



ZEISS CALYPSO

7.0.0806

Part name **GB 425VT Main Body Rev. 3**
 Drawing number GB 425VT Main Body Rev. 2
 Order number 2-26-2021
 Variant
 Company
 Department
 CMM Type SPECTRUM3
 CMM No. 720113
 Operator Master
 Text

Last 1 measurements
 ► Approval ≠ Blocked

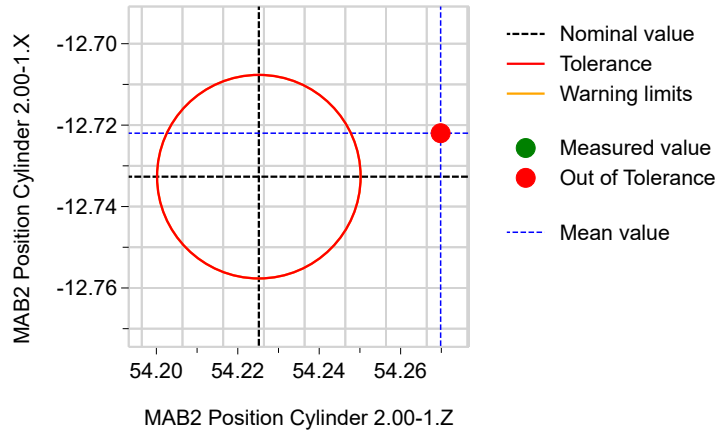
Part ident
 Time/Date 8/6/2021 10:42 AM
 Run
 No. measured values 58
 No. values: red 24
 Measurement Duration 00:00:00.0

Name	Measured value	Nominal value	+Tol	-Tol	Deviation	+/-
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Group MAB2

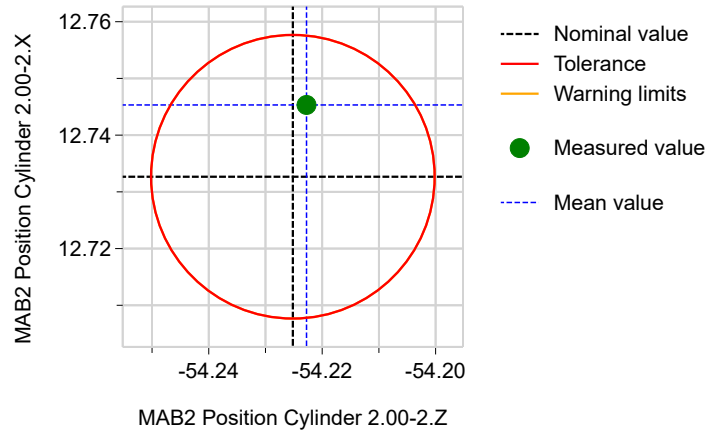
MAB2 Diameter_Cylinder 2.00-1	1.9647	2.0000	-0.0060	-0.0160	-0.0353	-0.0193
MAB2 Diameter_Cylinder 2.00-2	1.9734	2.0000	-0.0060	-0.0160	-0.0266	-0.0106
MAB2 Position Cylinder 2.00-1	0.0918	0.0000	0.0500	0.0000	0.0918	0.0418

Points 25
 Filter type No Filter
 Lc
 upr
 Vmess[mm/sec] 2.00
 Probe radius 0.7504
 Evaluation method Maximum Inscribed Element



MAB2 Position Cylinder 2.00-1.Z	54.2698	54.2252	0.0250	-0.0250	0.0447	0.0197
MAB2 Position Cylinder 2.00-1.X	-12.7220	-12.7327	0.0250	-0.0250	0.0107	
MAB2 Position Cylinder 2.00-2	0.0258	0.0000	0.0500	0.0000	0.0258	

Points 24
 Filter type No Filter
 Lc
 upr
 Vmess[mm/sec] 2.00
 Probe radius 0.7504
 Evaluation method Maximum Inscribed Element



MAB2 Position Cylinder 2.00-2.Z	-54.2228	-54.2252	0.0250	-0.0250	0.0024	
MAB2 Position Cylinder 2.00-2.X	12.7453	12.7327	0.0250	-0.0250	0.0127	



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 Part ident Test1
 Operator Master
 Time/Date 8/6/2021 10:42 AM

Name	Measured value	Nominal value	+Tol	-Tol	Deviation	+/-
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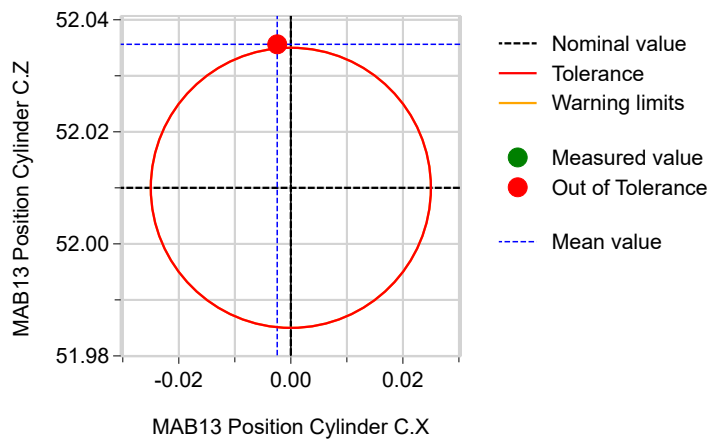
Group MAB3

MAB3 Diameter_Cylinder C	2.9965	3.0000	-0.0060	-0.0120	-0.0035	0.0025
MAB3 Diameter_Cylinder 2	2.9962	3.0000	-0.0060	-0.0120	-0.0038	0.0022
MAB3 Diameter_Cylinder 3	2.9961	3.0000	-0.0060	-0.0120	-0.0039	0.0021
MAB3 Diameter_Cylinder 4	2.9952	3.0000	-0.0060	-0.0120	-0.0048	0.0012
MAB3 Diameter_Cylinder 5	2.9938	3.0000	-0.0060	-0.0120	-0.0062	
MAB3 Diameter_Cylinder 6	2.9954	3.0000	-0.0060	-0.0120	-0.0046	0.0014
MAB3 Diameter_Cylinder 7	2.9972	3.0000	-0.0060	-0.0120	-0.0028	0.0032

Group MAB13

MAB13 Position Cylinder C	0.0515	0.0000	0.0500	0.0000	0.0515	0.0015
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Points 143
 Filter type No Filter
 Lc
 upr
 Vmess[mm/sec] 2.00
 Probe radius 0.7504
 Evaluation method Maximum Inscribed Element

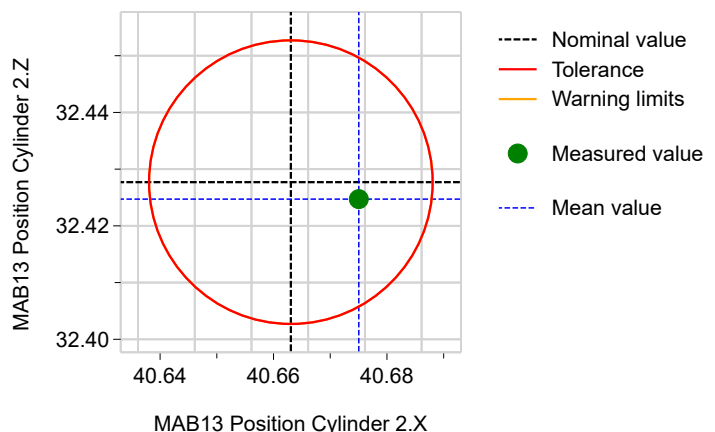


MAB13 Position Cylinder C.Z	52.0356	52.0100	0.0250	-0.0250	0.0256	0.0006
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MAB13 Position Cylinder C.X	-0.0024	0.0000	0.0250	-0.0250	-0.0024	
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MAB13 Position Cylinder 2	0.0247	0.0000	0.0500	0.0000	0.0247	
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Points 127
 Filter type No Filter
 Lc
 upr
 Vmess[mm/sec] 2.00
 Probe radius 0.7504
 Evaluation method Maximum Inscribed Element



MAB13 Position Cylinder 2.Z	32.4247	32.4277	0.0250	-0.0250	-0.0030	
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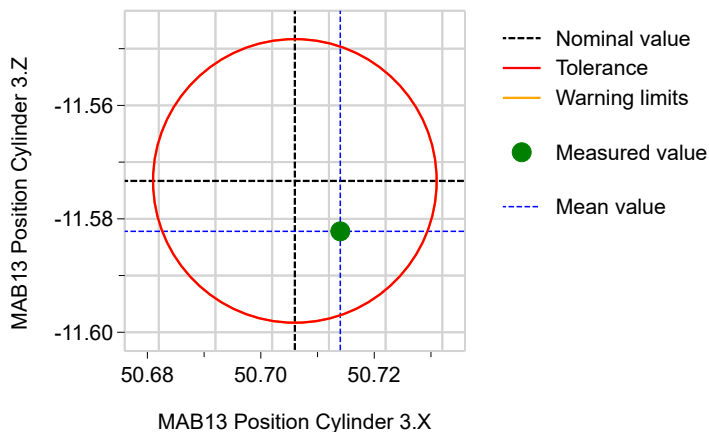
Part name **GB 425VT Main Body Rev. 3**
 Order number 2-26-2021
 Part ident Test1
 Operator Master
 Time/Date 8/6/2021 10:42 AM

Name	Measured value	Nominal value	+Tol	-Tol	Deviation +/-
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⊕ MAB13 Position Cylinder 2.X	40.6750	40.6631	0.0250	-0.0250	0.0120
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⊕ MAB13 Position Cylinder 3	0.0239	0.0000	0.0500	0.0000	0.0239 
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Points 132
 Filter type No Filter
 Lc
 upr
 Vmess[mm/sec] 2.00
 Probe radius 0.7504
 Evaluation method Maximum Inscribed Element

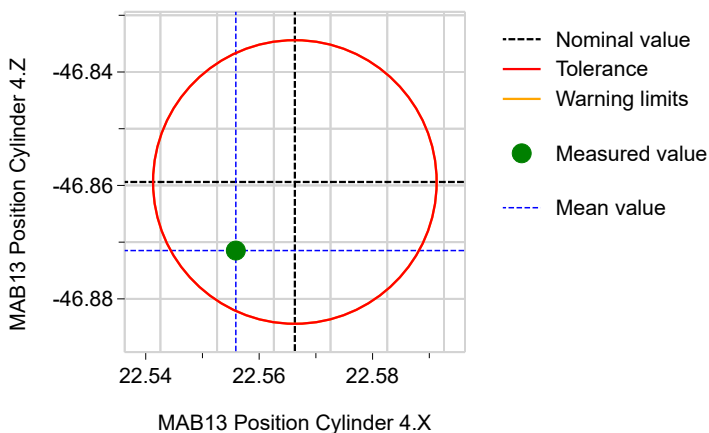


⊕ MAB13 Position Cylinder 3.Z	-11.5822	-11.5733	0.0250	-0.0250	-0.0089
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⊕ MAB13 Position Cylinder 3.X	50.7140	50.7060	0.0250	-0.0250	0.0080
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⊕ MAB13 Position Cylinder 4	0.0319	0.0000	0.0500	0.0000	0.0319 
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Points 143
 Filter type No Filter
 Lc
 upr
 Vmess[mm/sec] 2.00
 Probe radius 0.7504
 Evaluation method Maximum Inscribed Element



⊕ MAB13 Position Cylinder 4.Z	-46.8715	-46.8594	0.0250	-0.0250	-0.0121
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⊕ MAB13 Position Cylinder 4.X	22.5559	22.5663	0.0250	-0.0250	-0.0104
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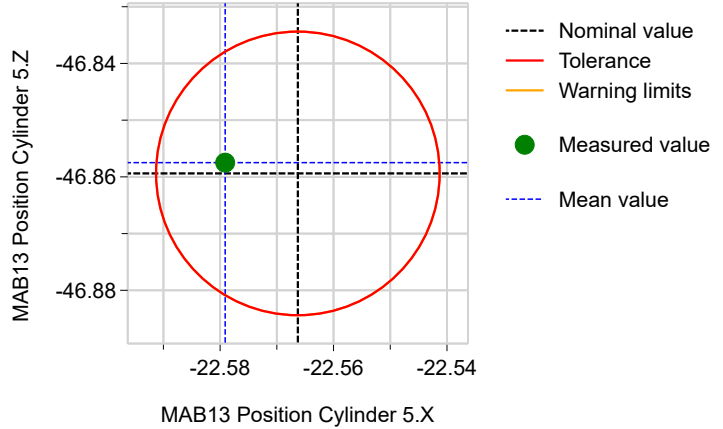
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Part name **GB 425VT Main Body Rev. 3**
 Order number 2-26-2021
 Part ident Test1
 Operator Master
 Time/Date 8/6/2021 10:42 AM

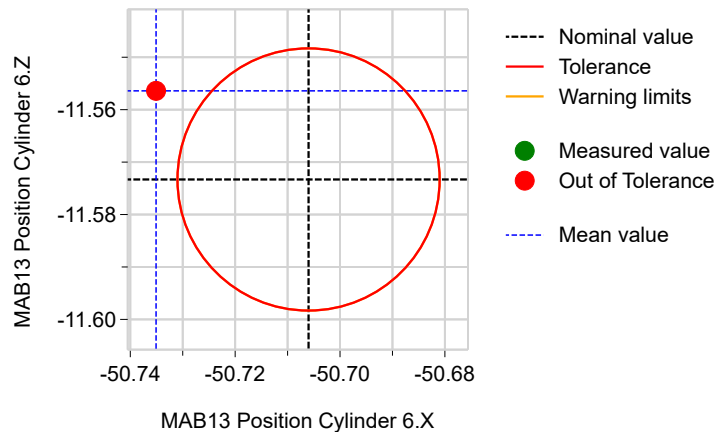
Name	Measured value	Nominal value	+Tol	-Tol	Deviation +/-
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MAB13 Position Cylinder 5 Points 144 Filter type No Filter Lc upr Vmess[mm/sec] 2.00 Probe radius 0.7504 Evaluation method Maximum Inscribed Element	0.0259	0.0000	0.0500	0.0000	0.0259
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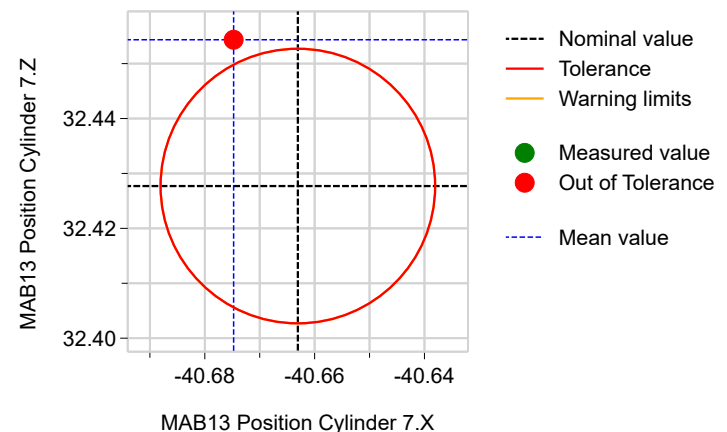
MAB13 Position Cylinder 5.Z	-46.8575	-46.8594	0.0250	-0.0250	0.0019
MAB13 Position Cylinder 5.X	-22.5791	-22.5663	0.0250	-0.0250	-0.0128

MAB13 Position Cylinder 6 Points 143 Filter type No Filter Lc upr Vmess[mm/sec] 2.00 Probe radius 0.7504 Evaluation method Maximum Inscribed Element	0.0673	0.0000	0.0500	0.0000	0.0673 0.0173
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MAB13 Position Cylinder 6.Z	-11.5564	-11.5733	0.0250	-0.0250	0.0169
MAB13 Position Cylinder 6.X	-50.7351	-50.7060	0.0250	-0.0250	-0.0291 -0.0041

MAB13 Position Cylinder 7 Points 133 Filter type No Filter Lc upr Vmess[mm/sec] 2.00 Probe radius 0.7504 Evaluation method Maximum Inscribed Element	0.0582	0.0000	0.0500	0.0000	0.0582 0.0082
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Name	Measured value	Nominal value	+Tol	-Tol	Deviation	+/-
MAB13 Position Cylinder 7.Z	32.4543	32.4277	0.0250	-0.0250	0.0266	0.0016
MAB13 Position Cylinder 7.X	-40.6748	-40.6631	0.0250	-0.0250	-0.0117	
Concentricity Bolt Circle Pin Holes	0.0121	0.0000	0.0500	0.0000	0.0121	

Best Fit

X

Y

Z

Angle

Concentricity Bolt Circle Pin Holes.Z	0.0055	0.0000			0.0055	
Concentricity Bolt Circle Pin Holes.X	-0.0024	0.0000			-0.0024	

Group MAB4

MAB4 Radius Bolt Circle 52.01	52.0204	52.0100	0.0200	-0.0200	0.0104	
MAB4 Distance 52.01-1	52.0255	52.0100	0.0100	-0.0100	0.0155	0.0055
MAB4 Distance 52.01-2	52.0182	52.0100	0.0100	-0.0100	0.0082	
MAB4 Distance 52.01-3	52.0222	52.0100	0.0100	-0.0100	0.0122	0.0022
MAB4 Distance 52.01-4	52.0193	52.0100	0.0100	-0.0100	0.0093	
MAB4 Distance 52.01-5	52.0131	52.0100	0.0100	-0.0100	0.0031	
MAB4 Distance 52.01-6	51.9981	52.0100	0.0100	-0.0100	-0.0119	-0.0019
MAB4 Distance 52.01-7	51.9988	52.0100	0.0100	-0.0100	-0.0112	-0.0012
MAB6 Distance 3.55	3.5448	3.5500	0.0150	-0.0150	-0.0052	
MAB7 Distance 5.55	5.5512	5.5500	0.0150	-0.0150	0.0012	
MAB8 Diameter_Circle B 90.00	89.9850	90.0000	0.0220	-0.0130	-0.0150	-0.0020
MAB9 Diameter_Cylinder 96.00	95.9971	96.0000	0.0000	-0.0350	-0.0029	
MAB10 Diameter_Circle 90.00	89.9775	90.0000	0.0540	0.0000	-0.0225	-0.0225
MAB11 Diameter_Circle 90.00	89.9806	90.0000	0.0220	-0.0130	-0.0194	-0.0064
MAB12 Diameter_Circle 115.00	115.0058	115.0000	0.0000	-0.0500	0.0058	0.0058



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Name	Measured value	Nominal value	+Tol	-Tol	Deviation	+/-
Group						
Y Y Value_Plane -6.45 →	-6.4831	-6.4500	0.1000	-0.1000	-0.0331	
Y Y Value_Plane 25.55 →	25.5455	25.5500	0.1000	-0.1000	-0.0045	
∅ Diameter_Circle 106.00 GS	106.0201	106.0000	0.1000	-0.1000	0.0201	
∅ Diameter_Circle 107.00 GS	107.0152	107.0000	0.1000	-0.1000	0.0152	

Text

Event

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n.def.