

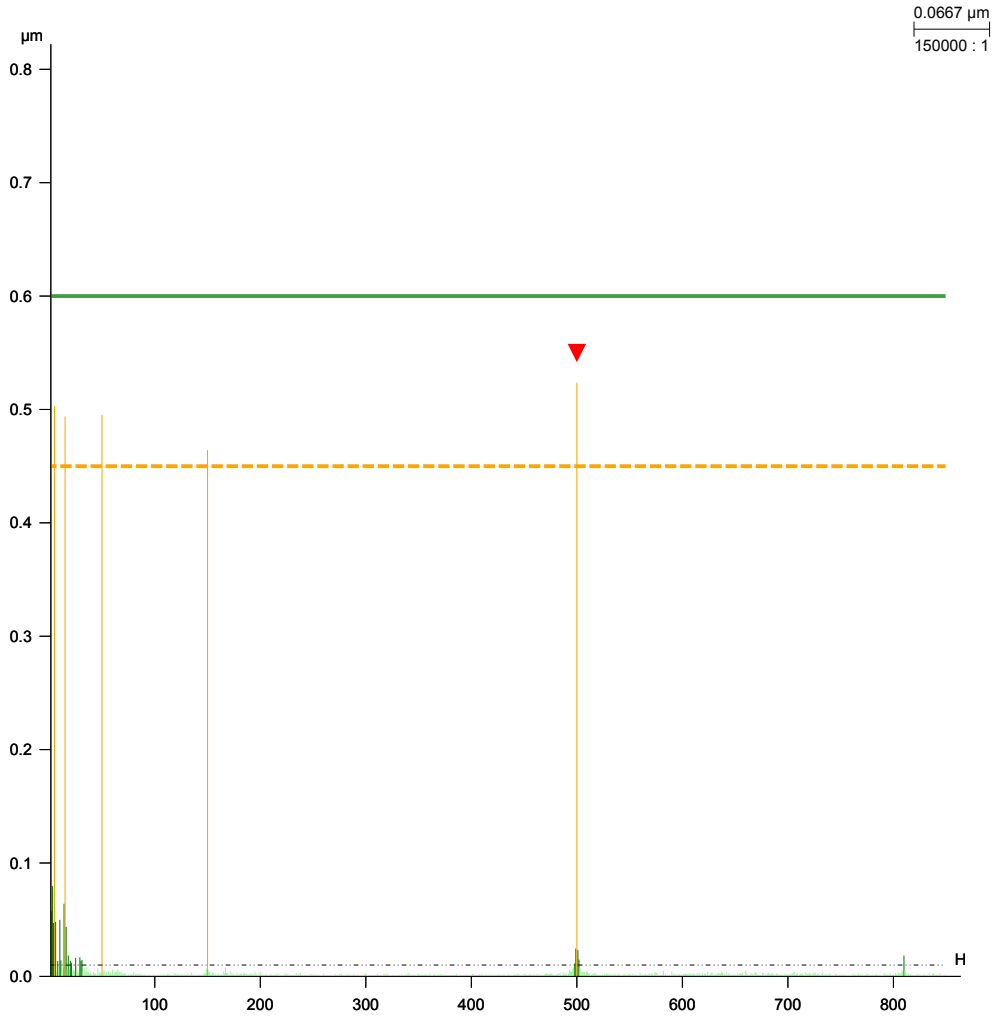


Inspection	Waviness_662
DrawingNo	Waviness-Gauge 19-07-22
Type	5-15-50-150-500
Process	Test
MiniPlan	All Characteristics

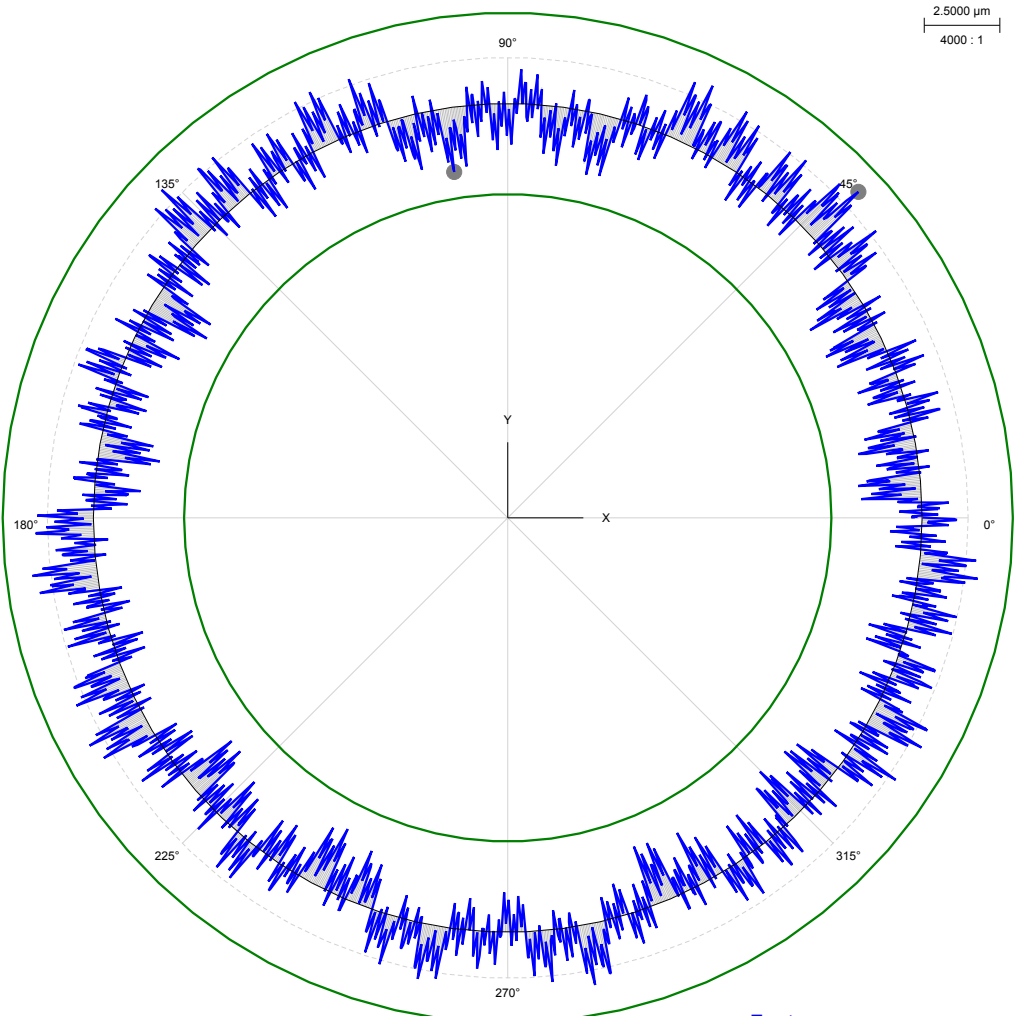
OrderNo	Validation	Date	7/25/2019 12:33 PM		
PartNo	2_SE21	Mach-No	123456	CMM-No	000000
Gauge-No	123-456	Customer	Customer	CMM	PRISMO_RT-AB
		CostCenter	CostCenter	MPEe =	0.9 ± L / 350
Plant	CZ IMT GmbH	Deprmt	SES-AP	Worker	Master / 1

FFT Radial & Roundness 1

C_Waviness_1




Round_Circle_1



Name	Comment	Actual	Tolerance
critical_C_Waviness_1	to Tolerance or Exceed [µm]	0.523643	0.600000

Feature	Circle_1
Sigma	0.000799
Stylus-Ø	1.000374
Vs[mm/sec]	10.000000

Name	Comment	Actual	Tolerance	Evaluation method	Min	Max	Points	Filter type	Lc	W/R
Round_Circle_1		0.004259	0.006000	Minimum Feature	-0.002129	0.002129	8499	No Filter	-	-

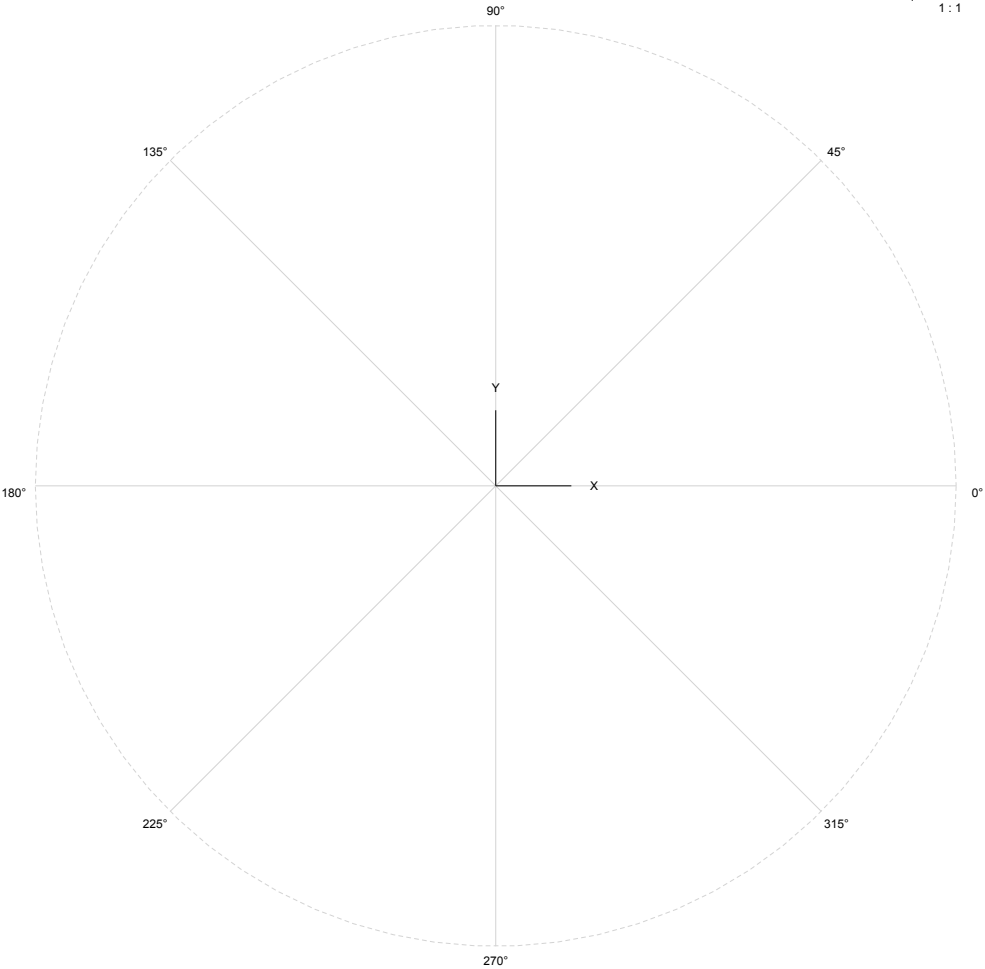
<div></div> <div>PiWeb</div> <div>Reporting Plus</div> <div>FFT Radial & Roundness 2</div>	Inspection	Waviness_662	OrderNo	Date		
	DrawingNo	Waviness-Gauge	PartNo	Mach-No	CMM-No	
	Type	5-15-50-150-500	Gauge-No	Customer	CMM	
	Process			CostCenter	MPEe =	
	MiniPlan		Plant	CZ IMT GmbH	Deprmt	SES-AP

C_Waviness_2

Round_Circle_2

0.0667 µm
150000 : 1

10.0000 mm
1 : 1




Feature

Sigma
Stylus-Ø
Vs[mm/sec]

Name	Comment	Actual	Tolerance
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Name	Comment	Actual	Tolerance	Evaluation method	Min	Max	Points	Filter type	Lc	W/R
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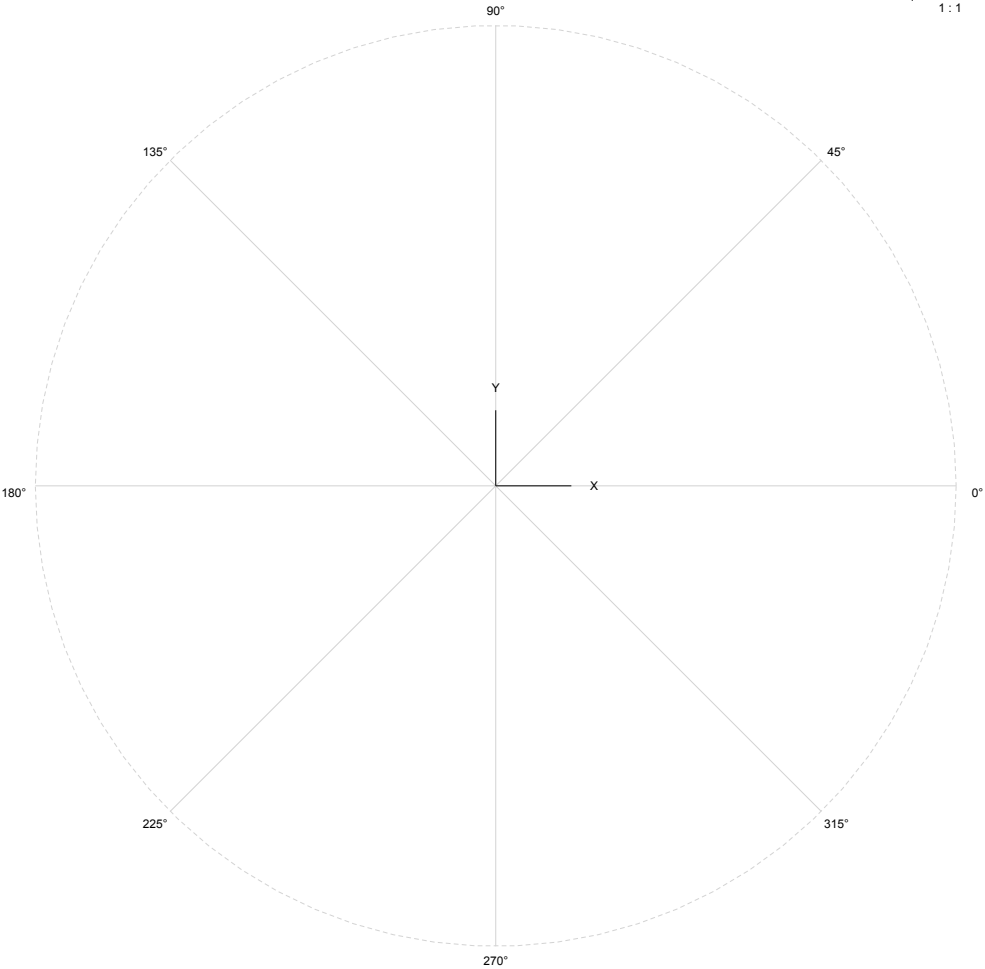
<div><div><div>PiWeb</div><div>Reporting Plus</div></div><div>FFT Radial & Roundness 3</div></div>	Inspection	Waviness_662	OrderNo	Date		
	DrawingNo	Waviness-Gauge	PartNo	Mach-No	CMM-No	
	Type	5-15-50-150-500	Gauge-No	Customer	CMM	
	Process			CostCenter	MPEe =	
	MiniPlan		Plant	CZ IMT GmbH	Deprmt	SES-AP

C_Waviness_3

Round_Circle_3

0.0667 µm
150000 : 1

10.0000 mm
1 : 1




Feature

Sigma
Stylus-Ø
Vs[mm/sec]

Name	Comment	Actual	Tolerance
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Name	Comment	Actual	Tolerance	Evaluation method	Min	Max	Points	Filter type	Lc	W/R
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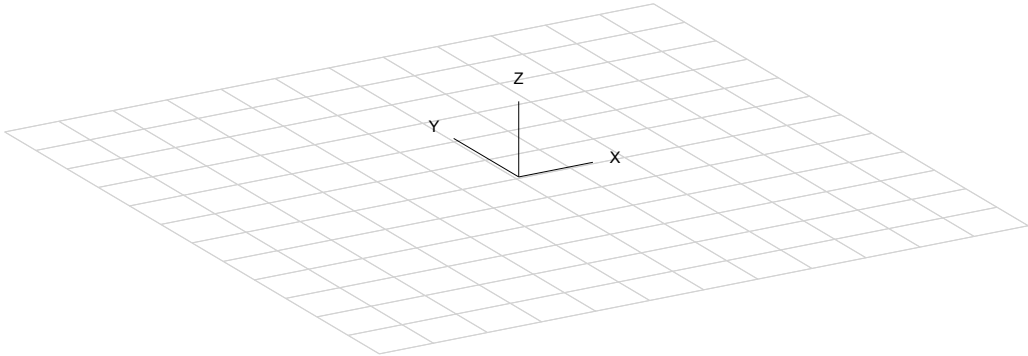
<div></div> <div>PiWeb</div> <div>Reporting Plus</div> <div>FFT Axial & Flatness</div>	Inspection	Waviness_662	OrderNo	Date		
	DrawingNo	Waviness-Gauge	PartNo	Mach-No	CMM-No	
	Type	5-15-50-150-500	Gauge-No	Customer	CMM	
	Process			CostCenter	MPEe =	
	MiniPlan		Plant	CZ IMT GmbH	Deprmt	SES-AP

Plane_Waviness

2.0000 µm
5000 : 1

Plane_1_Flatness

14.5369 mm
1 : 1



mm	X	Y	Z
Corner points 1	0.0000	0.0000	0.0000
2	0.0000	0.0000	0.0000
3	0.0000	0.0000	0.0000
4	0.0000	0.0000	0.0000
Max	0.0000	0.0000	0.0000
Min	0.0000	0.0000	0.0000

Feature

Sigma
Stylus-Ø
Vs[mm/sec]

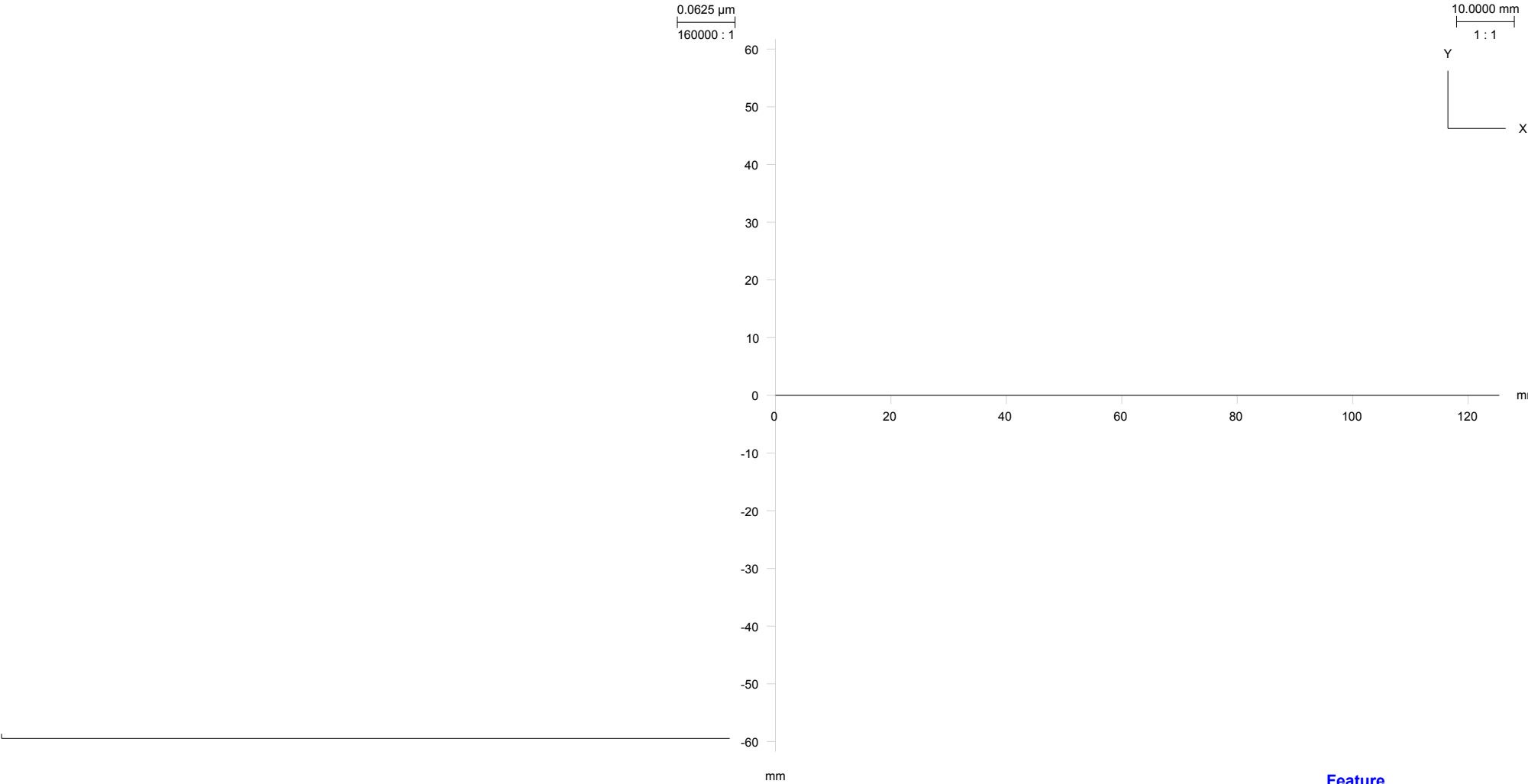
Name	Comment	Actual	Tolerance
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Name	Comment	Actual	Tolerance	Evaluation method	Min	Max	Points	Filter type	Lc	W/R
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<div><div>ZEISS</div><div>PiWeb Reporting Plus</div></div> <div>FFT Line & Straightness</div>	Inspection	Waviness_662	OrderNo	Date		
	DrawingNo	Waviness-Gauge	PartNo	Mach-No	CMM-No	
	Type	5-15-50-150-500	Gauge-No	Customer	CMM	
	Process			CostCenter	MPEe =	
	MiniPlan		Plant	CZ IMT GmbH	Deprmt	SES-AP

Waviness_Line

Line_Straightness

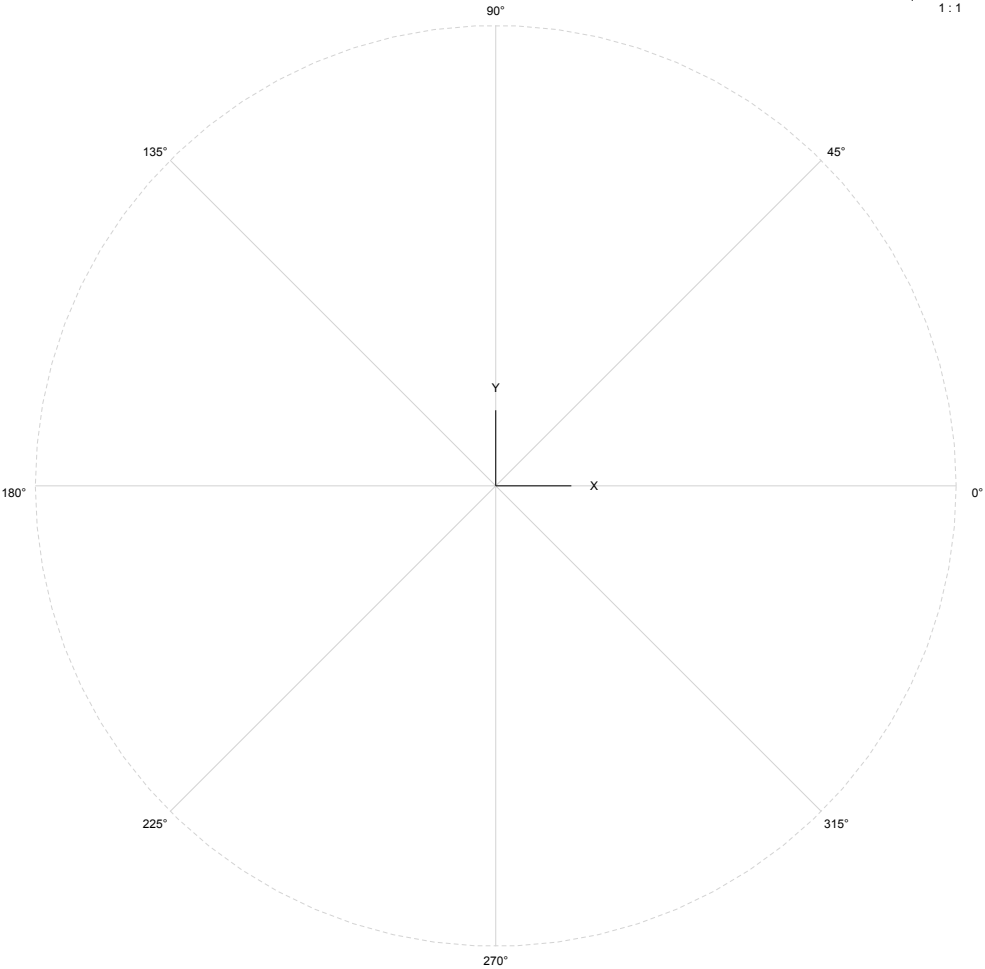


Name	Comment	Actual	Tolerance	Feature						
				Sigma Stylus-Ø Vs[mm/sec]						
Name	Comment	Actual	Tolerance	Evaluation method	Min	Max	Points	Filter type	Lc	W/R

 <div>PiWeb Reporting Plus</div> <div>Dom FFT Radial & Roundness (5)</div>	Inspection	Waviness_662	OrderNo	Date				
	DrawingNo	Waviness-Gauge	PartNo	Mach-No	CMM-No			
	Type	5-15-50-150-500	Gauge-No	Customer	CMM			
	Process			CostCenter	MPEe =			
	MiniPlan		Plant	CZ IMT GmbH	Deprmt	SES-AP	Worker	/
	Wave_5				Filter_5			

0.0333 µm
300000 : 1

10.0000 mm
1 : 1



Feature

Sigma
Stylus-Ø
Vs[mm/sec]

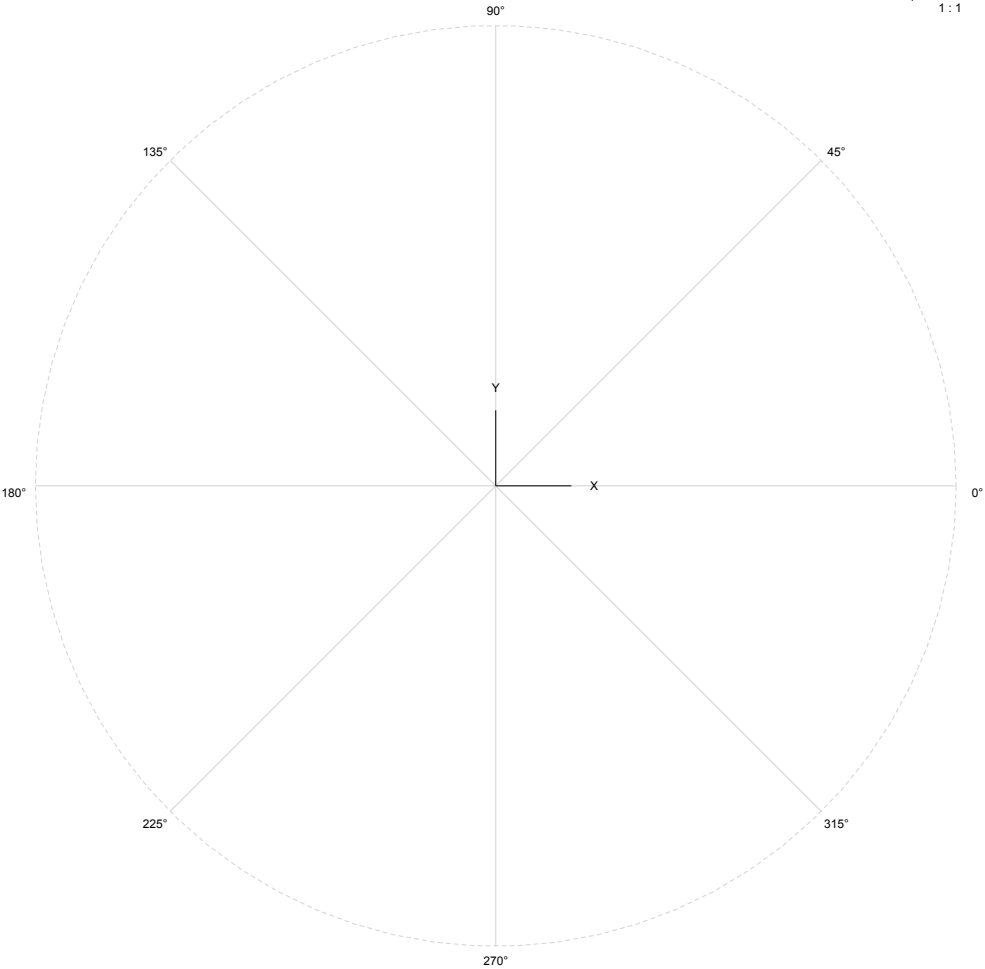
Name	Comment	Actual	Tolerance
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Name	Comment	Actual	Tolerance	Evaluation method	Min	Max	Points	Filter type	Lc	W/R
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<div><div>ZEISS</div><div>PiWeb Reporting Plus</div></div>	Inspection	Waviness_662	OrderNo	Date			
	DrawingNo	Waviness-Gauge	PartNo	Mach-No	CMM-No		
	Type	5-15-50-150-500	Gauge-No	Customer	CMM		
	Process			CostCenter	MPEe =		
	MiniPlan		Plant	CZ IMT GmbH	Deprmt	SES-AP	Worker
Dom FFT Radial & Roundness (15)	Wave_15				Filter_15		

0.0333 µm
300000 : 1

10.0000 mm
1 : 1



Feature

Sigma
Stylus-Ø
Vs[mm/sec]

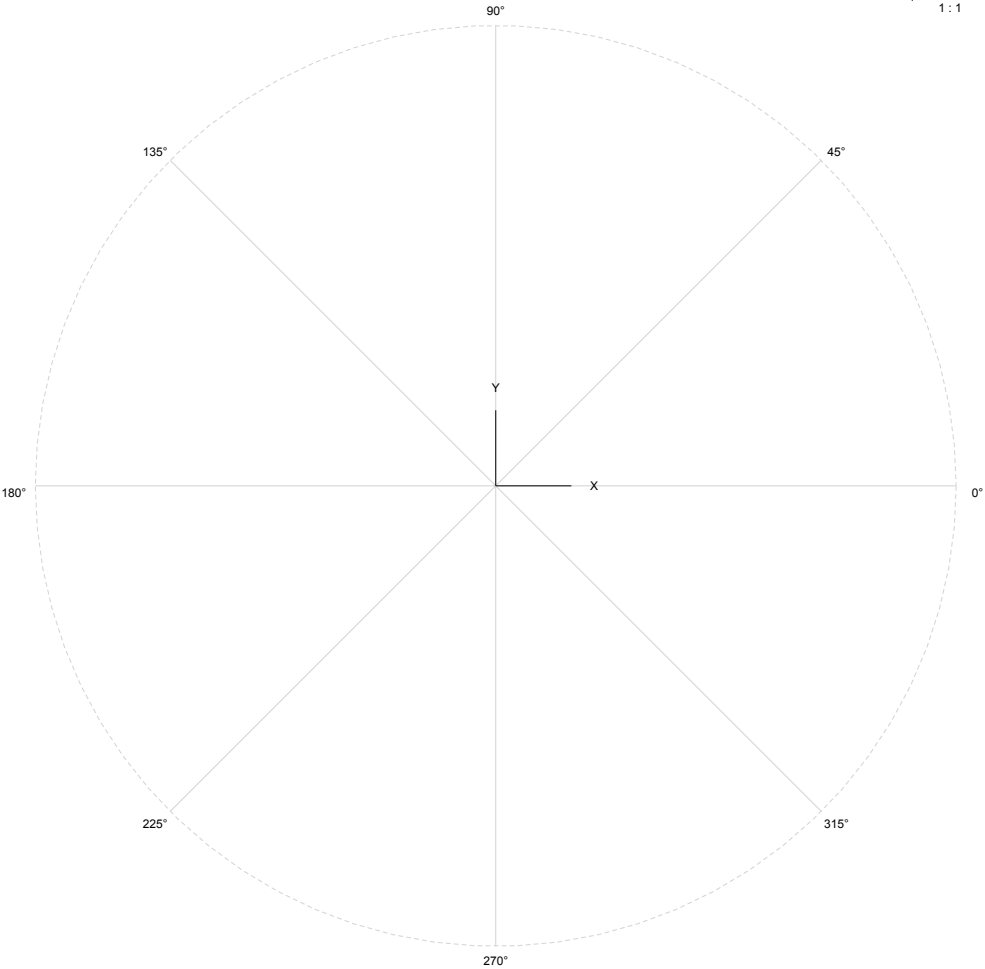
Name	Comment	Actual	Tolerance
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Name	Comment	Actual	Tolerance	Evaluation method	Min	Max	Points	Filter type	Lc	W/R
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<div><div>ZEISS</div><div>PiWeb Reporting Plus</div></div> <div>Dom FFT Radial & Roundness (50)</div>	Inspection	Waviness_662	OrderNo	Date				
	DrawingNo	Waviness-Gauge	PartNo	Mach-No	CMM-No			
	Type	5-15-50-150-500	Gauge-No	Customer	CMM			
	Process			CostCenter	MPEe =			
	MiniPlan		Plant	CZ IMT GmbH	Deprmt	SES-AP	Worker	/
	Wave_50				Filter_50			

0.0333 µm
300000 : 1

10.0000 mm
1 : 1



Feature

Sigma
Stylus-Ø
Vs[mm/sec]

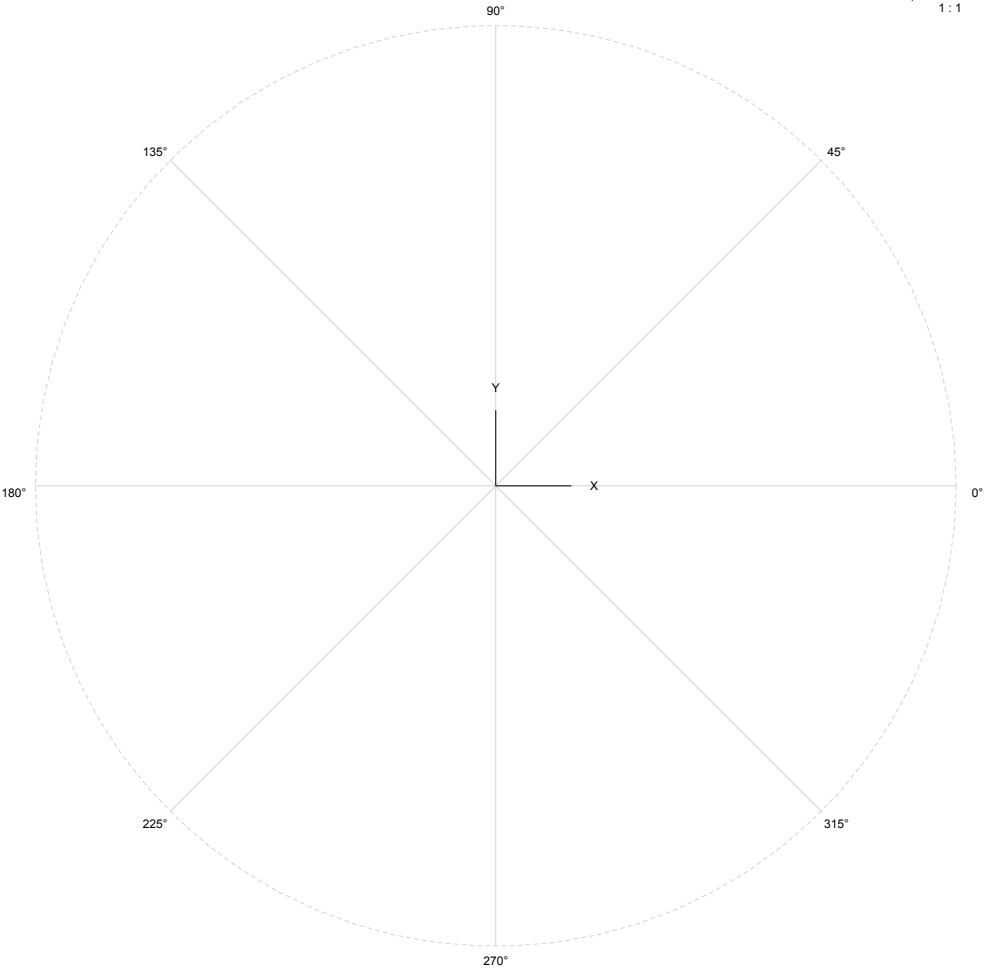
Name	Comment	Actual	Tolerance
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Name	Comment	Actual	Tolerance	Evaluation method	Min	Max	Points	Filter type	Lc	W/R
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<div><div>ZEISS</div><div>PiWeb Reporting Plus</div></div> <div>Dom FFT Radial & Roundness (150)</div>	Inspection	Waviness_662	OrderNo	Date				
	DrawingNo	Waviness-Gauge	PartNo	Mach-No	CMM-No			
	Type	5-15-50-150-500	Gauge-No	Customer	CMM			
	Process			CostCenter	MPEe =			
	MiniPlan		Plant	CZ IMT GmbH	Deprmt	SES-AP	Worker	/
	Wave_150				Filter_150			

0.0333 µm
300000 : 1

10.0000 mm
1 : 1



Feature

Sigma
Stylus-Ø
Vs[mm/sec]

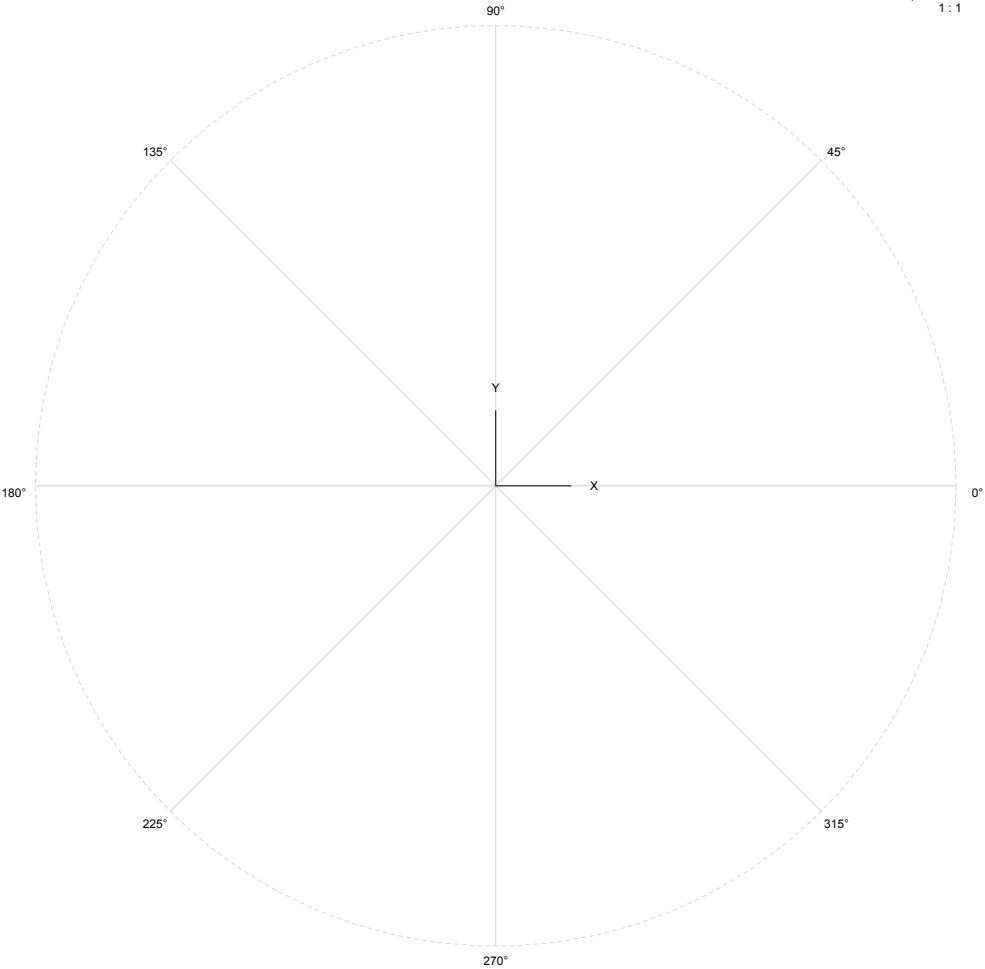
Name	Comment	Actual	Tolerance
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Name	Comment	Actual	Tolerance	Evaluation method	Min	Max	Points	Filter type	Lc	W/R
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<div><div>ZEISS</div><div>PiWeb Reporting Plus</div></div>	Inspection	Waviness_662	OrderNo	Date			
	DrawingNo	Waviness-Gauge	PartNo	Mach-No	CMM-No		
	Type	5-15-50-150-500	Gauge-No	Customer	CMM		
	Process			CostCenter	MPEe =		
	MiniPlan		Plant	CZ IMT GmbH	Deprmt	SES-AP	Worker
Dom FFT Radial & Roundness (500)	Wave_500				Filter_500		

0.0333 µm
300000 : 1

10.0000 mm
1 : 1




Feature

Sigma
Stylus-Ø
Vs[mm/sec]

Name	Comment	Actual	Tolerance
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Name	Comment	Actual	Tolerance	Evaluation method	Min	Max	Points	Filter type	Lc	W/R
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PiWeb

Reporting Plus

Inspection

DrawingNo

Type

Process

MiniPlan

Waviness_662

Waviness-Gauge

5-15-50-150-500

OrderNo

PartNo

Gauge-No

Plant

CZ IMT GmbH

Date

Mach-No

Customer

CostCenter

Deprmt

SES-AP

CMM-No

CMM

MPEe =

Worker

/

[Circle-1 as Curve to unwind](#)

CurveForm

