



PiWeb Report Plus

Part name **Probe Qual**

Drawing number

Order number

Variant

Company

Department

CMM Type

CMM No.

AMC

Quality

CON_2014_G2

531218

Part ident

2263

Time/Date

5/26/2020 7:55 AM

Run

All Characteristics

No. measured values

48

No. values: red

0

Measurement Duration

00:50:26.0

Plan Comments:

Name	Measured value	Nominal value	+Tol	-Tol	Deviation +/-	
Master						
Master Probe - Diameter <small>First Time Radius (Jan 10, 2020) : 3.9999mm</small>	8.0005	8.0000	0.0008	-0.0008	0.0005	
Master Probe - Sigma	0.0001	0.0000	0.0008		0.0001	
3mm Stili						
3mm Probe - Diameter <small>First Time Diameter (Jan 21, 2020) : 2.9995mm</small>	3.0000	2.9995	0.0010	-0.0010	0.0005	
3mm Probe - Sigma	0.0003	0.0000	0.0010		0.0003	
10mm Stylus						
10mm Probe - Diameter <small>First Time Diameter (Feb 6, 2020) : 10.0000mm</small>	10.0003	10.0000	0.0010	-0.0010	0.0003	
10mm Probe - Sigma	0.0002	0.0000	0.0010		0.0002	
Rotational Stylus ▶ 1mm Probe						
#1 -Z Probe - Diamter <small>First Time Diameter (Jan 31, 2020) : 1.0008mm</small>	1.0011	1.0008	0.0010	-0.0010	0.0003	
#1 -Z Probe - Sigma	0.0001	0.0000	0.0015		0.0001	
Rotational Stylus ▶ 3mm Long Probe <small>Speed Qual Passed, Maximum 15mm/Sec.</small>						
#2 +Y Probe - Diameter	3.0027	3.0019	0.0010	-0.0010	0.0008	
#2 +Y Probe - Sigma	0.0004	0.0000	0.0015		0.0004	
#3 +X Probe - Diameter	3.0020	3.0019	0.0010	-0.0010	0.0002	
#3 +X Probe - Sigma	0.0004	0.0000	0.0015		0.0004	
#4 -Y Probe - Diameter	3.0024	3.0019	0.0010	-0.0010	0.0005	
#4 -Y Probe - Sigma	0.0004	0.0000	0.0015		0.0004	
#5 -X Probe - Diameter	3.0018	3.0019	0.0010	-0.0010	-0.0001	
#5 -X Probe - Sigma	0.0005	0.0000	0.0015		0.0005	



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6.8.1203

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Name	Measured value	Nominal value	+Tol	-Tol	Deviation +/-
#16 A 105 Probe - Diameter	3.0021	3.0019	0.0010	-0.0010	0.0003
#16 A 105 Probe - Sigma	0.0004	0.0000	0.0015		0.0004
#17 A 75 Probe - Diameter	3.0019	3.0019	0.0010	-0.0010	0.0001
#17 A 75 Probe - Sigma	0.0004	0.0000	0.0015		0.0004

Rotational Stylus ▶ 1.5mm Probe

#10 +Y_1.5mm - Diameter <small>First Time Diameter (May 21, 2020) : 1.5016mm</small>	1.5019	1.5016	0.0010	-0.0010	0.0003
#10 +Y_1.5mm - Sigma	0.0006	0.0000	0.0010		0.0006
#11 +X_1.5mm - Diameter <small>First Time Diameter (May 21, 2020) : 1.5016mm</small>	1.5015	1.5016	0.0010	-0.0010	-0.0001
#11 +X_1.5mm - Sigma	0.0005	0.0000	0.0010		0.0005
#12 -Y_1.5mm - Diameter <small>First Time Diameter (May 21, 2020) : 1.5016mm</small>	1.5018	1.5016	0.0010	-0.0010	0.0002
#12 -Y_1.5mm - Sigma	0.0006	0.0000	0.0010		0.0006
#13 -X_1.5mm - Diameter <small>First Time Diameter (May 21, 2020) : 1.5016mm</small>	1.5015	1.5016	0.0010	-0.0010	-0.0001
#13 -X_1.5mm - Sigma	0.0007	0.0000	0.0010		0.0007

Rotational Stylus ▶ 10mm Probe

#6 +Y_10mm - Diameter <small>First Time Diameter (May 20, 2020) : 10.0008mm</small>	10.0010	10.0008	0.0010	-0.0010	0.0002
#6 +Y_10mm - Sigma	0.0001	0.0000	0.0010		0.0001
#7 +X_10mm - Diameter <small>First Time Diameter (May 20, 2020) : 10.0008mm</small>	10.0008	10.0008	0.0010	-0.0010	0.0000
#7 +X_10mm - Sigma	0.0001	0.0000	0.0010		0.0001
#8 -Y_10mm - Diameter <small>First Time Diameter (May 20, 2020) : 10.0008mm</small>	10.0008	10.0008	0.0010	-0.0010	0.0000
#8 -Y_10mm - Sigma	0.0001	0.0000	0.0010		0.0001
#9 -X_10mm - Diameter <small>First Time Diameter (May 20, 2020) : 10.0008mm</small>	10.0006	10.0008	0.0010	-0.0010	-0.0002
#9 -X_10mm - Sigma	0.0001	0.0000	0.0010		0.0001

Special Stylus ▶ -Z Cylinder

#1 -Z_3mm Cylinder - Diameter	2.9902	2.9893	0.0010	-0.0010	0.0009
#1 -Z_3mm Cylinder - Sigma	0.0003	0.0000	0.0010		0.0003



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Name	Measured value	Nominal value	+Tol	-Tol	Deviation +/-	
Special Stylus ▶ 0.8mm Probe						
#3 +X_0.8mm - Diameter <small>First Time Diameter (Mar 26, 2019) : 0.7993mm</small>	0.8000	0.7993	0.0010	-0.0010	0.0007	
#3 +X_0.8mm - Sigma	0.0002	0.0000	0.0010		0.0002	
#4 -Y_0.8mm - Diameter	0.7998	0.7993	0.0010	-0.0010	0.0005	
#4 -Y_0.8mm - Sigma	0.0002	0.0000	0.0010		0.0002	
#5 -X_0.8mm - Diameter <small>First Time Diameter (Mar 26, 2019) : 0.7993mm</small>	0.7999	0.7993	0.0010	-0.0010	0.0006	
#5 -X_0.8mm - Sigma	0.0001	0.0000	0.0010		0.0001	
Special Stylus ▶ 3mm Angle						
#6 +Y_3mm Angle - Diameter	3.0011	3.0005	0.0010	-0.0010	0.0006	
#6 +Y_3mm Angle - Sigma	0.0001	0.0000	0.0005		0.0001	
Special Stylus ▶ -X Cylinder						
#7 -X_3mm Cylinder - Diameter	2.9927	2.9918	0.0010	-0.0010	0.0009	
#7 -X_3mm Cylinder - Sigma	0.0008	0.0000	0.0010		0.0008	