accuracy of the subsystems of hybrid structured-light technique, a flexible calibration technique is investigated based on calibration targets that can be easily manufactured. Details of the calibration algorithms and strategy are also presented.

2 Principle and method

2.1 Measurement principle and system

Figure 1 presents an illustration of a stereo-camera hybrid structured-light metrology system [9]. The system contains two cameras, a projector and a screen. The cameras and the screen form a stereo PMD system, which measures reflective surfaces. Vertical and horizontal phase measuring profilometry (PMP) patterns are generated by a computer, displayed on the screen, and captured by the cameras through the reflection of the measured surfaces. The measured surfaces' form data can be calculated based on the captured fringe patterns. One of the cameras and the projector generate a FPP system, which can measure the form of rough surfaces. PMP patterns generated by the computer are projected by the projector on the measured surface and captured by the camera. FPP reconstructs the 3D data of the measured surfaces based on the captured structured-light patterns. The reconstructed 3D data of PMD and FPP are fused to generate the final output.

In our proposed hybrid structured-light metrology system [9], a plate beam splitter (BS) is applied to fold the optical beam paths to decrease the system volume. Figure 2 illustrates an equivalent configuration of the system.

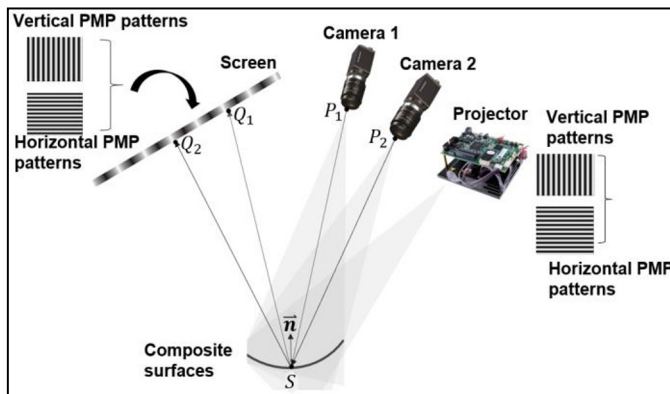


Fig. 1. Illustration of the principle of the hybrid structured-light metrology technique.

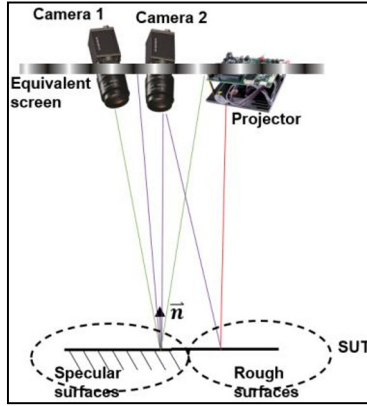


Fig. 2. Illustration of configuration of a hybrid structured-light metrology system.

2.2 Calibration method

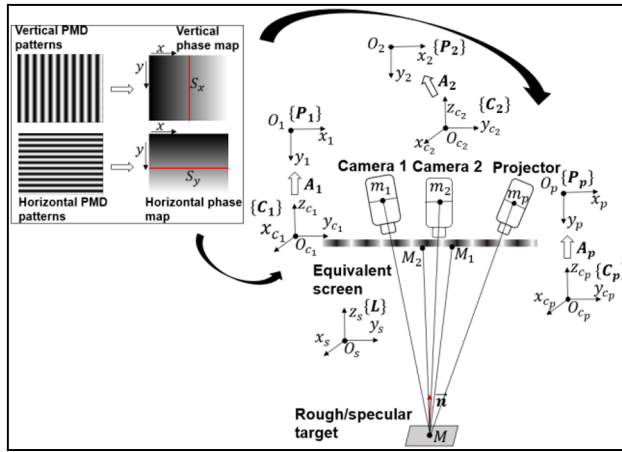


Fig. 3. Illustration of the calibration of a hybrid structured-light metrology system.

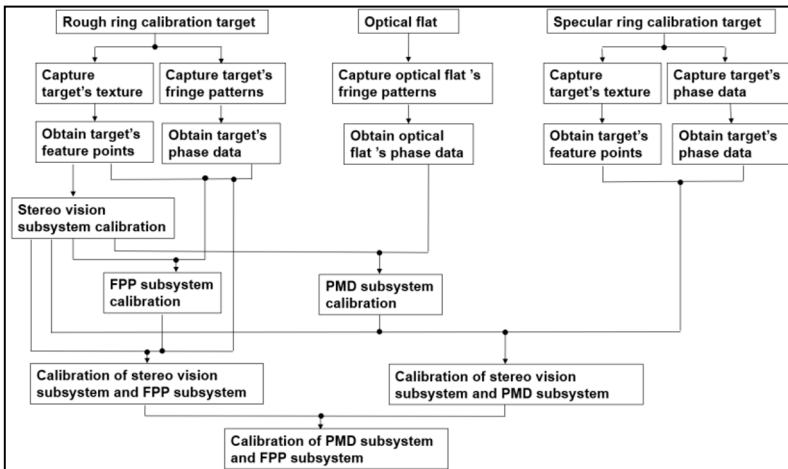


Fig. 4. Diagram of the proposed hybrid structured-light metrology system calibration technique

Calibration is an essential process to obtain the imaging parameters of the hybrid structured-light metrology system for the surfaces' form reconstruction. This process also plays an important role in the data fusion between FPP subsystem and PMD subsystem. Figure 3 illustrates the purpose of the calibration process, which is to calculate the imaging parameters of the cameras (denoted as \mathbf{A}_1 and \mathbf{A}_2 , respectively), the relationship between the cameras (using $\{\mathbf{C}_1\}$ and $\{\mathbf{C}_2\}$ to express the Camera 1 coordinate system and the Camera 2 coordinate system, respectively), the projector's imaging parameter (denoted as \mathbf{A}_p), the relationship between $\{\mathbf{C}_2\}$ and the projector coordinate system (expressed with $\{\mathbf{C}_p\}$), and the relationships between equivalent screen coordinate system (denoted as $\{\mathbf{L}\}$), $\{\mathbf{C}_1\}$, and $\{\mathbf{C}_2\}$. Figure 4 illustrates the strategy of the proposed calibration technique. A rough ring calibration target is placed at several arbitrary positions during the calibration process. The centre of the rings on target can be extracted through imaging processing. The ring centres are used as feature points to obtain \mathbf{A}_1 , \mathbf{A}_2 , and the relationship between $\{\mathbf{C}_1\}$ and $\{\mathbf{C}_2\}$, based on pin-hole model [10]. \mathbf{A}_p and the relationship between $\{\mathbf{C}_2\}$ and $\{\mathbf{C}_p\}$ can be obtained by projecting fringe patterns on the rough ring target [11]. The relationships between $\{\mathbf{L}\}$, $\{\mathbf{C}_1\}$, and $\{\mathbf{C}_2\}$ can be calibrated based on the previous method [12] by using an optical flat. The ring centres of the rough calibration target can be reconstructed with two ways. One is the stereo cameras based on stereo vision algorithm [10]. Another is to calculate the 3D positions of the ring centres by using FPP. Using \mathbf{F} to denote as the reconstructed 3D position of the ring centres by FPP, \mathbf{S} express the corresponding reconstructed data by the stereo cameras. The relationship between the stereo vision system and the FPP system can be calculated based on Eq. (1).

$$\mathbf{S} = \mathbf{R}_{F,S} \mathbf{F} + \mathbf{T}_{F,S} \quad (1)$$

where $\mathbf{R}_{F,S}$ and $\mathbf{T}_{F,S}$ present the transformation relationship from the FPP system to the stereo vision system. A specular ring calibration target is used to obtain the relationship between stereo vision subsystem and PMD subsystem. A specular ring calibration target is applied to obtain the relationship between the stereo cameras system and the PMD system. The ring centres on the specular target can be reconstructed by the stereo cameras system and the PMD system, respectively. Denoting \mathbf{S} as the reconstructed 3D data by the stereo cameras and \mathbf{P} as the reconstructed data by the PMD, respectively. The relationship between the stereo cameras system and the PMD system can be obtained according to Eq. (2).

$$\mathbf{P} = \mathbf{R}_{S,P} \mathbf{S} + \mathbf{T}_{S,P} \quad (2)$$

where $\mathbf{R}_{S,P}$ and $\mathbf{T}_{S,P}$ are the transformation relationship from the stereo cameras system to the PMD system. Equation (3) can be used to conduct the relationship between the FPP system and the PMD system.

$$\begin{cases} \mathbf{R}_{F,P} = \mathbf{R}_{S,P} \mathbf{R}_{F,S} \\ \mathbf{T}_{F,P} = \mathbf{R}_{S,P} \mathbf{T}_{F,S} + \mathbf{T}_{S,P} \end{cases} \quad (3)$$

where $\mathbf{R}_{F,P}$ and $\mathbf{T}_{F,P}$ represent the transformation from the FPP system to the PMD system. The reconstructed data from the FPP system and the PMD system can be fused accurately based on $\mathbf{R}_{F,P}$ and $\mathbf{T}_{F,P}$.

3 Experiment and results

A hybrid structured-light metrology prototype has been developed and calibrated with the proposed technique. Calibration results of the optical parameters of the stereo cameras system is illustrated in Fig. 5. Calibration error of the Camera 1 and the Camera 2 in stereo cameras system are demonstrated in Fig. 5(a) and 5(b), respectively. The calibration error of the stereo cameras system is within ± 1 pixel. Figure 6 illustrates calibration results of the PMD system. Fig. 6(a) and 6(b) demonstrate the calibration error of the Camera 1 and the Camera 2 in PMD system, respectively. The calibration error of the PMD system is within ± 5 pixels.

Calibration results of the FPP system is shown in Fig. 7. Reprojection error of the Camera 1 and the Camera 2 in FPP system are illustrated in Fig. 7(a) and 7(b), respectively. The calibration error of the FPP system is within ± 1 pixel. A structured composite workpiece has been measured by the hybrid structured-light metrology system calibrated by the proposed calibration technique. Figure 8(a) shows the picture of the measured workpiece. The reconstruction data of the workpiece is illustrated in Fig. 8(b). The RMS of the reconstruction error of the rough surface and the specular surface are $24.8 \mu\text{m}$ and $0.4 \mu\text{m}$, respectively.

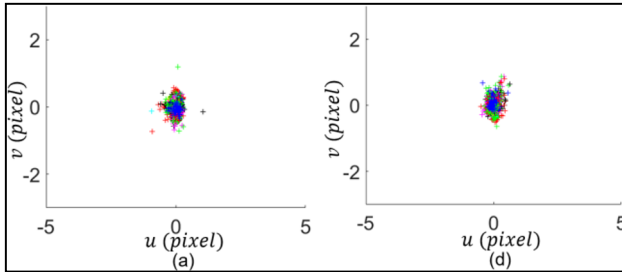


Fig. 5. Calibration results of the optical parameters in the stereo cameras system. (a) Reprojection error of the Camera 1 in stereo vision system; (b) Reprojection error of the Camera 2 in stereo vision system

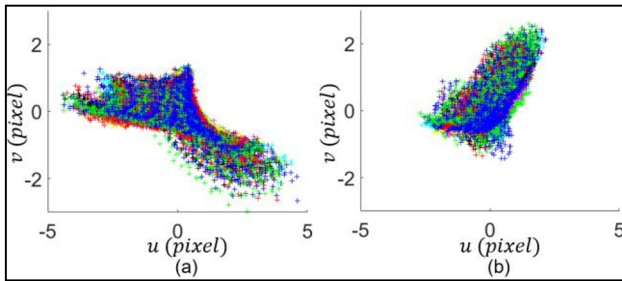


Fig. 6. Calibration results of the optical parameters in the PMD system. (a) Reprojection error of the Camera 1 in PMD system; (b) Reprojection error of the Camera 2 in PMD system

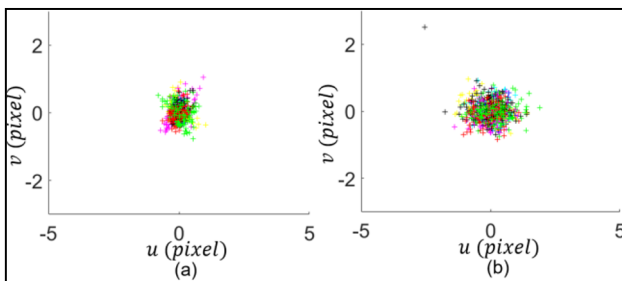


Fig. 7. Calibration results of the optical parameters in the FPP system. (a) Reprojection error of the Camera 1 in FPP system; (b) Reprojection error of the Camera 2 in FPP system

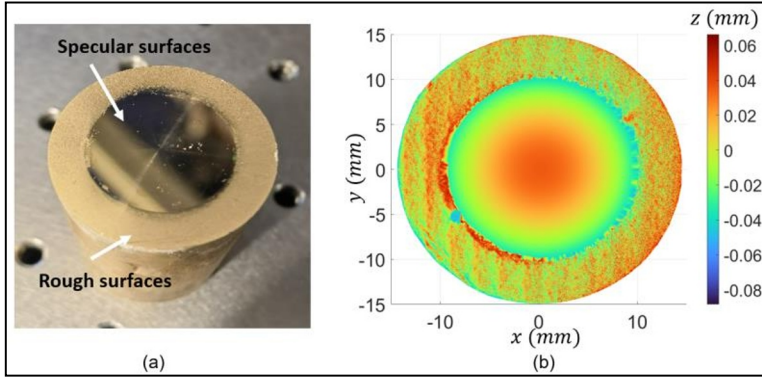


Fig. 8. Measurement result of the structured composite workpiece. (a) A picture of the measured workpiece (b) the reconstruction data after data fusion of the subsystems

4 Conclusion

A calibration technique has been explored for hybrid structured-light system. Calibration targets, calibration algorithm, and strategy are described and discussed in this paper. The proposed calibration technique is easily conducted and has good calibration accuracy. More experiments will be conducted to test the calibration technique in the next step.

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