PiWeb Reporting Plus

Last 1 measurements
► Approval ≠ Blocked
No. measured values 86

Date 3/5/2019 3:41 PM
Run-Time 00:00:00.0
No. values: red 19

Program	**ProgramName**				
Drawing-No	Drawing-No & Revision	MiniPlan	*All Characteristics*		
Order-No	4431227	Mach-No	123456	Plant	CZ IMT GmbH
Type	Worm	CMM-No	000000	Deprmt	SES-AP
Process	*Grinding*			CostCenter	*420*
Part-No	Test-35	Gauge-No	*Lehre-123*	Operator	Master
				Shift	Shift-2

DMC
Text Test Comment

Name / Comment	M-Klasse	P-Klasse	Act / Feature	NOM / Form	UpTol / Sigma	LowTol / Min	Dev / Max	Exc / Pt	Tolerance / Filter
0 Temperature									
Temperature			21.5695	21.5000			0.0695		
1-1 Evaluation Thread total									
StartThread_27,0			26.9987	27.0000	0.1000	-0.1000	-0.0013		
			Pt_27mm	0.0000					
m1Dia			45.9332	45.9600	0.0000	-0.0300	-0.0268		
Cylinderform_aL			0.0017	0.0000	0.0080	0.0000	0.0017		
			ThreadCylinder	0.0017	0.0004	-0.0008	0.0008	13215	Low-pass Spline 50
Lead_360			-10.9993	-11.0000	0.0150	-0.0150	0.0007		
RadialTotal_Form			0.0031	0.0000	0.0080	0.0000	0.0031		
			RRadial	0.0031		-0.0009	0.0022		
Vg			0.0045	0.0000	0.0080	0.0000	0.0045		
Natürliche Grenze "0" durch Position			Pt_Vg	0.0000					
Vg_min			0.0019	0.0000	0.0040	0.0000	0.0019		
Ist "positiv" durch Position			Pt_Vg_min	0.0000					
Vg_max			0.0026	0.0000	0.0040	0.0000	0.0026		
Über Position			Pt_Vg_max	0.0000					
Coax_Thread_Datum_A-B			0.0063	0.0000	0.0300	0.0000	0.0063		
			ThreadCylinder	0.0022	0.0004	-0.0008	0.0014		
1-2 Over Ball Diameter per revolution									
m1Dia_1			45.9336	45.9600	0.0000	-0.0300	-0.0264		
m1Dia_2			45.9335	45.9600	0.0000	-0.0300	-0.0265		
m1Dia_3			45.9329	45.9600	0.0000	-0.0300	-0.0271		
m1Dia_4			45.9334	45.9600	0.0000	-0.0300	-0.0266		
m1Dia_5			45.9326	45.9600	0.0000	-0.0300	-0.0274		
m1Dia_6			45.9332	45.9600	0.0000	-0.0300	-0.0268		
m1Dia_7			45.9338	45.9600	0.0000	-0.0300	-0.0262		
1-3 Roundness OBD per revolution									
Spline-Tiefpass 150 W/U									
m1Round_1			0.0019	0.0000	0.0050	0.0000	0.0019		
			Circle_FFT_1	0.0019	0.0004	-0.0010	0.0010	1851	Low-pass Spline 150
m1Round_2			0.0020	0.0000	0.0050	0.0000	0.0020		
			Circle_FFT_2	0.0020	0.0004	-0.0010	0.0010	1842	Low-pass Spline 150
m1Round_3			0.0021	0.0000	0.0050	0.0000	0.0021		
			Circle_FFT_3	0.0021	0.0004	-0.0010	0.0010	1813	Low-pass Spline 150
m1Round_4			0.0019	0.0000	0.0050	0.0000	0.0019		
			Circle_FFT_4	0.0019	0.0004	-0.0010	0.0010	1844	Low-pass Spline 150
m1Round_5			0.0017	0.0000	0.0050	0.0000	0.0017		
			Circle_FFT_5	0.0017	0.0003	-0.0009	0.0009	1850	Low-pass Spline 150
m1Round_6			0.0017	0.0000	0.0050	0.0000	0.0017		
			Circle_FFT_6	0.0017	0.0004	-0.0009	0.0009	1846	Low-pass Spline 150

Name / Comment	M-Klasse	P-Klasse	Act / Feature	NOM / Form	UpTol / Sigma	LowTol / Min	Dev / Max	Exc / Pt	Tolerance / Filter
m1Round_7			0.0017	0.0000	0.0050	0.0000	0.0017		
			Circle_FFT_7	0.0017	0.0003	-0.0008	0.0008	1851	Low-pass Spline 150
2-1 Lead per revolution									
Gauss-Tiefpass 2.448 Lambda [mm]									
Lead_1			-11.0010	-11.0000	0.0050	-0.0050	-0.0010		
			RLead_1	0.0024		-0.0013	0.0011	361	Low-pass Gauss 2.447
Lead_2			-11.0004	-11.0000	0.0050	-0.0050	-0.0004		
			RLead_2	0.0028		-0.0016	0.0012	361	Low-pass Gauss 2.447
Lead_3			-10.9995	-11.0000	0.0050	-0.0050	0.0005		
			RLead_3	0.0021		-0.0012	0.0008	361	Low-pass Gauss 2.447
Lead_4			-11.0000	-11.0000	0.0050	-0.0050	0.0000		
			RLead_4	0.0031		-0.0014	0.0017	361	Low-pass Gauss 2.447
Lead_5			-10.9992	-11.0000	0.0050	-0.0050	0.0008		
			RLead_5	0.0027		-0.0013	0.0013	361	Low-pass Gauss 2.447
Lead_6			-10.9990	-11.0000	0.0050	-0.0050	0.0010		
			RLead_6	0.0021		-0.0011	0.0010	361	Low-pass Gauss 2.447
Lead_7			-10.9988	-11.0000	0.0050	-0.0050	0.0012		
			RLead_7	0.0024		-0.0015	0.0009	361	Low-pass Gauss 2.447
2-3 Thread Radial per revolution									
Gauss-Tiefpass 2.448 Lambda [mm]									
Radial_Form_1			0.0028	0.0000	0.0050	0.0000	0.0028		
Tiefpass Lc = 2.448			RRadial_1	0.0028		-0.0008	0.0021		
Radial_Form_2			0.0018	0.0000	0.0050	0.0000	0.0018		
Tiefpass Lc = 2.448			RRadial_2	0.0018		-0.0007	0.0011		
Radial_Form_3			0.0020	0.0000	0.0050	0.0000	0.0020		
Tiefpass Lc = 2.448			RRadial_3	0.0020		-0.0005	0.0015		
Radial_Form_4			0.0028	0.0000	0.0050	0.0000	0.0028		
Tiefpass Lc = 2.448			RRadial_1	0.0028		-0.0008	0.0021		
Radial_Form_5			0.0013	0.0000	0.0050	0.0000	0.0013		
Tiefpass Lc = 2.448			RRadial_5	0.0013		-0.0005	0.0008		
Radial_Form_6			0.0016	0.0000	0.0050	0.0000	0.0016		
Tiefpass Lc = 2.448			RRadial_6	0.0016		-0.0007	0.0009		
Radial_Form_7			0.0012	0.0000	0.0050	0.0000	0.0012		
Tiefpass Lc = 2.448			RRadial_7	0.0012		-0.0004	0.0008		
2-4 Variation V2pi									
Gauss-Tiefpass 2.448 Lambda [mm]									
V2pi_1			0.0027	0.0000	0.0160	0.0000	0.0027		
V2pi_min_1			-0.0014	0.0000	0.0000	-0.0050	-0.0014		
V2pi_max_1			0.0012	0.0000	0.0050	0.0000	0.0012		
V2pi_2			0.0027	0.0000	0.0160	0.0000	0.0027		
V2pi_min_2			-0.0015	0.0000	0.0000	-0.0050	-0.0015		
V2pi_max_2			0.0011	0.0000	0.0050	0.0000	0.0011		
V2pi_3			0.0021	0.0000	0.0160	0.0000	0.0021		
V2pi_min_3			-0.0012	0.0000	0.0000	-0.0050	-0.0012		
V2pi_max_3			0.0009	0.0000	0.0050	0.0000	0.0009		
V2pi_4			0.0031	0.0000	0.0160	0.0000	0.0031		
V2pi_min_4			-0.0014	0.0000	0.0000	-0.0050	-0.0014		
V2pi_max_4			0.0017	0.0000	0.0050	0.0000	0.0017		
V2pi_5			0.0023	0.0000	0.0160	0.0000	0.0023		
V2pi_min_5			-0.0010	0.0000	0.0000	-0.0050	-0.0010		

Name / Comment	M-Klasse	P-Klasse	Act / Feature	NOM / Form	UpTol / Sigma	LowTol / Min	Dev / Max	Exc / Pt	Tolerance / Filter
V2pi_max_5			0.0014	0.0000	0.0050	0.0000	0.0014		
V2pi_6			0.0017	0.0000	0.0160	0.0000	0.0017		
V2pi_min_6			-0.0007	0.0000	0.0000	-0.0050	-0.0007		
V2pi_max_6			0.0010	0.0000	0.0050	0.0000	0.0010		
V2pi_7			0.0019	0.0000	0.0160	0.0000	0.0019		
V2pi_min_7			-0.0010	0.0000	0.0000	-0.0050	-0.0010		
V2pi_max_7			0.0009	0.0000	0.0050	0.0000	0.0009		

3-1 Waviness 1

Name / Comment	M-Klasse	P-Klasse	Act / Feature	NOM / Form	UpTol / Sigma	LowTol / Min	Dev / Max	Exc / Pt	Tolerance / Filter
DominantRound_1			0.0003	0.0000	0.0005	0.0000	0.0003		
Bandpass 95 - 97 W/U			Circle_FFT_1	0.0003	0.0001	-0.0002	0.0002	1851	Band-pass Gauss 95 - 97
Waviness_Radial_1			0.4327	0.0000	0.3578	0.0000	0.4327	0.0750	
Dominante Welligkeit = 96			Circle_FFT_1	0.0028	0.0005	-0.0014	0.0014	1851	No Filter
DWaviness_Radial_1			0.1443	0.0000	0.5010	0.0000	0.1443		
Dominante Welligkeit = 96			Circle_FFT_1	0.0003	0.0001	-0.0002	0.0002	1851	Band-pass Gauss 95 - 97
DominantRadial_1			0.5774	0.0000	0.5010	0.0000	0.5774	0.0764	
4-facher Bandpass Wert									
DominantFlat_1			0.0016	0.0000	0.0005	0.0000	0.0016	0.0011	
Bandpass 95 - 97 W/U			FFT_Plane_1	0.0016	0.0005	-0.0008	0.0008	1869	Band-pass Gauss 95 - 97
Waviness_Axial_1			5.1601	0.0000	0.5010	0.0000	5.1601	4.6592	
Dominante Welligkeit = 96			FFT_Plane_1	0.0091	0.0020	-0.0043	0.0048	1869	No Filter
DWaviness_Axial_1			1.3279	0.0000	0.5010	0.0000	1.3279	0.8269	
Dominante Welligkeit = 96			FFT_Plane_1	0.0016	0.0005	-0.0008	0.0008	1869	Band-pass Gauss 95 - 97
DominantAxial_1			5.3115	0.0000	0.5010	0.0000	5.3115	4.8106	
4-facher Bandpass Wert									

3-2 Waviness 2

Name / Comment	M-Klasse	P-Klasse	Act / Feature	NOM / Form	UpTol / Sigma	LowTol / Min	Dev / Max	Exc / Pt	Tolerance / Filter
DominantRound_2			0.0004	0.0000	0.0005	0.0000	0.0004		
Bandpass 95 - 97 W/U			Circle_FFT_2	0.0004	0.0001	-0.0002	0.0002	1842	Band-pass Gauss 95 - 97
Waviness_Radial_2			0.6286	0.0000	0.5010	0.0000	0.6286	0.1277	
Dominante Welligkeit = 96			Circle_FFT_2	0.0025	0.0004	-0.0012	0.0013	1842	No Filter
DWaviness_Radial_2			0.1612	0.0000	0.1252	0.0000	0.1612	0.0359	
Dominante Welligkeit = 96			Circle_FFT_2	0.0004	0.0001	-0.0002	0.0002	1842	Band-pass Gauss 95 - 97
DominantRadial_2			0.6447	0.0000	0.5010	0.0000	0.6447	0.1438	
4-facher Bandpass Wert									
DominantFlat_2			0.0016	0.0000	0.0005	0.0000	0.0016	0.0011	
Bandpass 95 - 97 W/U			FFT_Plane_2	0.0016	0.0005	-0.0008	0.0008	1868	Band-pass Gauss 95 - 97
Waviness_Axial_2			5.0085	0.0000	0.5010	0.0000	5.0085	4.5075	
Dominante Welligkeit = 96			FFT_Plane_2	0.0085	0.0019	-0.0042	0.0043	1868	No Filter
DWaviness_Axial_2			1.2889	0.0000	0.1252	0.0000	1.2889	1.1637	
Dominante Welligkeit = 96			FFT_Plane_2	0.0016	0.0005	-0.0008	0.0008	1868	Band-pass Gauss 95 - 97
DominantAxial_2			5.1557	0.0000	0.5010	0.0000	5.1557	4.6547	
4-facher Bandpass Wert									

3-2 Waviness 3

Name / Comment	M-Klasse	P-Klasse	Act / Feature	NOM / Form	UpTol / Sigma	LowTol / Min	Dev / Max	Exc / Pt	Tolerance / Filter
DominantRound_3			0.0003	0.0000	0.0005	0.0000	0.0003		
Bandpass 95 - 97 W/U			Circle_FFT_3	0.0003	0.0001	-0.0002	0.0002	1813	Band-pass Gauss 95 - 97
Waviness_Radial_3			0.4425	0.0000	0.3569	0.0000	0.4425	0.0856	
Dominante Welligkeit = 96			Circle_FFT_3	0.0026	0.0005	-0.0013	0.0014	1813	No Filter
DWaviness_Radial_3			0.1487	0.0000	0.5010	0.0000	0.1487		
Dominante Welligkeit = 96			Circle_FFT_3	0.0004	0.0001	-0.0002	0.0002	1813	Band-pass Gauss 95 - 97
DominantRadial_3			0.5947	0.0000	0.5010	0.0000	0.5947	0.0938	
4-facher Bandpass Wert									
DominantFlat_3			0.0016	0.0000	0.0005	0.0000	0.0016	0.0011	
Bandpass 95 - 97 W/U			FFT_Plane_3	0.0016	0.0005	-0.0007	0.0009	1869	Band-pass Gauss 95 - 97
Waviness_Axial_3			4.9645	0.0000	0.5010	0.0000	4.9645	4.4635	
Dominante Welligkeit = 96			FFT_Plane_3	0.0086	0.0019	-0.0038	0.0048	1869	No Filter

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Operator Master

Name / Comment	M-Klasse	P-Klasse	Act / Feature	NOM / Form	UpTol / Sigma	LowTol / Min	Dev / Max	Exc / Pt	Tolerance / Filter
DWaviness_Axial_3			1.2773	0.0000	0.5010	0.0000	1.2773	0.7763	
Dominante Welligkeit = 96			FFT_Plane_3	0.0016	0.0005	-0.0007	0.0009	1869	Band-pass Gauss 95 - 97
DominantAxial_3			5.1092	0.0000	0.5010	0.0000	5.1092	4.6082	
4-facher Bandpass Wert									-

4 Additional

StraightAxis_Form_N			0.0005	0.0000	0.0010	0.0000	0.0005		
			ThreadAxis	0.0005	0.0002	-0.0002	0.0002	7	No Filter -
StraightAxis_Form_N1			0.0001	0.0000	0.0010	0.0000	0.0001		
			ThreadAxis	0.0005	0.0002	-0.0002	0.0002	7	No Filter -
OuterDia_Top_1_Round			0.0013	0.0000	0.0050	0.0000	0.0013		
			OuterDia_Top_1	0.0013	0.0002	-0.0006	0.0006	740	Band-pass Gauss 50 - 101