

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	ProgName	MiniPlan	<i>All Characteristics</i>	Plant	CZ IMT GmbH
Drawing-No	DrawingNo & Revision	Mach-No	123456	Deprmt	SES-AP
Order-No	Worm	CMM-No	000000	CostCenter	420
Type	Grinding	Gauge-No	123	Operator	Master
Process	Test_SE135			Shift	Shift-2
Part-No					

DMC
 Text

Name	Act	NOM	UpTol	LowTol	Dev	Exc	Tolerance
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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		
m1Dia	45.9332	45.9600	0.0000	-0.0300	-0.0268		
Cylinderform_aL	0.0017	0.0000	0.0080	0.0000	0.0017		
Lead_360	-10.9993	-11.0000	0.0150	-0.0150	0.0007		
RadialTotal_Form	0.0031	0.0000	0.0080	0.0000	0.0031		
Vg Natürliche Grenze "0" durch Position	0.0045	0.0000	0.0080	0.0000	0.0045		
Vg_min Ist "positiv" durch Position	0.0019	0.0000	0.0040	0.0000	0.0019		
Vg_max Über Position	0.0026	0.0000	0.0040	0.0000	0.0026		
Coax_Thread_Datum_A-B	0.0063	0.0000	0.0300	0.0000	0.0063		

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		
m1Round_2	0.0020	0.0000	0.0050	0.0000	0.0020		
m1Round_3	0.0021	0.0000	0.0050	0.0000	0.0021		
m1Round_4	0.0019	0.0000	0.0050	0.0000	0.0019		
m1Round_5	0.0017	0.0000	0.0050	0.0000	0.0017		
m1Round_6	0.0017	0.0000	0.0050	0.0000	0.0017		





Name	Act	NOM	UpTol	LowTol	Dev	Exc	Tolerance
Comment	M-Klasse	P-Klasse					
○ m1Round_7	0.0017	0.0000	0.0050	0.0000	0.0017		
2-1 Lead per revolution							
Gauss-Tiefpass 2.448 Lambda [mm]							
△ Lead_1	-11.0010	-11.0000	0.0050	-0.0050	-0.0010		
△ Lead_2	-11.0004	-11.0000	0.0050	-0.0050	-0.0004		
△ Lead_3	-10.9995	-11.0000	0.0050	-0.0050	0.0005		
△ Lead_4	-11.0000	-11.0000	0.0050	-0.0050	0.0000		
△ Lead_5	-10.9992	-11.0000	0.0050	-0.0050	0.0008		
△ Lead_6	-10.9990	-11.0000	0.0050	-0.0050	0.0010		
△ Lead_7	-10.9988	-11.0000	0.0050	-0.0050	0.0012		
2-3 Thread Radial per revolution							
Gauss-Tiefpass 2.448 Lambda [mm]							
∩ Radial_Form_1 Tiefpass Lc = 2.448	0.0028	0.0000	0.0050	0.0000	0.0028		
∩ Radial_Form_2 Tiefpass Lc = 2.448	0.0018	0.0000	0.0050	0.0000	0.0018		
∩ Radial_Form_3 Tiefpass Lc = 2.448	0.0020	0.0000	0.0050	0.0000	0.0020		
∩ Radial_Form_4 Tiefpass Lc = 2.448	0.0028	0.0000	0.0050	0.0000	0.0028		
∩ Radial_Form_5 Tiefpass Lc = 2.448	0.0013	0.0000	0.0050	0.0000	0.0013		
∩ Radial_Form_6 Tiefpass Lc = 2.448	0.0016	0.0000	0.0050	0.0000	0.0016		
∩ Radial_Form_7 Tiefpass Lc = 2.448	0.0012	0.0000	0.0050	0.0000	0.0012		
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	Act	NOM	UpTol	LowTol	Dev	Exc	Tolerance
Comment	M-Klasse	P-Klasse					
● 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							
○ DominantRound_1 Bandpass 95 - 97 W/U	0.0003	0.0000	0.0005	0.0000	0.0003		
⊗ Waviness_Radial_1 Dominante Welligkeit = 96	0.4327	0.0000	0.3578	0.0000	0.4327	0.0750	
⊗ DWaviness_Radial_1 Dominante Welligkeit = 96	0.1443	0.0000	0.5010	0.0000	0.1443		
● DominantRadial_1 4-facher Bandpass Wert	0.5774	0.0000	0.5010	0.0000	0.5774	0.0764	
▧ DominantFlat_1 Bandpass 95 - 97 W/U	0.0016	0.0000	0.0005	0.0000	0.0016	0.0011	
⊗ Waviness_Axial_1 Dominante Welligkeit = 96	5.1601	0.0000	0.5010	0.0000	5.1601	4.6592	
⊗ DWaviness_Axial_1 Dominante Welligkeit = 96	1.3279	0.0000	0.5010	0.0000	1.3279	0.8269	
● DominantAxial_1 4-facher Bandpass Wert	5.3115	0.0000	0.5010	0.0000	5.3115	4.8106	
3-2 Waviness 2							
○ DominantRound_2 Bandpass 95 - 97 W/U	0.0004	0.0000	0.0005	0.0000	0.0004		
⊗ Waviness_Radial_2 Dominante Welligkeit = 96	0.6286	0.0000	0.5010	0.0000	0.6286	0.1277	
⊗ DWaviness_Radial_2 Dominante Welligkeit = 96	0.1612	0.0000	0.1252	0.0000	0.1612	0.0359	
● DominantRadial_2 4-facher Bandpass Wert	0.6447	0.0000	0.5010	0.0000	0.6447	0.1438	
▧ DominantFlat_2 Bandpass 95 - 97 W/U	0.0016	0.0000	0.0005	0.0000	0.0016	0.0011	
⊗ Waviness_Axial_2 Dominante Welligkeit = 96	5.0085	0.0000	0.5010	0.0000	5.0085	4.5075	
⊗ DWaviness_Axial_2 Dominante Welligkeit = 96	1.2889	0.0000	0.1252	0.0000	1.2889	1.1637	
● DominantAxial_2 4-facher Bandpass Wert	5.1557	0.0000	0.5010	0.0000	5.1557	4.6547	
3-2 Waviness 3							
○ DominantRound_3 Bandpass 95 - 97 W/U	0.0003	0.0000	0.0005	0.0000	0.0003		
⊗ Waviness_Radial_3 Dominante Welligkeit = 96	0.4425	0.0000	0.3569	0.0000	0.4425	0.0856	
⊗ DWaviness_Radial_3 Dominante Welligkeit = 96	0.1487	0.0000	0.5010	0.0000	0.1487		
● DominantRadial_3 4-facher Bandpass Wert	0.5947	0.0000	0.5010	0.0000	0.5947	0.0938	
▧ DominantFlat_3 Bandpass 95 - 97 W/U	0.0016	0.0000	0.0005	0.0000	0.0016	0.0011	
⊗ Waviness_Axial_3 Dominante Welligkeit = 96	4.9645	0.0000	0.5010	0.0000	4.9645	4.4635	


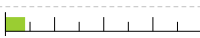

**PiWeb
Reporting Plus**

Program
Drawing-No
Part-No

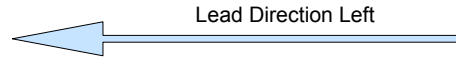
Date 3/5/2019 3:41 PM
Order-No 4431227
Operator Master

Name	M-Klasse	P-Klasse	Act	NOM	UpTol	LowTol	Dev	Exc	Tolerance
 DWaviness_Axial_3 Dominante Welligkeit = 96			1.2773	0.0000	0.5010	0.0000	1.2773	0.7763	
 DominantAxial_3 4-facher Bandpass Wert			5.1092	0.0000	0.5010	0.0000	5.1092	4.6082	

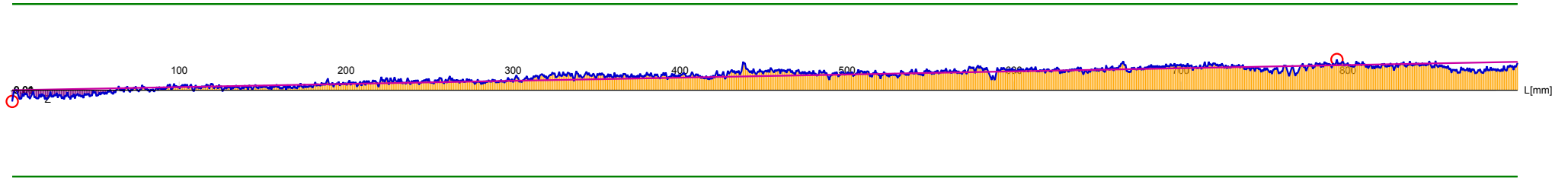
4 Additional

— StraightAxis_Form_N			0.0005	0.0000	0.0010	0.0000	0.0005		
— StraightAxis_Form_N1			0.0001	0.0000	0.0010	0.0000	0.0001		
○ OuterDia_Top_1_Round			0.0013	0.0000	0.0050	0.0000	0.0013		

PiWeb Reporting Plus Gewinde Axial & Radial	Inspection	Order-No	4431227	Gauge-No	Lehre-123	Date	3/5/2019 3:41 PM
	Drawing-No	Part-No	Samara_SE135	Customer	MB-Truck	CMM-No	000000
	Type	LeadAngle	5.1355°	Cost-Center	420	CMM	PRISMO_RT-AB
	Process	Mach-No	123456	Deprmt	SES-AP	MPEe =	0.9 ± L / 350
	MiniPlan	Plant	CZ IMT GmbH	Shift	Shift-2	Operator	Master

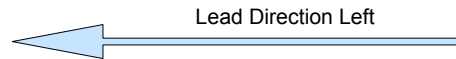


LeadTotal

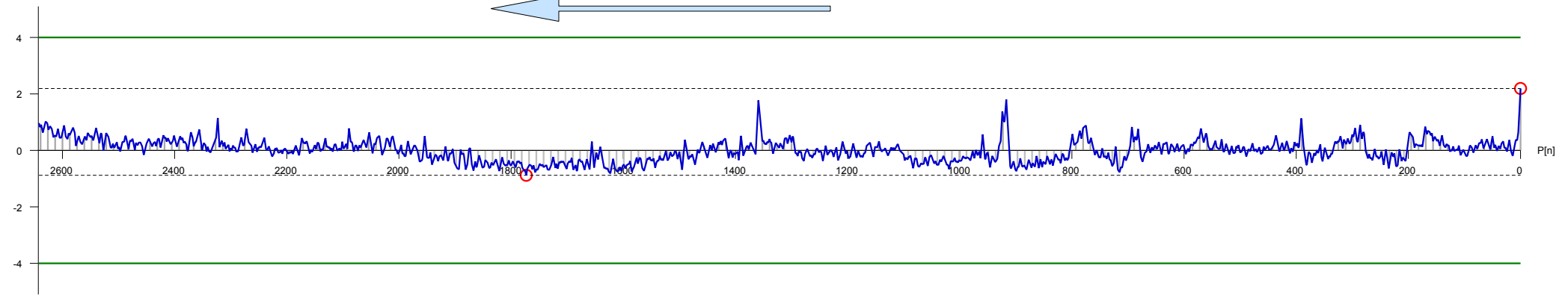


10.0000 µm
1000 : 1

Name	Comment	Actual	Nom	Dev	LowTol	UpTol	Vn	Min	Max	FormMinPt	FormMaxPt	Points	Filter type	Lc	Method
LeadTotal		-80.695	-80.700	0.001	-0.0150	0.0150	0.0073	-0.0044	0.0029	1	1284	2643	Low-pass Gauss	2.4479	Nominal Vector Direction



RadialTotal



2.0000 µm
5000 : 1

Name	Comment	Actual	Tolerance	Min	Max	LowTol	UpTol	Points	Filter type	Lc	Stylus-Ø	Vs[mm/s]	Method
RadialTotal		0.0031	0.0080	-0.0009	0.0022	-0.0040	0.0040	2643	Low-pass Gauss	2.448	7.0002		Nominal Vector Direction

PiWeb Reporting Plus

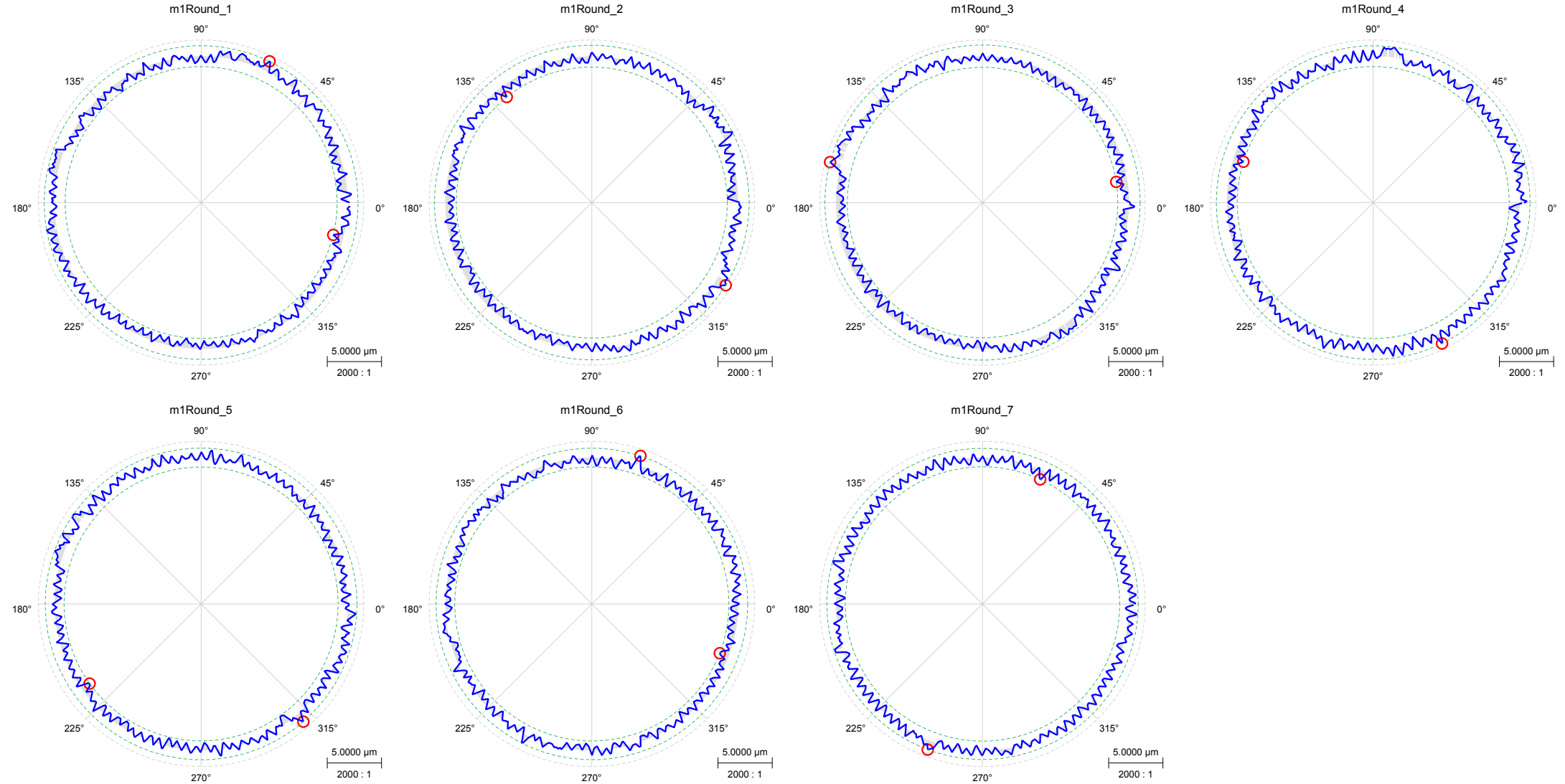
Rundheit

Inspection
Drawing-No
Type
Process
MiniPlan

Order-No 4431227
Part-No Samara_SE135
LeadAngle 5.1355°
Mach-No 123456
Plant CZ IMT GmbH

Gauge-No Lehre-123
Customer MB-Truck
Cost-Center 420
Deprmt SES-AP
Shift Shift-2

Date 3/5/2019 3:41 PM
CMM-No 000000
CMM PRISMO_RT-AB
MPEe = 0.9 ± L / 350
Operator Master



Act 1	Act 2	Act 3	Act 4	Act 5	Act 6	Act 7	Tolerance	Points	Filter type	Lc	W/R	Stylus-Ø	Vs[mm/s]	Method
0.0019	0.0020	0.0021	0.0019	0.0017	0.0017	0.0017	0.0050	1851	Low-pass Spline	-	150	0.0000		Minimum Feature

PiWeb Reporting Plus

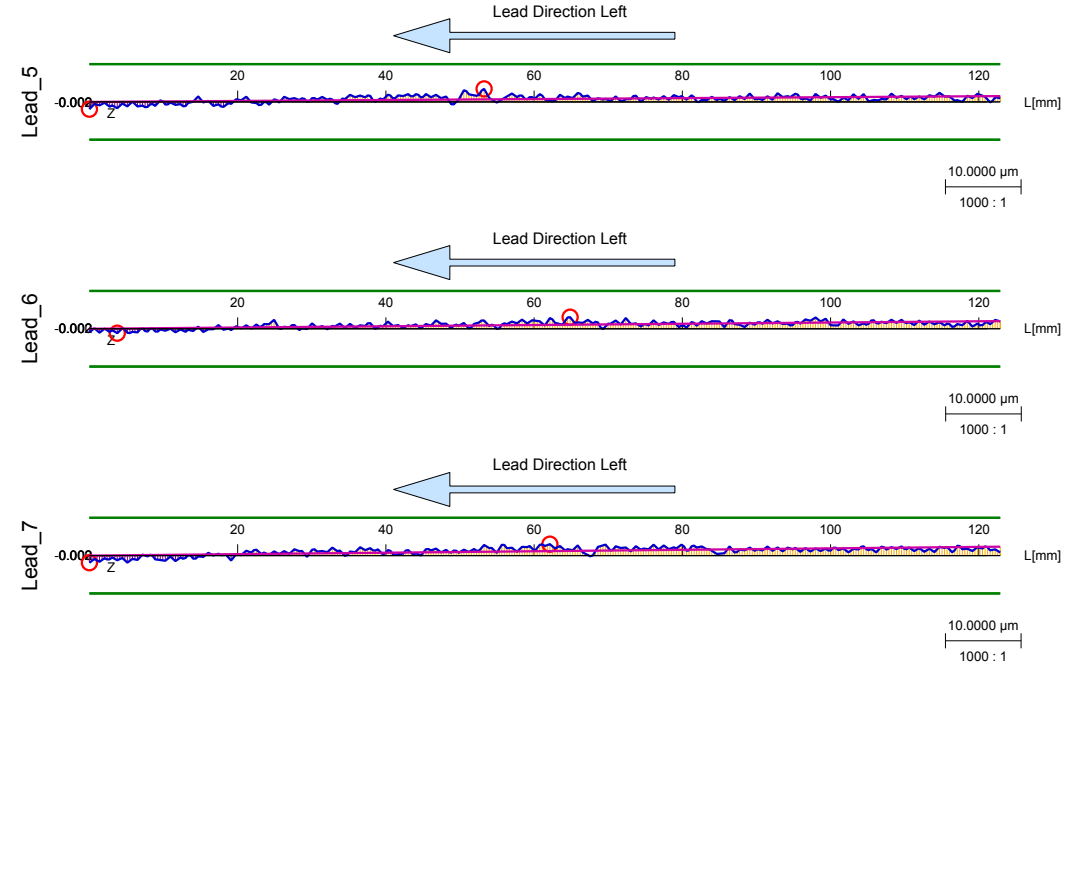
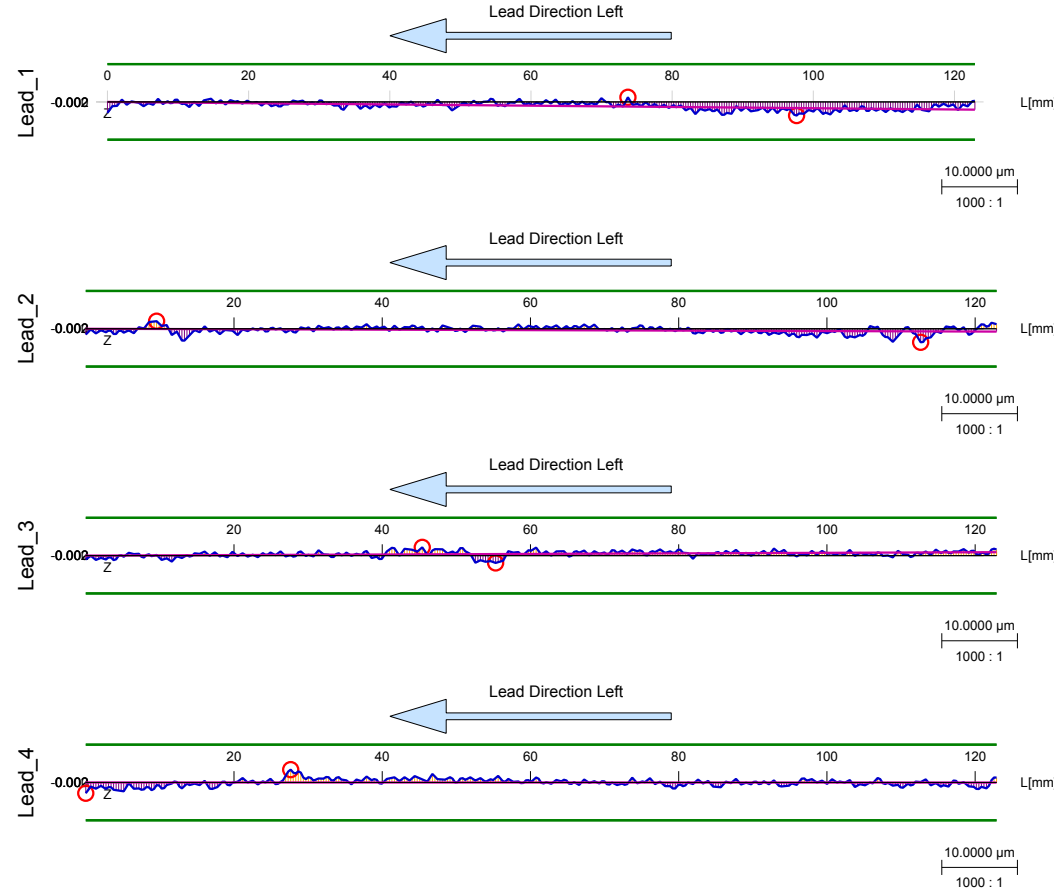
Einzel-Mutter Steigung

Inspection
Drawing-No
Type
Process
MiniPlan

Order-No 4431227
Part-No Samara_SE135
LeadAngle 5.1355°
Mach-No 123456
Plant CZ IMT GmbH

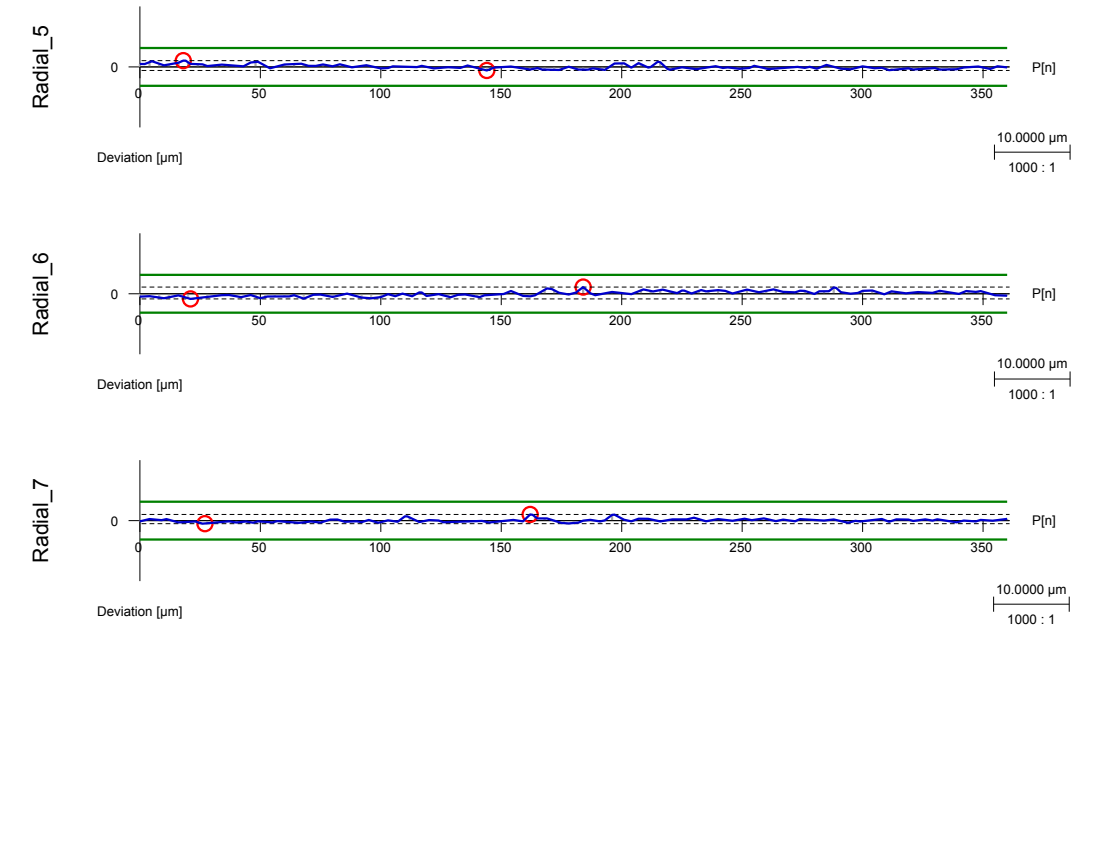
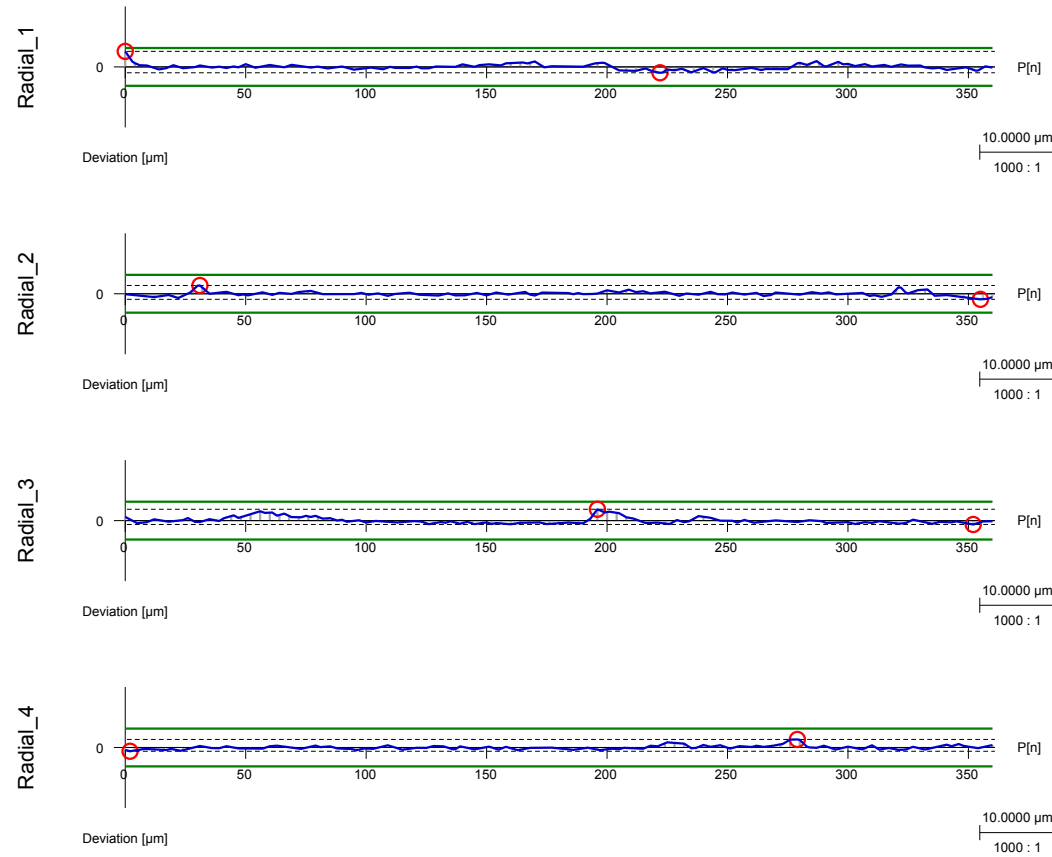
Gauge-No Lehre-123
Customer MB-Truck
Cost-Center 420
Deprmt SES-AP
Shift Shift-2

Date 3/5/2019 3:41 PM
CMM-No 000000
CMM PRISMO_RT-AB
MPEe = 0.9 ± L / 350
Operator Master



Name	Comment	Actual	Nom	Dev	LowTol	UpTol	V2π	Min	Max	FormMinPt	FormMaxPt	Points	Filter type	Lc	Method
Lead_1		-11.001	-11.000	-0.001	-0.0050	0.0050	0.0024	-0.0013	0.0011	1	217	361	Low-pass Gauss	2.4479	Nominal Vector Direction
Lead_2		-11.000	-11.000	0.000	-0.0050	0.0050	0.0028	-0.0016	0.0012	40	359	361	Low-pass Gauss	2.4479	Nominal Vector Direction
Lead_3		-11.000	-11.000	0.000	-0.0050	0.0050	0.0021	-0.0012	0.0008	163	134	361	Low-pass Gauss	2.4479	Nominal Vector Direction
Lead_4		-11.000	-11.000	0.000	-0.0050	0.0050	0.0031	-0.0014	0.0017	1	82	361	Low-pass Gauss	2.4479	Nominal Vector Direction
Lead_5		-10.999	-11.000	0.001	-0.0050	0.0050	0.0027	-0.0013	0.0013	1	157	361	Low-pass Gauss	2.4479	Nominal Vector Direction
Lead_6		-10.999	-11.000	0.001	-0.0050	0.0050	0.0021	-0.0011	0.0010	342	191	361	Low-pass Gauss	2.4479	Nominal Vector Direction
Lead_7		-10.999	-11.000	0.001	-0.0050	0.0050	0.0024	-0.0015	0.0009	16	183	361	Low-pass Gauss	2.4479	Nominal Vector Direction

PiWeb Reporting Plus Einzel-Mutter Radial	Inspection	Order-No	4431227	Gauge-No	Lehre-123	Date	3/5/2019 3:41 PM
	Drawing-No	Part-No	Samara_SE135	Customer	MB-Truck	CMM-No	000000
	Type	LeadAngle	5.1355°	Cost-Center	420	CMM	PRISMO_RT-AB
	Process	Mach-No	123456	Deprmt	SES-AP	MPEe =	0.9 ± L / 350
	MiniPlan	Plant	CZ IMT GmbH	Shift	Shift-2	Operator	Master



Name	Comment	Actual	Tolerance	Min	Max	LowTol	UpTol	Points	Filter type	Lc	Stylus-Ø	Vs[mm/s]	Method
Radial_1		0.0028	0.0050	-0.0008	0.0021	-0.0025	0.0025	361	Low-pass Gauss	2.448	7.0002		Nominal Vector Direction
Radial_2		0.0018	0.0050	-0.0007	0.0011	-0.0025	0.0025	361	Low-pass Gauss	2.448	7.0002		Nominal Vector Direction
Radial_3		0.0020	0.0050	-0.0005	0.0015	-0.0025	0.0025	361	Low-pass Gauss	2.448	7.0002		Nominal Vector Direction
Radial_4		0.0016	0.0050	-0.0005	0.0011	-0.0025	0.0025	361	Low-pass Gauss	2.448	7.0002		Nominal Vector Direction
Radial_5		0.0013	0.0050	-0.0005	0.0008	-0.0025	0.0025	361	Low-pass Gauss	2.448	7.0002		Nominal Vector Direction
Radial_6		0.0016	0.0050	-0.0007	0.0009	-0.0025	0.0025	361	Low-pass Gauss	2.448	7.0002		Nominal Vector Direction
Radial_7		0.0012	0.0050	-0.0004	0.0008	-0.0025	0.0025	361	Low-pass Gauss	2.448	7.0002		Nominal Vector Direction

Inspection
 Drawing-No
 Type
 Process
 MiniPlan

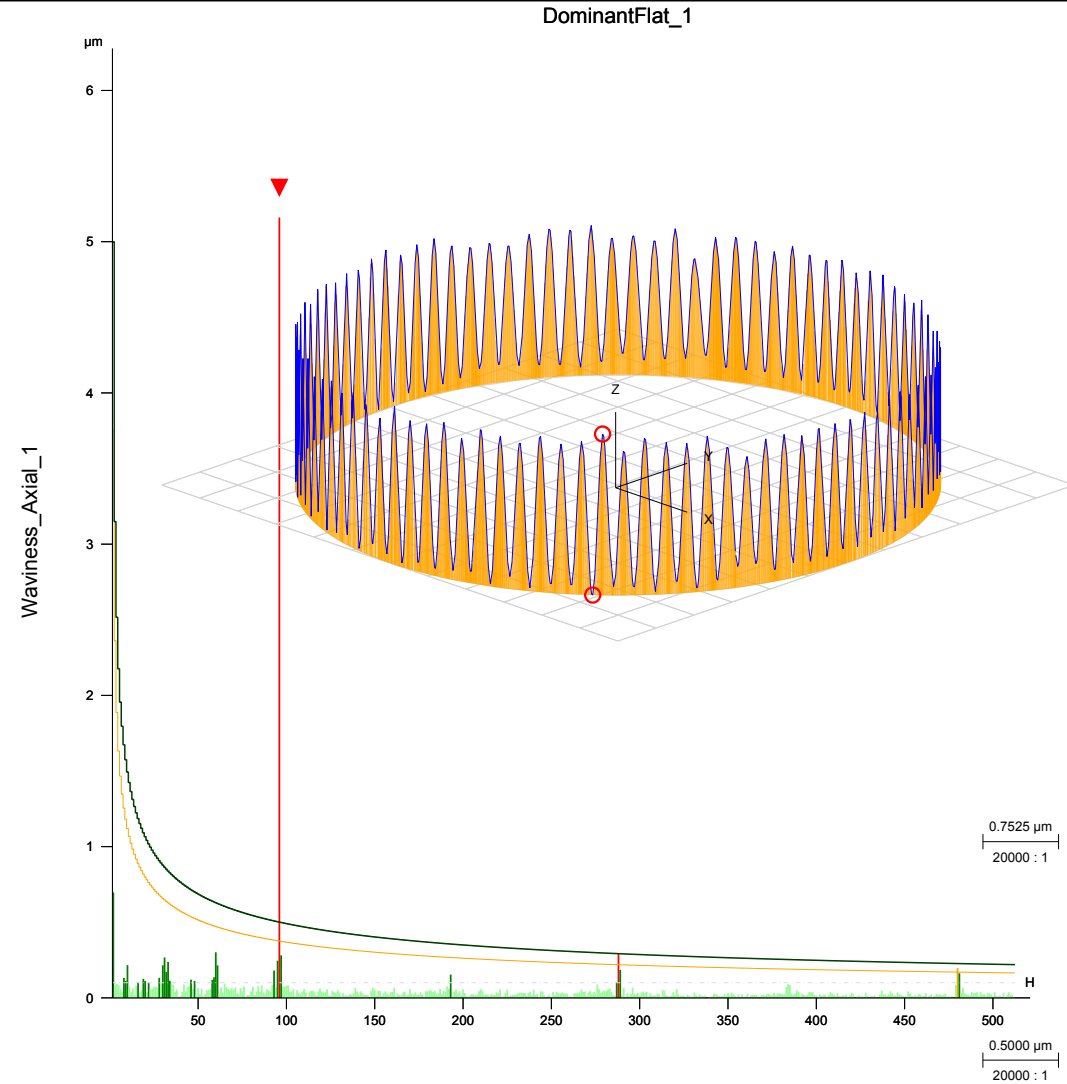
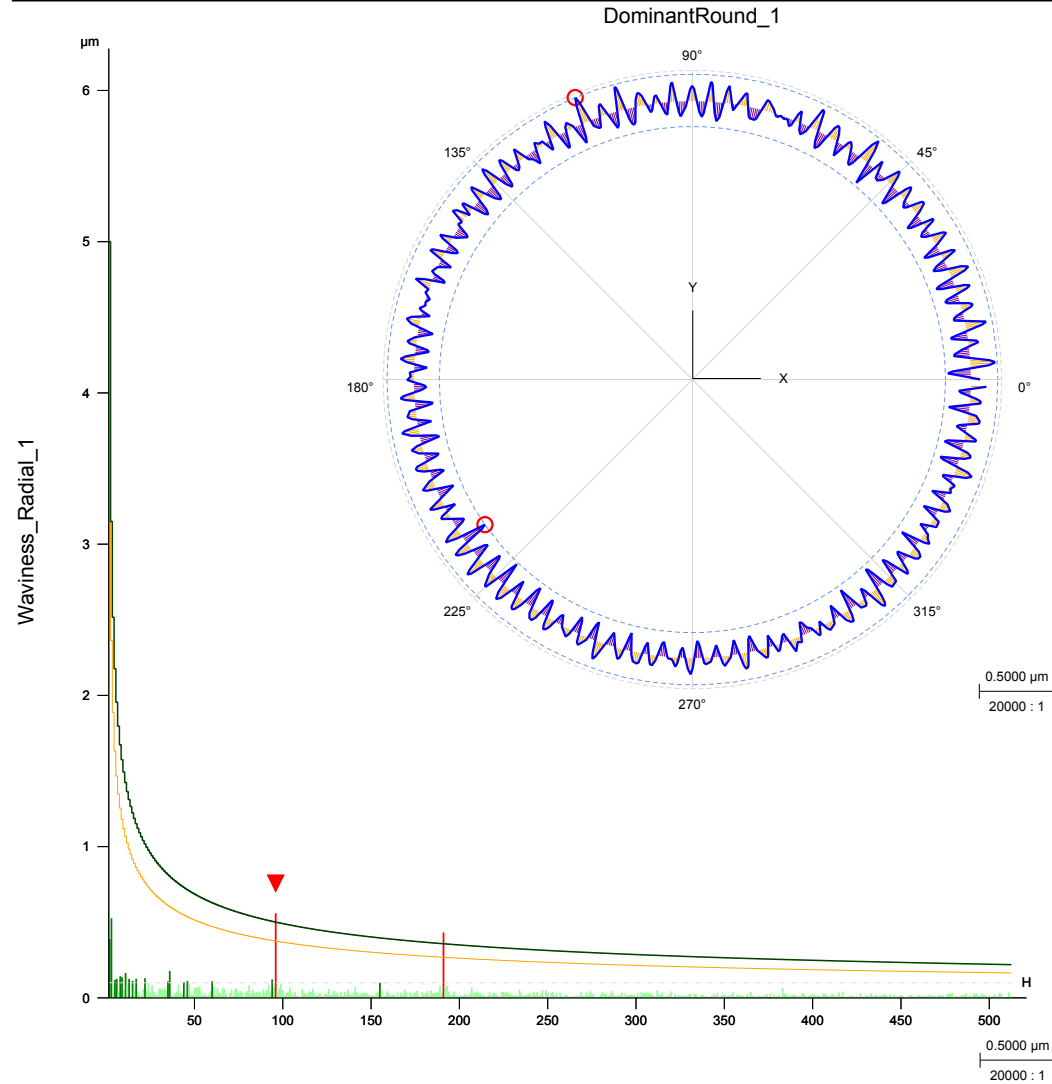
Order-No 4431227
 Part-No Samara_SE135
 LeadAngle 5.1355°
 Mach-No 123456
 Plant CZ IMT GmbH

Gauge-No Lehre-123
 Customer MB-Truck
 Cost-Center 420
 Depmnt SES-AP
 Shift Shift-2

Date 3/5/2019 3:41 PM
 CMM-No 000000
 CMM PRISMO_RT-AB
 MPEe = 0.9 ± L / 350
 Operator Master

PiWeb Reporting Plus

FFT Radial & Axial Schleifen 1



Name	Comment	Points	Filter type	Lc	W/R	Method	Dominant Waviness
Waviness_Radial_1	Dominante Welligkeit = 96	1851	No Filter	-	-	LSQ Feature	0.5774
Waviness_Axial_1	Dominante Welligkeit = 96	1869	No Filter	-	-	LSQ Feature	5.3115

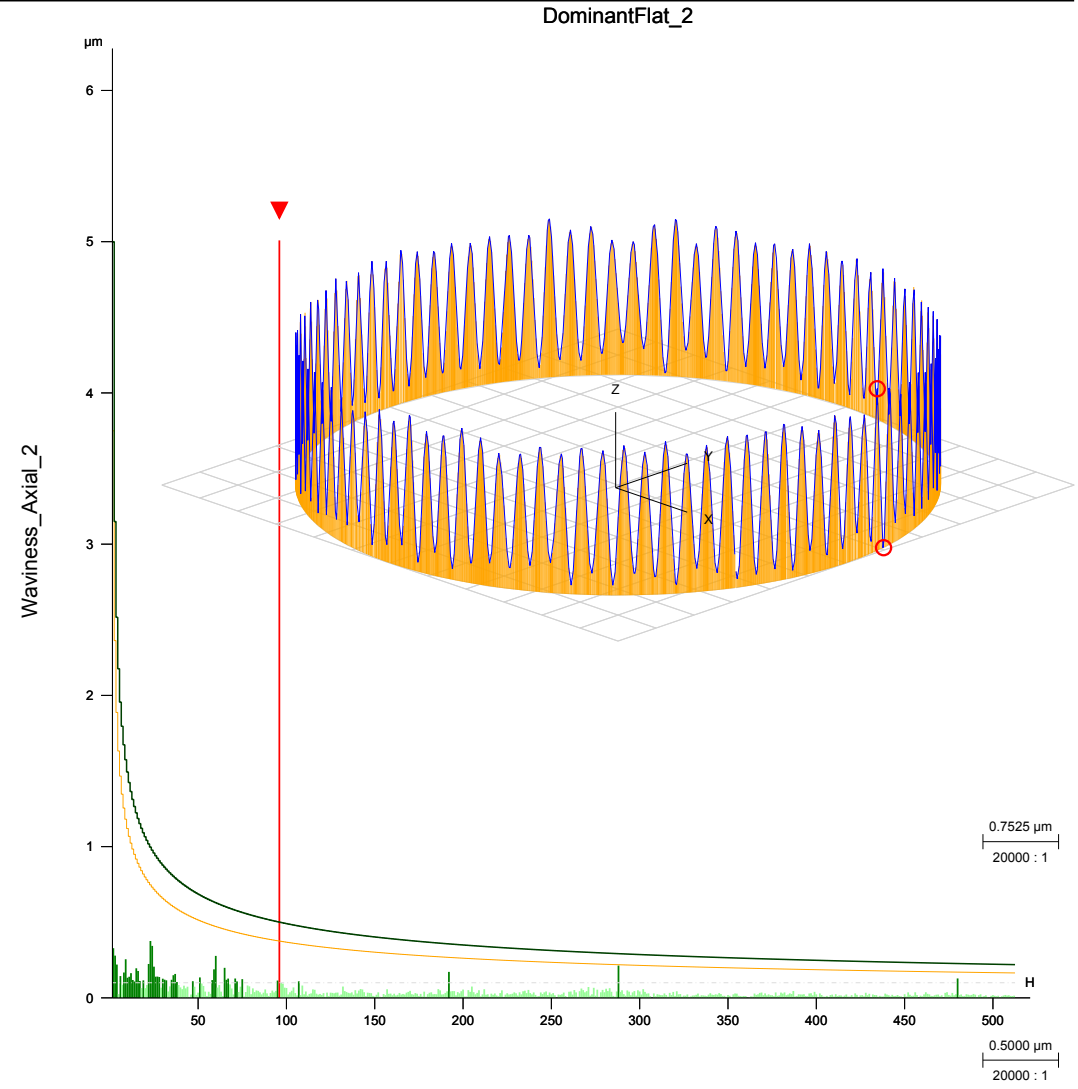
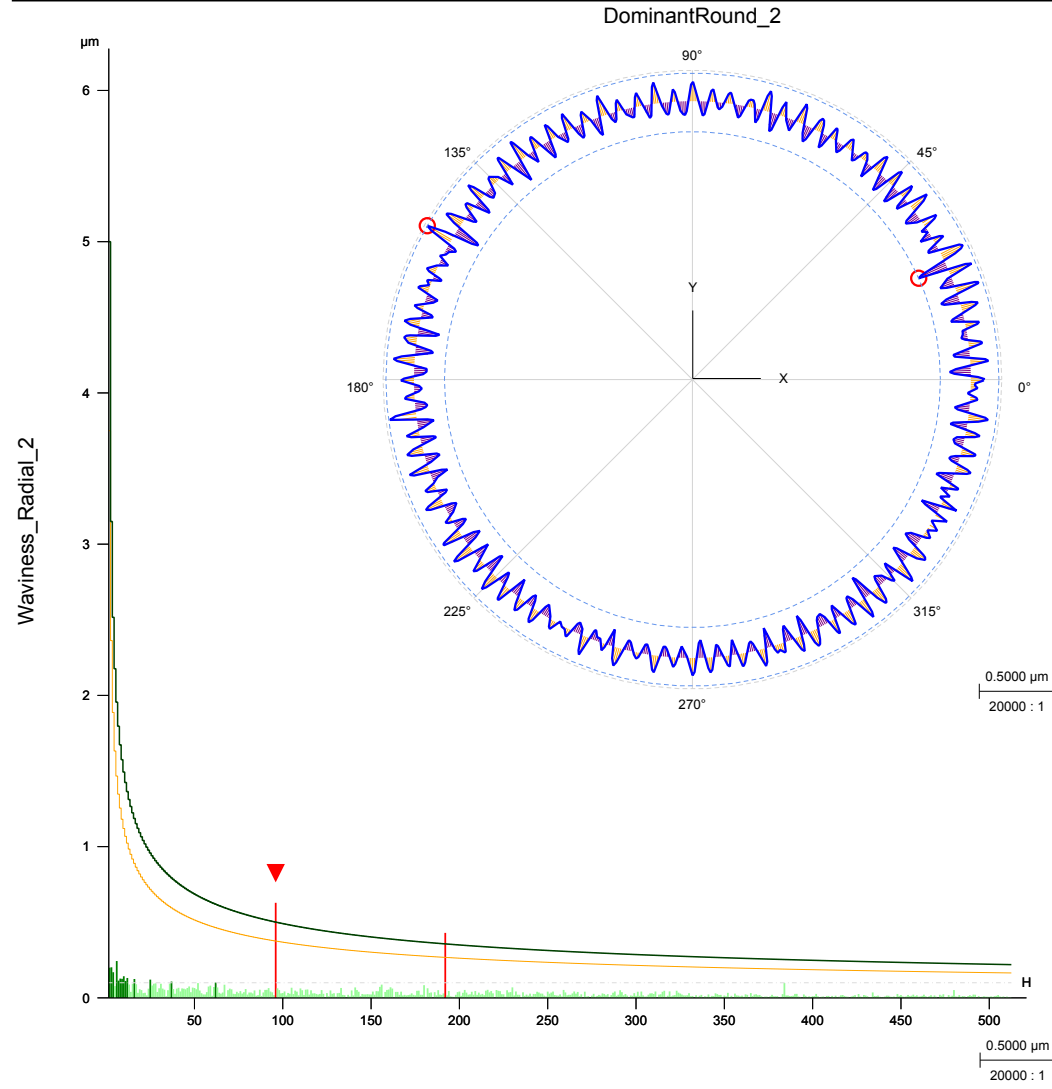
PiWeb Reporting Plus
 FFT Radial & Axial Schleifen 2

Inspection
 Drawing-No
 Type
 Process
 MiniPlan

Order-No 4431227
 Part-No Samara_SE135
 LeadAngle 5.1355°
 Mach-No 123456
 Plant CZ IMT GmbH

Gauge-No Lehre-123
 Customer MB-Truck
 Cost-Center 420
 Depmnt SES-AP
 Shift Shift-2

Date 3/5/2019 3:41 PM
 CMM-No 000000
 CMM PRISMO_RT-AB
 MPEe = 0.9 ± L / 350
 Operator Master



Name	Comment	Points	Filter type	Lc	W/R	Method	Dominant Waviness
Waviness_Radial_2	Dominante Welligkeit = 96	1842	No Filter	-	-	LSQ Feature	0.6447
Waviness_Axial_2	Dominante Welligkeit = 96	1868	No Filter	-	-	LSQ Feature	5.1557

Inspection
 Drawing-No
 Type
 Process
 MiniPlan

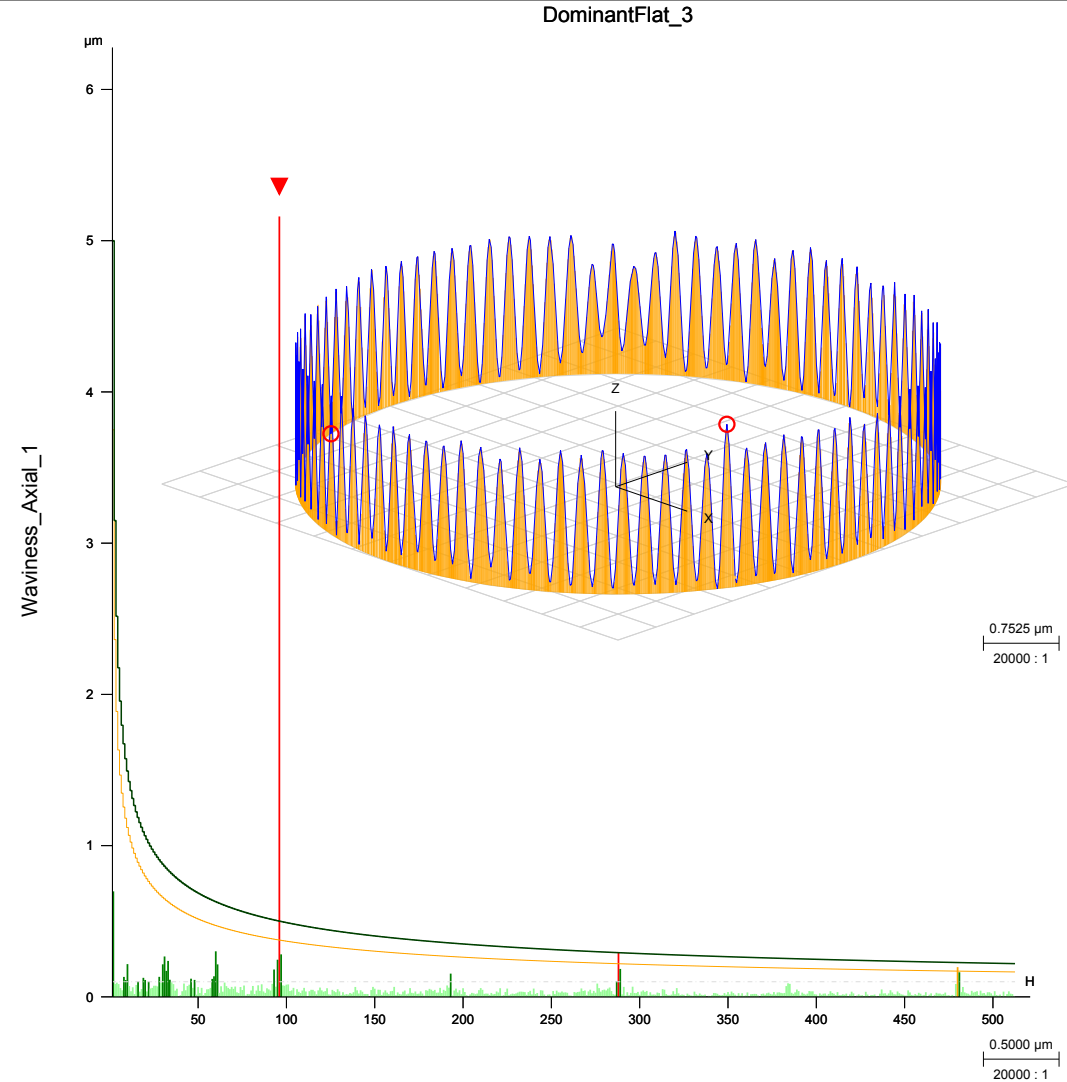
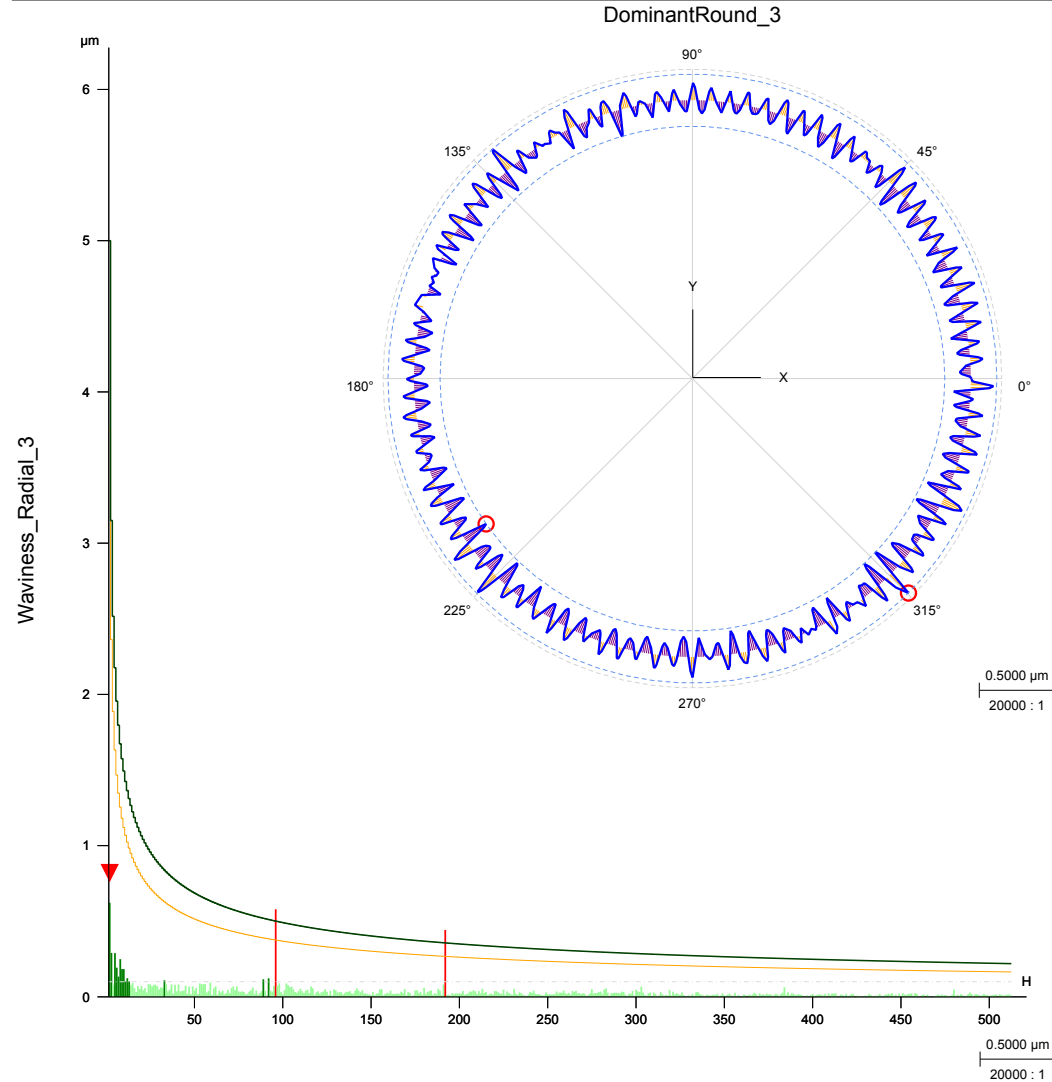
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 Part-No Samara_SE135
 LeadAngle 5.1355°
 Mach-No 123456
 Plant CZ IMT GmbH

Gauge-No Lehre-123
 Customer MB-Truck
 Cost-Center 420
 Depmnt SES-AP
 Shift Shift-2

Date 3/5/2019 3:41 PM
 CMM-No 000000
 CMM PRISMO_RT-AB
 MPEe = 0.9 ± L / 350
 Operator Master

PiWeb Reporting Plus

FFT Radial & Axial Schleifen 3



Name	Comment	Points	Filter type	Lc	W/R	Method	Dominant Waviness
Waviness_Radial_3	Dominante Welligkeit = 96	1813	No Filter	-	-	LSQ Feature	0.5947
Waviness_Axial_3	Dominante Welligkeit = 96	1869	No Filter	-	-	LSQ Feature	5.1092