



PiWeb Reporting Plus

Last 1 measurements
► Approval ≠ Gesperrt
No. measured values 35

Date 7/25/2019 12:33 PM
Run-Time 00:00:56.0
No. values: red 4

Program **Waviness_662**
Drawing-No Waviness-Gauge 19-07-22
Order-No Validation
Type 5-15-50-150-500
Process *Test*
Part-No 2_SE21

MiniPlan *All Characteristics*
Mach-No 123456
CMM-No 000000
CMM PRISMO_RT-AB
MPEe = $0.9 \pm L / 350$
Gauge-No 123-456

Plant CZ IMT GmbH
Depmnt SES-AP
CostCenter *CostCenter*
Operator Master
Shift 1

DMC

Text StartComment

Name	Act	NOM	UpTol	LowTol	Dev	Exc	Tolerance
Comment	M-Class	P-Class					

1. Roundness

○ Round_Circle_1_5WU	0.000664	0.000000	0.001100	0.000000	0.000664		
○ Round_Circle_1_15WU	0.001304	0.000000	0.001370	0.000000	0.001304		
○ Round_Circle_1_50WU	0.002125	0.000000	0.002230	0.000000	0.002125		
○ Round_Circle_1_150WU	0.002773	0.000000	0.002760	0.000000	0.002773	0.000013	
○ Round_Circle_1_500WU	0.003652	0.000000	0.003410	0.000000	0.003652	0.000242	

2. CALYPSO_Waviness

○ Round_Circle_1	0.004259	0.000000	0.006000	0.000000	0.004259		
⊗ C_Waviness_1	0.523643	0.000000	0.600000	0.000000	0.523643		
⊕ critical_C_Waviness_1 to Tolerance or Exceed [µm]	0.523643	0.000000	0.600000	0.000000	0.523643		
○ Round_Circle_2	0.004242	0.000000	0.006000	0.000000	0.004242		
⊗ C_Waviness_2	0.522248	0.000000	0.600000	0.000000	0.522248		
⊕ critical_C_Waviness_2 to Tolerance or Exceed [µm]	0.522248	0.000000	0.600000	0.000000	0.522248		
○ Round_Circle_3	0.004427	0.000000	0.006000	0.000000	0.004427		
⊗ C_Waviness_3	0.518271	0.000000	0.600000	0.000000	0.518271		
⊕ critical_C_Waviness_3 to Tolerance or Exceed [µm]	0.518271	0.000000	0.600000	0.000000	0.518271		

3.1 DominateWaviness_5

○ Filter_5	0.000369	0.000000	0.001000	0.000000	0.000369		
⊗ Wave_5	0.205633	0.000000	0.150000	0.000000	0.205633	0.055633	
⊕ DomWave_5 FFT-value by Factor 4 [µm]	0.822530	0.000000	0.600000	0.000000	0.822530	0.222530	

3.2 DominateWaviness_15

○ Filter_15	0.000374	0.000000	0.001000	0.000000	0.000374		
⊗ Wave_15	0.147331	0.000000	0.150000	0.000000	0.147331		
⊕ DomWave_15 FFT-value by Factor 4 [µm]	0.589323	0.000000	0.600000	0.000000	0.589323		



Name	Act	NOM	UpTol	LowTol	Dev	Exc	Tolerance
Comment	M-Class	P-Class					
3.3 DominateWaviness_50							
○ Filter_50	0.000326	0.000000	0.001000	0.000000	0.000326		
⊗ Wave_50	0.130738	0.000000	0.150000	0.000000	0.130738		
⊕ DomWave_50 FFT-value by Factor 4 [µm]	0.522952	0.000000	0.600000	0.000000	0.522952		
3.4 DominateWaviness_150							
○ Filter_150	0.000294	0.000000	0.001000	0.000000	0.000294		
⊗ Wave_150	0.118212	0.000000	0.150000	0.000000	0.118212		
⊕ DomWave_150 FFT-value by Factor 4 [µm]	0.472849	0.000000	0.600000	0.000000	0.472849		
3.5 DominateWaviness_500							
○ Filter_500	0.000352	0.000000	0.001000	0.000000	0.000352		
⊗ Wave_500	0.131631	0.000000	0.150000	0.000000	0.131631		
⊕ DomWave_500 FFT-value by Factor 4 [µm]	0.589323	0.000000	0.600000	0.000000	0.589323		
4. Waviness Line							
— Line_Straightness	0.004405	0.000000	0.006000	0.000000	0.004405		
⊗ Waviness_Line	0.530671	0.000000	0.600000	0.000000	0.530671		
⊕ critical_Line_Waviness to Tolerance or Exceed [µm]	0.530671	0.000000	0.600000	0.000000	0.530671		
5. Waviness Plane							
▧ Plane_1_Flatness	0.023003	0.000000	0.025000	0.000000	0.023003		
⊗ Plane_Waviness	0.130822	0.000000	3.072691	0.000000	0.130822		
⊕ Plane_Waviness_critical to Tolerance or Exceed [µm]	0.130822	0.000000	3.073000	0.000000	0.130822		