



# PiWeb Reporting Plus

Last 1 measurements  
► Approval ≠ Blocked  
No. measured values 204

Date 9/28/2019 9:18 AM  
Run-Time 00:00:06.0  
No. values: red ● 2

Program **Plott\_CALYPSO\_2019\_LetterShort**  
 Drawing-No 123-456-789 A - 2019.04.01 MiniPlan *All Characteristics* Plant CZ IMT GmbH  
 Order-No Test Mach-No FlexCenter\_1 Deprmt IS-AP  
 Type CheeseBlock CMM-No 000000 CostCenter *CostCenter 123*  
 Process 5-AxisCenter MPEe = 2.5 ± L/250 Operator Master  
 Part-No 265 Shift ShiftLabel\_1

DMC 1234567890-234567890

Text StartComment

Name	M	P	Act Feature	NOM Form	UpTol Sigma	LowTol Min	Dev Max	Exc Pt	Tolerance Filter
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## 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			0.0039 Plane_Top	0.0000 0.0039	0.0200 0.0009	0.0000 -0.0020	0.0039 0.0020	374	Low-pass Gauss 25
Flatness_Y_Gauss_8			0.0018 Plane_Front	0.0000 0.0018	0.0200 0.0005	0.0000 -0.0009	0.0018 0.0009	399	Low-pass Spline 25
Flatness_X_RC_8			0.0031 Plane_Right	0.0000 0.0031	0.0200 0.0007	0.0000 -0.0015	0.0031 0.0015	467	Low-pass 2RC 25

## 2.2 Datum Perpendicularity

Perpendicularity_Plane_Right-Top			0.0048 Plane_Right	0.0000 0.0048	0.0200 0.0010	0.0000 -0.0023	0.0048 0.0026	467	Low-pass Spline 8
Perpendicularity_Plane_Front-Left_Top			0.0020 Plane_Front	0.0000 0.0020	0.0200 0.0004	0.0000 -0.0012	0.0020 0.0009	399	Low-pass Spline 25

## 3.1.1 BorePattern YX

Borepattern_YX			0.0008						
Borepattern_YX^1^X			0.0008 Circle_XY_30	0.0000 0.0108	0.1000 0.0028	0.0000 -0.0054	0.0008 0.0054		
Borepattern_YX^1^X.X			-40.1996	-40.2000	0.0500	-0.0500	0.0004		
Borepattern_YX^1^Y			0.0006 Circle_XY_30	0.0000 0.0108	0.2000 0.0028	0.0000 -0.0054	0.0006 0.0054		
Borepattern_YX^1^Y.Y			31.9997	32.0000	0.1000	-0.1000	-0.0003		
Borepattern_YX^2^X			0.0001 Circle_XY_12_1	0.0000 0.0102	0.1000 0.0029	0.0000 -0.0049	0.0001 0.0053		
Borepattern_YX^2^X.X			-53.6001	-53.6000	0.0500	-0.0500	-0.0001		
Borepattern_YX^2^Y			0.0001 Circle_XY_12_1	0.0000 0.0102	0.2000 0.0029	0.0000 -0.0049	0.0001 0.0053		
Borepattern_YX^2^Y.Y			55.6001	55.6000	0.1000	-0.1000	0.0001		
Borepattern_YX^3^X			0.0000 Circle_XY_12_2	0.0000 0.0102	0.1000 0.0029	0.0000 -0.0052	0.0000 0.0050		
Borepattern_YX^3^X.X			-53.6000	-53.6000	0.0500	-0.0500	0.0000		
Borepattern_YX^3^Y			0.0001 Circle_XY_12_2	0.0000 0.0102	0.2000 0.0029	0.0000 -0.0052	0.0001 0.0050		
Borepattern_YX^3^Y.Y			8.2000	8.2000	0.1000	-0.1000	0.0000		
Borepattern_YX^4^X			0.0006 Circle_XY_12_3	0.0000 0.0107	0.1000 0.0029	0.0000 -0.0053	0.0006 0.0054		
Borepattern_YX^4^X.X			-20.5503	-20.5500	0.0500	-0.0500	-0.0003		

C:\Users\Public\Documents\Zeiss\CALYPSO 6.0\protocol\PiWebReportingTemplates\Letter\_1\_n\_p.pix

Name	M	P	Act	NOM	UpTol	LowTol	Dev	Exc	Tolerance
Comment			Feature	Form	Sigma	Min	Max	Pt	Filter
⊕ Borepattern_YX^4^Y			0.0005	0.0000	0.2000	0.0000	0.0005		
			Circle_XY_12_3	0.0107	0.0029	-0.0053	0.0054		
⊕ Borepattern_YX^4^Y.Y			12.5503	12.5500	0.1000	-0.1000	0.0003		
<b>3.1.2 Roundness YX</b>									
○ Roundness_Circle_XY_30			0.0041	0.0000	0.0200	0.0000	0.0041		
			Circle_XY_30	0.0041	0.0009	-0.0020	0.0020	720	Low-pass Gauss 50-
○ Roundness_Circle_XY_12_1			0.0056	0.0000	0.0200	0.0000	0.0056		
			Circle_XY_12_1	0.0056	0.0011	-0.0028	0.0028	720	Low-pass Spline 50-
○ Roundness_Circle_XY_12_2			0.0047	0.0000	0.0200	0.0000	0.0047		
			Circle_XY_12_2	0.0047	0.0010	-0.0023	0.0023	720	Low-pass Spline 50-
○ Roundness_Circle_XY_12_3			0.0043	0.0000	0.0200	0.0000	0.0043		
			Circle_XY_12_3	0.0043	0.0009	-0.0022	0.0022	720	Low-pass Spline 50-
<b>3.1.3 Diameter YX</b>									
∅ Dia_Circle_XY_30			30.0000	30.0000	0.1000	-0.1000	0.0000		
GS			Circle_XY_30	0.0108	0.0028	-0.0054	0.0054		
∅ Dia_Circle_XY_12_1			11.9997	12.0000	0.1000	-0.1000	-0.0003		
GS			Circle_XY_12_1	0.0102	0.0029	-0.0049	0.0053		
∅ Dia_Circle_XY_12_2			12.0002	12.0000	0.1000	-0.1000	0.0002		
GS			Circle_XY_12_2	0.0102	0.0029	-0.0052	0.0050		
∅ Dia_Circle_XY_12_3			11.9999	12.0000	0.1000	-0.1000	-0.0001		
GS			Circle_XY_12_3	0.0107	0.0029	-0.0053	0.0054		
<b>3.1.4 Straightness Slot</b>									
— Straightness_SlotLine_Left			0.0022	0.0000	0.0200	0.0000	0.0022		
			SlotLine_Left	0.0022	0.0007	-0.0011	0.0011	101	Low-pass Spline 2.5-
— Straightness_SlotLine_Right			0.0032	0.0000	0.0200	0.0000	0.0032		
			SlotLine_Right	0.0032	0.0010	-0.0016	0.0016	101	Low-pass Gauss 2.5-
— Straightness_40_SlotLine_Bottom			0.0032	0.0000	0.0200	0.0000	0.0032		
			SlotLine_Bottom	0.0032	0.0009	-0.0016	0.0016	101	Low-pass Gauss 2.5-
<b>3.1.5 Curveform</b>									
∩ Banana			-0.0014	0.0000	0.0000	0.0000	-0.0014	-0.0014	
			M_Banana	0.0026		-0.0014	0.0012	237	Low-pass Gauss 8-
∩ Banana.range			0.0026						
∩ Banana^1			-0.0002	0.0000	0.0100	-0.0100	-0.0002		
			M_Banana	0.0026		-0.0014	0.0012	60	Low-pass Gauss 8-
∩ Banana^2			-0.0005	0.0000	0.0200	-0.0200	-0.0005		
			M_Banana	0.0026		-0.0014	0.0012	61	Low-pass Gauss 8-
∩ Banana^3			-0.0014	0.0000	0.0100	-0.0100	-0.0014		
			M_Banana	0.0026		-0.0014	0.0012	58	Low-pass Gauss 8-
∩ Banana^4			-0.0006	0.0000	0.0200	-0.0200	-0.0006		
			M_Banana	0.0026		-0.0014	0.0012	58	Low-pass Gauss 8-
∩ Banana_all			-0.0014	0.0000	0.0200	-0.0200	-0.0014		
			M_Banana	0.0026		-0.0014	0.0012	237	Low-pass Gauss 8-
∩ Banana_all.standard			0.0026						
∩ Lineform_Banana			0.0110	0.0000	0.0300	0.0000	0.0110		
			M_Banana	0.0108		-0.0055	0.0053	237	Low-pass Gauss 8-
∩ Lineform_Banana.x			-13.3601	-13.3645			0.0044		
∩ Lineform_Banana.y			52.3207	52.3174			0.0033		
∩ Lineform_Banana.z			-3.0000	-3.0000			0.0000		
∩ Banana_Form_1			0.0064	0.0000	0.0200	0.0000	0.0064		
			M_Banana_1	0.0064		0.0016	0.0064		
∩ Banana_Form_2			0.0064	0.0000	0.0400	0.0000	0.0064		
			M_Banana_1	0.0064		0.0016	0.0064		