

Programm CustomizedPlott_CALYPSO_2018

Zeichnungs-Nr 123-456-789 A - 2019.04.01

MiniPlan

0_ALL

Standort

CZ IMT GmbH

Auftrags-Nr Test

Masch-Nr

FlexCenter_1

Abt

SES-AP

Typ CheeseBlock

KMG-Nr

000000

Auftraggeber

CostCenter 123

Operation 5-AxisCenter

MPEe =

2.5 ± L/250

Prüfer

Master

Teile-Nr 270

Schicht

ShiftLabel_1

DMC DMC-Value

Text StartComment

Name	M-C	P-C	Ist	Soll	OT	UT	Abw	Ueb	Toleranz
Kommentar									

1. Temperature

Coefficient of linear Expansion = 23.1 [μ / (delta(°)*m)]

Temperature			20.0000	20.0000			0.0000		
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2.1 Datum Form

Flatness_Z_Spline_8			0.0013	0.0000	0.0200	0.0000	0.0013		
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Flatness_Y_Gauss_8			0.0010	0.0000	0.0200	0.0000	0.0010		
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Flatness_X_RC_8			0.0011	0.0000	0.0200	0.0000	0.0011		
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2.2 Datum Perpendicularity

Perpendicularity_Plane_Right-Top			0.0017	0.0000	0.0200	0.0000	0.0017		
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Perpendicularity_Plane_Front-Left_Top			0.0014	0.0000	0.0200	0.0000	0.0014		
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3.1.1 BorePattern YX

Borepattern_YX			0.0001						
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Borepattern_YX^1^X			0.0000	0.0000	0.1000	0.0000	0.0000		
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Borepattern_YX^1^Y			0.0001	0.0000	0.2000	0.0000	0.0001		
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Borepattern_YX^2^X			0.0000	0.0000	0.1000	0.0000	0.0000		
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Borepattern_YX^2^Y			0.0001	0.0000	0.2000	0.0000	0.0001		
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Borepattern_YX^3^X			0.0000	0.0000	0.1000	0.0000	0.0000		
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Borepattern_YX^3^Y			0.0001	0.0000	0.2000	0.0000	0.0001		
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Borepattern_YX^4^X			0.0001	0.0000	0.1000	0.0000	0.0001		
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Borepattern_YX^4^Y			0.0000	0.0000	0.2000	0.0000	0.0000		
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3.1.2 Roundness YX

Roundness_Circle_XY_30			0.0016	0.0000	0.0200	0.0000	0.0016		
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Roundness_Circle_XY_12_1			0.0020	0.0000	0.0200	0.0000	0.0020		
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Roundness_Circle_XY_12_2			0.0019	0.0000	0.0200	0.0000	0.0019		
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Roundness_Circle_XY_12_3			0.0018	0.0000	0.0200	0.0000	0.0018		
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3.1.3 Diameter YX

Dia_Circle_XY_30			30.0000	30.0000	0.1000	-0.1000	0.0000		
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Name	M-C	P-C	Ist	Soll	OT	UT	Abw	Ueb	Toleranz
Ø Dia_Circle_XY_12_1			12.0000	12.0000	0.1000	-0.1000	0.0000		<div></div>
GS Ø Dia_Circle_XY_12_2			12.0001	12.0000	0.1000	-0.1000	0.0001		<div></div>
GS Ø Dia_Circle_XY_12_3			11.9999	12.0000	0.1000	-0.1000	-0.0001		<div></div>

3.1.4 Straightness Slot

— Straightness_SlotLine_Left			0.0010	0.0000	0.0200	0.0000	0.0010		<div></div>
— Straightness_SlotLine_Right			0.0012	0.0000	0.0200	0.0000	0.0012		<div></div>
— Straightness_40_SlotLine_Bottom			0.0013	0.0000	0.0200	0.0000	0.0013		<div></div>

3.1.5 Curveform

📐 Banana			0.0015	0.0000	0.0000	0.0000	0.0015	0.0015	<div></div>
📐 Banana.standard			0.0020						<div></div>
📐 Banana^1			-0.0004	0.0000	0.0100	-0.0100	-0.0004		<div></div>
📐 Banana^2			-0.0004	0.0000	0.0200	-0.0200	-0.0004		<div></div>
📐 Banana^3			-0.0005	0.0000	0.0100	-0.0100	-0.0005		<div></div>
📐 Banana^4			0.0000	0.0000	0.0200	-0.0200	0.0000		<div></div>
📐 Banana_all			0.0015	0.0000	0.0200	-0.0200	0.0015		<div></div>
📐 Banana_all.standard			0.0020						<div></div>
⤿ Lineform_Banana			0.0131	0.0000	0.0300	0.0000	0.0131		<div></div>
📈 Banana_Form_1			0.0091	0.0000	0.0200	0.0000	0.0091		<div></div>
📈 Banana_Form_2			0.0091	0.0000	0.0400	0.0000	0.0091		<div></div>
📈 Banana_Form_3			0.0091	0.0000	0.0200	0.0000	0.0091		<div></div>
📈 Banana_Form_4			0.0118	0.0000	0.0400	0.0000	0.0118		<div></div>
📐 Banana_ABC			0.0066	0.0000	0.0050	-0.0050	0.0066	0.0016	<div></div>
📐 Banana_ABC.standard			0.0123						<div></div>
📈 Form_Banana_ABC			0.0123	0.0000	0.0100	0.0000	0.0123	0.0023	<div></div>
⤿ Lineform_Banana_ABC			0.0131	0.0000	0.0100	0.0000	0.0131	0.0031	<div></div>
📐 Banana_BestFit			0.0015	0.0000	0.0030	-0.0030	0.0015		<div></div>
📐 Banana_BestFit.range			0.0020						<div></div>
📈 Form_Banana_BestFit			0.0020	0.0000	0.0060	0.0000	0.0020		<div></div>
⤿ Lineform_Banana_BestFit			0.0029	0.0000	0.0060	0.0000	0.0029		<div></div>

3.2.1 Borepattern ZY

⊕ Borepattern_YZ			0.0002						<div></div>
⊕ Borepattern_YZ^1			0.0002	0.0000	0.0200	0.0000	0.0002		<div></div>

Name Kommentar	M-C	P-C	Ist	Soll	OT	UT	Abw	Ueb	Toleranz
⊕ Borepattern_YZ^2			0.0001	0.0000	0.0200	0.0000	0.0001	<div><div></div></div>	
⊕ Borepattern_YZ^3			0.0001	0.0000	0.0200	0.0000	0.0001	<div><div></div></div>	
⊕ Borepattern_YZ^4			0.0002	0.0000	0.0200	0.0000	0.0002	<div><div></div></div>	
⊕ Borepattern_YZ^5			0.0002	0.0000	0.0200	0.0000	0.0002	<div><div></div></div>	
⊕ Borepattern_YZ^6			0.0000	0.0000	0.0200	0.0000	0.0000	<div><div></div></div>	
⊕ Borepattern_YZ^7			0.0001	0.0000	0.0200	0.0000	0.0001	<div><div></div></div>	
⊕ Borepattern_YZ^8			0.0001	0.0000	0.0200	0.0000	0.0001	<div><div></div></div>	
⊕ Borepattern_YZ^9			0.0002	0.0000	0.0200	0.0000	0.0002	<div><div></div></div>	

3.2.2 Roundness ZY

○ Roundness_Circle_ZY_12_Center			0.0018	0.0000	0.0200	0.0000	0.0018	<div><div></div></div>	
○ Roundness_Circle_ZY_12_1			0.0021	0.0000	0.0200	0.0000	0.0021	<div><div></div></div>	
○ Roundness_Circle_ZY_12_2			0.0019	0.0000	0.0200	0.0000	0.0019	<div><div></div></div>	
○ Roundness_Circle_ZY_12_3			0.0020	0.0000	0.0200	0.0000	0.0020	<div><div></div></div>	
○ Roundness_Circle_ZY_12_4			0.0018	0.0000	0.0200	0.0000	0.0018	<div><div></div></div>	
○ Roundness_Circle_ZY_6_1			0.0018	0.0000	0.0200	0.0000	0.0018	<div><div></div></div>	
○ Roundness_Circle_ZY_6_2			0.0022	0.0000	0.0200	0.0000	0.0022	<div><div></div></div>	
○ Roundness_Circle_ZY_6_3			0.0018	0.0000	0.0200	0.0000	0.0018	<div><div></div></div>	
○ Roundness_Circle_ZY_6_4			0.0018	0.0000	0.0200	0.0000	0.0018	<div><div></div></div>	

3.2.3 Diameter ZY

∅ Dia_Circle_ZY_12_Center			12.0000	12.0000	0.1000	-0.1000	0.0000	<div><div></div></div>	
GG ∅ Dia_Circle_ZY_12_1			11.9999	12.0000	0.1000	-0.1000	-0.0001	<div><div></div></div>	
GG ∅ Dia_Circle_ZY_12_2			12.0000	12.0000	0.1000	-0.1000	0.0000	<div><div></div></div>	
GG ∅ Dia_Circle_ZY_12_3			12.0000	12.0000	0.1000	-0.1000	0.0000	<div><div></div></div>	
GG ∅ Dia_Circle_ZY_12_4			11.9999	12.0000	0.1000	-0.1000	-0.0001	<div><div></div></div>	
GG ∅ Dia_Circle_ZY_6_1			6.0001	6.0000	0.0500	-0.0500	0.0001	<div><div></div></div>	
GG ∅ Dia_Circle_ZY_6_2			6.0000	6.0000	0.0500	-0.0500	0.0000	<div><div></div></div>	
GG ∅ Dia_Circle_ZY_6_3			6.0000	6.0000	0.0500	-0.0500	0.0000	<div><div></div></div>	
GG ∅ Dia_Circle_ZY_6_4			6.0000	6.0000	0.0500	-0.0500	0.0000	<div><div></div></div>	

3.3.1 Borepattern XZ

⊕ Borepattern_XZ			0.0003					<div><div></div></div>	
⊕ Borepattern_XZ^1			0.0001	0.0000	0.0500	0.0000	0.0001	<div><div></div></div>	
⊕ Borepattern_XZ^2			0.0001	0.0000	0.0500	0.0000	0.0001	<div><div></div></div>	

Name	M-C	P-C	Ist	Soll	OT	UT	Abw	Ueb	Toleranz
⊕ Borepattern_XZ^3			0.0003	0.0000	0.0500	0.0000	0.0003	<div><div></div></div>	
⊕ Borepattern_XZ^4			0.0002	0.0000	0.0500	0.0000	0.0002	<div><div></div></div>	

3.3.2 Roundness XZ

○ Roundness_Circle_XZ_15			0.0018	0.0000	0.0200	0.0000	0.0018	<div><div></div></div>	
○ Roundness_Circle_XZ_30			0.0040	0.0000	0.0200	0.0000	0.0040	<div><div></div></div>	
○ Roundness_Circle_XZ_12			0.0026	0.0000	0.0200	0.0000	0.0026	<div><div></div></div>	
○ Roundness_Circle_XZ_20			0.0006	0.0000	0.0200	0.0000	0.0006	<div><div></div></div>	

3.3.3 Diameter XZ

⌀ Dia_Circle_XZ_15			15.0000	15.0000	0.1000	-0.1000	0.0000	<div><div></div></div>	
Ⓞ Dia_Circle_XZ_30			30.0000	30.0000	0.1000	-0.1000	0.0000	<div><div></div></div>	
Ⓞ Dia_Circle_XZ_12			12.0001	12.0000	0.1000	-0.1000	0.0001	<div><div></div></div>	
Ⓞ Dia_Circle_XZ_20			20.0001	20.0000	0.1000	-0.1000	0.0001	<div><div></div></div>	

3.3.4 Cylindricity_Cylinder_30_Y

Ⓢ Cylindricity_Cylinder_XZ_30_Line			0.0015	0.0000	0.0200	0.0000	0.0015	<div><div></div></div>	
Ⓢ Cylindricity_RCylinder_XZ_30			0.0015	0.0000	0.0200	0.0000	0.0015	<div><div></div></div>	
Ⓢ Cylindricity_Cylinder_XZ_30_Helix			0.0015	0.0000	0.0200	0.0000	0.0015	<div><div></div></div>	
Ⓢ Cylindricity_CircularLineCylinder_XZ_30_Circ...			0.0026	0.0000	0.2000	0.0000	0.0026	<div><div></div></div>	

3.3.5 Straightness_Cylinder_30_Y

— Straightness_Axis_N			0.0001	0.0000	0.0020	0.0000	0.0001	<div><div></div></div>	
— Straightness_Axis_P			0.0003	0.0000	0.0020	0.0000	0.0003	<div><div></div></div>	
— Straightness_Axis_3D			0.0003	0.0000	0.0050	0.0000	0.0003	<div><div></div></div>	

3.3.6 Perpendicularity_Cylinder_30_Y - Plane_Front

⊥ Perpendicularity_Axis-Y_Front-Top			0.0001	0.0000	0.0020	0.0000	0.0001	<div><div></div></div>	
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4. Parallelism

// Parallelism_Left2Right			0.0027	0.0000	0.0200	0.0000	0.0027	<div><div></div></div>	
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5. Angularity

⊥ Perpendicularity_Plane40_Front			0.0041	0.0000	0.0200	0.0000	0.0041	<div><div></div></div>	
∠ Angularity_PlaneTilted2TopPlane			0.2359	0.0000	0.5000	0.0000	0.2359	<div><div></div></div>	

6. Surfaceform

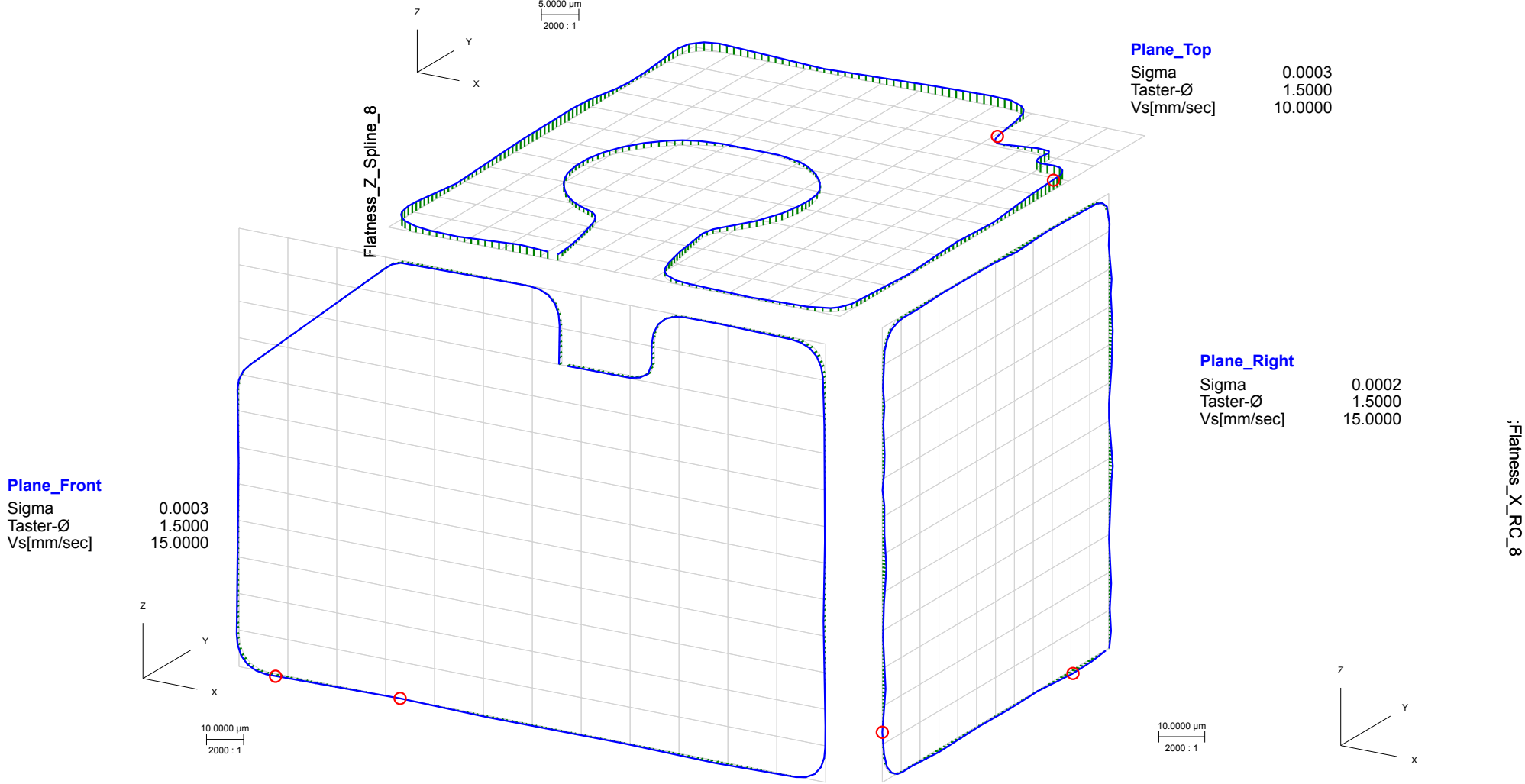
⤿ Surfaceform			0.0140	0.0000	0.0200	0.0000	0.0140	<div><div></div></div>	
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Customer

PiWeb Reporting Plus

Flatness Datum

Programm	CustomizedPlott_CALYPSO_2018	MiniPlan	0_ALL	Datum	02.06.2019 15:27
Zeichungs-Nr	123-456-789-A - 2019.04.01	Maschinen-Nr	FlexCenter_1	Firma	CZ IMT GmbH
Auftrags-Nr	Test	Auftraggeber	CostCenter 123	Abt	SES-AP
Teil-Nr	270	Operation	5-AxisCenter	Prüfer	Master - ShiftLabel_1
Typ	CheeseBlock	KMG-Nr	000000	MPEe =	2.5 ± L/250



Name	Kommentar	IST	TOL	Methode	Min	Max	Punkte	Filtertyp	Lc	W/U
Flatness_Z_Spline_8		0.001	0.020	Minimum-Element	-0.001	0.001	374	Tiefpass Gauß	25 -	-
Flatness_Y_Gauss_8		0.001	0.020	Minimum-Element	0.000	0.000	399	Tiefpass Spline	25 -	-
Flatness_X_RC_8		0.001	0.020	Minimum-Element	-0.001	0.001	467	Tiefpass 2RC	25 -	-

Customer

PiWeb Reporting Plus

Programm
Zeichungs-Nr
Auftrags-Nr
Teil-Nr
Typ

CustomizedPlott_CALYPSO_2018
123-456-789-A - 2019.04.01
Test
270
CheeseBlock

MiniPlan
Maschinen-Nr
Auftraggeber
Operation
KMG-Nr

0_ALL
FlexCenter_1
CostCenter 123
5-AxisCenter
000000

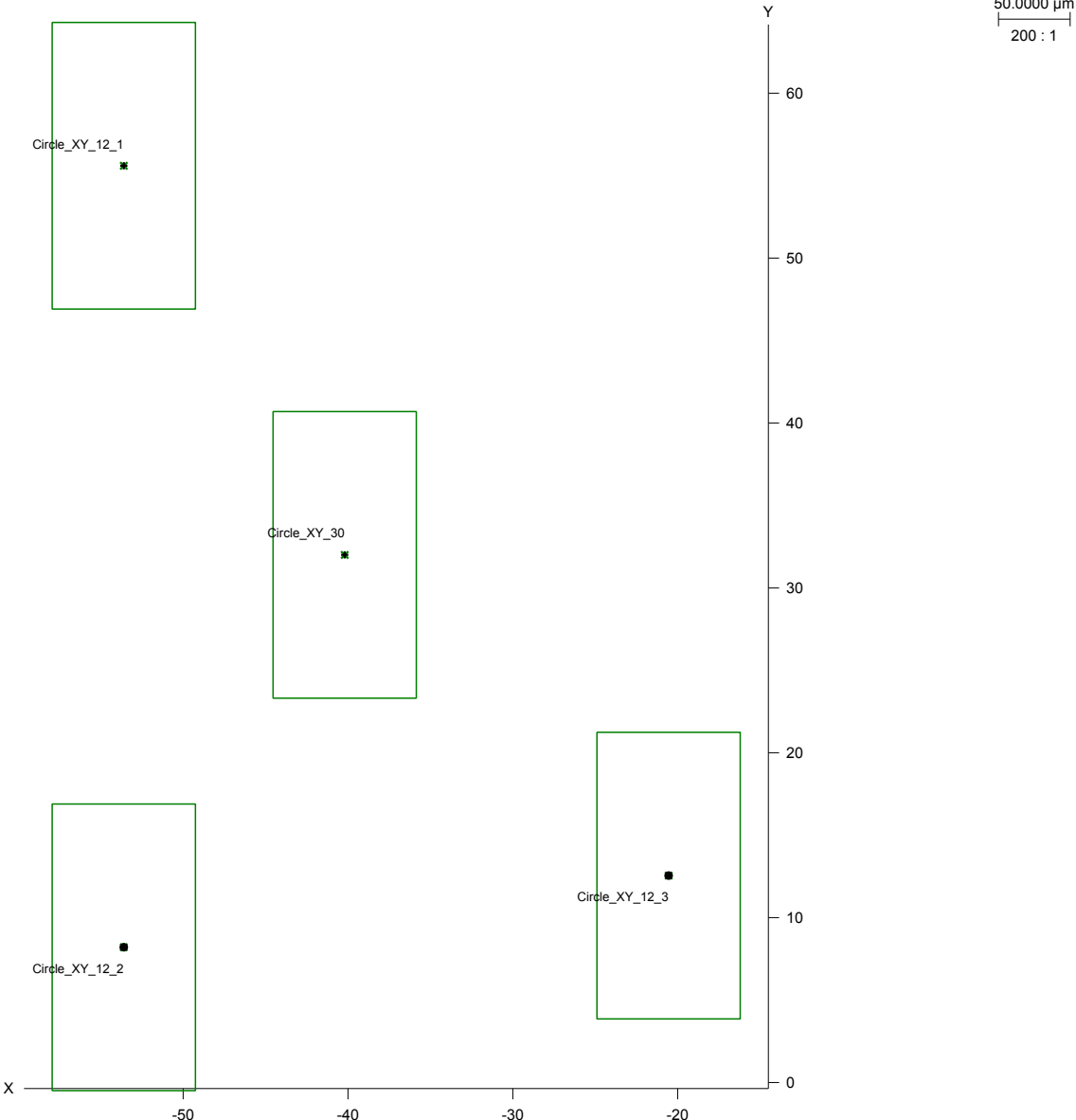
Datum
Firma
Abt
Prüfer
MPEe =
02.06.2019 15:27
CZ IMT GmbH
SES-AP
Master - ShiftLabel_1
2.5 ± L/250

Pattern YX

Name	Kommentar	IST	TOL
Borepattern_YX		0.0001	
Borepattern_YX^1^X		0.0000	0.1000
Borepattern_YX^1^Y		0.0001	0.2000
Borepattern_YX^2^X		0.0000	0.1000
Borepattern_YX^2^Y		0.0001	0.2000
Borepattern_YX^3^X		0.0000	0.1000
Borepattern_YX^3^Y		0.0001	0.2000
Borepattern_YX^4^X		0.0001	0.1000
Borepattern_YX^4^Y		0.0000	0.2000

Einpassergebnis Borepattern_YX	
Trans X [mm]	0.0050
Trans Y [mm]	0.0020
Trans Z [mm]	
Rot Winkel [°]	0.0000

Name	Kommentar	IST	SOLL	OT	UT
Dia_Circle_XY_30		30.0000	30.0000	0.1000	-0.1000
Dia_Circle_XY_12_1		12.0000	12.0000	0.1000	-0.1000
Dia_Circle_XY_12_2		12.0001	12.0000	0.1000	-0.1000
Dia_Circle_XY_12_3		11.9999	12.0000	0.1000	-0.1000



Customer**PiWeb
Reporting Plus**

Programm
Zeichnungs-Nr
Auftrags-Nr
Teil-Nr
Typ

CustomizedPlott_CALYPSO_2018
123-456-789-A - 2019.04.01
Test
270
CheeseBlock

MiniPlan
Maschinen-Nr
Auftraggeber
Operation
KMG-Nr

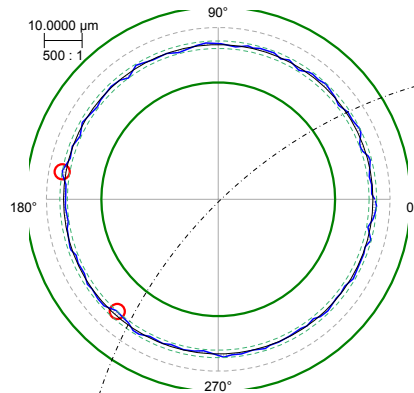
0_ALL
FlexCenter_1
CostCenter 123
5-AxisCenter
000000

Datum
Firma
Abt
Prüfer
MPEe =

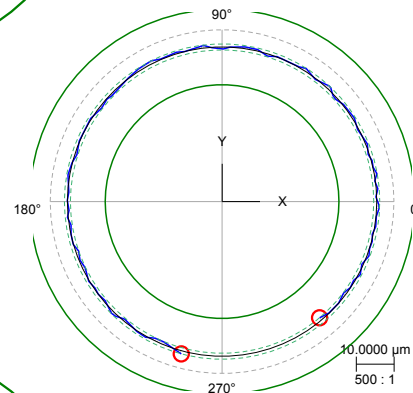
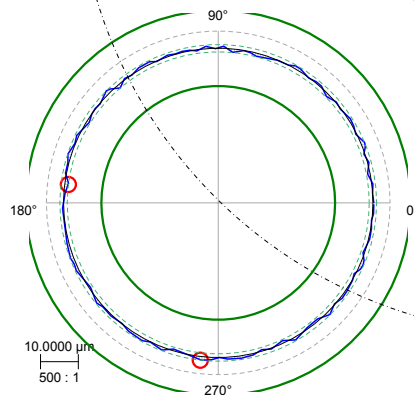
02.06.2019 15:27
CZ IMT GmbH
SES-AP
Master - ShiftLabel_1
2.5 ± L/250

RoundnessYX**Circle_XY_12_1**

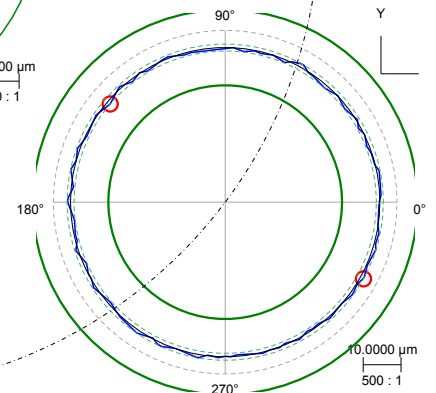
Sigma 0.0004
Taster-Ø 1.5000
Vs[mm/sec] 5.0000

**Circle_XY_12_2**

Sigma 0.0004
Taster-Ø 1.5000
Vs[mm/sec] 5.0000

**Circle_XY_30**

Sigma 0.0004
Taster-Ø 1.5000
Vs[mm/sec] 15.0000

**Circle_XY_12_3**

Sigma 0.0004
Taster-Ø 1.5000
Vs[mm/sec] 5.0000

Name	Kommentar	IST	TOL	Methode	USG	OSG	Min	Max	Punkte	Filtertyp	Lc	W/U
Roundness_Circle_XY_30		0.002	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	720	Tiefpass Gauß	-	50 -
Roundness_Circle_XY_12_1		0.002	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	720	Tiefpass Spline	-	50 -
Roundness_Circle_XY_12_2		0.002	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	720	Tiefpass Spline	-	50 -
Roundness_Circle_XY_12_3		0.002	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	720	Tiefpass Spline	-	50 -

Customer

PiWeb
Reporting Plus

Programm
Zeichungs-Nr
Auftrags-Nr
Teil-Nr
Typ

CustomizedPlott_CALYPSO_2018
123-456-789-A - 2019.04.01
Test
270
CheeseBlock

MiniPlan
Maschinen-Nr
Auftraggeber
Operation
KMG-Nr

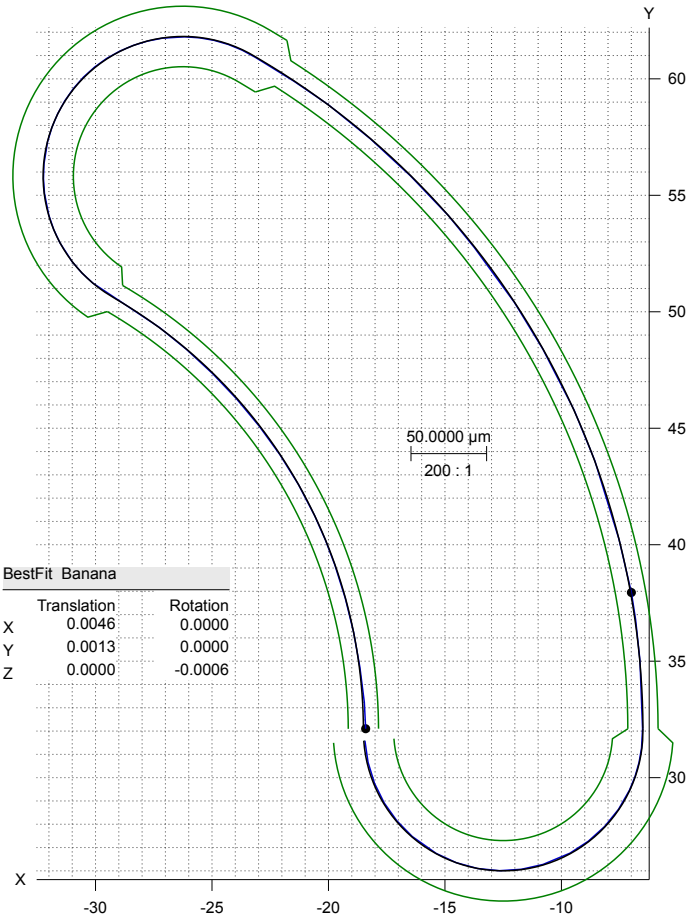
0_ALL
FlexCenter_1
CostCenter 123
5-AxisCenter
000000

Datum
Firma
Abt
Prüfer
MPEe =

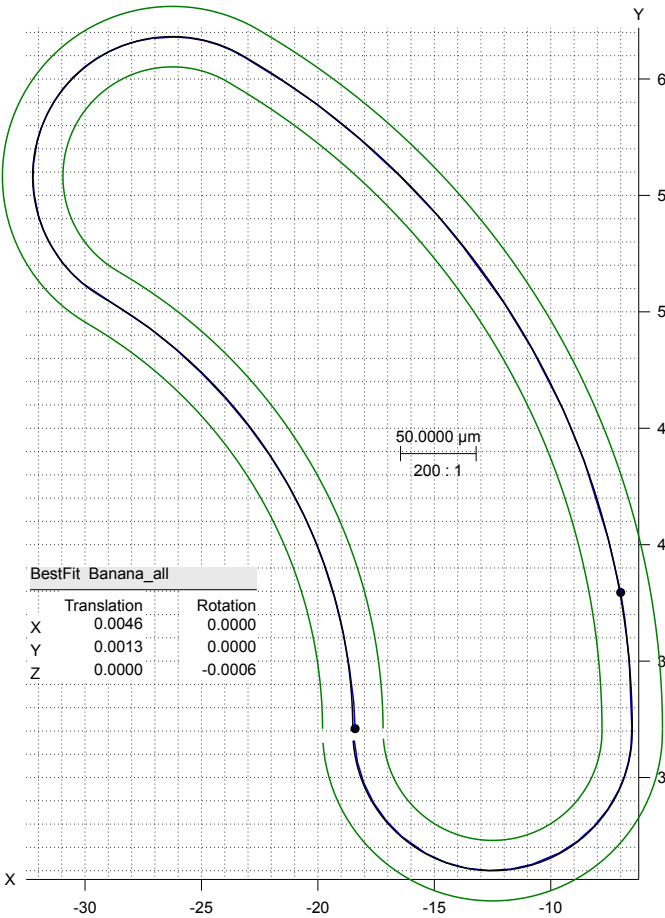
02.06.2019 15:27
CZ IMT GmbH
SES-AP
Master - ShiftLabel_1
2.5 ± L/250

Curve YX

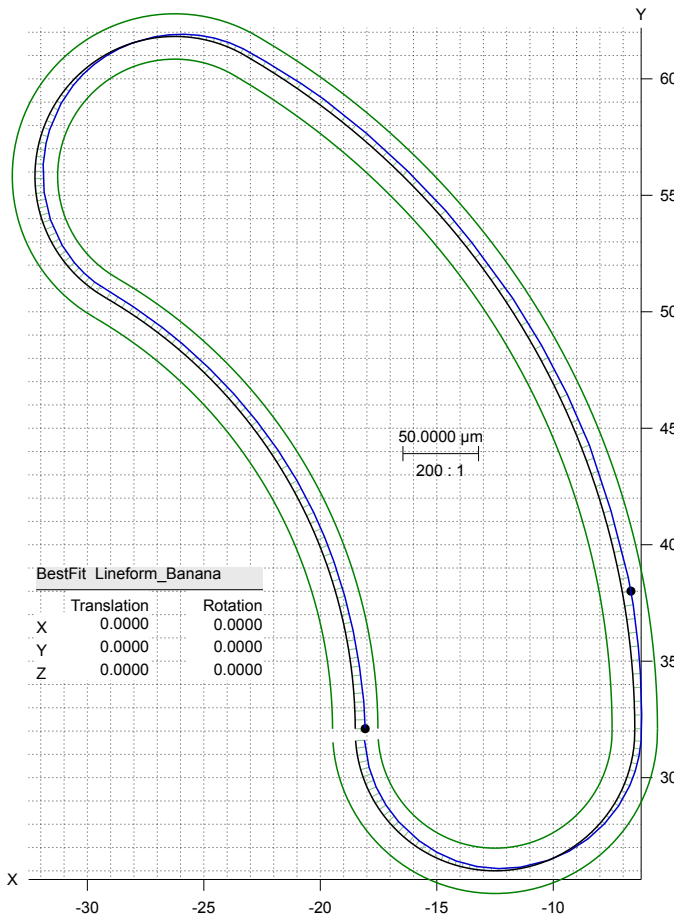
Banana



Banana_all



Lineform_Banana



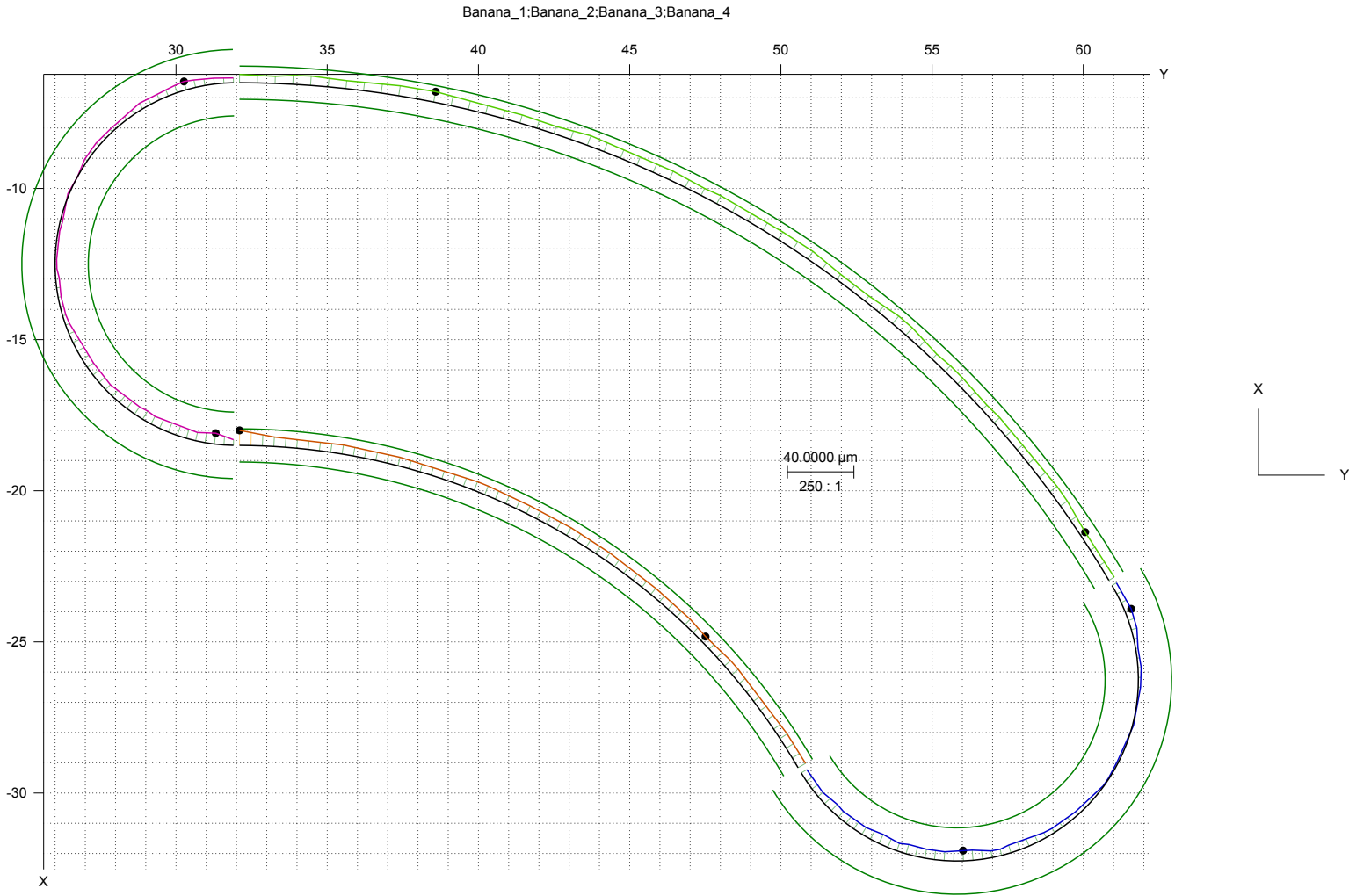
Name	Kommentar	Min	Max	Range	UT	OT	Punkte	Filtertyp	Lc	Taster-Ø	Vs[mm/sec]	Methode
Banana		-0.0005	0.0015	0.0020	0.0000	0.0000	237	Tiefpass Gauß	8.000	1.5000	3.000	Sollvektorrichtung
Banana_all		-0.0005	0.0015	0.0020	-0.0200	0.0200	237	Tiefpass Gauß	8.000	1.5000	3.000	Sollvektorrichtung
Lineform_Banana		-0.0057	0.0066	0.0123	0.0000	0.0300	237	Tiefpass Gauß	8.000	1.5000	3.000	Sollvektorrichtung

Customer

PiWeb Reporting Plus

Segment Curve YX

Programm	CustomizedPlott_CALYPSO_2018	MiniPlan	0_ALL	Datum	02.06.2019 15:27
Zeichungs-Nr	123-456-789-A - 2019.04.01	Maschinen-Nr	FlexCenter_1	Firma	CZ IMT GmbH
Auftrags-Nr	Test	Auftraggeber	CostCenter 123	Abt	SES-AP
Teil-Nr	270	Operation	5-AxisCenter	Prüfer	Master - ShiftLabel_1
Typ	CheeseBlock	KMG-Nr	000000	MPEe =	2.5 ± L/250




Name	Kommentar	Min	Max	Range	UT	OT	Punkte	Filtertyp	Lc	Taster-Ø	Vs[mm/sec]	Methode
Banana_1		0.0036	0.0091	0.0054	-0.0100	0.0100	60	Tiefpass Gauß	2.500	1.5000		Sollvektorrichtung
Banana_2		-0.0040	0.0062	0.0103	-0.0200	0.0200	60	Tiefpass Gauß	1.250	1.5000		Sollvektorrichtung
Banana_3		-0.0063	-0.0033	0.0030	-0.0100	0.0100	60	Tiefpass Gauß	2.500	1.5000		Sollvektorrichtung
Banana_4		-0.0052	0.0066	0.0118	-0.0200	0.0200	60	Tiefpass Gauß	1.250	1.5000		Sollvektorrichtung

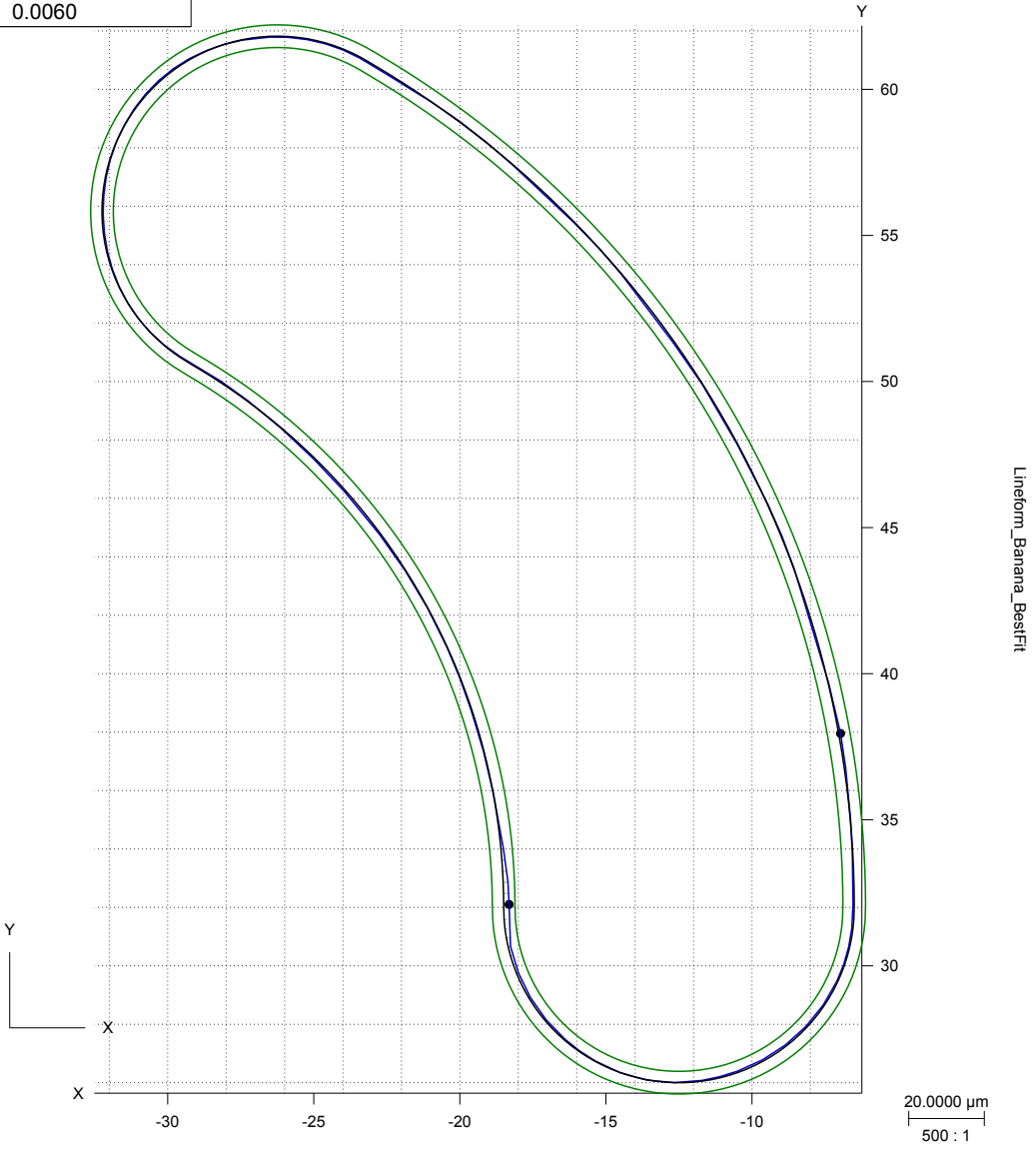
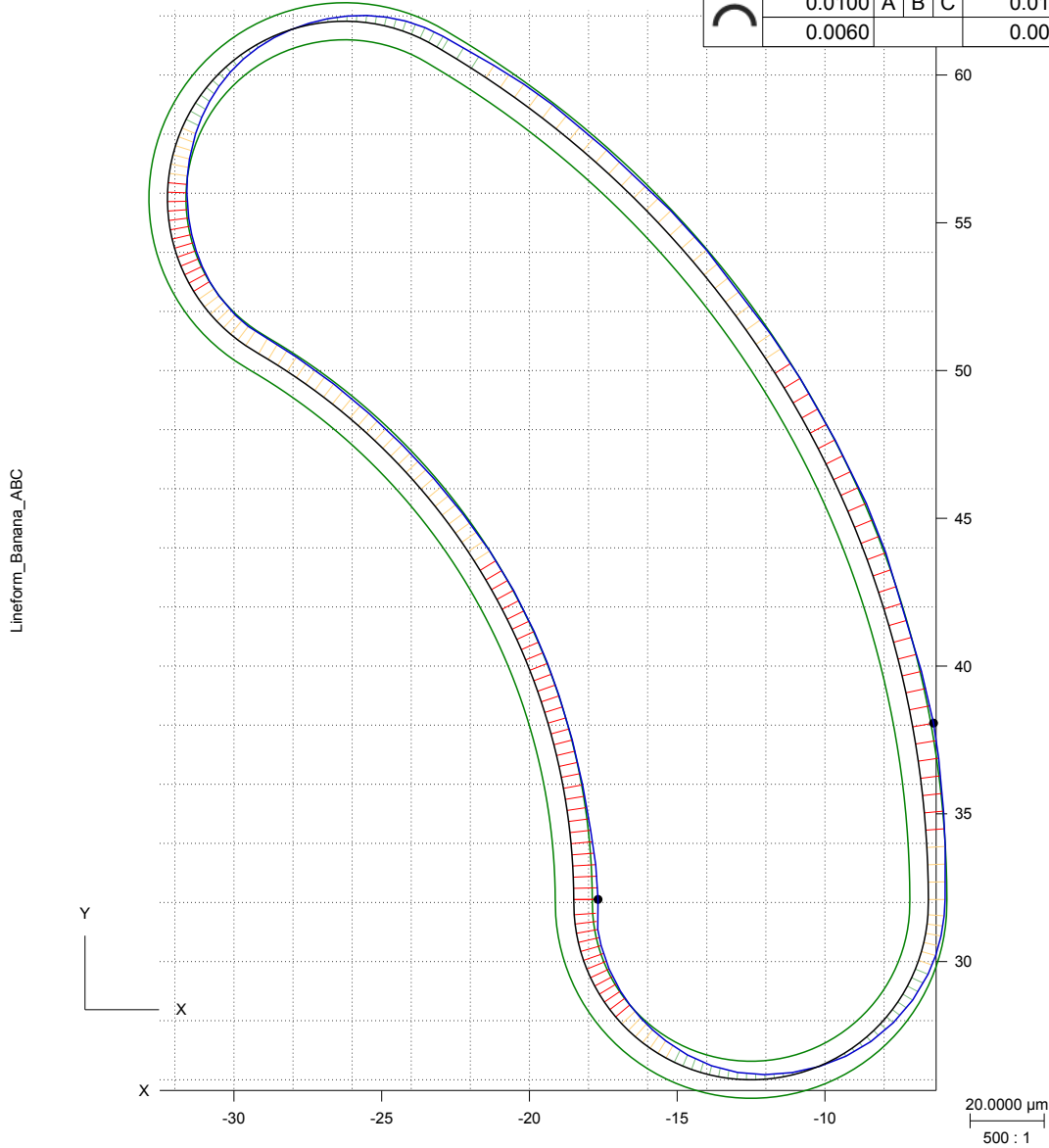
Customer

PiWeb Reporting Plus

Lineform YX

Programm	CustomizedPlott_CALYPSO_2018	MiniPlan	0_ALL	Datum	02.06.2019 15:27
Zeichungs-Nr	123-456-789-A - 2019.04.01	Maschinen-Nr	FlexCenter_1	Firma	CZ IMT GmbH
Auftrags-Nr	Test	Auftraggeber	CostCenter 123	Abt	SES-AP
Teil-Nr	270	Operation	5-AxisCenter	Prüfer	Master - ShiftLabel_1
Typ	CheeseBlock	KMG-Nr	000000	MPEe =	2.5 ± L/250

Banana				IST	TOL	UEB
	0.0100	A	B	0.0131	0.0100	0.0031
	0.0060		C	0.0029	0.0060	



Customer

PiWeb Reporting Plus

Programm
Zeichungs-Nr
Auftrags-Nr
Teil-Nr
Typ

CustomizedPlott_CALYPSO_2018
123-456-789-A - 2019.04.01
Test
270
CheeseBlock

MiniPlan
Maschinen-Nr
Auftraggeber
Operation
KMG-Nr

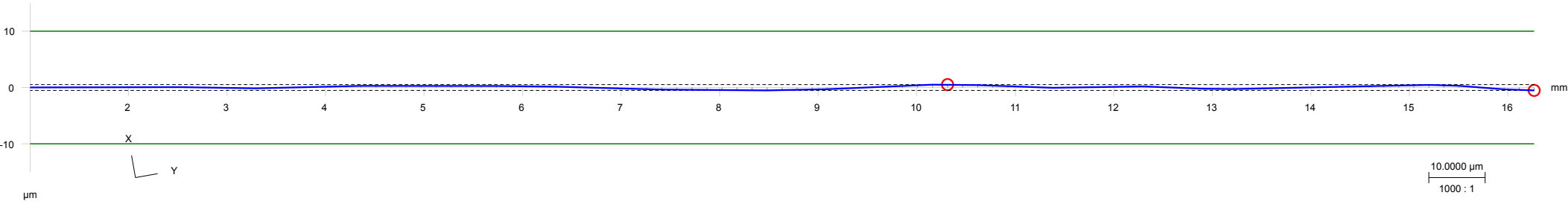
0_ALL
FlexCenter_1
CostCenter 123
5-AxisCenter
000000

Datum
Firma
Abt
Prüfer
MPEe =

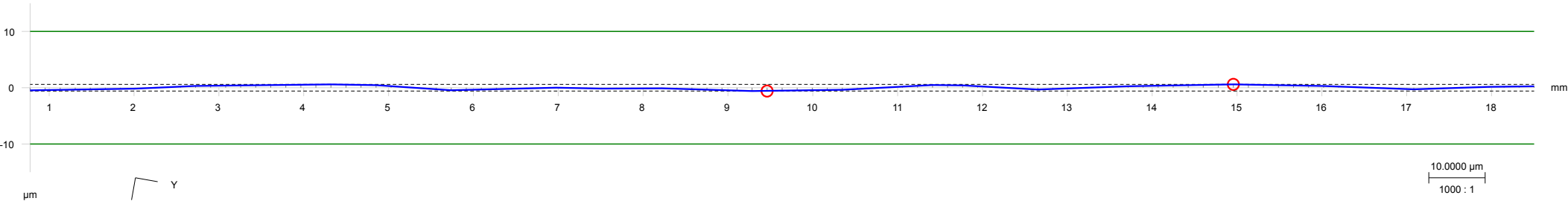
02.06.2019 15:27
CZ IMT GmbH
SES-AP
Master - ShiftLabel_1
2.5 ± L/250

Straightness Slot

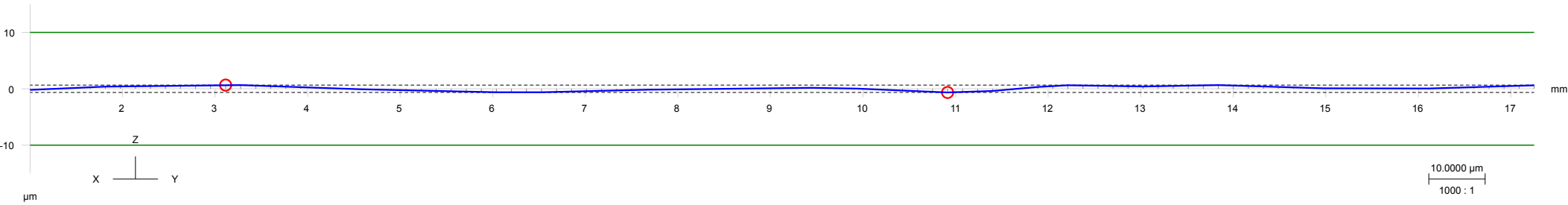
Straightness_SlotLine_Left



Straightness_SlotLine_Right



Straightness_40_SlotLine_Bottom



Name	Kommentar	IST	TOL	Methode	USG	OSG	Min	Max	Punkte	Filtertyp	Lc	W/U
Straightness_SlotLine_Left		0.001	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	101	Tiefpass Spline	2.5 -	-
Straightness_SlotLine_Right		0.001	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	101	Tiefpass Gauß	2.5 -	-
Straightness_40_SlotLine_Bottom		0.001	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	101	Tiefpass Gauß	2.5 -	-

Customer

PiWeb Reporting Plus

Programm
Zeichungs-Nr
Auftrags-Nr
Teil-Nr
Typ

CustomizedPlott_CALYPSO_2018
123-456-789-A - 2019.04.01
Test
270
CheeseBlock

MiniPlan
Maschinen-Nr
Auftraggeber
Operation
KMG-Nr

0_ALL
FlexCenter_1
CostCenter 123
5-AxisCenter
000000

Datum
Firma
Abt
Prüfer
MPEe =
02.06.2019 15:27
CZ IMT GmbH
SES-AP
Master - ShiftLabel_1
2.5 ± L/250

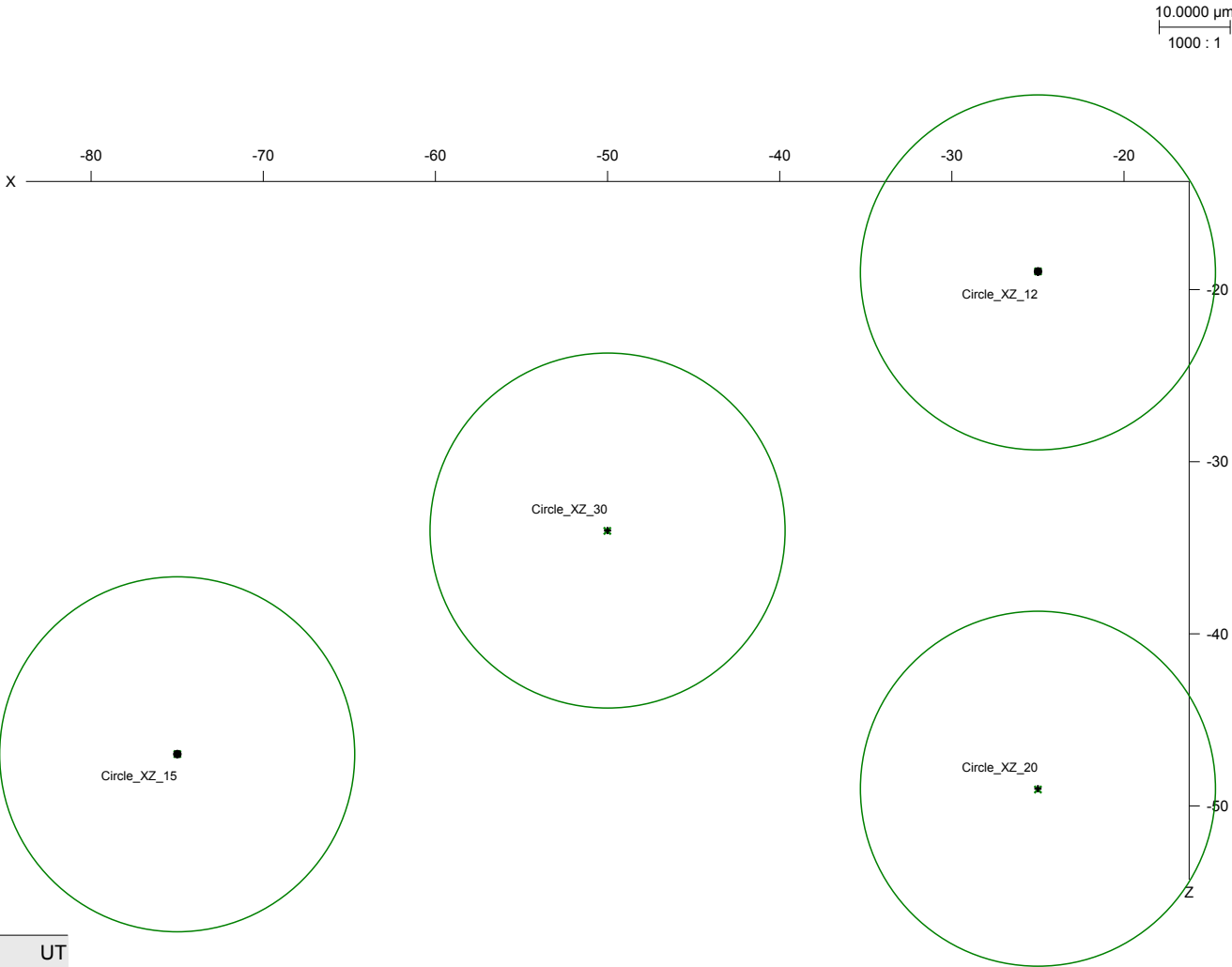
Pattern XZ

Name	Kommentar	IST	TOL
Borepattern_XZ		0.0003	
Borepattern_XZ^1		0.0001	0.0500
Borepattern_XZ^2		0.0001	0.0500
Borepattern_XZ^3		0.0003	0.0500
Borepattern_XZ^4		0.0002	0.0500

Einpassergebnis Borepattern_XZ	
Trans X [mm]	0.0050
Trans Y [mm]	
Trans Z [mm]	-0.0001
Rot Winkel [°]	-0.0001

Name	Kommentar	IST	SOLL	OT	UT
Dia_Circle_XZ_15		15.0000	15.0000	0.1000	-0.1000
Dia_Circle_XZ_30		30.0000	30.0000	0.1000	-0.1000
Dia_Circle_XZ_12		12.0001	12.0000	0.1000	-0.1000
Dia_Circle_XZ_20		20.0001	20.0000	0.1000	-0.1000

Borepattern_XZ



Customer

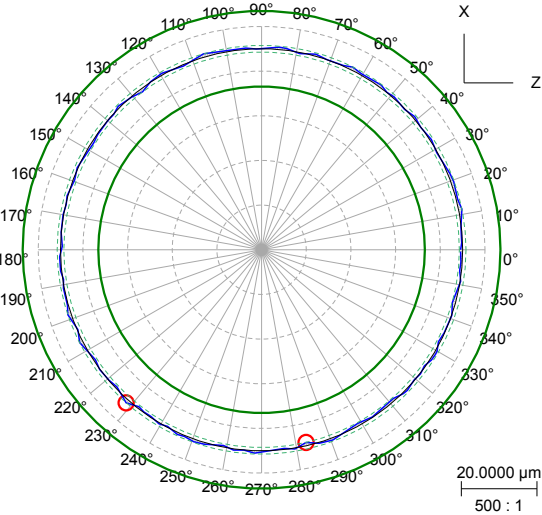
PiWeb Reporting Plus

Roundness XZ

Programm	CustomizedPlott_CALYPSO_2018	MiniPlan	0_ALL	Datum	02.06.2019 15:27
Zeichungs-Nr	123-456-789-A - 2019.04.01	Maschinen-Nr	FlexCenter_1	Firma	CZ IMT GmbH
Auftrags-Nr	Test	Auftraggeber	CostCenter 123	Abt	SES-AP
Teil-Nr	270	Operation	5-AxisCenter	Prüfer	Master - ShiftLabel_1
Typ	CheeseBlock	KMG-Nr	000000	MPEe =	2.5 ± L/250

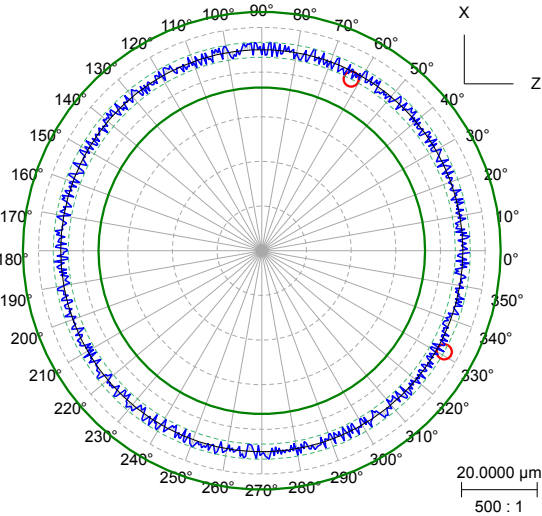
Circle_XZ_15

Sigma 0.0004
Taster-Ø 1.5000
Vs[mm/sec] 9.5000



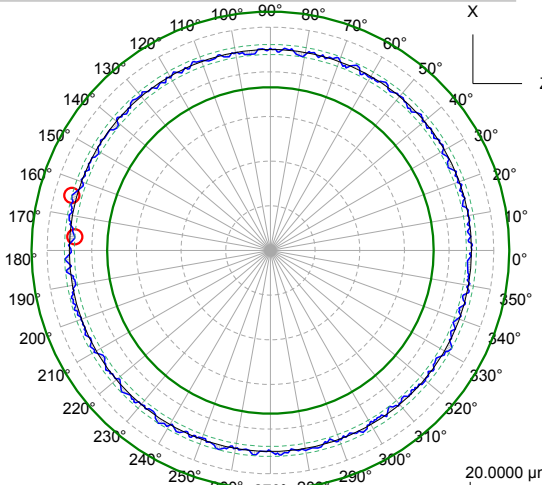
Circle_XZ_30

Sigma 0.0011
Taster-Ø 1.5000
Vs[mm/sec] 15.0000



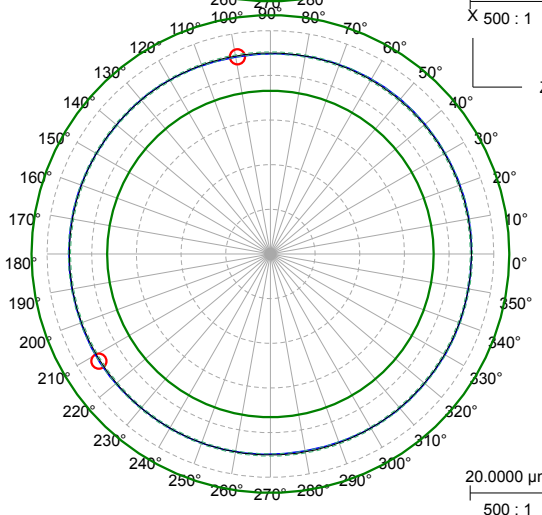
Circle_XZ_12

Sigma 0.0005
Taster-Ø 1.5000
Vs[mm/sec] 5.0000



Circle_XZ_20

Sigma 0.0002
Taster-Ø 1.5000
Vs[mm/sec] 12.0000



Name	Kommentar	IST	TOL	Methode	USG	OSG	Min	Max	Punkte	Filtertyp	Lc	W/U
Roundness_Circle_XZ_15		0.002	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	720	Tiefpass Gauß	-	50 -
Roundness_Circle_XZ_30		0.004	0.016	Minimum-Element	0.000	0.016	-0.002	0.002	720	Kein Filter	-	-
Roundness_Circle_XZ_12		0.003	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	720	Tiefpass 2RC	-	50 -
Roundness_Circle_XZ_20		0.001	0.016	Minimum-Element	0.000	0.016	0.000	0.000	720	Tiefpass Spline	8 -	-

Customer

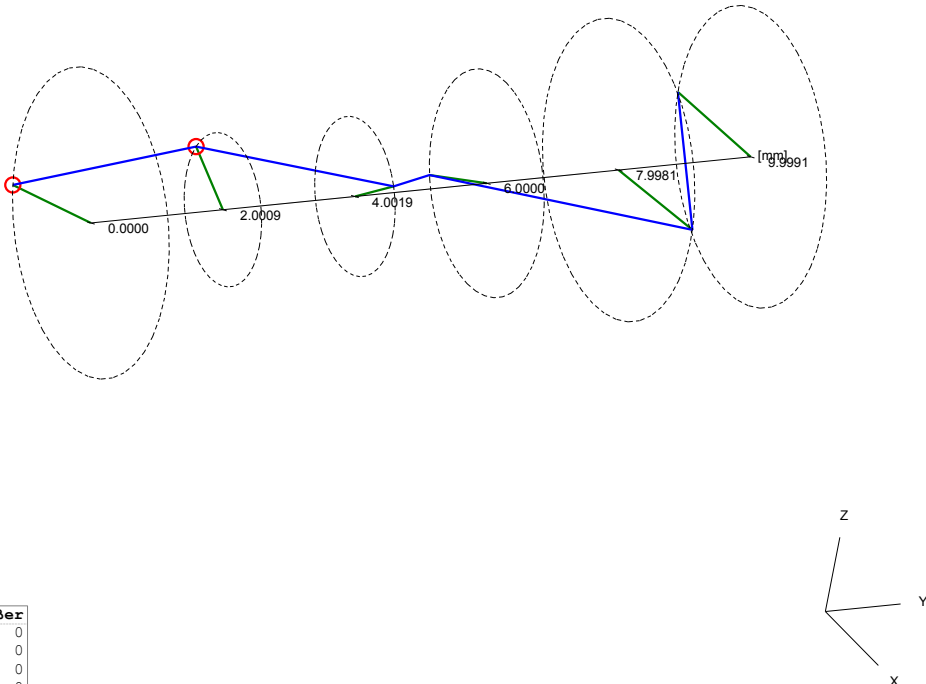
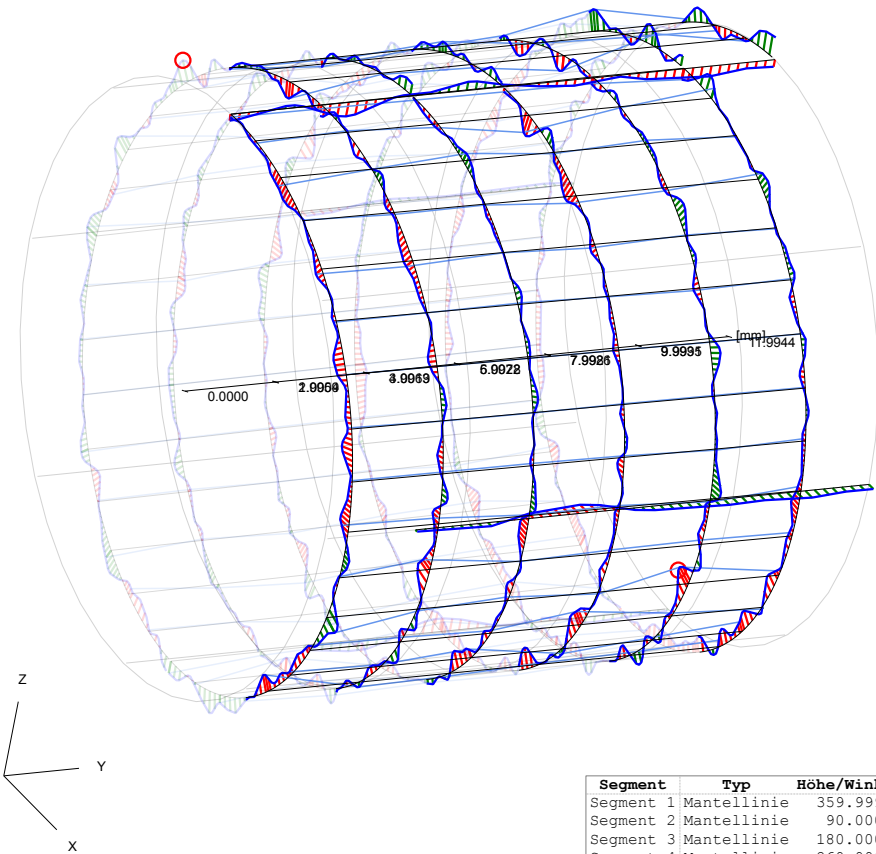
PiWeb Reporting Plus

Cylindricity

Programm	CustomizedPlott_CALYPSO_2018	MiniPlan	0_ALL	Datum	02.06.2019 15:27
Zeichungs-Nr	123-456-789-A - 2019.04.01	Maschinen-Nr	FlexCenter_1	Firma	CZ IMT GmbH
Auftrags-Nr	Test	Auftraggeber	CostCenter 123	Abt	SES-AP
Teil-Nr	270	Operation	5-AxisCenter	Prüfer	Master - ShiftLabel_1
Typ	CheeseBlock	KMG-Nr	000000	MPEe =	2.5 ± L/250

Cylindricity_CircularLineCylinder_XZ_30_CircularLine

Straightness_Axis_3D



Segment	Typ	Höhe/Winkel	Punkte	Ausreißer
Segment 1	Mantellinie	359.9994°	61	0
Segment 2	Mantellinie	90.0009°	51	0
Segment 3	Mantellinie	180.0003°	41	0
Segment 4	Mantellinie	269.9999°	31	0

Name	Kommentar	IST	TOL	Methode	USG	OSG	Min	Max	Punkte	Filtertyp	Lc	W/U
Cylindricity_Circul...r_XZ_30_CircularLine		0.003	0.160	Minimum-Element	0.000	0.160	-0.001	0.001	2343	Tiefpass Spline	2.5 -	-
Straightness_Axis_3D		0.000	0.005	Minimum-Element	0.000	0.005	0.000	0.000	6	Kein Filter	-	-

Customer

PiWeb Reporting Plus

Programm
Zeichungs-Nr
Auftrags-Nr
Teil-Nr
Typ

CustomizedPlott_CALYPSO_2018
123-456-789-A - 2019.04.01
Test
270
CheeseBlock

MiniPlan
Maschinen-Nr
Auftraggeber
Operation
KMG-Nr

0_ALL
FlexCenter_1
CostCenter 123
5-AxisCenter
000000

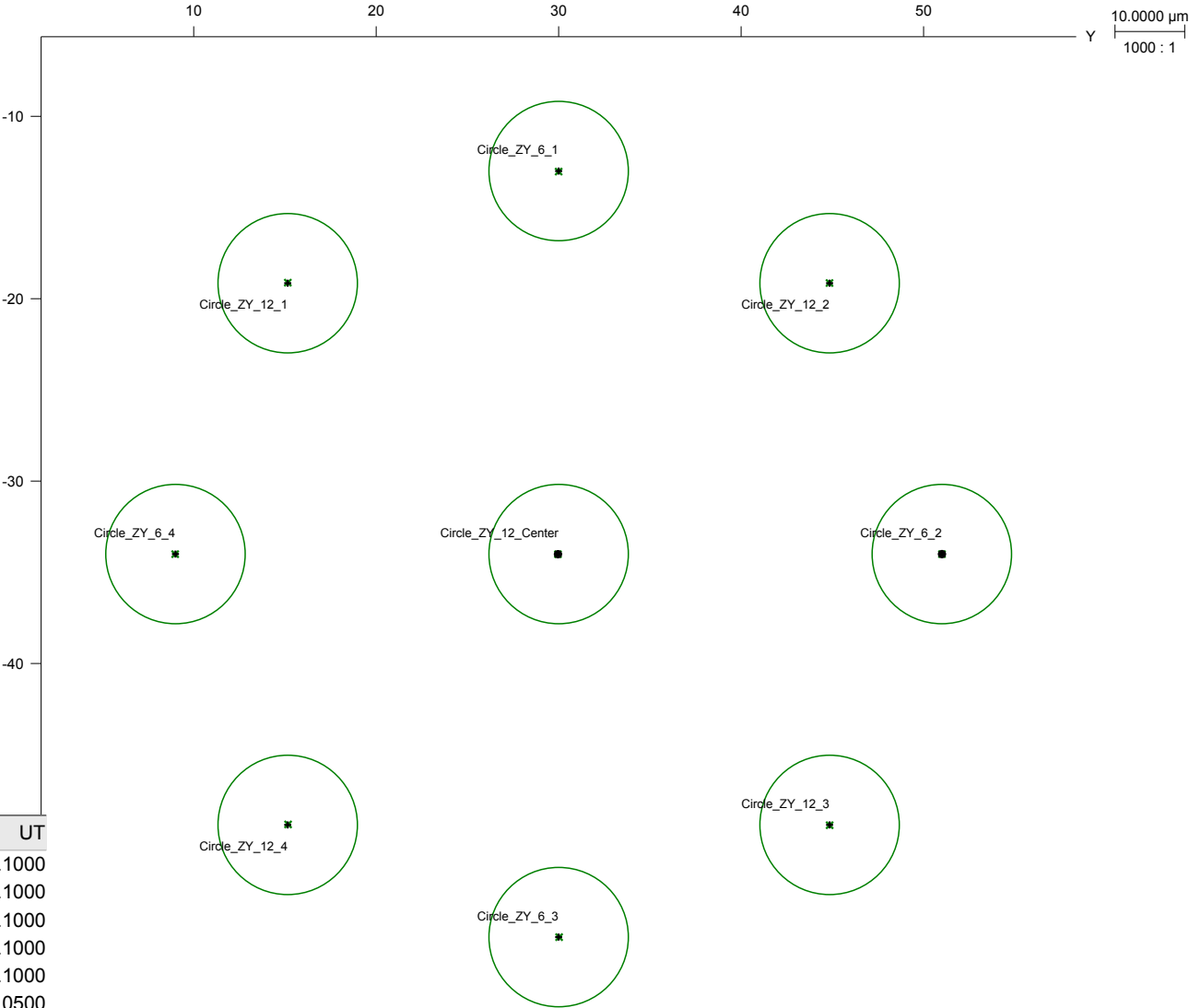
Datum
Firma
Abt
Prüfer
MPEe =
02.06.2019 15:27
CZ IMT GmbH
SES-AP
Master - ShiftLabel_1
2.5 ± L/250

Pattern ZY

Name	Kommentar	IST	TOL
Borepattern_YZ		0.0002	
Borepattern_YZ^1		0.0002	0.0200
Borepattern_YZ^2		0.0001	0.0200
Borepattern_YZ^3		0.0001	0.0200
Borepattern_YZ^4		0.0002	0.0200
Borepattern_YZ^5		0.0002	0.0200
Borepattern_YZ^6		0.0000	0.0200
Borepattern_YZ^7		0.0001	0.0200
Borepattern_YZ^8		0.0001	0.0200
Borepattern_YZ^9		0.0002	0.0200

Einpassergebnis Borepattern_YZ	
Trans X [mm]	
Trans Y [mm]	0.0020
Trans Z [mm]	-0.0001
Rot Winkel [°]	-0.0001

Name	Kommentar	IST	SOLL	OT	UT
Dia_Circl...12_Center		12.0000	12.0000	0.1000	-0.1000
Dia_Circle_ZY_12_1		11.9999	12.0000	0.1000	-0.1000
Dia_Circle_ZY_12_2		12.0000	12.0000	0.1000	-0.1000
Dia_Circle_ZY_12_3		12.0000	12.0000	0.1000	-0.1000
Dia_Circle_ZY_12_4		11.9999	12.0000	0.1000	-0.1000
Dia_Circle_ZY_6_1		6.0001	6.0000	0.0500	-0.0500
Dia_Circle_ZY_6_2		6.0000	6.0000	0.0500	-0.0500
Dia_Circle_ZY_6_3		6.0000	6.0000	0.0500	-0.0500
Dia_Circle_ZY_6_4		6.0000	6.0000	0.0500	-0.0500



Customer**PiWeb
Reporting Plus**

Programm
Zeichnungs-Nr
Auftrags-Nr
Teil-Nr
Typ

CustomizedPlott_CALYPSO_2018
123-456-789-A - 2019.04.01
Test
270
CheeseBlock

MiniPlan
Maschinen-Nr
Auftraggeber
Operation
KMG-Nr

0_ALL
FlexCenter_1
CostCenter 123
5-AxisCenter
000000

Datum
Firma
Abt
Prüfer
MPEe =

02.06.2019 15:27
CZ IMT GmbH
SES-AP
Master - ShiftLabel_1
2.5 ± L/250

Roundness ZY**Circle_ZY_12_Center**

Sigma 0.0004
Taster-Ø 1.5000
Vs[mm/sec] 5.0000

Circle_ZY_12_1

Sigma 0.0004
Taster-Ø 1.5000
Vs[mm/sec] 5.0000

Circle_ZY_12_2

Sigma 0.0004
Taster-Ø 1.5000
Vs[mm/sec] 5.0000

Circle_ZY_12_3

Sigma 0.0004
Taster-Ø 1.5000
Vs[mm/sec] 5.0000

Circle_ZY_12_4

Sigma 0.0003
Taster-Ø 1.5000
Vs[mm/sec] 5.0000

Circle_ZY_6_1

Sigma 0.0004
Taster-Ø 1.5000
Vs[mm/sec] 2.5000

Circle_ZY_6_2

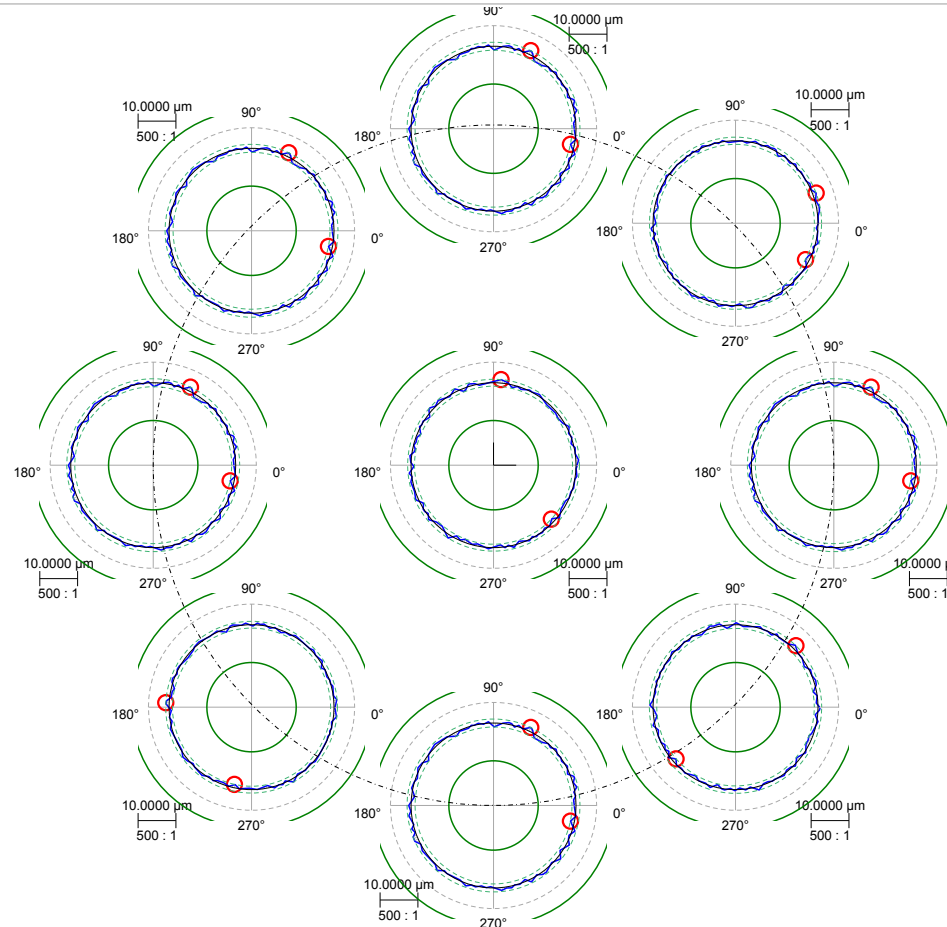
Sigma 0.0004
Taster-Ø 1.5000
Vs[mm/sec] 2.5000

Circle_ZY_6_3

Sigma 0.0004
Taster-Ø 1.5000
Vs[mm/sec] 2.5000

Circle_ZY_6_4

Sigma 0.0004
Taster-Ø 1.5000
Vs[mm/sec] 2.5000



Name	Kommentar	IST	TOL	Methode	USG	OSG	Min	Max	Punkte	Filtertyp	Lc	W/U
Roundness_Circle_ZY_12_Center		0.002	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	720	Tiefpass Spline	-	50 -
Roundness_Circle_ZY_12_1		0.002	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	720	Tiefpass Spline	-	50 -
Roundness_Circle_ZY_12_2		0.002	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	720	Tiefpass Spline	-	50 -
Roundness_Circle_ZY_12_3		0.002	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	720	Tiefpass Spline	-	50 -
Roundness_Circle_ZY_12_4		0.002	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	720	Tiefpass Spline	-	50 -
Roundness_Circle_ZY_6_1		0.002	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	720	Tiefpass Spline	-	50 -
Roundness_Circle_ZY_6_2		0.002	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	720	Tiefpass Spline	-	50 -
Roundness_Circle_ZY_6_3		0.002	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	720	Tiefpass Spline	-	50 -
Roundness_Circle_ZY_6_4		0.002	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	720	Tiefpass Spline	-	50 -