



PiWeb Reporting Plus

Last 1 measurements

▶ Approval ≠ Gesperrt

No. measured values 21

Date

2/20/2024 1:37 PM

Measurement Du...

00:00:02.0

No. values: red

2

Program **CurveOffset / CurveBlock**

Drawing-No 123-456-789 / 01.01.2024

MiniPlan *All Characteristics*

Plant CZ IMT GmbH

Order-No Prog

Mach-No 5_Axis-1

Deprmt QS

Type Sample

CMM-No 000000

Cost Center *HomeOffice*Process *Test*

MPEe = 1.5 ± L / 400

Inc-Part-No 4

Operator Master

DMC

Text

Characteristic	Docu	ACT	NOM	UT	LT	DEV	EXC	TOL
Curve Up								
CurveForm-Up	1	0.00653	0.00000	0.01100	0.00000	0.00653		
minDevUp	1	-0.00422	0.00000	0.05000	-0.05000	-0.00422		
maxDevUp	1	0.00232	0.00000	0.05000	-0.05000	0.00232		
Circle XY								
Circle_XY_D	1	92.99795	93.00000	0.01500	-0.01500	-0.00205		
Circle_XY_X	1	-47.50194	-47.50000	0.01000	-0.01000	-0.00194		
Circle_XY_Y	1	47.49987	47.50000	0.01000	-0.01000	-0.00013		
Curve Down								
CurveForm-Down	1	0.00681	0.00000	0.01100	0.00000	0.00681		
minDevDown	1	-0.00514	0.00000	0.05000	-0.05000	-0.00514		
maxDevDown	1	0.00167	0.00000	0.05000	-0.05000	0.00167		
Offset Calculation								
Minimum_UpDown	1	-0.00514	0.00000	0.05000	-0.05000	-0.00514		
Maximum_UpDown	1	0.00232	0.00000	0.05000	-0.05000	0.00232		
Offset_UpDown	1	-0.00141	0.00000	0.05000	-0.05000	-0.00141		
Both Curves with Tolerance Offset								
CurveFormOffset-Up	1	0.00653	0.00000	0.01100	0.00000	0.00653		
CurveFormOffset-Down	1	0.00681	0.00000	0.01100	0.00000	0.00681		
Line Profile								
LineProfileUp	1	0.00844	0.00000	0.01100	0.00000	0.00844		
LineProfileDown	1	0.01028	0.00000	0.01100	0.00000	0.01028		
Line Profile OneSide								
LineProfileUp_OneSide	1	0.00731	0.00000	0.01100	0.00000	0.00731		
Tol(one side) = 0.00416	1							
LineProfileDown_OneSide	1	0.00760	0.00000	0.01100	0.00000	0.00760		
Tol(one side) = 0.00416	1							
CurveFormUp_0	1	-0.01852	0.00000	-0.00500	-0.01500	-0.01852	-0.00352	
Tolerance Offset: -0.0100	1							
CurveFormUp_0.range	1	0.01323						
LineFormUp_0	1	0.01704	0.00000	0.01000	0.00000	0.01704	0.00704	

ALYPSO 7.2.08 & PiWeb 7.8.10.0 | C:\Users\Public\Documents\Zeiss\CALYPSO 7.2\workarea\inspections\CurveOffset\PiWebReporting Templates\Protocol_720.ptx



**PiWeb
Reporting
Plus**

Program/Part-Name CurveOffset/CurveBlock
Drawing-No 123-456-789 / 01.01.2024
Inc-Part-No 4

Date 2/20/2024 1:37 PM
Order-No Prog
Operator Master

Characteristic	Docu	ACT	NOM	UT	LT	DEV	EXC	TOL
Comment								



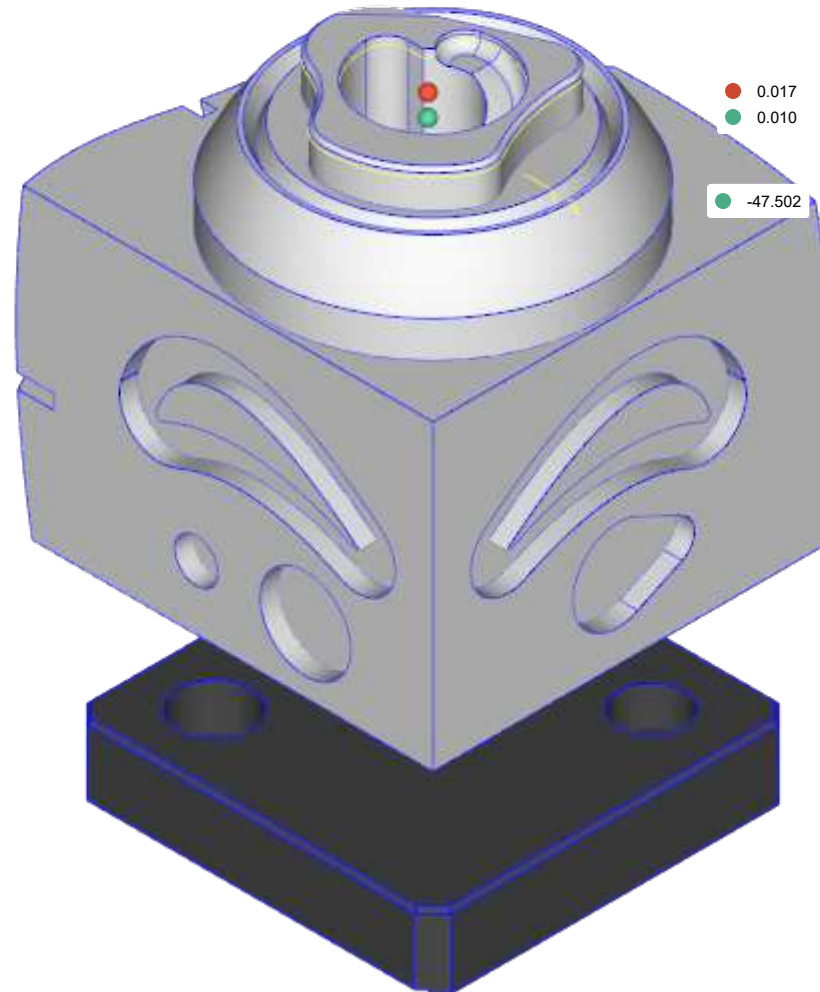
Inspection CurveOffset / CurveBlock
Order-No Prog
Inc-Part-No 4

Content

Drawing-No 123-456-789 / 01.01.2024
CMM-No 000000 **MPEe =** 1.5 ± L / 400
Machine-No 5_Axis-1 **RunTime** 00:00:02.0

Date 2/20/2024 1:37 PM
 Last 1 measurements
 No Char 29
 No Char Red ● 2
Operator Master

Content 1
 2D CurveForm without & with Offset 2
 Linear CurveForm without & with Offset 3
 2D Line Form without & with Tol(one side) 4
 Linear Line Profile without & with Tol(one side) 5
 CurveForm & LineForm 6



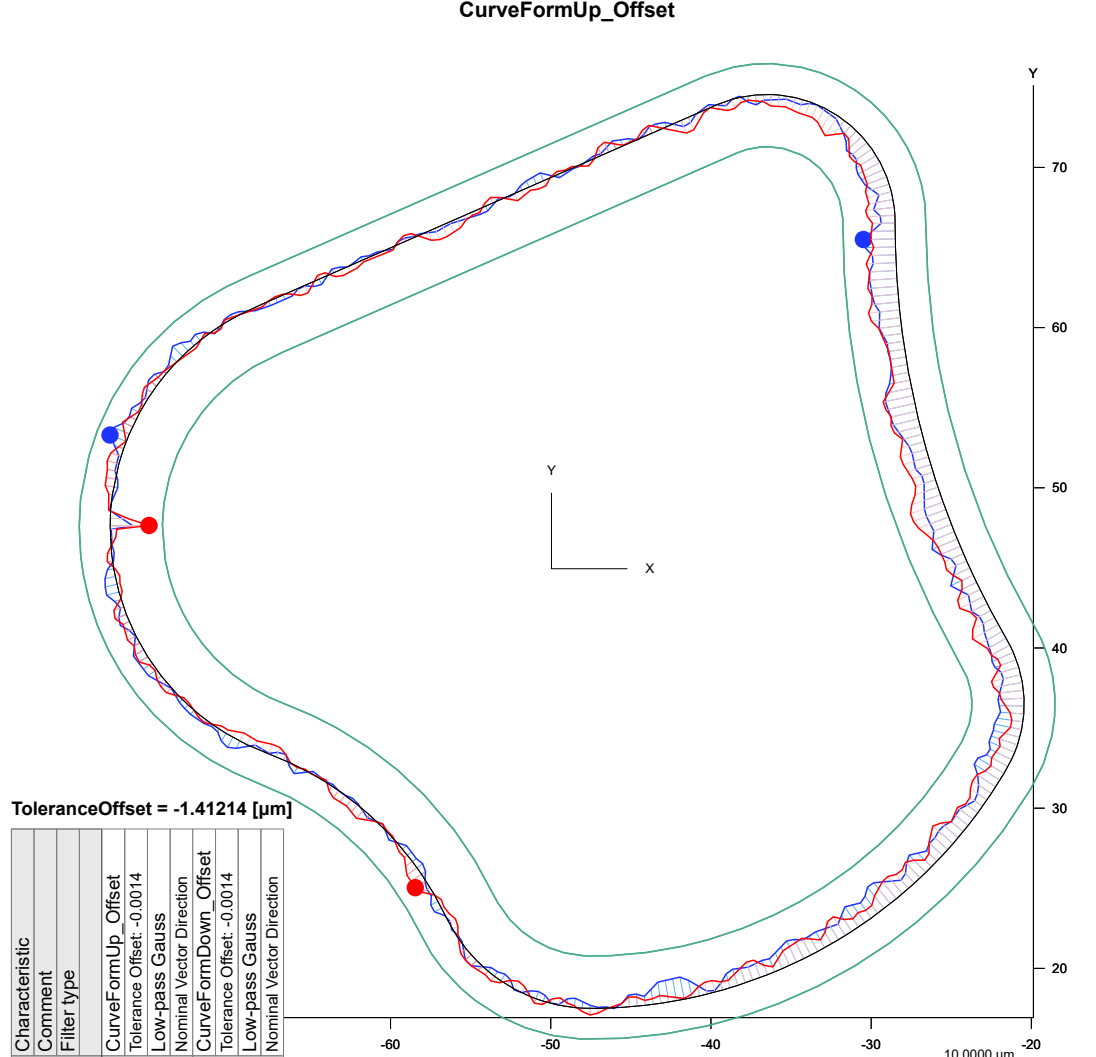
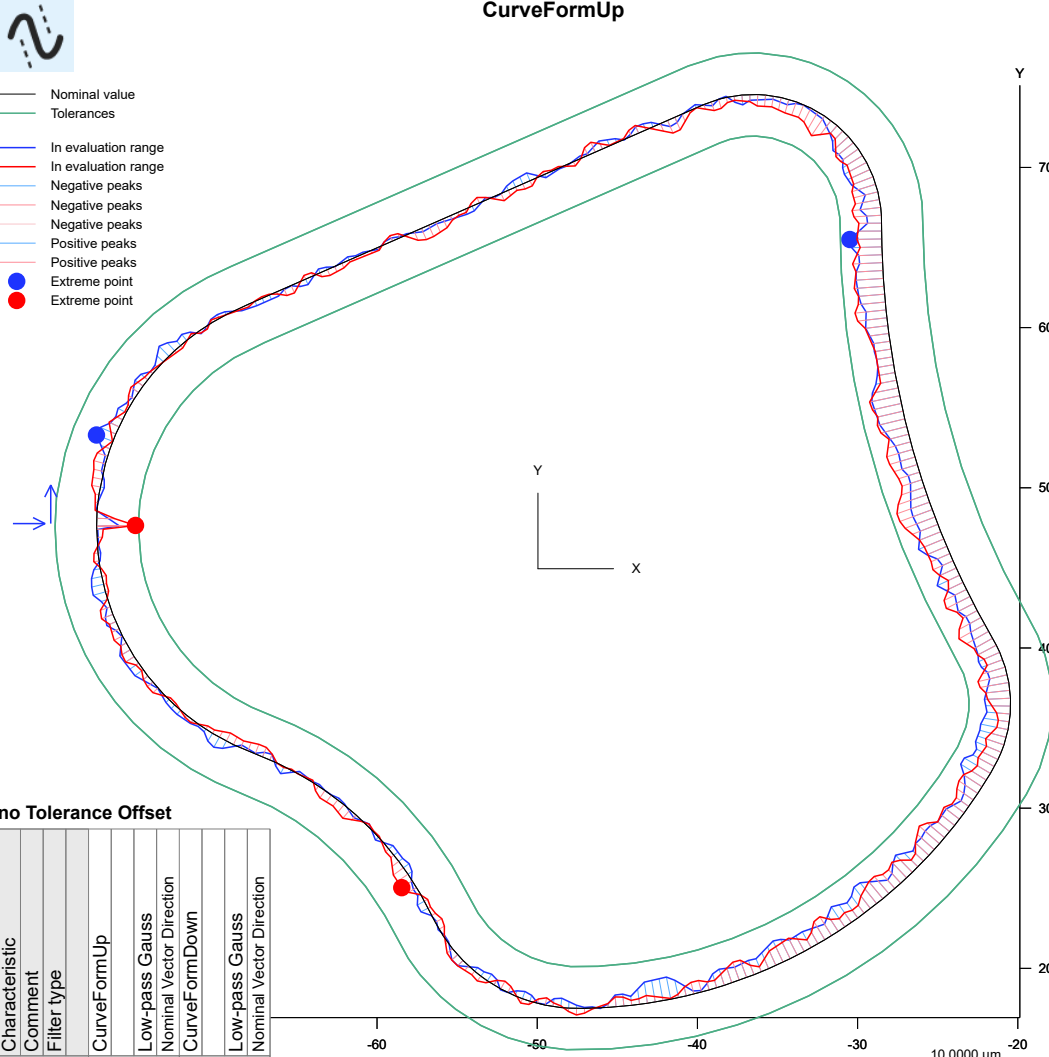


2D CurveForm without & with Offset

Date 2/20/2024 1:37 PM
 Last 1 measurements
 No Char 29
 No Char Red 2
Operator Master

Inspection CurveOffset / CurveBlock
Order-No Prog
Inc-Part-No 4

Drawing-No 123-456-789 / 01.01.2024
CMM-No 000000 **MPEe =** 1.5 ± L / 400
Machine-No 5_Axis-1 **RunTime** 00:00:02.0



no Tolerance Offset

Characteristic	Comment	Filter type	CurveFormUp	Low-pass Gauss	Nominal Vector Direction	CurveFormDown	Low-pass Gauss	Nominal Vector Direction
Range			6.534	6.812				
Tol			11.000	11.000				
λc			2.5 -	2.5 -				
Min			-4.2190	-5.1396				
Max			2.3154	1.6725				
Points			359	359				
Sigma			1.7754	1.8787				
L-Tol			-5.5000	-5.5000				
U-Tol			5.5000	5.5000				

CurveFormDown

BestFit CurveFormUp		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000

BestFit CurveFormDown		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000

ToleranceOffset = -1.41214 [µm]

Characteristic	Comment	Filter type	CurveFormUp_Offset	Tolerance Offset	Low-pass Gauss	Nominal Vector Direction	CurveFormDown_Offset	Tolerance Offset	Low-pass Gauss	Nominal Vector Direction
Range			6.534		6.812					
Tol			11.000	-0.0014	11.000			-0.0014		
λc			2.5 -		2.5 -					
Min			-4.2190		-5.1396					
Max			2.3154		1.6725					
Points			359		359					
Sigma			1.7754		1.8787					
L-Tol			-6.9121		-6.9121					
U-Tol			4.0879		4.0879					

CurveFormDown_Offset

BestFit CurveFormUp_Offset		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000

BestFit CurveFormDown_Offset		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000



Linear CurveForm without & with Offset

Date 2/20/2024 1:37 PM
 Last 1 measurements
 No Char 29
 No Char Red 2
Operator Master

Inspection CurveOffset / CurveBlock
Order-No Prog
Inc-Part-No 4

Drawing-No 123-456-789 / 01.01.2024
CMM-No 000000 **MPEe =** 1.5 ± L / 400
Machine-No 5_Axis-1 **RunTime** 00:00:02.0



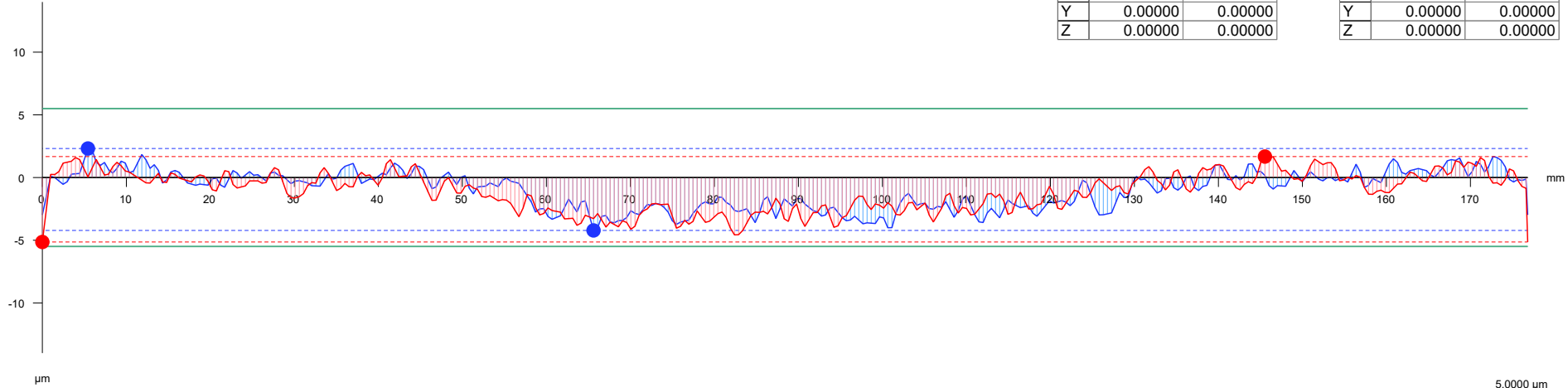
CurveFormUp

BestFit CurveFormUp		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000

BestFit CurveFormDown		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000

no Tolerance Offset

Characteristic Comment Filter type	CurveFormUp	Low-pass Gauss Nominal Vector Direction	CurveFormDown	Low-pass Gauss Nominal Vector Direction
Range [µm]	6.534	6.812		
Tol [µm]	11.000	11.000		
λc [mm]	2.5 -	2.5 -		
Min [µm]	-4.2190	-5.1396		
Max [µm]	2.3154	1.6725		
Points	359	359		
Sigma [µm]	1.7754	1.8787		
L-Tol [mm]	-5.5000	-5.5000		
U-Tol [mm]	5.5000	5.5000		



— Nominal value
 — Tolerances

--- Extreme lines
 --- Extreme lines
 --- In evaluation range
 --- In evaluation range
 --- Negative peaks
 --- Negative peaks
 --- Positive peaks
 --- Positive peaks
 ● Extreme point
 ● Extreme point

CurveFormDown

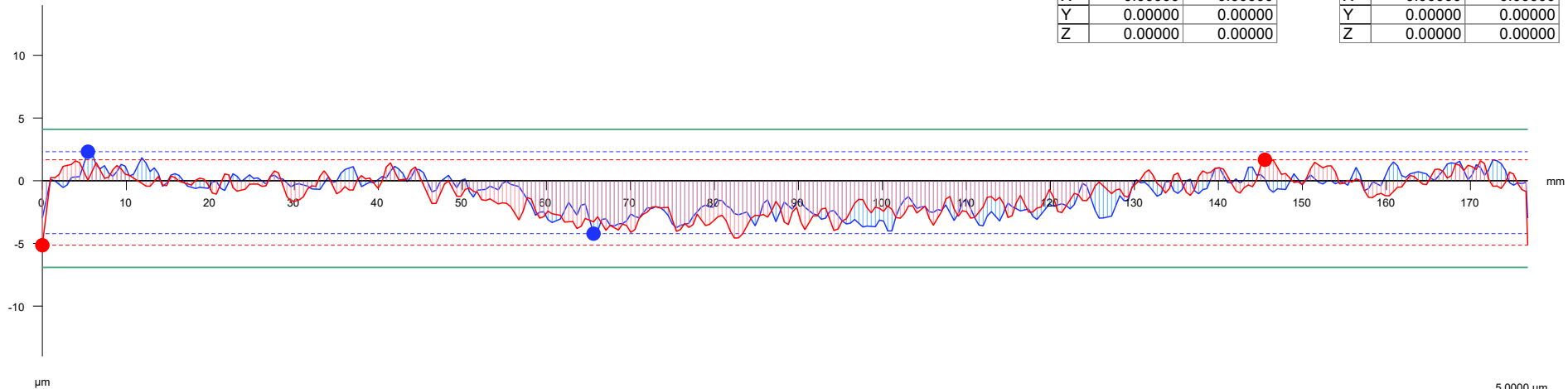
CurveFormUp_Offset

BestFit CurveFormUp_Offset		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000

BestFit CurveFormDown_Offset		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000

ToleranceOffset = -1.41214 [µm]

Characteristic Comment Filter type	CurveFormUp_Offset	Tolerance Offset: -0.0014	Low-pass Gauss Nominal Vector Direction	CurveFormDown_Offset	Tolerance Offset: -0.0014	Low-pass Gauss Nominal Vector Direction
Range [µm]	6.534	6.812				
Tol [µm]	11.000	11.000				
λc [mm]	2.5 -	2.5 -				
Min [µm]	-4.2190	-5.1396				
Max [µm]	2.3154	1.6725				
Points	359	359				
Sigma [µm]	1.7754	1.8787				
L-Tol [mm]	-6.9121	-6.9121				
U-Tol [mm]	4.0879	4.0879				



CurveFormDown_Offset

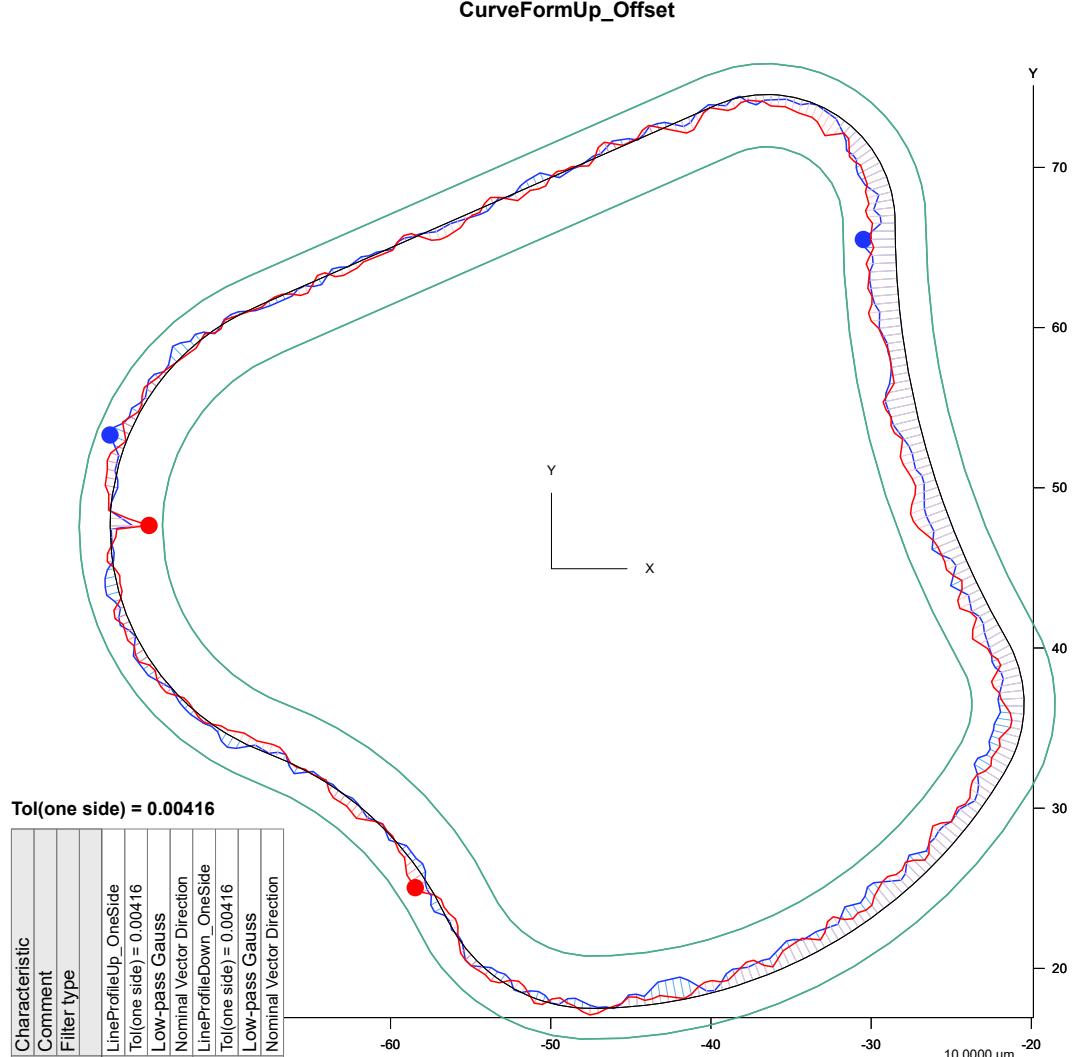
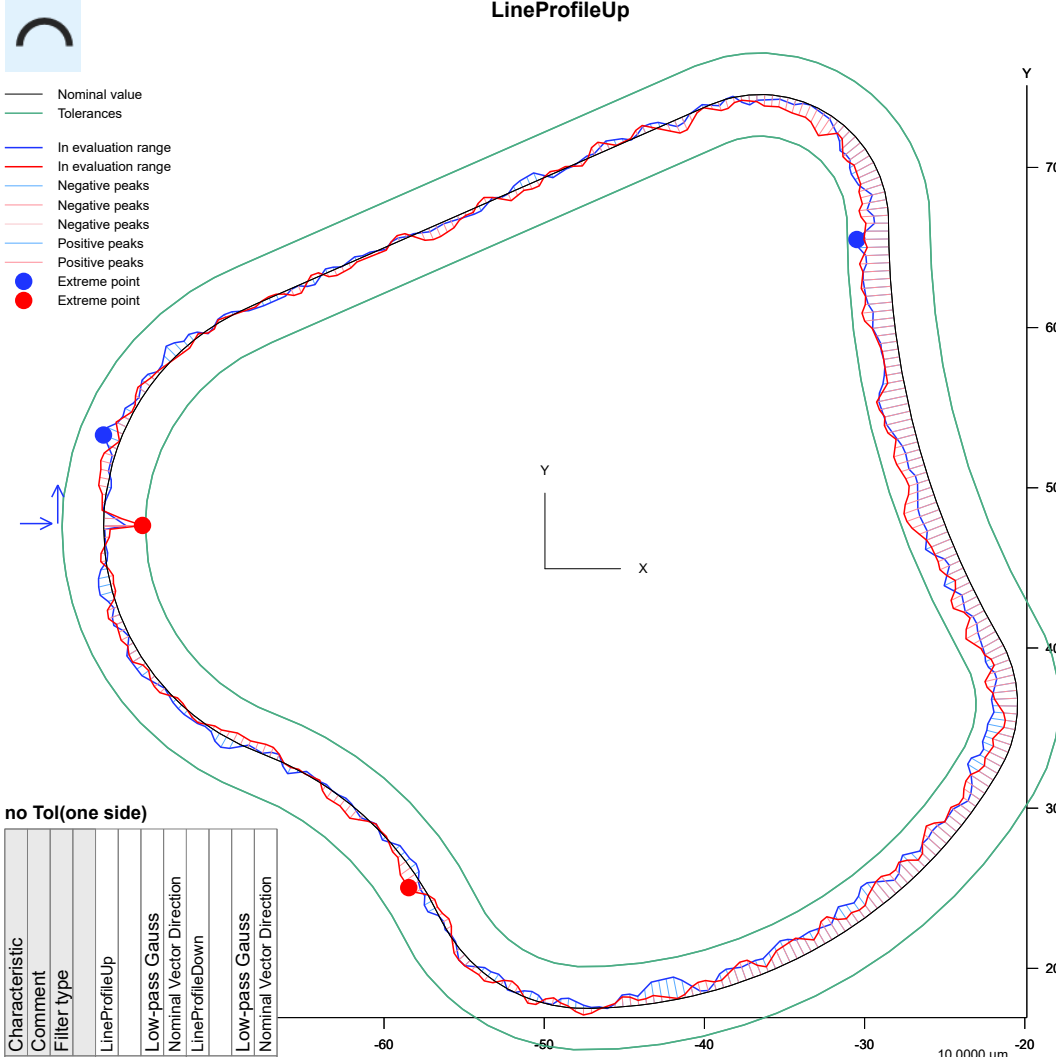


2D Line Form without & with Tol(one side)

Date 2/20/2024 1:37 PM
 Last 1 measurements
 No Char 29
 No Char Red 2
Operator Master

Inspection CurveOffset / CurveBlock
Order-No Prog
Inc-Part-No 4

Drawing-No 123-456-789 / 01.01.2024
CMM-No 000000 **MPEe =** 1.5 ± L / 400
Machine-No 5_Axis-1 **RunTime** 00:00:02.0



no Tol(one side)

Characteristic Comment Filter type	LineProfileUp	Low-pass Gauss Nominal Vector Direction	LineProfileDown	Low-pass Gauss Nominal Vector Direction
Actual [µm]	8.438	10.279		
Tol [µm]	11.000	11.000		
λc [mm]	2.5 -	2.5 -		
Min [µm]	-4.2190	-5.1396		
Max [µm]	2.3154	1.6725		
Points	359	359		
Sigma [µm]	1.7754	1.8787		
L-Tol [mm]	0.0000	0.0000		
U-Tol [mm]	11.0000	11.0000		

LineProfileDown

BestFit LineProfileUp		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000

BestFit LineProfileDown		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000

Tol(one side) = 0.00416

Characteristic Comment Filter type	LineProfileUp_OneSide Tol(one side) = 0.00416	Low-pass Gauss Nominal Vector Direction	LineProfileDown_OneSide Tol(one side) = 0.00416	Low-pass Gauss Nominal Vector Direction
Actual [µm]	7.306	7.604		
Tol [µm]	11.000	11.000		
λc [mm]	2.5 -	2.5 -		
Min [µm]	-4.2190	-5.1396		
Max [µm]	2.3154	1.6725		
Points	359	359		
Sigma [µm]	1.7754	1.8787		
L-Tol [mm]	0.0000	0.0000		
U-Tol [mm]	11.0000	11.0000		

CurveFormDown_Offset

BestFit CurveFormUp_Offset		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000

BestFit CurveFormDown_Offset		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000



Linear Line Profile without & with Tol(one side)

Date 2/20/2024 1:37 PM
 Last 1 measurements
 No Char 29
 No Char Red 2
Operator Master

Inspection CurveOffset / CurveBlock
Order-No Prog
Inc-Part-No 4

Drawing-No 123-456-789 / 01.01.2024
CMM-No 000000 **MPEe =** 1.5 ± L / 400
Machine-No 5_Axis-1 **RunTime** 00:00:02.0



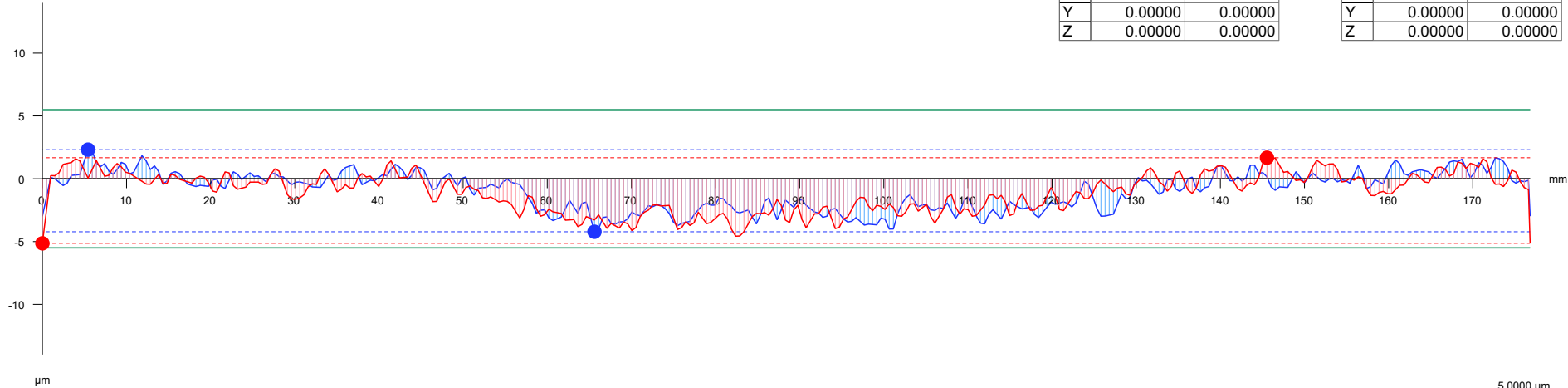
LineProfileUp

BestFit LineProfileUp_OneSide		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000

BestFit LineProfileDown_OneSide		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000

no Tol(one side)

Characteristic Comment Filter type	LineProfileUp	Low-pass Gauss Nominal Vector Direction LineProfileDown	Low-pass Gauss Nominal Vector Direction
Actual [µm]	8.438	10.279	
Tol [µm]	11.000	11.000	
λc [mm]	2.5 -	2.5 -	
Min [µm]	-4.2190	-5.1396	
Max [µm]	2.3154	1.6725	
Points	359	359	
Sigma [µm]	1.7754	1.8787	
L-Tol [mm]	0.0000	0.0000	
U-Tol [mm]	11.0000	11.0000	



— Nominal value
 — Tolerances

- Extreme lines
- Extreme lines
- In evaluation range
- In evaluation range
- Negative peaks
- Negative peaks
- Positive peaks
- Positive peaks
- Extreme point
- Extreme point

Tol(one side) = 0.00416

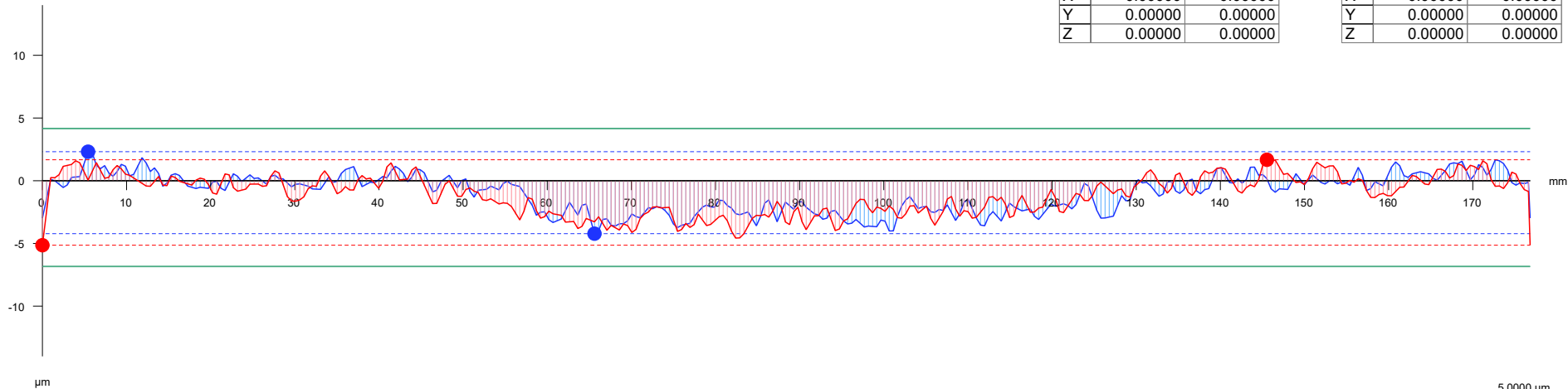
Characteristic Comment Filter type	LineProfileUp_OneSide	Tol(one side) = 0.00416	Low-pass Gauss Nominal Vector Direction LineProfileDown_OneSide	Tol(one side) = 0.00416	Low-pass Gauss Nominal Vector Direction
Actual [µm]	7.306	7.604			
Tol [µm]	11.000	11.000			
λc [mm]	2.5 -	2.5 -			
Min [µm]	-4.2190	-5.1396			
Max [µm]	2.3154	1.6725			
Points	359	359			
Sigma [µm]	1.7754	1.8787			
L-Tol [mm]	0.0000	0.0000			
U-Tol [mm]	11.0000	11.0000			

LineProfileDown

LineProfileUp_OneSide

BestFit LineProfileUp_OneSide		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000

BestFit LineProfileDown_OneSide		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000



LineProfileDown_OneSide

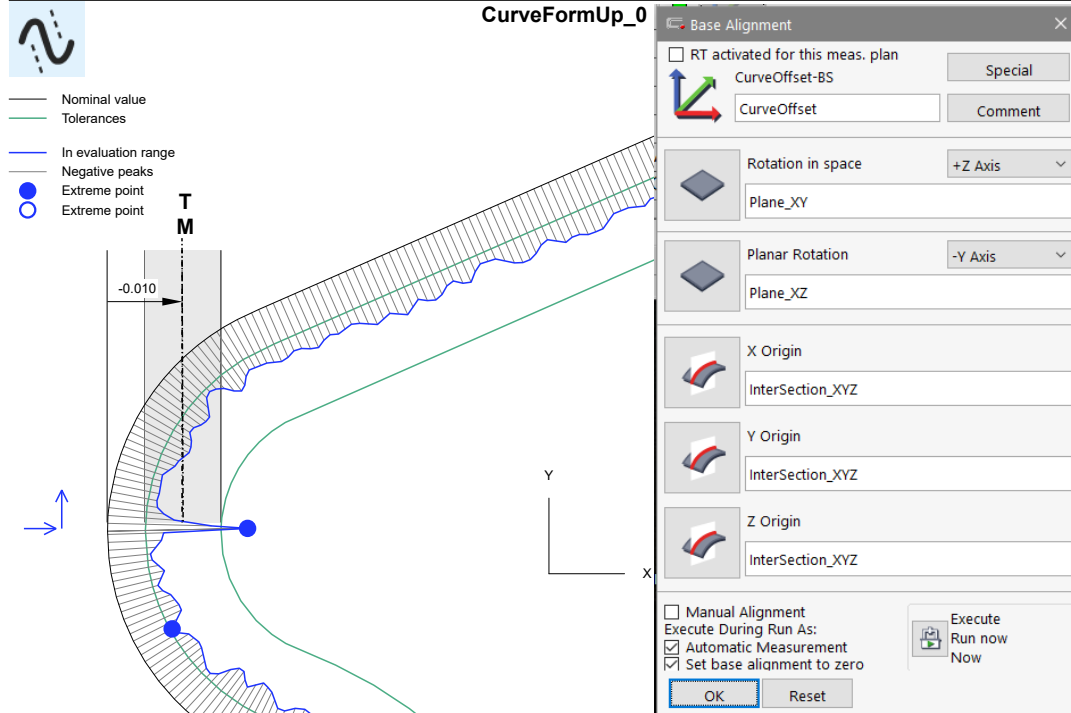


Inspection CurveOffset / CurveBlock
Order-No Prog
Inc-Part-No 4

CurveForm & LineForm

Drawing-No 123-456-789 / 01.01.2024
CMM-No 000000 **MPEe =** 1.5 ± L / 400
Machine-No 5_Axis-1 **RunTime** 00:00:02.0

Date 2/20/2024 1:37 PM
 Last 1 measurements
 No Char 29
 No Char Red 2
Operator Master



Tolerance Offset = -0.010 [mm]

Characteristic	Comment	Filter type	CurveFormUp_0
Range			13.232 = Max - Min
Tol			10.000
λc			2.5 -
Min			-18.521
Max			-5.289
Points			359
Sigma			8.775
L-Tol			-15.000 = -0.005 - 0.010
U-Tol			-5.000 = +0.005 - 0.010

Base Alignment

RT activated for this meas. plan
 CurveOffset-BS Special

CurveOffset Comment

Rotation in space +Z Axis

Plane_XY

Planar Rotation -Y Axis

Plane_XZ

X Origin
InterSection_XYZ

Y Origin
InterSection_XYZ

Z Origin
InterSection_XYZ

Manual Alignment
 Execute During Run As:
 Automatic Measurement
 Set base alignment to zero

Execute Run now Now

OK **Reset**

Curve Form

CurveFormUp_0 Comment

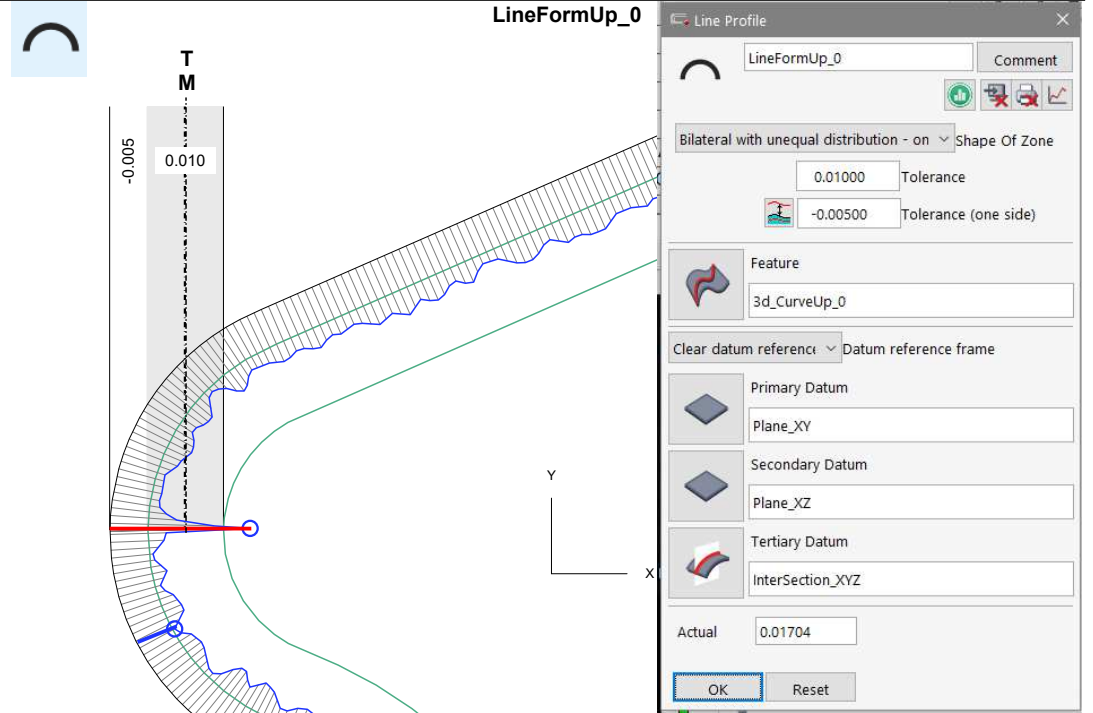
Upper Tol. None

Lower Tol. None

Shape Of Zone Range

Tolerance Offset ↩

BestFit CurveFormUp_0		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000



Tol(on side) = -0.005 [mm]

Characteristic	Comment	Filter type	LineFormUp_0
Actual			17.041 = 2 * max(min-TM , max-TM)
Tol			10.000 = 2 * max(-5.289-(-10.0) , -18.521-(-10.0))
λc			2.5 -
Min			-18.521 = 2 * max(4.711, 8.521) ≈ 17.042
Max			-5.289
Points			359
Sigma			8.775
L-Tol			0.000
U-Tol			10.000

BestFit LineFormUp_0		
	Trans [mm]	Rot [°]
X	0.00000	0.00000
Y	0.00000	0.00000
Z	0.00000	0.00000

Line Profile

LineFormUp_0 Comment

Bilateral with unequal distribution - on Shape Of Zone

Tolerance

Tolerance (one side)

Feature
3d_CurveUp_0

Clear datum reference Datum reference frame

Primary Datum
Plane_XY

Secondary Datum
Plane_XZ

Tertiary Datum
InterSection_XYZ

Actual

OK **Reset**