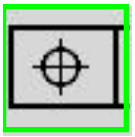
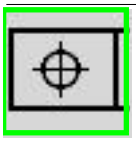
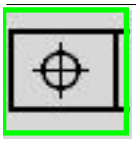
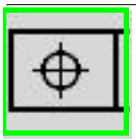
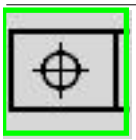
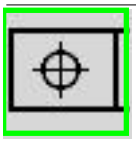
ZEISS Calypso

Methods Machine Tools Inc

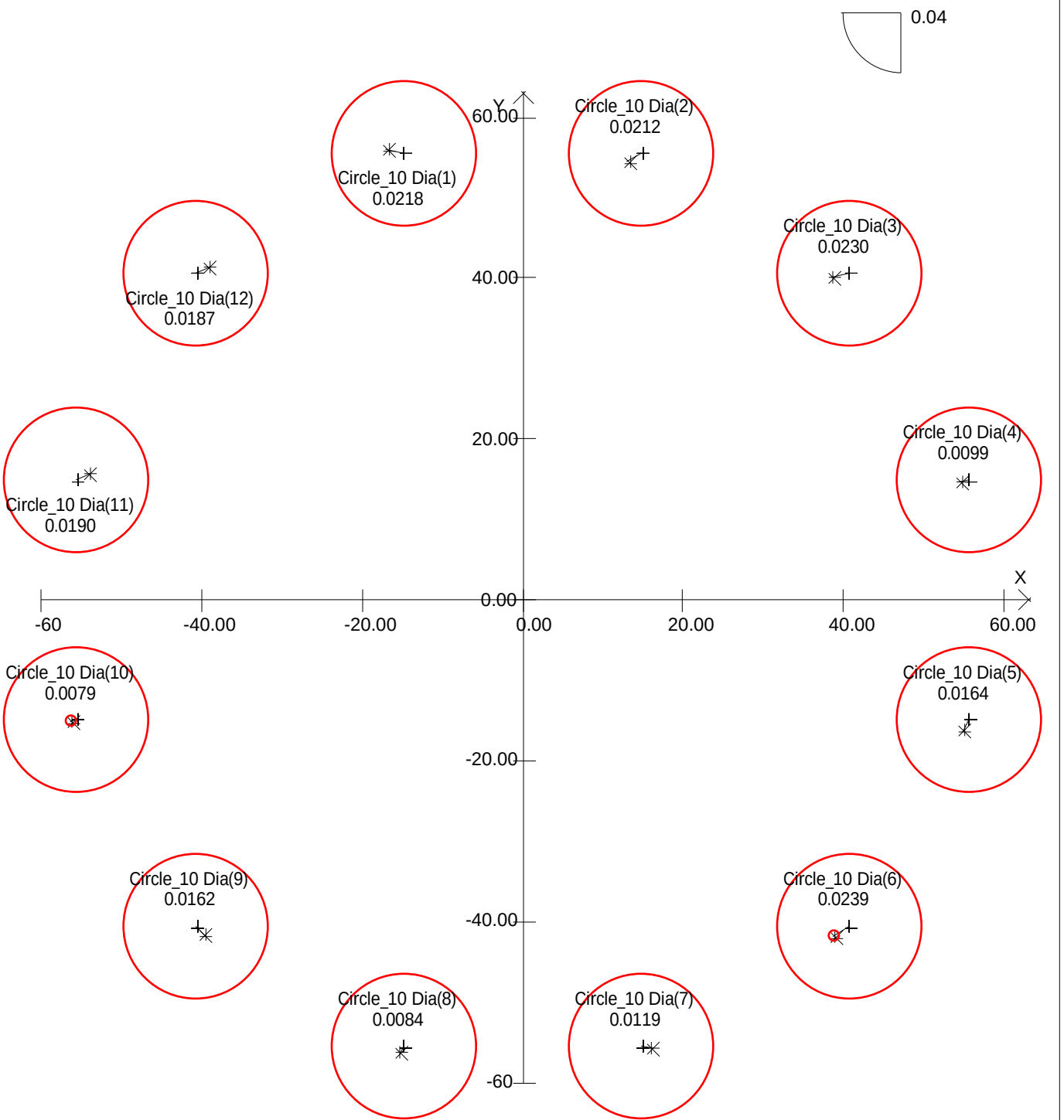
Measurement Plan BF Pattern Example	Date March 8, 2015	Order
Drawing No.	Time 6:11:32 am	Incremental Part Number 1

	Actual	Nominal	Upper Tol.	Lower Tol.	Deviation
Overall Result					
All Characteristics:	12				
...in Tolerance:		12			
...Out of tolerance:		0			
...Over Warning Limit:		0			
...Not Calculated:		0			
Total Coord. systems:		0			
...Not Calculated:		0			
Total Text elements:		0			
True Position to B^1(1)					|-
	0.0218	0.0000	0.1000		0.0218
R	57.5048	57.5000			0.0048
Angle	105.0098	105.0000			0.0098
True Position to B^1(2)					|-
	0.0212	0.0000	0.1000		0.0212
R	57.4919	57.5000			-0.0081
Angle	75.0068	75.0000			0.0068
True Position to B^1(3)					|-
	0.0230	0.0000	0.1000		0.0230
R	57.4901	57.5000			-0.0099
Angle	45.0058	45.0000			0.0058
True Position to B^1(4)					|-
	0.0099	0.0000	0.1000		0.0099
R	57.4951	57.5000			-0.0049
Angle	15.0001	15.0000			0.0001
True Position to B^1(5)					|-
	0.0164	0.0000	0.1000		0.0164
R	57.4989	57.5000			-0.0011
Angle	-15.0081	-15.0000			-0.0081
True Position to B^1(6)					|-
	0.0239	0.0000	0.1000		0.0239
R	57.4979	57.5000			-0.0021
Angle	-45.0117	-45.0000			-0.0117

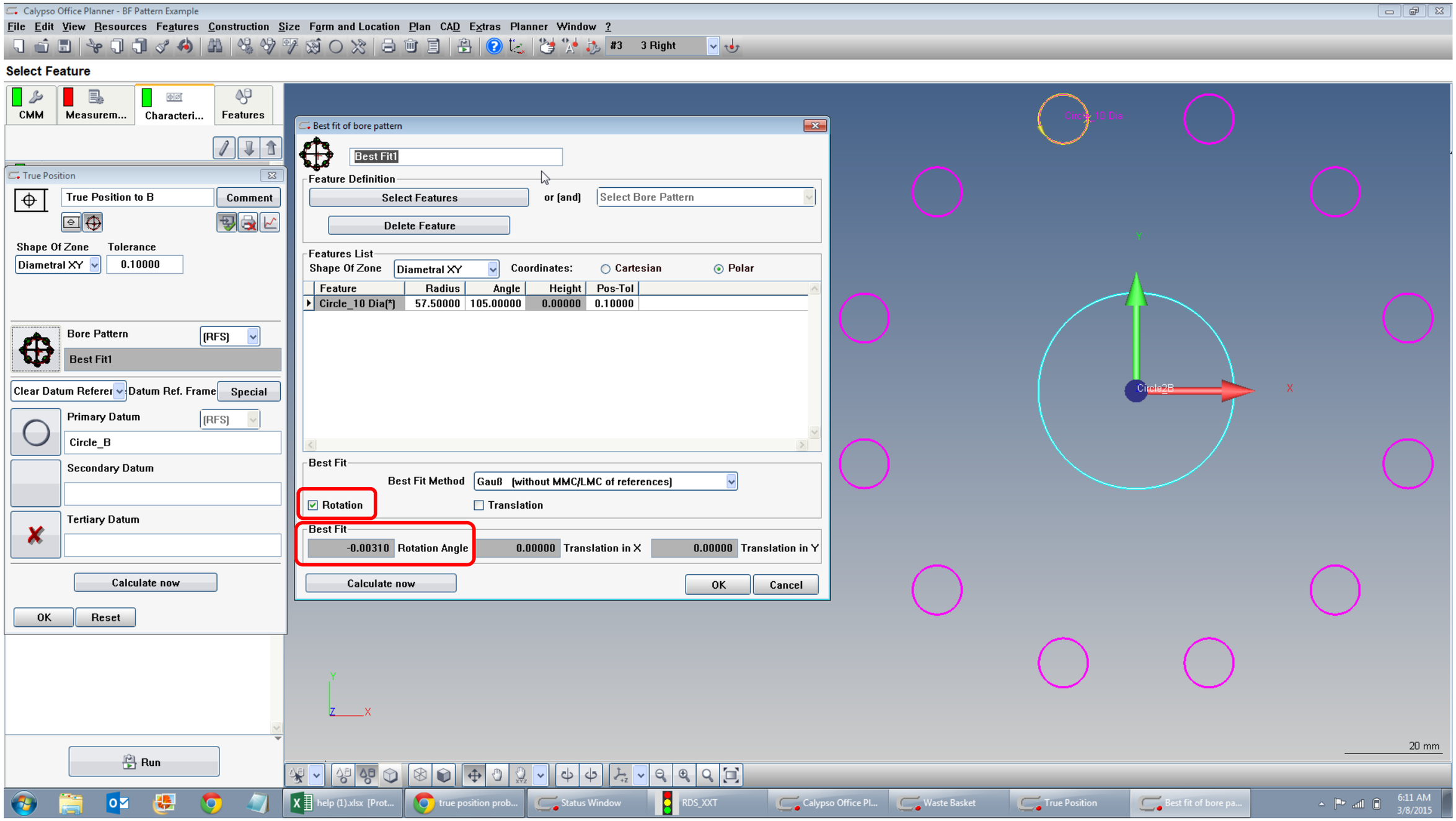
Plan Name	Operator	Time	Date
BF Pattern Example	Master	6:11:32 am	March 8, 2015

	Actual	Nominal	Upper Tol.	Lower Tol.	Deviation
	True Position to B^1(7)				|-
	0.0119	0.0000	0.1000		0.0119
	R 57.5026	57.5000			0.0026
	Angle -74.9946	-75.0000			0.0054
	True Position to B^1(8)				|-
	0.0084	0.0000	0.1000		0.0084
	R 57.5039	57.5000			0.0039
	Angle -105.0014	-105.0000			-0.0014
	True Position to B^1(9)				|-
	0.0162	0.0000	0.1000		0.0162
	R 57.5004	57.5000			0.0004
	Angle -134.9920	-135.0000			0.0080
	True Position to B^1(10)				|-
	0.0079	0.0000	0.1000		0.0079
	R 57.5038	57.5000			0.0038
	Angle -164.9991	-165.0000			0.0009
	True Position to B^1(11)				|-
	0.0190	0.0000	0.1000		0.0190
	R 57.4934	57.5000			-0.0066
	Angle 164.9932	165.0000			-0.0068
	True Position to B^1(12)				|-
	0.0187	0.0000	0.1000		0.0187
	R 57.4970	57.5000			-0.0030
	Angle 134.9912	135.0000			-0.0088

ZEISS Calypso 5.6.16	Carl Zeiss		Date March 8, 2015 Order
Part Number 1	CMM CONT_G2	Drawing No.	Department: Operator Master Signature:
Measurement Plan BF Pattern Example			True Position to B



Best Fit1 LSQ 2d Best Fit	X Y Angle	0.0000 0.0000 -0.0031	Magnification	250.0


Calypso Office Planner - BF Pattern Example
File Edit View Resources Features Construction Size Form and Location Plan CAD Extras Planner Window ?
#3 3 Right
Select Feature
CMM
Measurem...
Characteri...
Features
True Position
True Position to B
Comment
Shape Of Zone
Tolerance
Diametral XY
0.10000
Bore Pattern
(RFS)
Best Fit1
Clear Datum Referer
Datum Ref. Frame
Special
Primary Datum
(RFS)
Circle_B
Secondary Datum
Tertiary Datum
Calculate now
OK
Reset
Run
Best fit of bore pattern
Best Fit1
Feature Definition
Select Features
or (and)
Select Bore Pattern
Delete Feature
Features List
Shape Of Zone
Diametral XY
Coordinates:
Cartesian
Polar
Feature
Radius
Angle
Height
Pos-Tol
Circle_10 Dia(*)
57.50000
105.00000
0.00000
0.10000
Best Fit
Best Fit Method
Gauß (without MMC/LMC of references)
Rotation
Translation
Best Fit
-0.00310
Rotation Angle
0.00000
Translation in X
0.00000
Translation in Y
Calculate now
OK
Cancel
Circle_10 Dia
Circle2B
20 mm
help (1).xlsx [Prot...
true position prob...
Status Window
RDS_XXT
Calypso Office Pl...
Waste Basket
True Position
Best fit of bore pa...
6:11 AM
3/8/2015