ZEISS CALYPSO
7.2

Part name	**TextElement**		
Drawing number			
Order number		Last 1 measurements	
Variant		► Approval ≠ Gesperrt	
Company	CZ IMT GmbH	Part ident	25
Department	QS	Time/Date	6/30/2021 3:32 PM
CMM Type	Prismo	Run	All Characteristics
CMM No.	000000	No. measured values	32
Operator	Master	No. values: red ●	0
Text		Measurement Duration	00:00:01.0

Name	Measured value	Nominal value	+Tol	-Tol	Deviation	+/-
		Feature	Form	Sigma	Min	Max

1. BorePattern
Lochbild

Textelement X-Values
X-Werte

Name	Measured value	Nominal value	+Tol	-Tol	Deviation	
X X_Circle-1(1)	25.0007	25.0000	0.1000	-0.1000	0.0007 ●	
Index = 1		Circle-1(1)	0.0285	0.0075	-0.0163	0.0123
X X_Circle-1(2)	12.5001	12.5000	0.1000	-0.1000	0.0001 ●	
Index = 2		Circle-1(2)	0.0293	0.0094	-0.0151	0.0142
X X_Circle-1(3)	-12.4967	-12.5000	0.1000	-0.1000	0.0033 ●	
Index = 3		Circle-1(3)	0.0318	0.0086	-0.0166	0.0152
X X_Circle-1(4)	-24.9990	-25.0000	0.1000	-0.1000	0.0010 ●	
Index = 4		Circle-1(4)	0.0298	0.0085	-0.0150	0.0148
X X_Circle-1(5)	-12.5044	-12.5000	0.1000	-0.1000	-0.0044 ●	
Index = 5		Circle-1(5)	0.0303	0.0077	-0.0154	0.0149
X X_Circle-1(6)	12.5031	12.5000	0.1000	-0.1000	0.0031 ●	
Index = 6		Circle-1(6)	0.0333	0.0098	-0.0164	0.0168

Textelement Y-Values
Y-Werte

Name	Measured value	Nominal value	+Tol	-Tol	Deviation	
Y Y_Circle-1(1)	-0.0001	0.0000	0.0500	-0.0500	-0.0001 ●	
		Circle-1(1)	0.0285	0.0075	-0.0163	0.0123
Y Y_Circle-1(2)	21.6499	21.6506	0.1000	-0.1000	-0.0008 ●	
		Circle-1(2)	0.0293	0.0094	-0.0151	0.0142
Y Y_Circle-1(3)	21.6489	21.6506	0.1000	-0.1000	-0.0018 ●	
		Circle-1(3)	0.0318	0.0086	-0.0166	0.0152
Y Y_Circle-1(4)	-0.0002	0.0000	0.0500	-0.0500	-0.0002 ●	
		Circle-1(4)	0.0298	0.0085	-0.0150	0.0148
Y Y_Circle-1(5)	-21.6498	-21.6506	0.1000	-0.1000	0.0008 ●	
		Circle-1(5)	0.0303	0.0077	-0.0154	0.0149
Y Y_Circle-1(6)	-21.6488	-21.6506	0.1000	-0.1000	0.0019 ●	
		Circle-1(6)	0.0333	0.0098	-0.0164	0.0168

Textelement Diameter-Values
Durchmesser-Werte

Name	Measured value	Nominal value	+Tol	-Tol	Deviation	
Ø Dia_Circle-1(1)	12.0036	12.0000	0.1000	-0.1000	0.0036 ●	
		Circle-1(1)	0.0285	0.0075	-0.0163	0.0123
Ø Dia_Circle-1(2)	12.0006	12.0000	0.1000	-0.1000	0.0006 ●	
		Circle-1(2)	0.0293	0.0094	-0.0151	0.0142
Ø Dia_Circle-1(3)	12.0006	12.0000	0.1000	-0.1000	0.0006 ●	
		Circle-1(3)	0.0318	0.0086	-0.0166	0.0152
Ø Dia_Circle-1(4)	12.0012	12.0000	0.1000	-0.1000	0.0012 ●	
		Circle-1(4)	0.0298	0.0085	-0.0150	0.0148
Ø Dia_Circle-1(5)	11.9971	12.0000	0.1000	-0.1000	-0.0029 ●	
		Circle-1(5)	0.0303	0.0077	-0.0154	0.0149
Ø Dia_Circle-1(6)	12.0013	12.0000	0.1000	-0.1000	0.0013 ●	
		Circle-1(6)	0.0333	0.0098	-0.0164	0.0168

(7.8_01b) StandardProtocol_720

Name	Measured value	Nominal value	+Tol	-Tol	Deviation	+/-
		Feature	Form	Sigma	Min	Max

2. PitchCircle
Lochkreis

Textelement Coordinates
    Koordinaten

Name	Measured value	Nominal value	+Tol	-Tol	Deviation	+/-
X X_Circle-2	0.0007	0.0000	0.0500	-0.0500	0.0007 🟢	
		Circle-2	0.0023	0.0012	-0.0013	0.0010
Y Y_Circle-2	-0.0015	0.0000	0.0500	-0.0500	-0.0015 🟢	
		Circle-2	0.0023	0.0012	-0.0013	0.0010

Textelement Diameter
    Durchmesser

Name	Measured value	Nominal value	+Tol	-Tol	Deviation	+/-
⌀ Dia_Circle-2	49.9991	50.0000	0.1500	-0.1500	-0.0009 🟢	
		Circle-2	0.0023	0.0012	-0.0013	0.0010

Textelement Roundness
    Rundheit

Name	Measured value	Nominal value	+Tol	-Tol	Deviation	+/-
◯ Round_Circle-2	0.0021	0.0000	0.0100	0.0000	0.0021 🟢	
		Circle-2	0.0021	0.0013	-0.0010	0.0010

Points	6
Filter type	No Filter
Lc	
W/upr	
Vmess[mm/sec]	
Probe radius	0.0000
Evaluation method	Minimum Feature
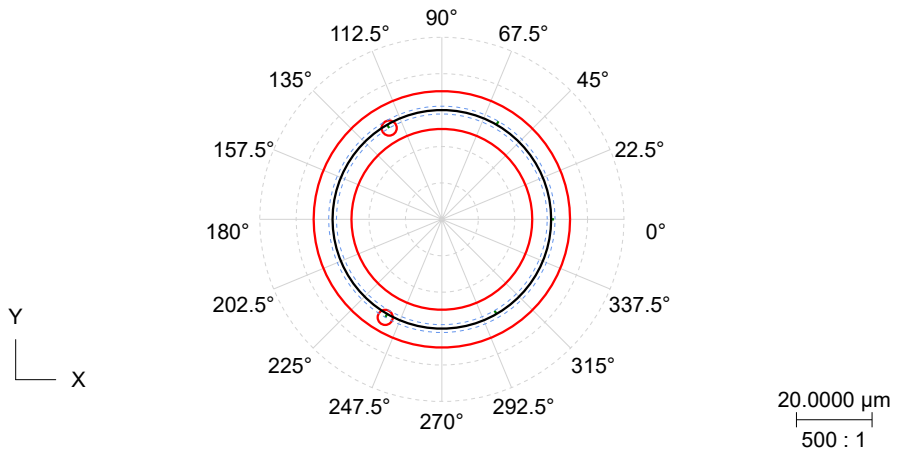
20.0000 µm
500 : 1

3. Special Diameter Circle-1
Min - Max - Delta

Textelement Natural Limit Resultelement
    Natürliche Grenze Resultats-Element

Name	Measured value	Nominal value	+Tol	-Tol	Deviation	+/-
MAX Dmax_Circle-1	12.0036	12.0000	0.1000	-0.1000	0.0036 🟢	
		Dia_Circle-1(1)				
MIN Dmin_Circle-1	11.9971	12.0000	0.1000	-0.1000	-0.0029 🟢	
		Dia_Circle-1(5)				
👤 Ddelta_Circle-1	0.0065	0.0000	0.0100	0.0000	0.0065 🟠	

Remark	Event
	–
	n.def.