

Programm CustomizedPlott_CALYPSO_2018

Zeichnungs-Nr 123-456-789 A - 2019.04.01

MiniPlan

2_OP_XZ

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 257

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			0.0045	0.0000	0.0200	0.0000	0.0045		
Flatness_Y_Gauss_8			0.0033	0.0000	0.0200	0.0000	0.0033		
Flatness_X_RC_8			0.0044	0.0000	0.0200	0.0000	0.0044		

2.2 Datum Perpendicularity

Perpendicularity_Plane_Right-Top			0.0070	0.0000	0.0200	0.0000	0.0070		
Perpendicularity_Plane_Front-Left_Top			0.0037	0.0000	0.0200	0.0000	0.0037		

3.3.1 Borepattern XZ

Borepattern_XZ			0.0008						
Borepattern_XZ^1			0.0006	0.0000	0.0500	0.0000	0.0006		
Borepattern_XZ^2			0.0004	0.0000	0.0500	0.0000	0.0004		
Borepattern_XZ^3			0.0008	0.0000	0.0500	0.0000	0.0008		
Borepattern_XZ^4			0.0000	0.0000	0.0500	0.0000	0.0000		

3.3.2 Roundness XZ





Roundness_Circle_XZ_15			0.0066	0.0000	0.0200	0.0000	0.0066		
Roundness_Circle_XZ_30			0.0150	0.0000	0.0200	0.0000	0.0150		
Roundness_Circle_XZ_12			0.0090	0.0000	0.0200	0.0000	0.0090		
Roundness_Circle_XZ_20			0.0019	0.0000	0.0200	0.0000	0.0019		

3.3.3 Diameter XZ




Dia_Circle_XZ_15			14.9996	15.0000	0.1000	-0.1000	-0.0004		
Dia_Circle_XZ_30			30.0003	30.0000	0.1000	-0.1000	0.0003		
Dia_Circle_XZ_12			11.9996	12.0000	0.1000	-0.1000	-0.0004		
Dia_Circle_XZ_20			19.9994	20.0000	0.1000	-0.1000	-0.0006		

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


3.3.4 Cylindricity_Cylinder_30_Y

 Cylindricity_Cylinder_XZ_30_Line			0.0059	0.0000	0.0200	0.0000	0.0059	<div><div></div></div>
 Cylindricity_Rcylinder_XZ_30			0.0059	0.0000	0.0200	0.0000	0.0059	<div><div></div></div>
 Cylindricity_Cylinder_XZ_30_Helix			0.0059	0.0000	0.0200	0.0000	0.0059	<div><div></div></div>
 Cylindricity_CircularLineCylinder_XZ_30_Circ...			0.0105	0.0000	0.2000	0.0000	0.0105	<div><div></div></div>

3.3.5 Straightness_Cylinder_30_Y

 Straightness_Axis_N			0.0007	0.0000	0.0020	0.0000	0.0007	<div><div></div></div>
 Straightness_Axis_P			0.0006	0.0000	0.0020	0.0000	0.0006	<div><div></div></div>
 Straightness_Axis_3D			0.0009	0.0000	0.0050	0.0000	0.0009	<div><div></div></div>

3.3.6 Perpendicularity Cylinder_30_Y - Plane_Front

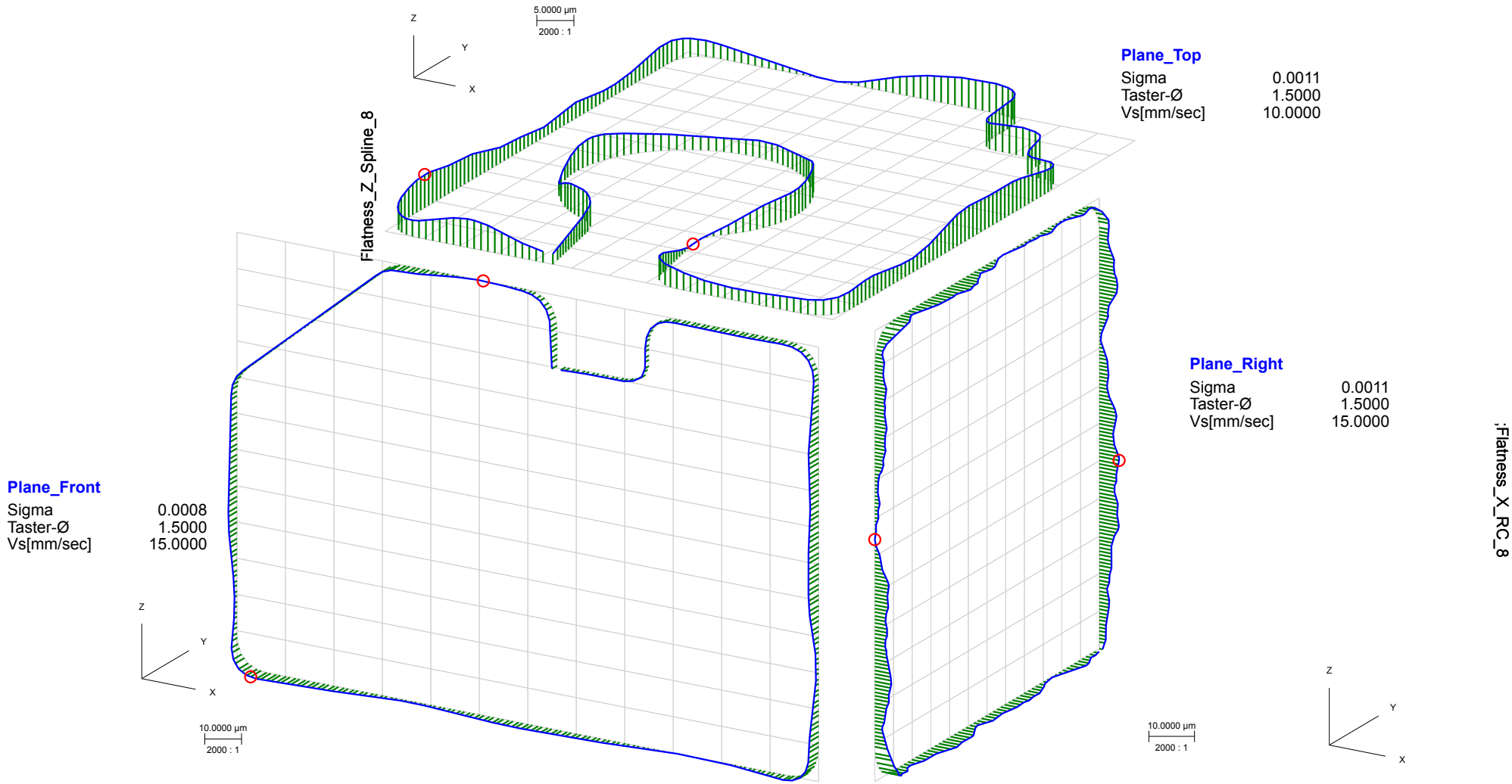
 Perpendicularity_Axis-Y_Front-Top			0.0003	0.0000	0.0020	0.0000	0.0003	<div><div></div></div>
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Customer

PiWeb
Reporting Plus

Programm	CustomizedPlott_CALYPSO_2018	MiniPlan	2_OP_XZ	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	257	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	-0.002	0.002	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
257
CheeseBlock

MiniPlan
Maschinen-Nr
Auftraggeber
Operation
KMG-Nr

2_OP_XZ
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

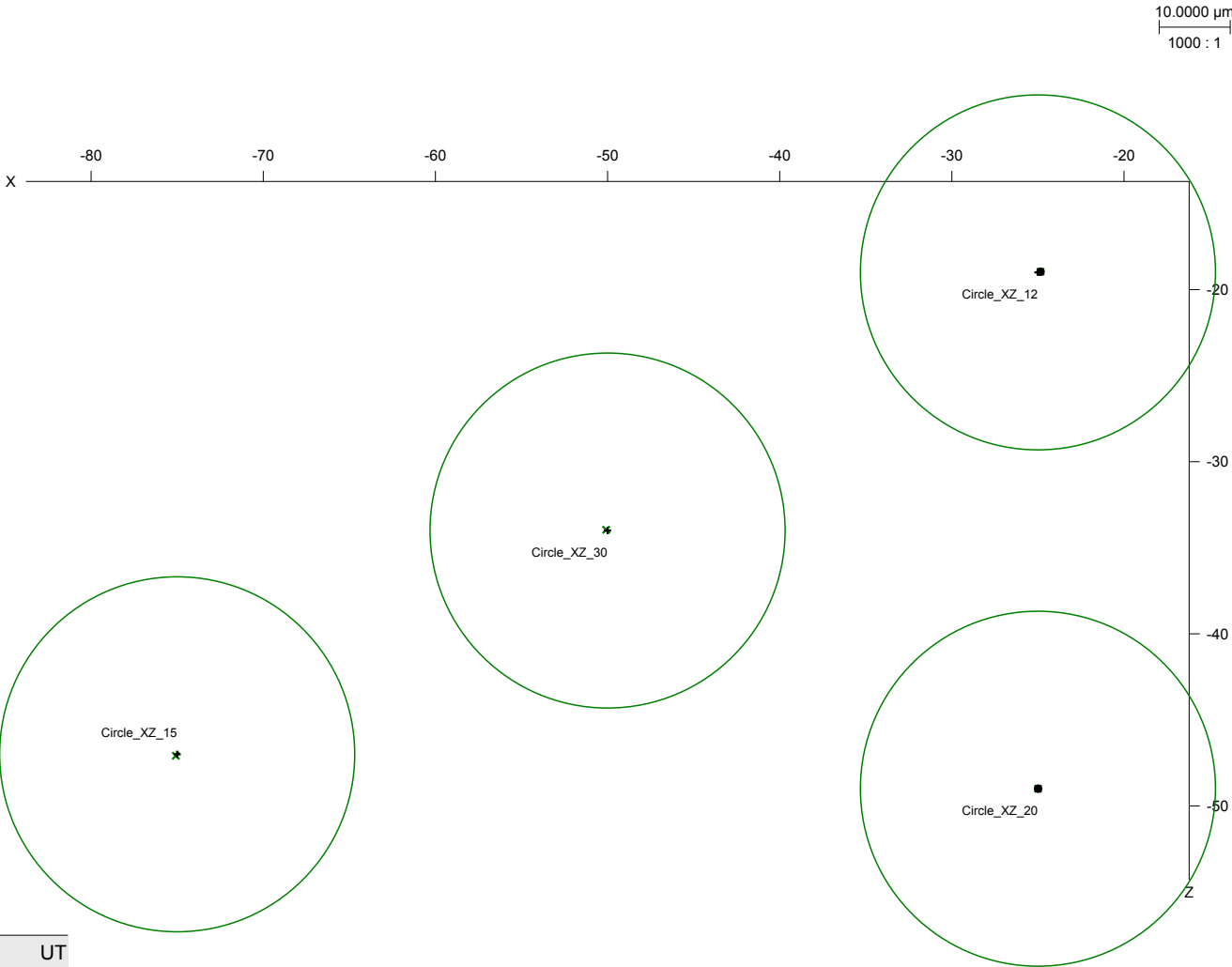
Pattern XZ

Name	Kommentar	IST	TOL
Borepattern_XZ		0.0008	
Borepattern_XZ^1		0.0006	0.0500
Borepattern_XZ^2		0.0004	0.0500
Borepattern_XZ^3		0.0008	0.0500
Borepattern_XZ^4		0.0000	0.0500

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

Name	Kommentar	IST	SOLL	OT	UT
Dia_Circle_XZ_15		14.9996	15.0000	0.1000	-0.1000
Dia_Circle_XZ_30		30.0003	30.0000	0.1000	-0.1000
Dia_Circle_XZ_12		11.9996	12.0000	0.1000	-0.1000
Dia_Circle_XZ_20		19.9994	20.0000	0.1000	-0.1000

Borepattern_XZ



Customer

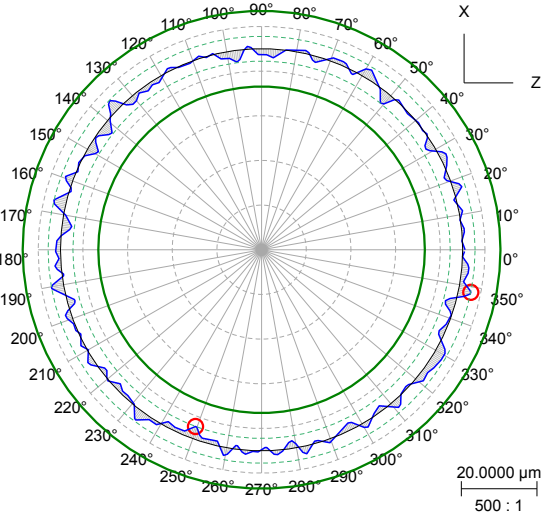
PiWeb Reporting Plus

Roundness XZ

Programm	CustomizedPlott_CALYPSO_2018	MiniPlan	2_OP_XZ	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	257	Operation	5-AxisCenter	Prüfer	Master - ShiftLabel_1
Typ	CheeseBlock	KMG-Nr	000000	MPEe =	2.5 ± L/250

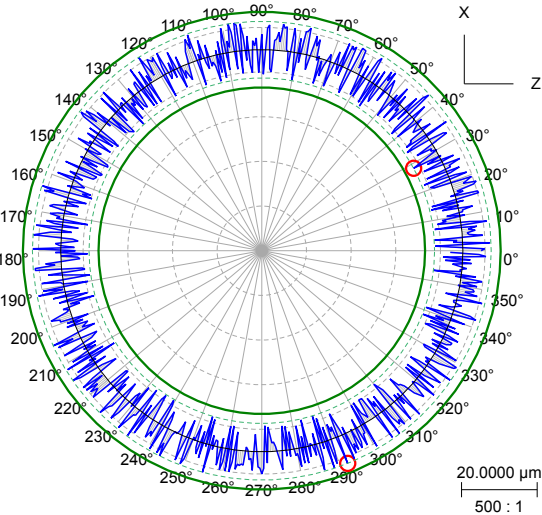
Circle_XZ_15

Sigma 0.0013
Taster-Ø 1.5000
Vs[mm/sec] 9.5000



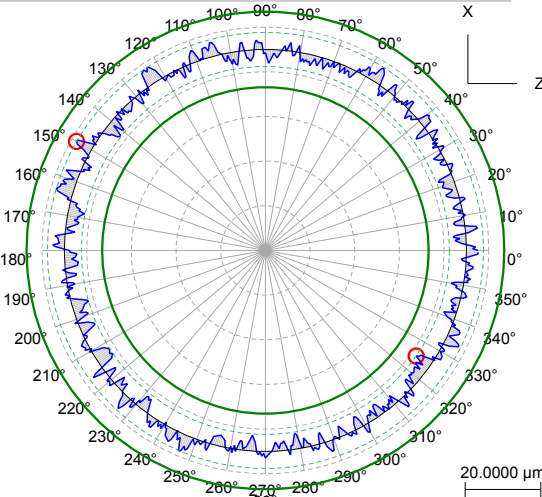
Circle_XZ_30

Sigma 0.0043
Taster-Ø 1.5000
Vs[mm/sec] 15.0000



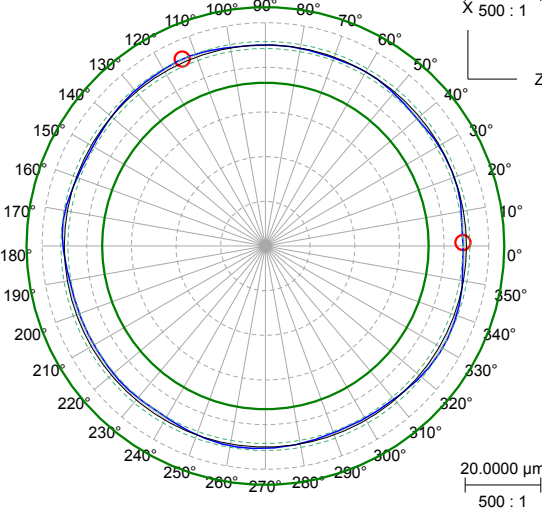
Circle_XZ_12

Sigma 0.0021
Taster-Ø 1.5000
Vs[mm/sec] 5.0000



Circle_XZ_20

Sigma 0.0005
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		0.007	0.016	Minimum-Element	0.000	0.016	-0.003	0.003	720	Tiefpass Gauß	-	50 -
Roundness_Circle_XZ_30		0.015	0.016	Minimum-Element	0.000	0.016	-0.007	0.007	720	Kein Filter	-	-
Roundness_Circle_XZ_12		0.009	0.016	Minimum-Element	0.000	0.016	-0.005	0.005	720	Tiefpass 2RC	-	50 -
Roundness_Circle_XZ_20		0.002	0.016	Minimum-Element	0.000	0.016	-0.001	0.001	720	Tiefpass Spline	8 -	-

Customer

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Programm CustomizedPlott_CALYPSO_2018
Zeichungs-Nr 123-456-789-A - 2019.04.01
Auftrags-Nr Test
Teil-Nr 257
Typ CheeseBlock

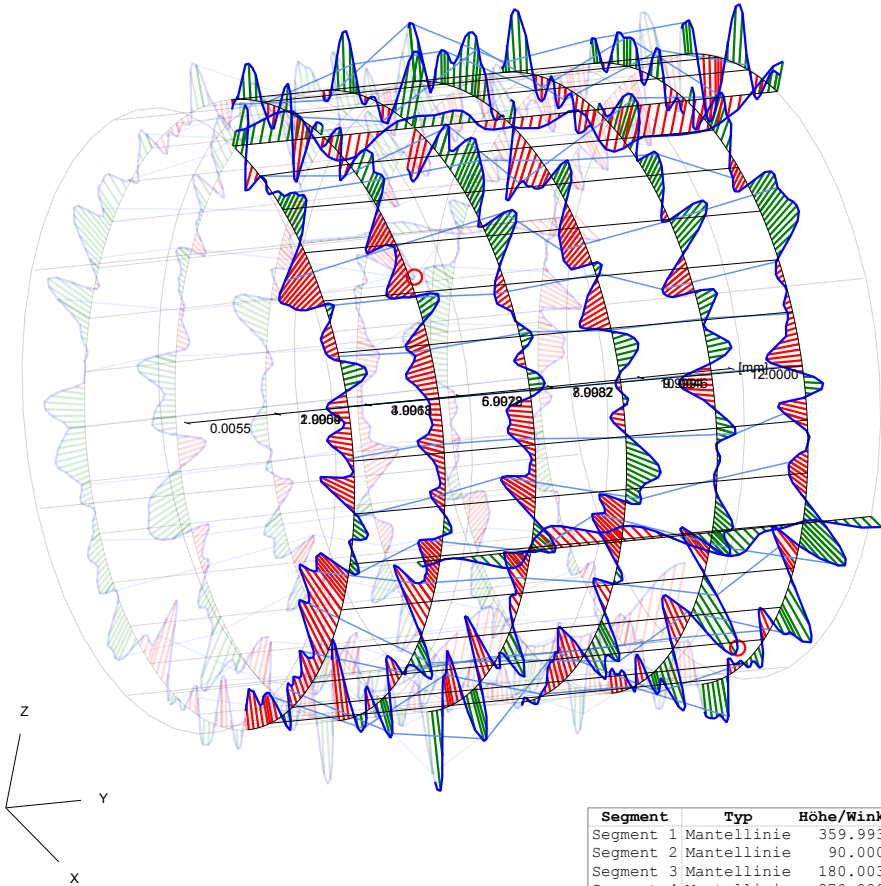
MiniPlan
Maschinen-Nr
Auftraggeber
Operation
KMG-Nr

2_OP_XZ
FlexCenter_1
CostCenter 123
5-AxisCenter
000000

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

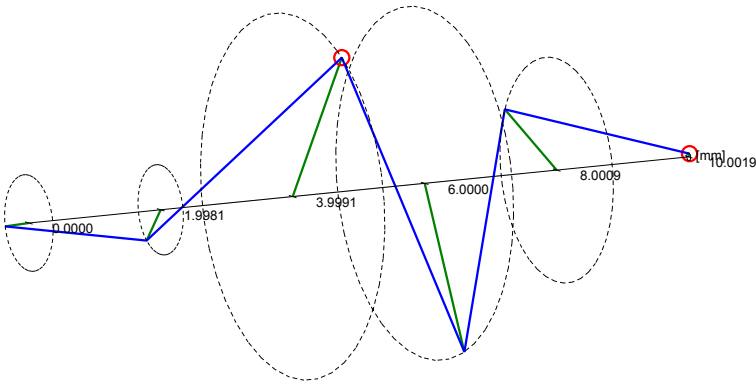
Cylindricity Y

Cylindricity_CircularLineCylinder_XZ_30_CircularLine



Segment	Typ	Höhe/Winkel	Punkte	Ausreißer
Segment 1	Mantellinie	359.9935°	61	0
Segment 2	Mantellinie	90.0001°	51	0
Segment 3	Mantellinie	180.0030°	41	0
Segment 4	Mantellinie	270.0000°	31	0

Straightness_Axis_3D



Name	Kommentar	IST	TOL	Methode	USG	OSG	Min	Max	Punkte	Filtertyp	Lc	W/U
Cylindricity_CircularLineCylinder_XZ_30_CircularLine		0.010	0.160	Minimum-Element	0.000	0.160	-0.005	0.005	2343	Tiefpass Spline	2.5 -	-
Straightness_Axis_3D		0.001	0.005	Gauß-Element	0.000	0.005	0.000	0.000	6	Kein Filter	-	-