

Programm CustomizedPlott_CALYPSO_2018

Zeichnungs-Nr 123-456-789 A - 2019.04.01

MiniPlan

1_OP_ZY

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 256

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			0.0041	0.0000	0.0200	0.0000	0.0041		
Flatness_Y_Gauss_8			0.0028	0.0000	0.0200	0.0000	0.0028		
Flatness_X_RC_8			0.0042	0.0000	0.0200	0.0000	0.0042		

2.2 Datum Perpendicularity

Perpendicularity_Plane_Right-Top			0.0075	0.0000	0.0200	0.0000	0.0075		
Perpendicularity_Plane_Front-Left_Top			0.0030	0.0000	0.0200	0.0000	0.0030		

3.2.1 Borepattern ZY

Borepattern_YZ			0.0012						
Borepattern_YZ^1			0.0006	0.0000	0.0200	0.0000	0.0006		
Borepattern_YZ^2			0.0008	0.0000	0.0200	0.0000	0.0008		
Borepattern_YZ^3			0.0004	0.0000	0.0200	0.0000	0.0004		
Borepattern_YZ^4			0.0004	0.0000	0.0200	0.0000	0.0004		
Borepattern_YZ^5			0.0005	0.0000	0.0200	0.0000	0.0005		
Borepattern_YZ^6			0.0001	0.0000	0.0200	0.0000	0.0001		
Borepattern_YZ^7			0.0004	0.0000	0.0200	0.0000	0.0004		
Borepattern_YZ^8			0.0003	0.0000	0.0200	0.0000	0.0003		
Borepattern_YZ^9			0.0012	0.0000	0.0200	0.0000	0.0012		

3.2.2 Roundness ZY

Roundness_Circle_ZY_12_Center			0.0073	0.0000	0.0200	0.0000	0.0073		
Roundness_Circle_ZY_12_1			0.0069	0.0000	0.0200	0.0000	0.0069		
Roundness_Circle_ZY_12_2			0.0062	0.0000	0.0200	0.0000	0.0062		
Roundness_Circle_ZY_12_3			0.0063	0.0000	0.0200	0.0000	0.0063		
Roundness_Circle_ZY_12_4			0.0063	0.0000	0.0200	0.0000	0.0063		
Roundness_Circle_ZY_6_1			0.0070	0.0000	0.0200	0.0000	0.0070		

Name	M-C	P-C	Ist	Soll	OT	UT	Abw	Ueb	Toleranz
Kommentar									
○ Roundness_Circle_ZY_6_2			0.0064	0.0000	0.0200	0.0000	0.0064		<div></div>
○ Roundness_Circle_ZY_6_3			0.0079	0.0000	0.0200	0.0000	0.0079		<div></div>
○ Roundness_Circle_ZY_6_4			0.0069	0.0000	0.0200	0.0000	0.0069		<div></div>

3.2.3 Diameter ZY

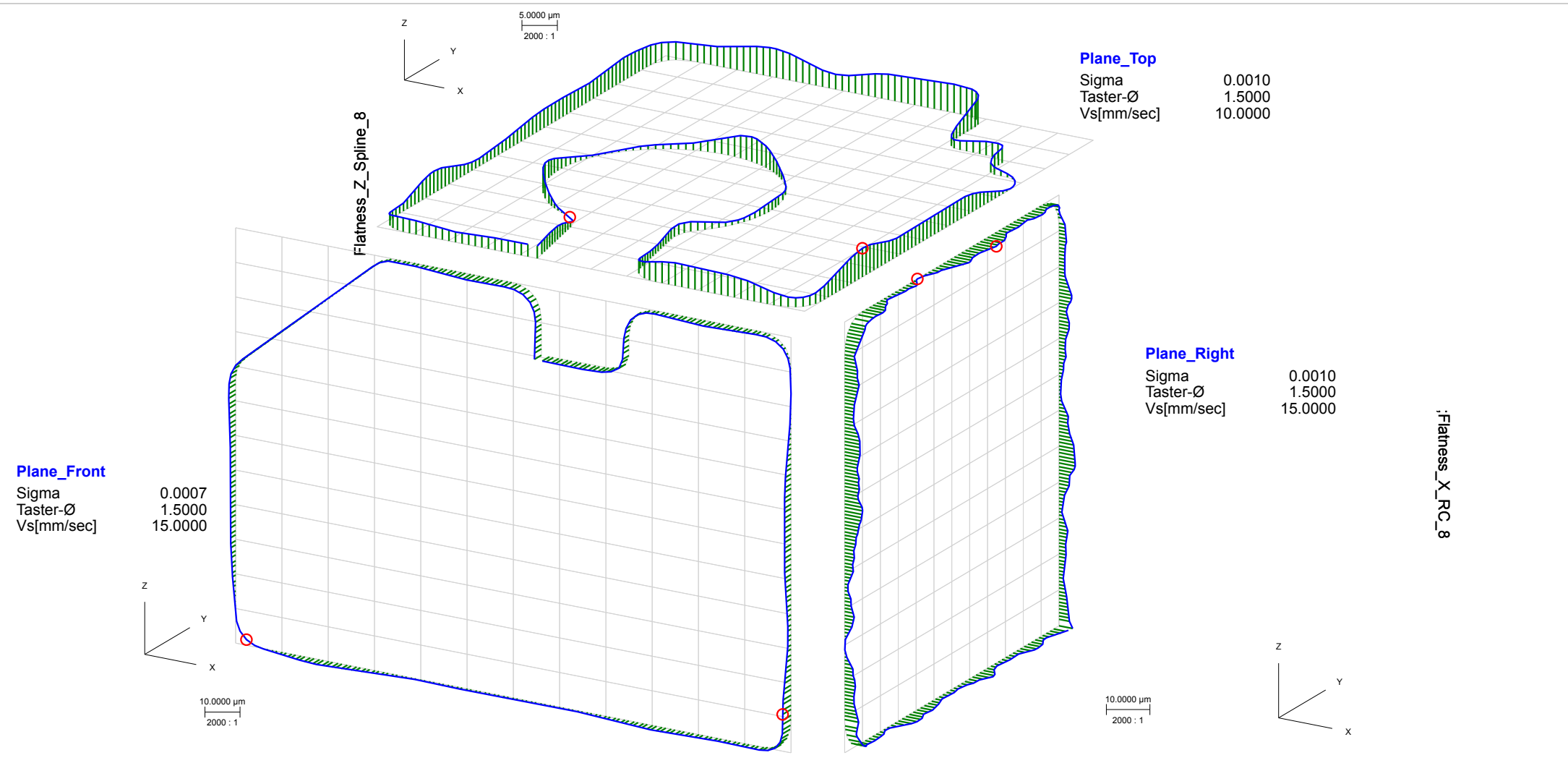
Ø Dia_Circle_ZY_12_Center			11.9995	12.0000	0.1000	-0.1000	-0.0005		<div></div>
GG									
Ø Dia_Circle_ZY_12_1			11.9999	12.0000	0.1000	-0.1000	-0.0001		<div></div>
GG									
Ø Dia_Circle_ZY_12_2			12.0005	12.0000	0.1000	-0.1000	0.0005		<div></div>
GG									
Ø Dia_Circle_ZY_12_3			11.9996	12.0000	0.1000	-0.1000	-0.0004		<div></div>
GG									
Ø Dia_Circle_ZY_12_4			12.0004	12.0000	0.1000	-0.1000	0.0004		<div></div>
GG									
Ø Dia_Circle_ZY_6_1			6.0002	6.0000	0.0500	-0.0500	0.0002		<div></div>
GG									
Ø Dia_Circle_ZY_6_2			6.0000	6.0000	0.0500	-0.0500	0.0000		<div></div>
GG									
Ø Dia_Circle_ZY_6_3			6.0000	6.0000	0.0500	-0.0500	0.0000		<div></div>
GG									
Ø Dia_Circle_ZY_6_4			6.0001	6.0000	0.0500	-0.0500	0.0001		<div></div>
GG									

Customer

PiWeb Reporting Plus

Programm	CustomizedPlott_CALYPSO_2018	MiniPlan	1_OP_ZY	Datum	15.04.2019 11:41
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	256	Operation	5-AxisCenter	Prüfer	Master - ShiftLabel_1
Typ	CheeseBlock	KMG-Nr	000000	MPEe =	2.5 ± L/250

Flatness Datum



Name	Kommentar	IST	TOL	Methode	Min	Max	Punkte	Filtertyp	Lc	W/U
Flatness_Z_Spline_8		0.004	0.020	Minimum-Element	-0.002	0.002	374	Tiefpass Gauß	25 -	-
Flatness_Y_Gauss_8		0.003	0.020	Minimum-Element	-0.001	0.001	399	Tiefpass Spline	25 -	-
Flatness_X_RC_8		0.004	0.020	Minimum-Element	-0.002	0.002	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
256
CheeseBlock

MiniPlan
Maschinen-Nr
Auftraggeber
Operation
KMG-Nr

1_OP_ZY
FlexCenter_1
CostCenter 123
5-AxisCenter
000000

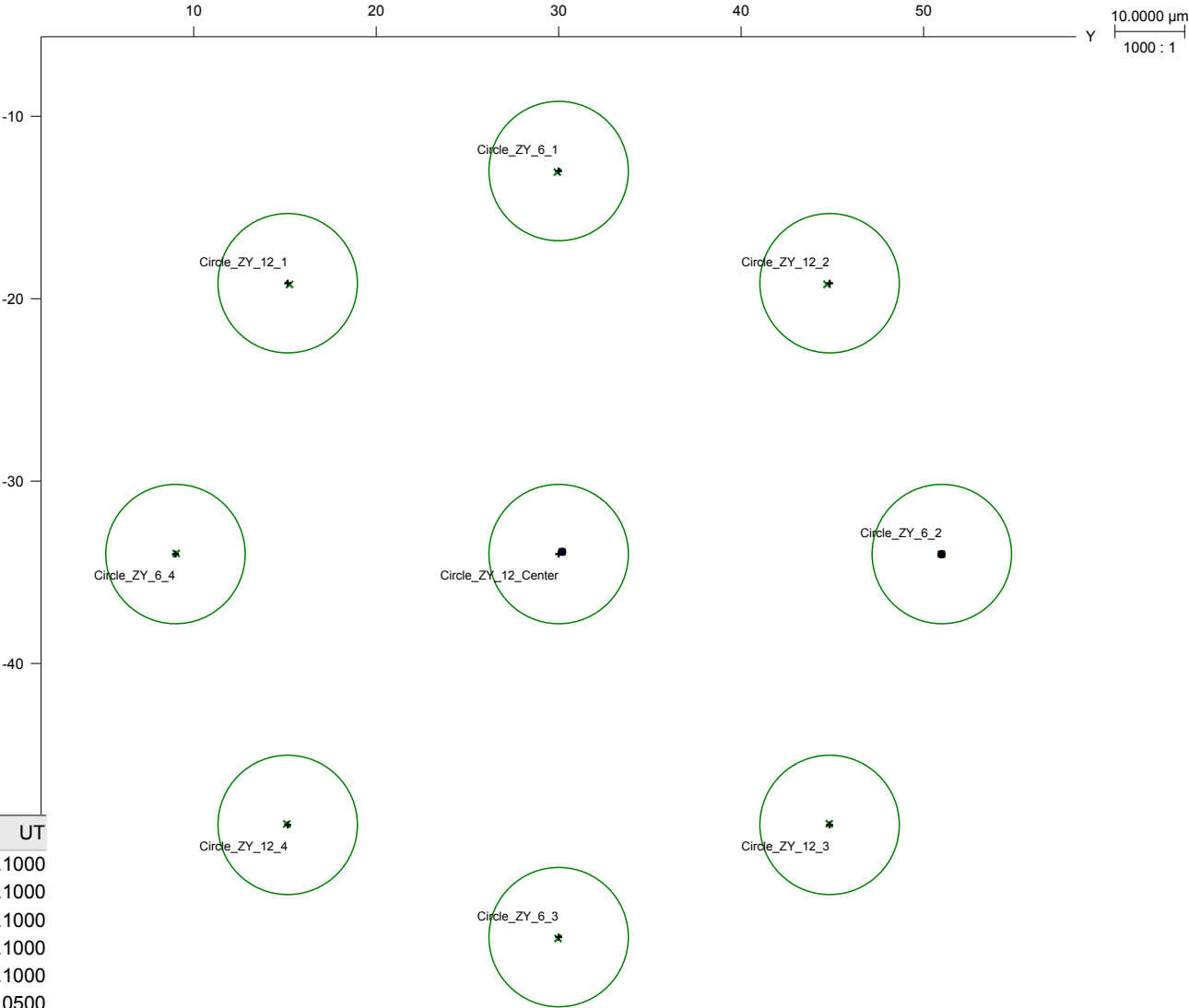
Datum
Firma
Abt
Prüfer
MPEe =
15.04.2019 11:41
CZ IMT GmbH
SES-AP
Master - ShiftLabel_1
2.5 ± L/250

Pattern ZY

Name	Kommentar	IST	TOL
Borepattern_YZ		0.0012	
Borepattern_YZ^1		0.0006	0.0200
Borepattern_YZ^2		0.0008	0.0200
Borepattern_YZ^3		0.0004	0.0200
Borepattern_YZ^4		0.0004	0.0200
Borepattern_YZ^5		0.0005	0.0200
Borepattern_YZ^6		0.0001	0.0200
Borepattern_YZ^7		0.0004	0.0200
Borepattern_YZ^8		0.0003	0.0200
Borepattern_YZ^9		0.0012	0.0200

Einpassergebnis Borepattern_YZ	
Trans X [mm]	
Trans Y [mm]	-0.0001
Trans Z [mm]	-0.0001
Rot Winkel [°]	-0.0002

Name	Kommentar	IST	SOLL	OT	UT
Dia_Circl...12_Center		11.9995	12.0000	0.1000	-0.1000
Dia_Circle_ZY_12_1		11.9999	12.0000	0.1000	-0.1000
Dia_Circle_ZY_12_2		12.0005	12.0000	0.1000	-0.1000
Dia_Circle_ZY_12_3		11.9996	12.0000	0.1000	-0.1000
Dia_Circle_ZY_12_4		12.0004	12.0000	0.1000	-0.1000
Dia_Circle_ZY_6_1		6.0002	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		6.0001	6.0000	0.0500	-0.0500



Customer**PiWeb
Reporting Plus**

Programm
Zeichnungs-Nr
Auftrags-Nr
Teil-Nr
Typ

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Test
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Auftraggeber
Operation
KMG-Nr

1_OP_ZY
FlexCenter_1
CostCenter 123
5-AxisCenter
000000

Datum
Firma
Abt
Prüfer
MPEe =

15.04.2019 11:41
CZ IMT GmbH
SES-AP
Master - ShiftLabel_1
2.5 ± L/250

Roundness ZY**Circle_ZY_12_Center**

Sigma 0.0015
Taster-Ø 1.5000
Vs[mm/sec] 5.0000

Circle_ZY_12_1

Sigma 0.0014
Taster-Ø 1.5000
Vs[mm/sec] 5.0000

Circle_ZY_12_2

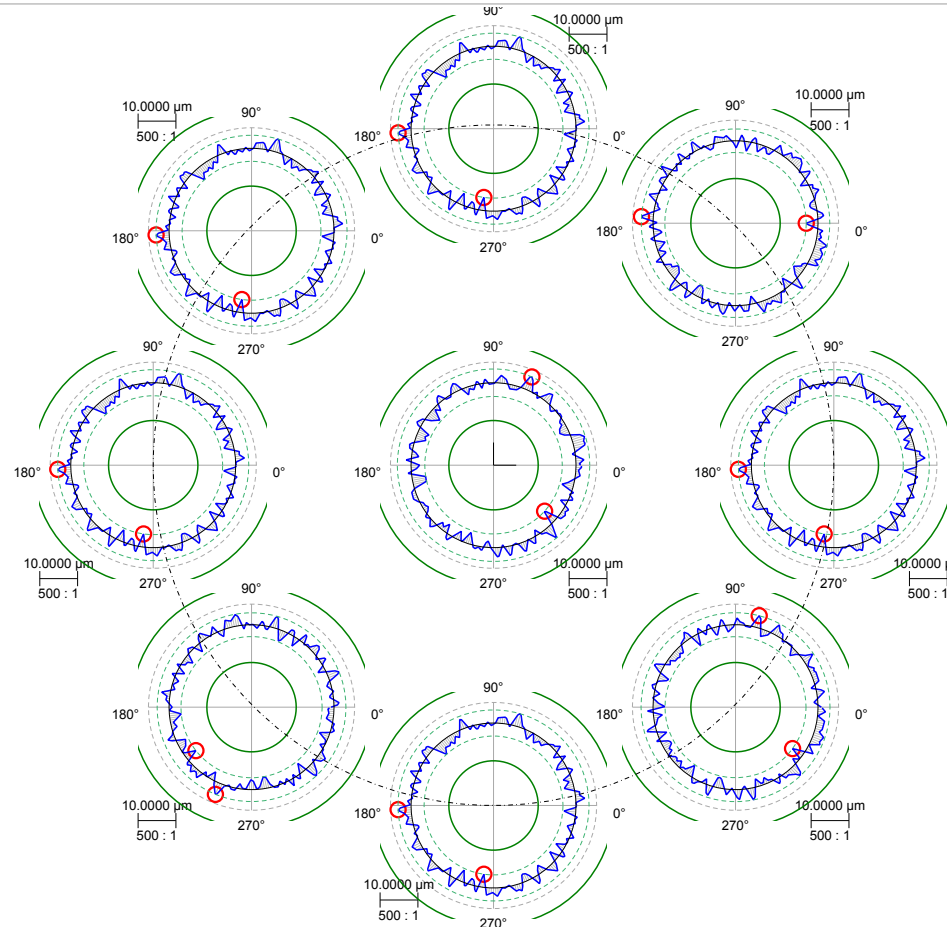
Sigma 0.0015
Taster-Ø 1.5000
Vs[mm/sec] 5.0000

Circle_ZY_12_3

Sigma 0.0015
Taster-Ø 1.5000
Vs[mm/sec] 5.0000

Circle_ZY_12_4

Sigma 0.0014
Taster-Ø 1.5000
Vs[mm/sec] 5.0000

**Circle_ZY_6_1**

Sigma 0.0015
Taster-Ø 1.5000
Vs[mm/sec] 2.5000

Circle_ZY_6_2

Sigma 0.0012
Taster-Ø 1.5000
Vs[mm/sec] 2.5000

Circle_ZY_6_3

Sigma 0.0018
Taster-Ø 1.5000
Vs[mm/sec] 2.5000

Circle_ZY_6_4

Sigma 0.0015
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		0.007	0.016	Minimum-Element	0.000	0.016	-0.004	0.004	720	Tiefpass Spline	-	50 -
Roundness_Circle_ZY_12_1		0.007	0.016	Minimum-Element	0.000	0.016	-0.003	0.003	720	Tiefpass Spline	-	50 -
Roundness_Circle_ZY_12_2		0.006	0.016	Minimum-Element	0.000	0.016	-0.003	0.003	720	Tiefpass Spline	-	50 -
Roundness_Circle_ZY_12_3		0.006	0.016	Minimum-Element	0.000	0.016	-0.003	0.003	720	Tiefpass Spline	-	50 -
Roundness_Circle_ZY_12_4		0.006	0.016	Minimum-Element	0.000	0.016	-0.003	0.003	720	Tiefpass Spline	-	50 -
Roundness_Circle_ZY_6_1		0.007	0.016	Minimum-Element	0.000	0.016	-0.004	0.004	720	Tiefpass Spline	-	50 -
Roundness_Circle_ZY_6_2		0.006	0.016	Minimum-Element	0.000	0.016	-0.003	0.003	720	Tiefpass Spline	-	50 -
Roundness_Circle_ZY_6_3		0.008	0.016	Minimum-Element	0.000	0.016	-0.004	0.004	720	Tiefpass Spline	-	50 -
Roundness_Circle_ZY_6_4		0.007	0.016	Minimum-Element	0.000	0.016	-0.003	0.003	720	Tiefpass Spline	-	50 -