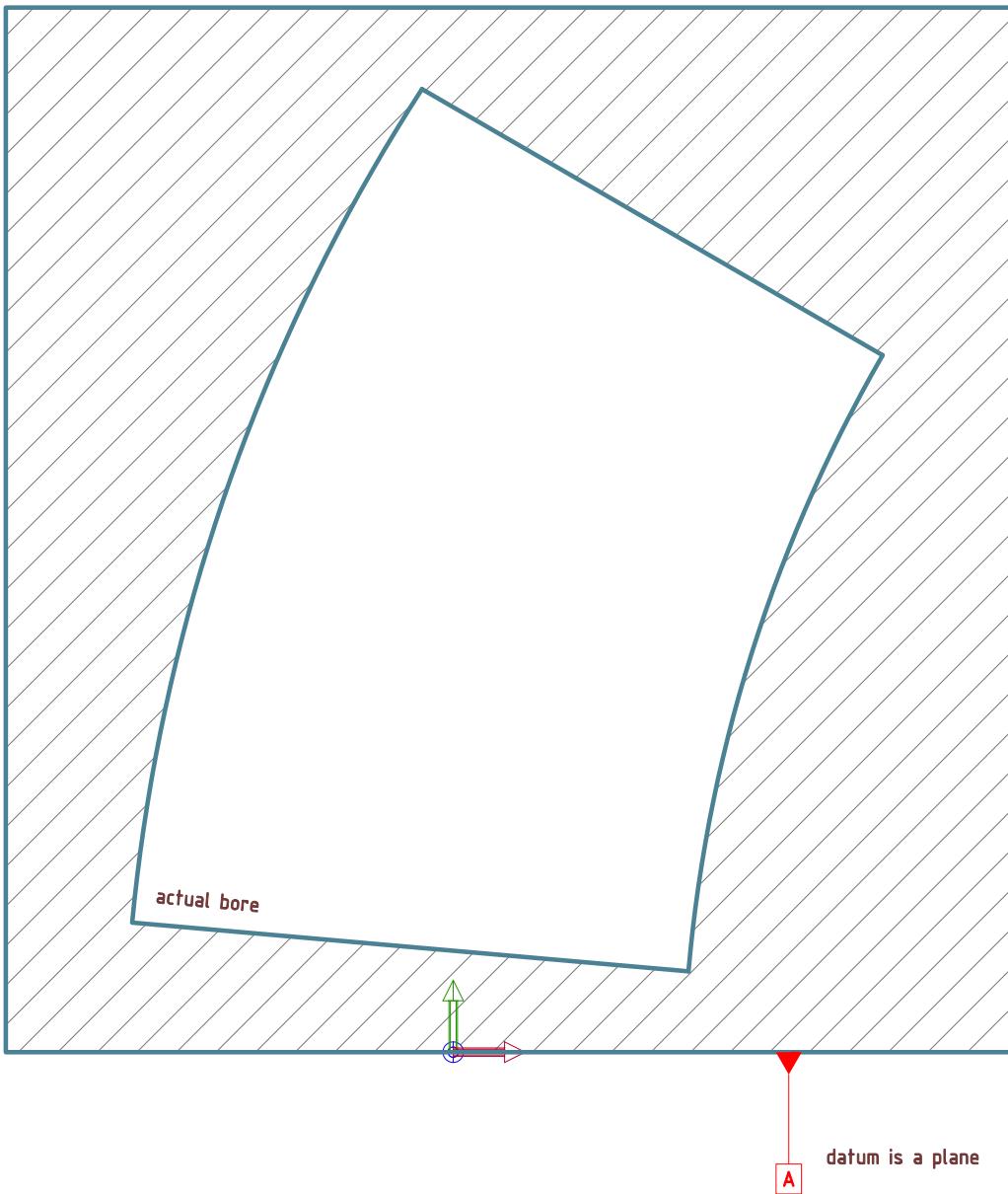


# Actual shape of a cylinder (bore)

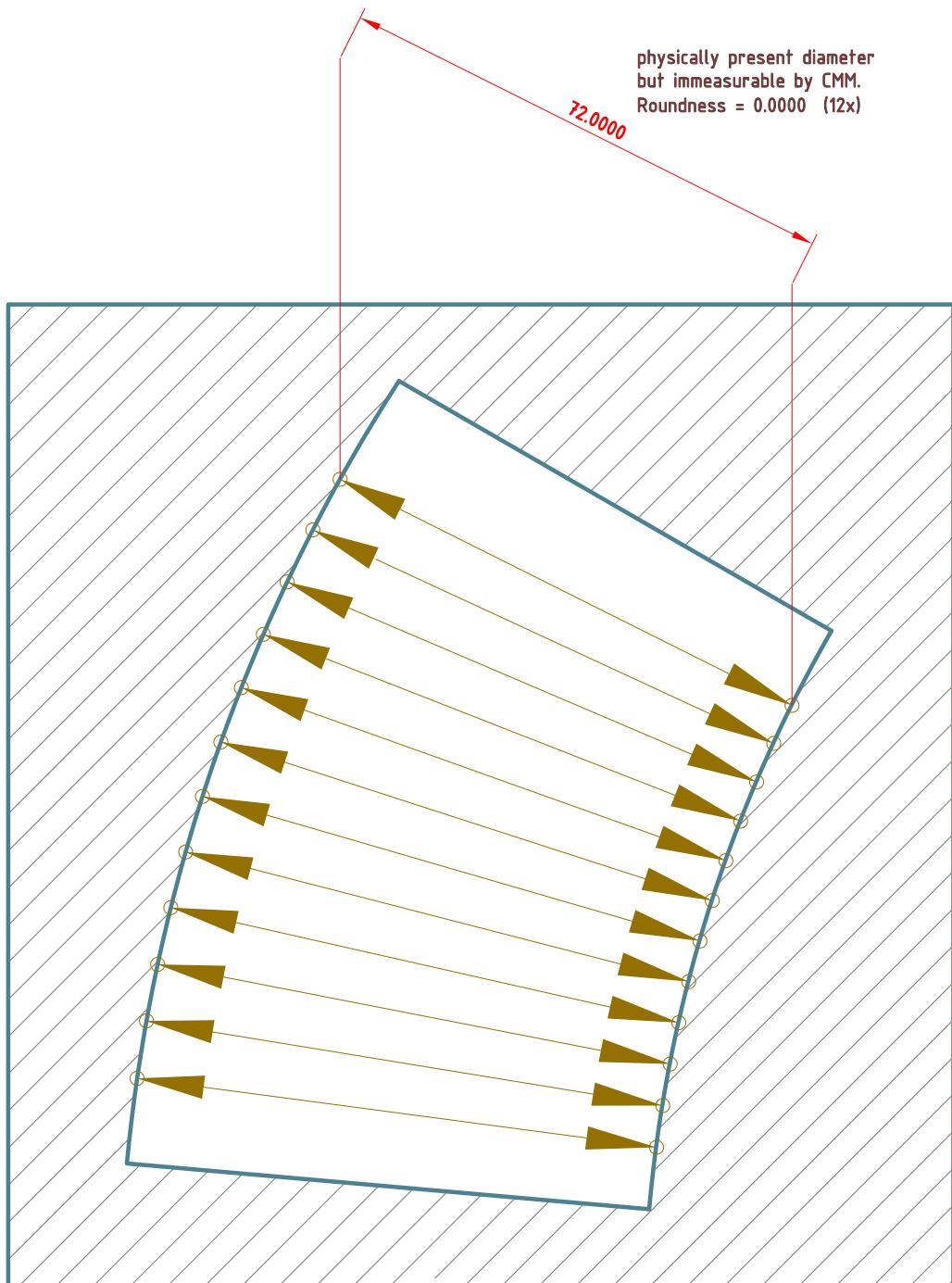
Pic. 1



# Actual shape of a cylinder

Pic. 2

## Local perfect actual circle diameters



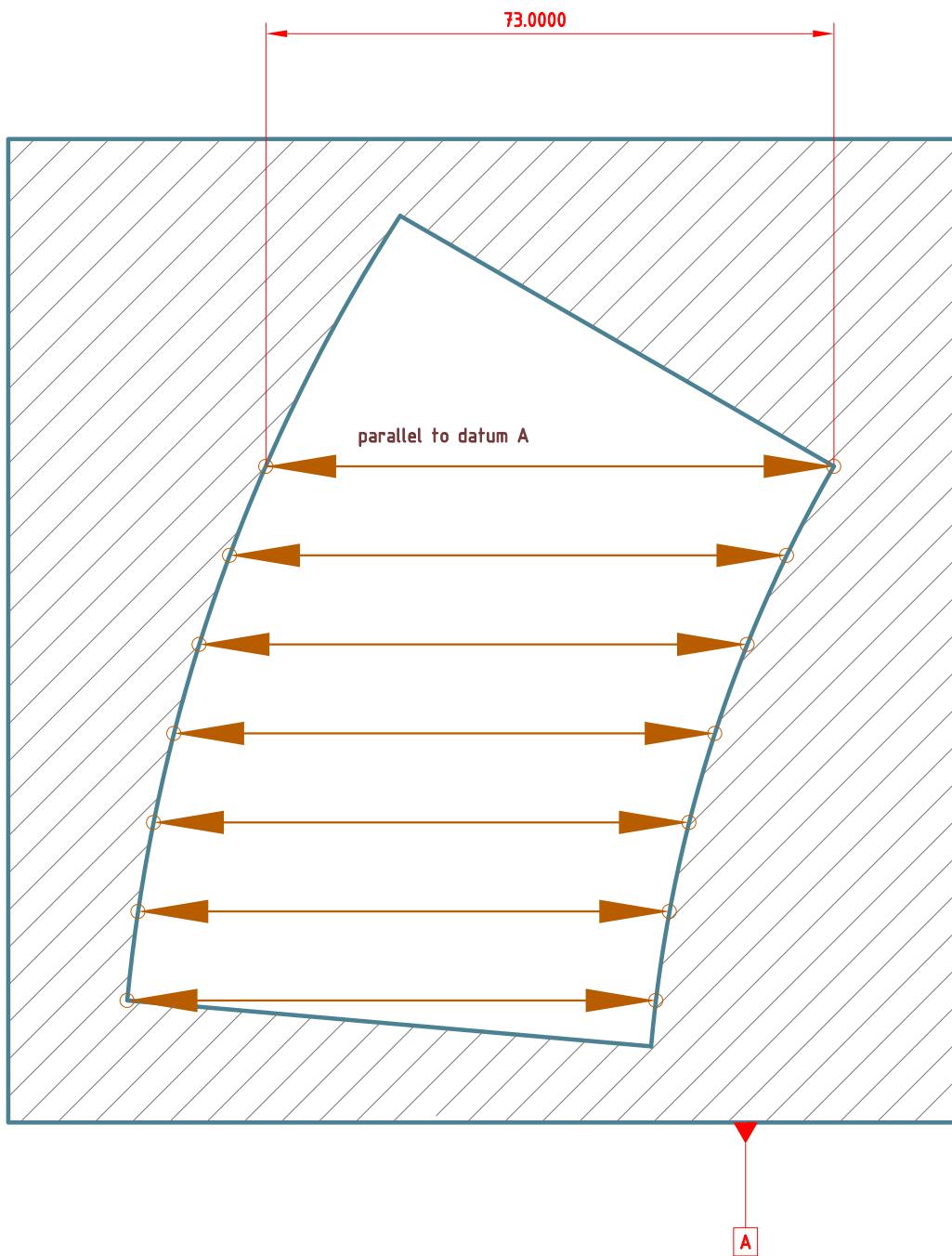
# Actual shape of a cylinder

Pic. 3

Seven actual circle diameters - first CMM probing



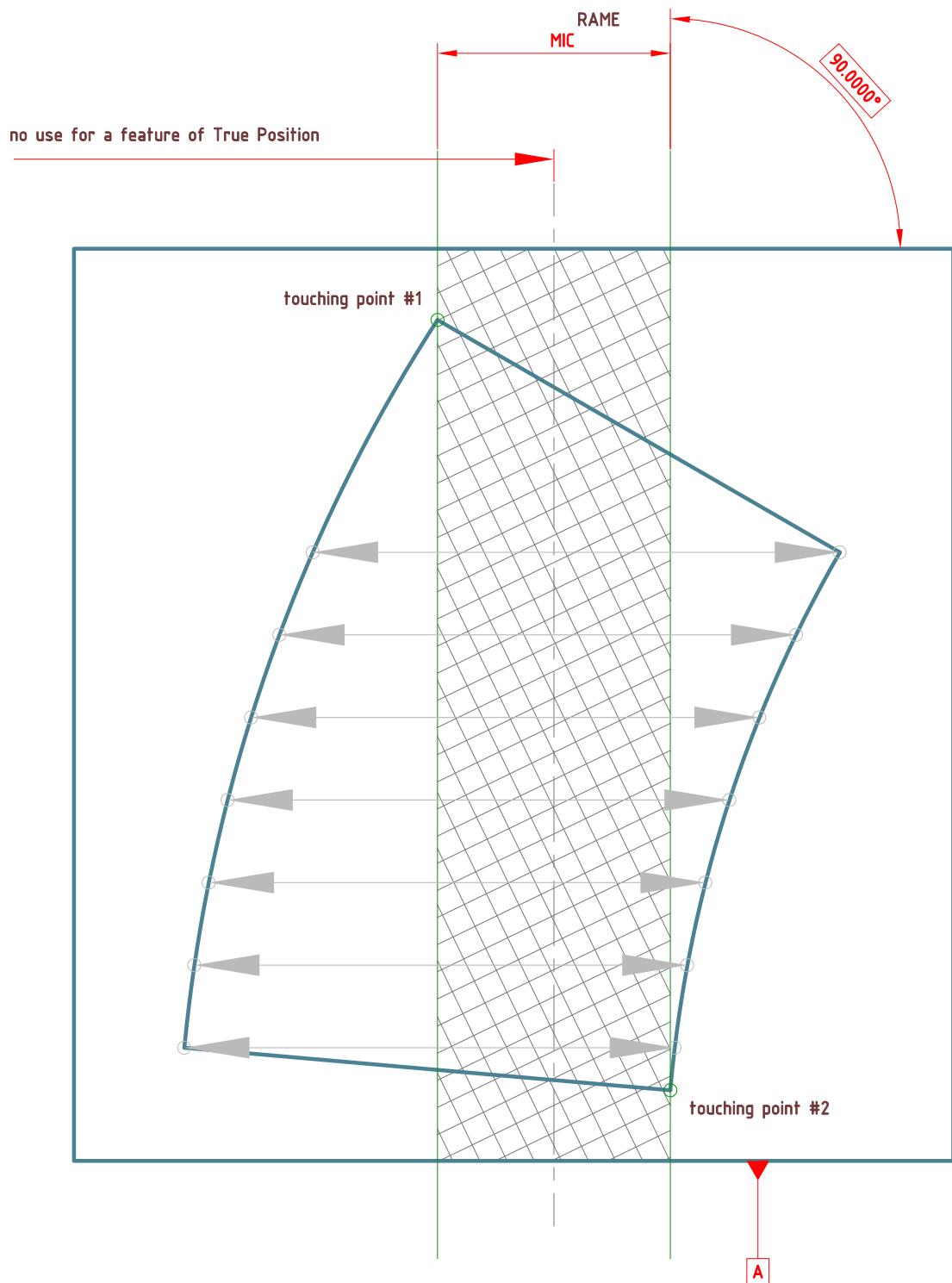
diameter as a result of  
CMM - probing.  
Roundness > 0.0000 (7x)



# Actual shape of a cylinder

Pic. 4

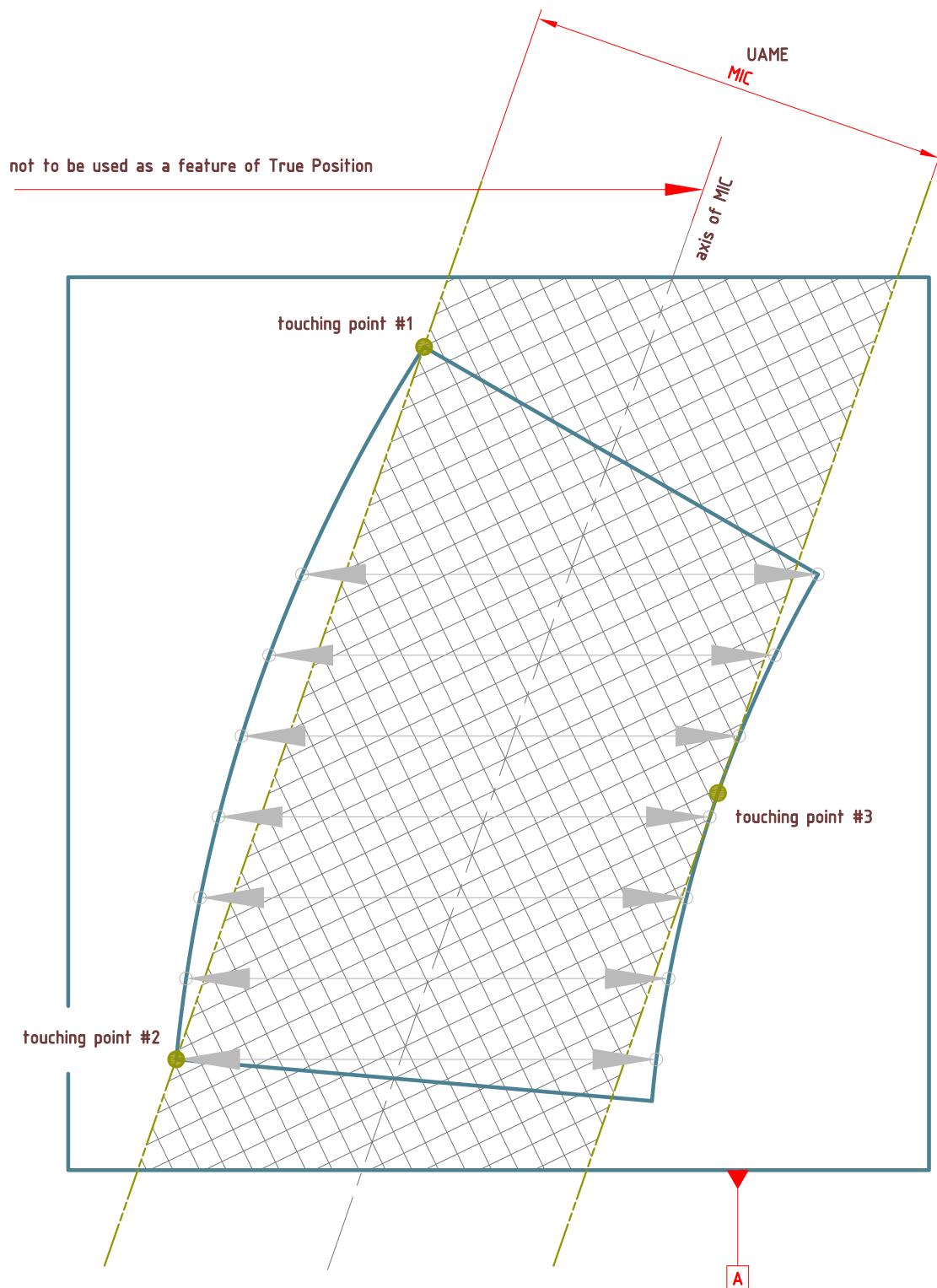
Actual cylinder diameter (MIC) ,constrained to datum A.



# Actual shape of a cylinder

Pic. 5

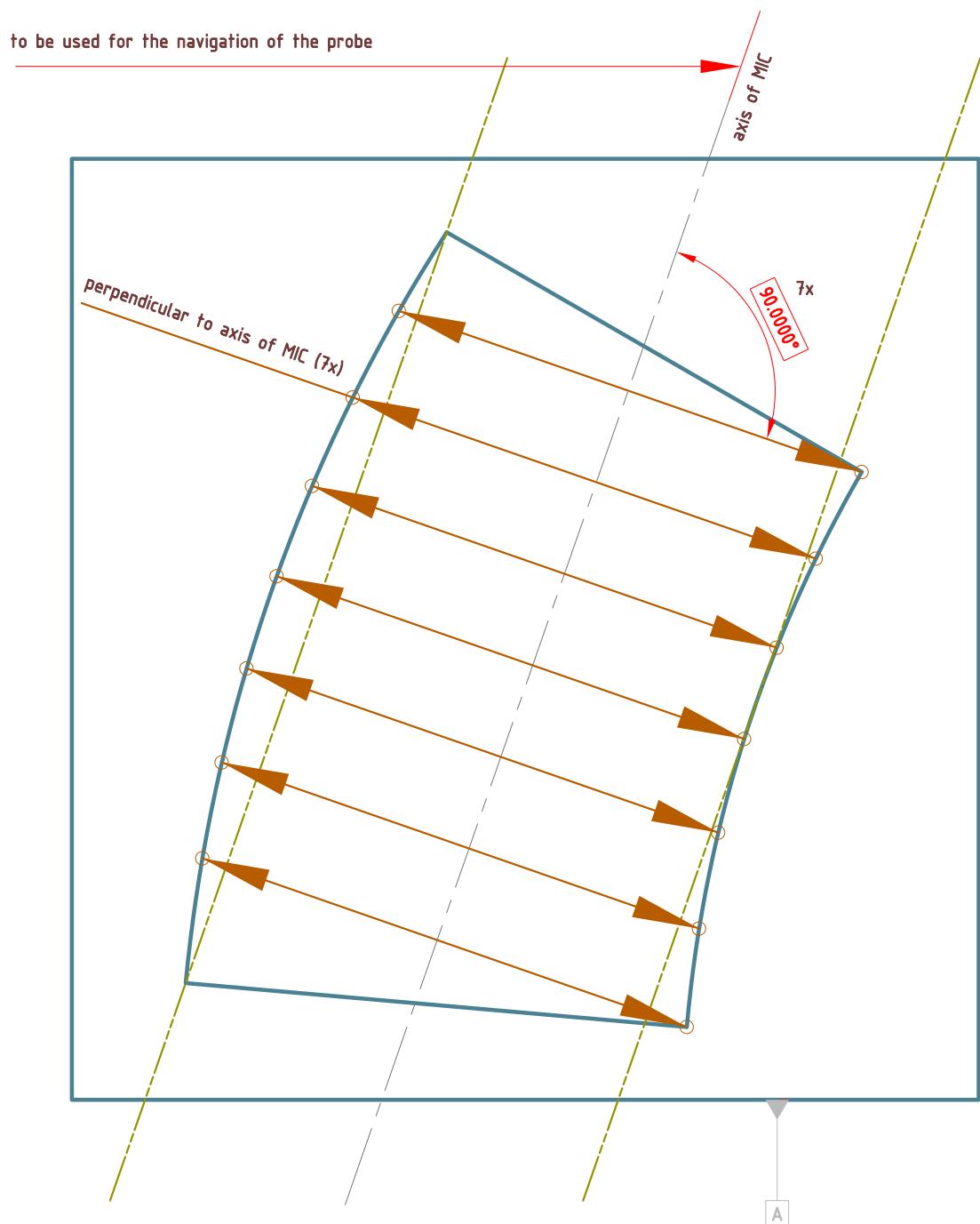
Actual cylinder diameter (MIC)



# Actual shape of a cylinder

Pic. 6

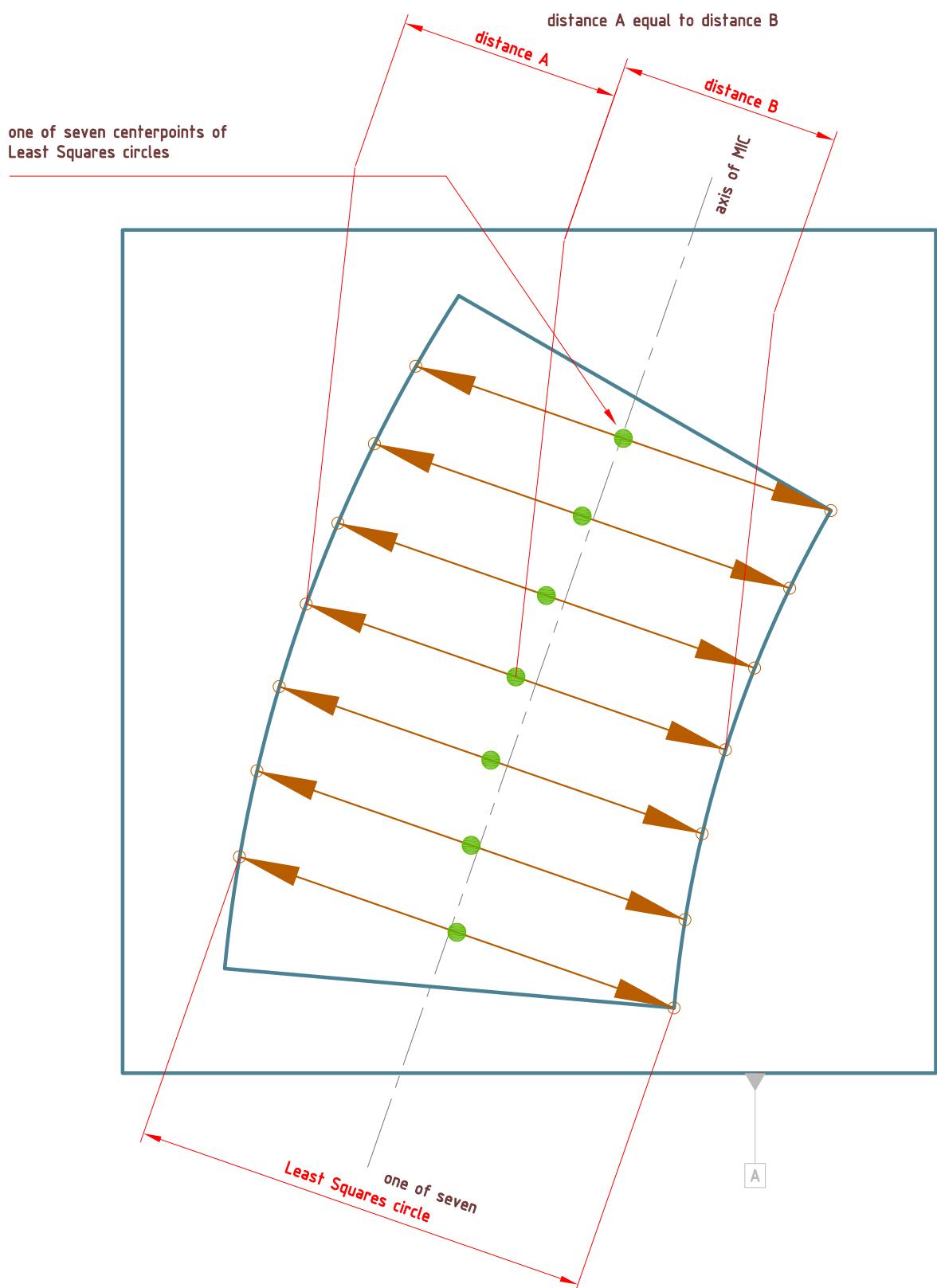
Seven actual circle diameters - second probing



# Actual shape of a cylinder

Pic. 7

Seven actual circle diameters - second CMM probing



# Actual shape of a cylinder

Pic. 8

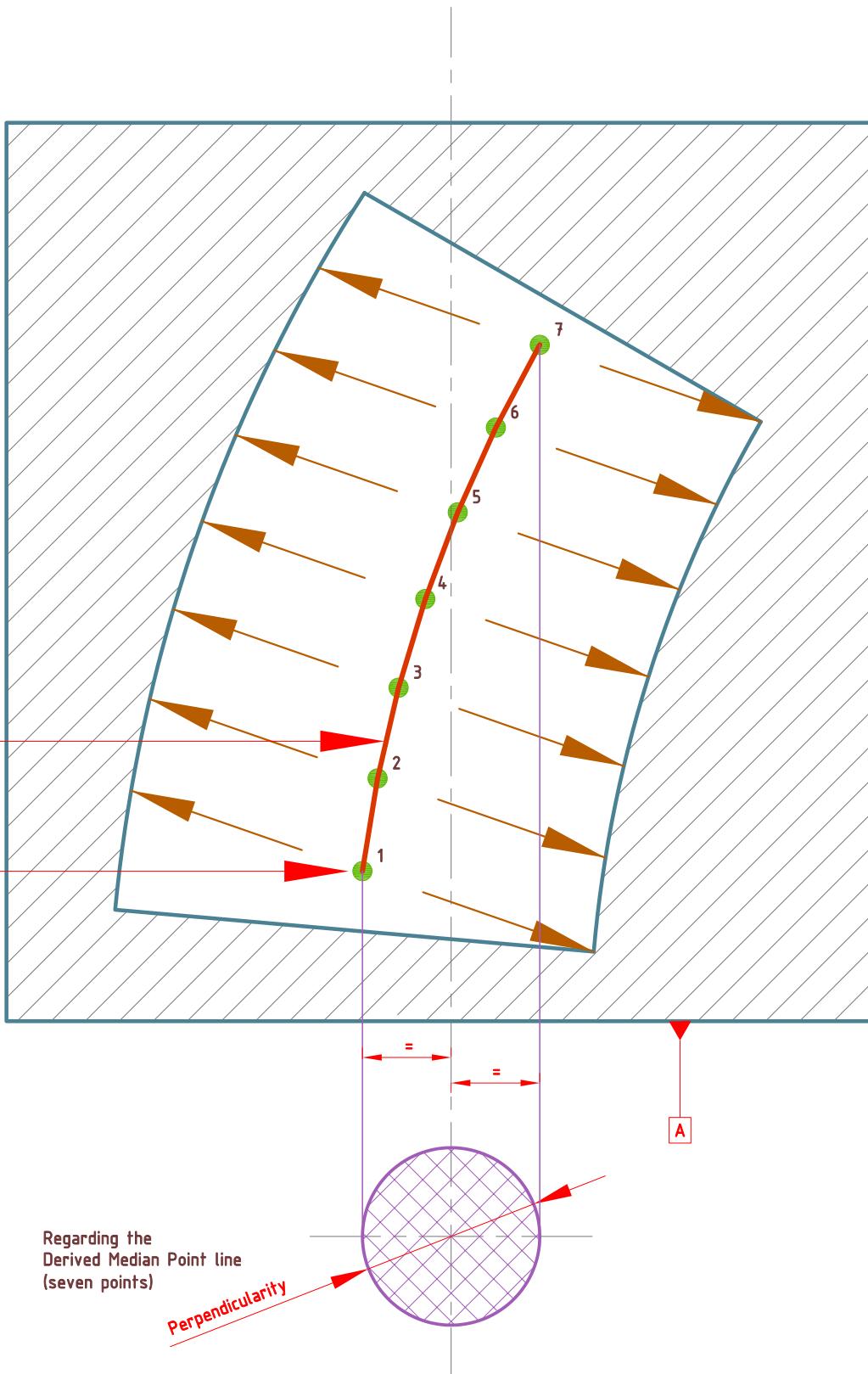
Connection of seven centerpoints

Definition of the term: "AXIS"



Derived Median Point line  
not Center Point line

centerpoint of  
Least Squares circle



Regarding the  
Derived Median Point line  
(seven points)

Perpendicularity

# Actual shape of a cylinder

Pic. 9

Definition of the term: "CONCENTRICITY"

Derived Median Points of one circle path

