



PiWeb Reporting Plus
Sample 20

Program BALL_8_4S_640
Drawing-No 5021011
Order-No Annahme
Note Start Comment

Type Ball_57
Customer

CMM-No 000000
Process Cutting

Date 6/12/2019 9:21:12 AM
Company OKO
Depmnt IS-AS
Operator Master

Date	12/2/2019 4:27:54 PM	12/2/2019 4:33:32 PM	12/2/2019 4:45:48 PM	12/2/2019 4:51:22 PM	12/2/2019 5:05:05 PM	12/2/2019 5:14:36 PM	12/2/2019 5:20:06 PM	12/3/2019 11:29:41 AM	12/3/2019 11:33:03 AM	12/3/2019 11:38:42 AM	12/3/2019 11:40:54 AM	12/4/2019 7:06:54 AM			
Part-No	6	7	8	9	10	11	12	18	19	20	21	22			
Order-No	Annahme	Annahme	Annahme	Annahme	Annahme	Annahme	Annahme	Annahme	Annahme	Annahme	Annahme	Annahme			
Text	Start Comment	Start Comment	Start Comment	Start Comment	Start Comment	Start Comment	Start Comment	Start Comment	Start Comment	Start Comment	Start Comment	Start Comment			
Characteristic	NOM	UT	LT										Σ	R	
^Temperatur-Kompensati...				20.0000	20.0000	20.0000	20.0000	20.0000	20.0000	20.0000	20.0000	20.0000	20.0000	20.0000	0.0000
1_Temperature															
Temperature	20.500			20.0000	20.0000	20.0000	20.0000	20.0000	20.0000	20.0000	20.0000	20.0000	20.0000	20.0000	0.0000
2_Datum															
DatumSphereCircle_Dia	57.000	0.075	-0.075	57.0001	57.0000	57.0001	57.0001	57.0001	57.0001	57.0001	57.0001	57.0001	57.0000	57.0001	0.0002
CageCircleBottom_Round	0.000	0.075	0.000	0.0019	0.0016	0.0015	0.0017	0.0016	0.0016	0.0017	0.0015	0.0017	0.0015	0.0017	0.0009
CageCircleTop_Round	0.000	0.075	0.000	0.0012	0.0019	0.0020	0.0016	0.0015	0.0019	0.0014	0.0016	0.0014	0.0011	0.0010	0.0010
DatumSphereCircle_Round	0.000	0.075	0.000	0.0018	0.0022	0.0022	0.0021	0.0018	0.0024	0.0018	0.0019	0.0018	0.0020	0.0024	0.0007
DatumPlane_Flatness	0.000	0.040	0.000	0.0019	0.0021	0.0019	0.0020	0.0019	0.0019	0.0021	0.0030	0.0026	0.0026	0.0020	0.0011
3_1_CageSphere															
CageSphere_Dia	57.000	0.075	-0.075	57.0000	57.0000	57.0000	57.0000	57.0000	57.0000	56.9999	57.0000	57.0000	57.0000	57.0000	0.0001
Distance_Top-CageSphere	47.733	0.050	-0.050	47.7331	47.7332	47.7334	47.7333	47.7333	47.7334	47.7335	47.7329	47.7330	47.7331	47.7330	0.0006
CageMid_Round	0.000	0.075	0.000	0.0061	0.0060	0.0062	0.0062	0.0062	0.0062	0.0060	0.0060	0.0060	0.0061	0.0062	0.0002
3_2_1_CageSphere_Dia_15															
CageSphereCircle_Dia_...	57.000	0.075	-0.075	56.9997	57.0002	57.0002	57.0001	57.0003	57.0005	56.9999	56.9999	57.0002	56.9996	56.9999	57.0002
CageSphereCircle_Dia_...	57.000	0.075	-0.075	57.0002	57.0001	56.9999	56.9997	57.0005	56.9998	57.0001	57.0003	57.0001	56.9994	56.9999	57.0001
CageSphereCircle_Dia_...	57.000	0.075	-0.075	57.0000	56.9998	56.9998	57.0002	57.0002	57.0000	57.0000	57.0005	57.0000	57.0003	57.0004	57.0000
3_2_2_CageSphere_Dia_26															
CageSphereCircle_Dia_...	57.000	0.075	-0.075	57.0005	57.0001	56.9997	57.0003	57.0001	57.0000	57.0005	57.0000	57.0000	56.9998	57.0000	0.0008
CageSphereCircle_Dia_...	57.000	0.075	-0.075	56.9997	57.0004	57.0001	57.0001	56.9997	57.0000	57.0001	57.0004	56.9999	56.9999	57.0002	56.9999
CageSphereCircle_Dia_...	57.000	0.075	-0.075	57.0003	57.0001	57.0001	56.9998	56.9999	56.9996	57.0000	57.0002	57.0000	56.9997	57.0000	0.0011
3_2_3_CageSphere_Dia_37															
CageSphereCircle_Dia_...	57.000	0.075	-0.075	56.9995	57.0000	56.9999	56.9999	56.9999	56.9993	56.9997	56.9998	56.9997	57.0000	57.0002	56.9997
CageSphereCircle_Dia_...	57.000	0.075	-0.075	56.9998	57.0002	57.0000	56.9998	56.9999	57.0001	56.9997	56.9994	56.9999	56.9998	56.9996	56.9999
CageSphereCircle_Dia_...	57.000	0.075	-0.075	57.0003	57.0004	56.9997	56.9995	56.9997	57.0001	57.0000	57.0003	57.0004	56.9998	56.9996	57.0004
3_2_4_CageSphere_Dia_48															
CageSphereCircle_Dia_...	57.000	0.075	-0.075	56.9995	57.0000	56.9999	56.9999	56.9999	56.9993	56.9997	56.9998	56.9997	57.0000	57.0002	56.9997
CageSphereCircle_Dia_...	57.000	0.075	-0.075	57.0003	56.9999	56.9998	56.9999	56.9999	57.0002	57.0002	57.0000	56.9996	57.0002	57.0001	56.9996
CageSphereCircle_Dia_...	57.000	0.075	-0.075	57.0001	57.0000	57.0000	57.0005	57.0004	56.9998	57.0002	56.9999	57.0003	57.0003	56.9998	57.0003
3_2_5_CageSphere_Average_Dia															
CageSphereCircle_Dia_...	57.000	0.075	-0.075	56.9998	57.0001	56.9999	57.0000	57.0000	56.9998	57.0000	56.9999	56.9999	56.9999	57.0000	56.9999
CageSphereCircle_Dia_...	57.000	0.075	-0.075	57.0000	57.0002	57.0000	56.9999	57.0000	57.0000	57.0000	56.9999	56.9998	56.9999	56.9999	0.0003
CageSphereCircle_Dia_...	57.000	0.075	-0.075	57.0002	57.0002	56.9998	56.9998	56.9999	56.9999	57.0000	57.0003	57.0002	57.0002	56.9998	57.0002
CageSphereCircle_Dia_...	0.000	0.008	0.000	0.0004	0.0001	0.0001	0.0003	0.0002	0.0001	0.0001	0.0004	0.0003	0.0002	0.0002	0.0003
CageSphereCircle_Dia_...	0.000	0.008	0.000	0.0003	0.0000	0.0001	0.0001	0.0001	0.0000	0.0001	0.0003	0.0003	0.0003	0.0001	0.0003



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Characteristic	NOM	UT	LT	Date	Part-No	Order-No	Text	Start Comment	Start Comment	Start Comment	Start Comment	Start Comment	Start Comment	Start Comment	Start Comment	Start Comment	Start Comment	Start Comment	x	R																											
				12/2/2019 4:27:54 PM	6	Annahme	Start	12/2/2019 4:33:32 PM	7	Annahme	Start	12/2/2019 4:45:48 PM	8	Annahme	Start	12/2/2019 4:51:22 PM	9	Annahme			Start	12/2/2019 5:05:05 PM	10	Annahme	Start	12/2/2019 5:14:36 PM	11	Annahme	Start	12/2/2019 5:20:06 PM	12	Annahme	Start	12/3/2019 11:29:41 AM	18	Annahme	Start	12/3/2019 11:33:03 AM	19	Annahme	Start	12/3/2019 11:38:42 AM	20	Annahme	Start	12/3/2019 11:40:54 AM	21
3_2_6_CageSphere_Form																																															
CageForm_1	0.000	0.019	-0.019	-0.0011	0.0008	0.0008	-0.0008	-0.0008	-0.0009	0.0007	-0.0010	-0.0010	-0.0010	0.0010	-0.0010				-0.0004	0.0021																											
CageForm_1.range				0.0019	0.0015	0.0012	0.0016	0.0014	0.0014	0.0012	0.0018	0.0016	0.0016	0.0016	0.0016				0.0015	0.0008																											
CageFormRange_1	0.000	0.038	0.000	0.0019	0.0015	0.0012	0.0016	0.0014	0.0014	0.0012	0.0018	0.0016	0.0016	0.0016	0.0016				0.0015	0.0008																											
CageForm_3	0.000	0.019	-0.019	-0.0010	0.0007	-0.0009	-0.0007	-0.0007	0.0006	-0.0014	0.0010	-0.0012	-0.0009	0.0008	-0.0012				-0.0004	0.0024																											
CageForm_3.range				0.0016	0.0014	0.0018	0.0012	0.0015	0.0011	0.0021	0.0018	0.0018	0.0016	0.0014	0.0018				0.0016	0.0010																											
CageFormRange_3	0.000	0.038	0.000	0.0016	0.0014	0.0018	0.0012	0.0015	0.0011	0.0021	0.0018	0.0018	0.0016	0.0014	0.0018				0.0016	0.0010																											
CageForm_5	0.000	0.019	-0.019	0.0010	-0.0008	0.0011	-0.0007	-0.0010	0.0009	0.0009	-0.0015	-0.0011	-0.0008	-0.0007	-0.0011				-0.0003	0.0026																											
CageForm_5.range				0.0016	0.0013	0.0018	0.0013	0.0017	0.0016	0.0014	0.0022	0.0019	0.0013	0.0013	0.0019				0.0016	0.0010																											
CageFormRange_5	0.000	0.038	0.000	0.0016	0.0013	0.0018	0.0013	0.0017	0.0016	0.0014	0.0022	0.0019	0.0013	0.0013	0.0019				0.0016	0.0010																											
CageForm_7	0.000	0.019	-0.019	-0.0008	-0.0007	-0.0009	-0.0006	0.0008	-0.0009	-0.0009	0.0010	-0.0010	-0.0012	0.0013	-0.0010				-0.0004	0.0025																											
CageForm_7.range				0.0015	0.0013	0.0016	0.0012	0.0012	0.0016	0.0017	0.0018	0.0019	0.0018	0.0022	0.0019				0.0016	0.0010																											
CageFormRange_7	0.000	0.038	0.000	0.0015	0.0013	0.0016	0.0012	0.0012	0.0016	0.0017	0.0018	0.0019	0.0018	0.0022	0.0019				0.0016	0.0010																											
CageForm_2	0.000	0.019	-0.019	0.0011	-0.0010	-0.0009	0.0007	0.0011	0.0007	-0.0008	-0.0011	0.0010	0.0010	-0.0009	0.0010				0.0002	0.0022																											
CageForm_2.range				0.0020	0.0019	0.0016	0.0011	0.0019	0.0013	0.0015	0.0019	0.0018	0.0013	0.0017	0.0018				0.0016	0.0009																											
CageFormRange_2	0.000	0.038	0.000	0.0020	0.0019	0.0016	0.0011	0.0019	0.0013	0.0015	0.0019	0.0018	0.0013	0.0017	0.0018				0.0016	0.0009																											
CageForm_4	0.000	0.019	-0.019	0.0010	-0.0009	-0.0008	-0.0008	0.0008	-0.0011	0.0010	-0.0014	-0.0007	-0.0006	-0.0007	-0.0007				-0.0004	0.0024																											
CageForm_4.range				0.0018	0.0017	0.0015	0.0015	0.0014	0.0017	0.0018	0.0022	0.0013	0.0012	0.0012	0.0013				0.0016	0.0010																											
CageFormRange_4	0.000	0.038	0.000	0.0018	0.0017	0.0015	0.0015	0.0014	0.0017	0.0018	0.0022	0.0013	0.0012	0.0012	0.0013				0.0016	0.0010																											
CageForm_6	0.000	0.019	-0.019	-0.0011	0.0009	-0.0008	0.0012	0.0008	-0.0008	-0.0011	-0.0009	-0.0009	0.0011	0.0007	-0.0009				-0.0002	0.0023																											
CageForm_6.range				0.0022	0.0017	0.0015	0.0018	0.0015	0.0017	0.0017	0.0013	0.0016	0.0021	0.0013	0.0016				0.0017	0.0009																											
CageFormRange_6	0.000	0.038	0.000	0.0022	0.0017	0.0015	0.0018	0.0015	0.0017	0.0017	0.0013	0.0016	0.0021	0.0013	0.0016				0.0017	0.0009																											
CageForm_8	0.000	0.019	-0.019	-0.0006	-0.0010	-0.0009	0.0008	-0.0007	-0.0008	0.0010	-0.0008	-0.0008	0.0008	-0.0009	-0.0008				-0.0004	0.0020																											
CageForm_8.range				0.0011	0.0019	0.0019	0.0015	0.0014	0.0015	0.0017	0.0016	0.0014	0.0014	0.0018	0.0014				0.0016	0.0007																											
CageFormRange_8	0.000	0.038	0.000	0.0011	0.0019	0.0019	0.0015	0.0014	0.0015	0.0017	0.0016	0.0014	0.0014	0.0018	0.0014				0.0016	0.0007																											
3_2_7_CageSegment_Export																																															
Dia_RCage_1	57.000			57.0006	56.9999	57.0007	56.9999	57.0014	56.9982	57.0023	57.0009	57.0014	57.0000	56.9990	57.0014				57.0005	0.0042																											
Dia_RCage_5	57.000			56.9999	57.0000	57.0002	56.9990	56.9999	57.0010	57.0005	57.0009	57.0020	56.9955	56.9982	57.0020				56.9999	0.0065																											
Dia_RCage_3	57.000			56.9953	56.9998	56.9979	56.9989	56.9986	56.9974	56.9944	57.0009	56.9986	57.0006	56.9972	56.9986				56.9982	0.0065																											
Dia_RCage_7	57.000			56.9991	57.0002	56.9999	57.0001	57.0035	56.9978	56.9993	56.9963	56.9982	57.0003	57.0022	56.9982				56.9996	0.0072																											
Dia_RCage_2	57.000			56.9980	56.9999	56.9980	57.0004	57.0005	57.0031	56.9997	57.0003	56.9973	56.9991	56.9998	56.9973				56.9995	0.0057																											
Dia_RCage_6	57.000			57.0004	57.0004	57.0009	56.9996	57.0000	56.9990	57.0049	57.0018	56.9987	56.9989	56.9996	56.9987				57.0002	0.0061																											
Dia_RCage_4	57.000			57.0027	57.0033	56.9951	56.9977	56.9995	57.0004	57.0008	56.9996	57.0017	56.9981	57.0013	57.0017				57.0002	0.0082																											
Dia_RCage_8	57.000			57.0010	57.0004	56.9989	56.9991	56.9984	56.9980	56.9974	56.9992	56.9963	57.0028	57.0003	56.9963				56.9990	0.0066																											