

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

DMC
 Text

Name	M-Klasse	P-Klasse	Act Feature	NOM Form	UpTol Sigma	LowTol Min	Dev Max	Exc Pt	Tolerance Filter
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0 Temperature

Temperature			21.5695	21.5000			0.0695		
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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		

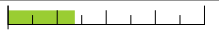
1-2 Over Ball Diameter per revolution

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	M-Klasse	P-Klasse	Act Feature	NOM Form	UpTol Sigma	LowTol Min	Dev Max	Exc Pt	Tolerance Filter
m1Round_7			0.0017 Circle_FFT_7	0.0000 0.0017	0.0050 0.0003	0.0000 -0.0008	0.0017 0.0008	1851	 Low-pass Spline 150 -





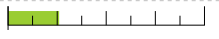
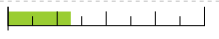

2-1 Lead per revolution

Gauss-Tiefpass 2.448 Lambda [mm]

Lead_1			-11.0010 RLead_1	-11.0000 0.0024	0.0050	-0.0050 -0.0013	-0.0010 0.0011	361	 Low-pass Gauss 2.447 -
Lead_2			-11.0004 RLead_2	-11.0000 0.0028	0.0050	-0.0050 -0.0016	-0.0004 0.0012	361	 Low-pass Gauss 2.447 -
Lead_3			-10.9995 RLead_3	-11.0000 0.0021	0.0050	-0.0050 -0.0012	0.0005 0.0008	361	 Low-pass Gauss 2.447 -
Lead_4			-11.0000 RLead_4	-11.0000 0.0031	0.0050	-0.0050 -0.0014	0.0000 0.0017	361	 Low-pass Gauss 2.447 -
Lead_5			-10.9992 RLead_5	-11.0000 0.0027	0.0050	-0.0050 -0.0013	0.0008 0.0013	361	 Low-pass Gauss 2.447 -
Lead_6			-10.9990 RLead_6	-11.0000 0.0021	0.0050	-0.0050 -0.0011	0.0010 0.0010	361	 Low-pass Gauss 2.447 -
Lead_7			-10.9988 RLead_7	-11.0000 0.0024	0.0050	-0.0050 -0.0015	0.0012 0.0009	361	 Low-pass Gauss 2.447 -

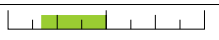













2-3 Thread Radial per revolution

Gauss-Tiefpass 2.448 Lambda [mm]

Radial_Form_1			0.0028 Tiefpass Lc = 2.448 RRadial_1	0.0000 0.0028	0.0050	0.0000 -0.0008	0.0028 0.0021		 -
Radial_Form_2			0.0018 Tiefpass Lc = 2.448 RRadial_2	0.0000 0.0018	0.0050	0.0000 -0.0007	0.0018 0.0011		 -
Radial_Form_3			0.0020 Tiefpass Lc = 2.448 RRadial_3	0.0000 0.0020	0.0050	0.0000 -0.0005	0.0020 0.0015		 -
Radial_Form_4			0.0028 Tiefpass Lc = 2.448 RRadial_1	0.0000 0.0028	0.0050	0.0000 -0.0008	0.0028 0.0021		 -
Radial_Form_5			0.0013 Tiefpass Lc = 2.448 RRadial_5	0.0000 0.0013	0.0050	0.0000 -0.0005	0.0013 0.0008		 -
Radial_Form_6			0.0016 Tiefpass Lc = 2.448 RRadial_6	0.0000 0.0016	0.0050	0.0000 -0.0007	0.0016 0.0009		 -
Radial_Form_7			0.0012 Tiefpass Lc = 2.448 RRadial_7	0.0000 0.0012	0.0050	0.0000 -0.0004	0.0012 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		 -

PiWeb Reporting Plus

Date 3/5/2019 3:41 PM
 Order-No 4431227
 Operator Master

Name	M-Klasse	P-Klasse	Act	NOM	UpTol	LowTol	Dev	Exc	Tolerance
Comment			Feature	Form	Sigma	Min	Max	Pt	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

<input type="radio"/> 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
<input type="radio"/> 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
<input type="radio"/> 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
<input type="radio"/> DominantRadial_1			0.5774	0.0000	0.5010	0.0000	0.5774	0.0764	
4-facher Bandpass Wert									
<input type="checkbox"/> 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
<input type="radio"/> 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
<input type="radio"/> 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
<input type="radio"/> DominantAxial_1			5.3115	0.0000	0.5010	0.0000	5.3115	4.8106	
4-facher Bandpass Wert									

3-2 Waviness 2

<input type="radio"/> 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
<input type="radio"/> 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
<input type="radio"/> 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
<input type="radio"/> DominantRadial_2			0.6447	0.0000	0.5010	0.0000	0.6447	0.1438	
4-facher Bandpass Wert									
<input type="checkbox"/> 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
<input type="radio"/> 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
<input type="radio"/> 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
<input type="radio"/> DominantAxial_2			5.1557	0.0000	0.5010	0.0000	5.1557	4.6547	
4-facher Bandpass Wert									

3-2 Waviness 3

<input type="radio"/> 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
<input type="radio"/> 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
<input type="radio"/> 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
<input type="radio"/> DominantRadial_3			0.5947	0.0000	0.5010	0.0000	0.5947	0.0938	
4-facher Bandpass Wert									
<input type="checkbox"/> 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
<input type="radio"/> 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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Date 3/5/2019 3:41 PM
 Order-No 4431227
 Operator Master

Name	M-Klasse	P-Klasse	Act	NOM	UpTol	LowTol	Dev	Exc	Tolerance
Comment			Feature	Form	Sigma	Min	Max	Pt	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