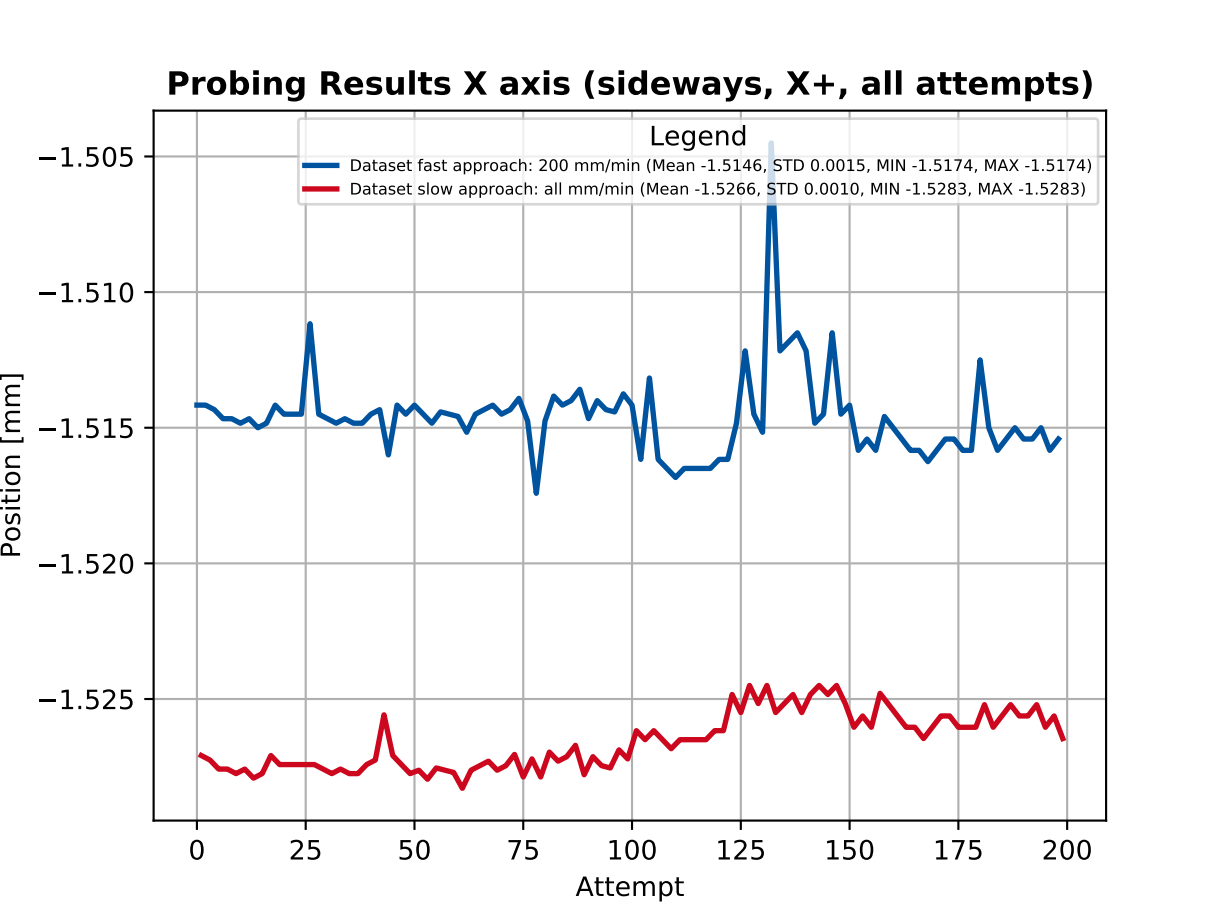
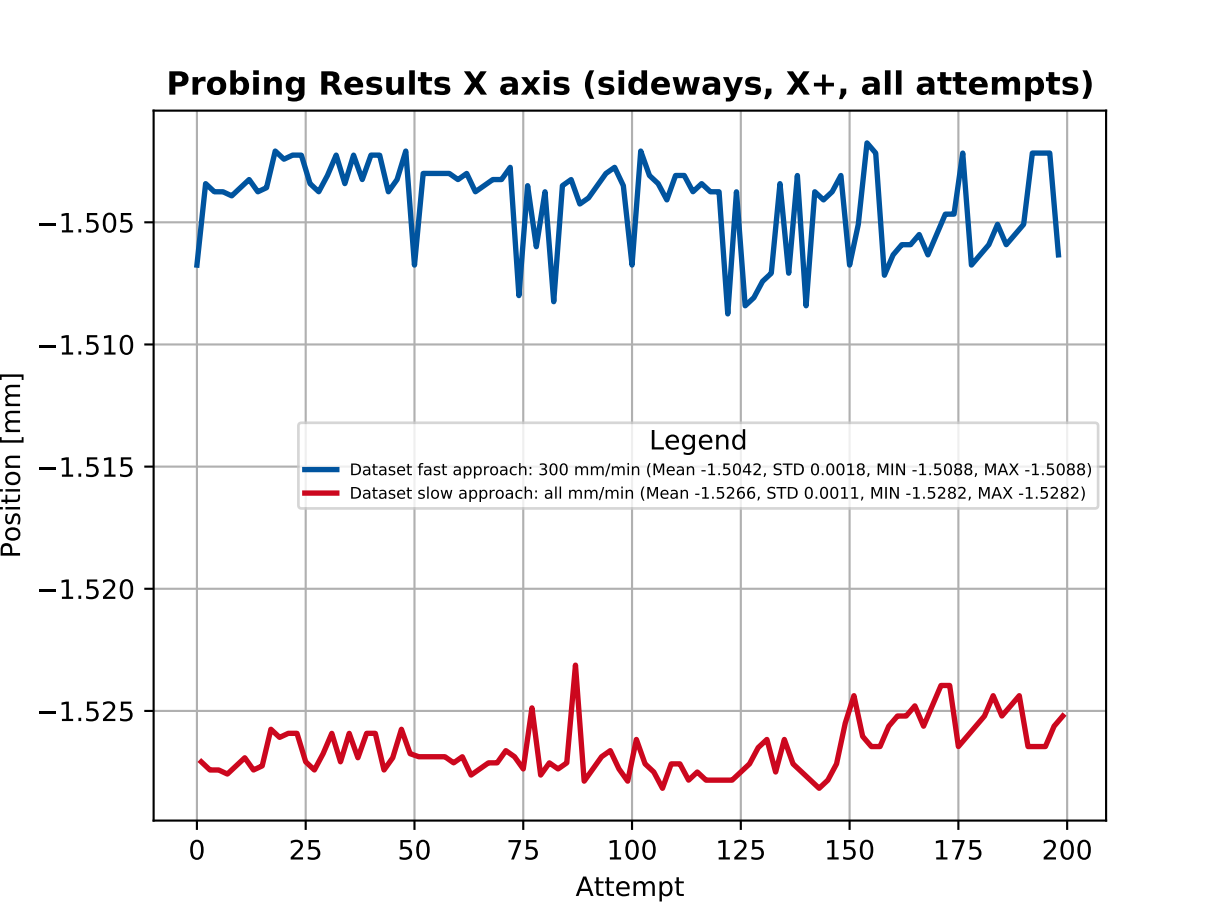
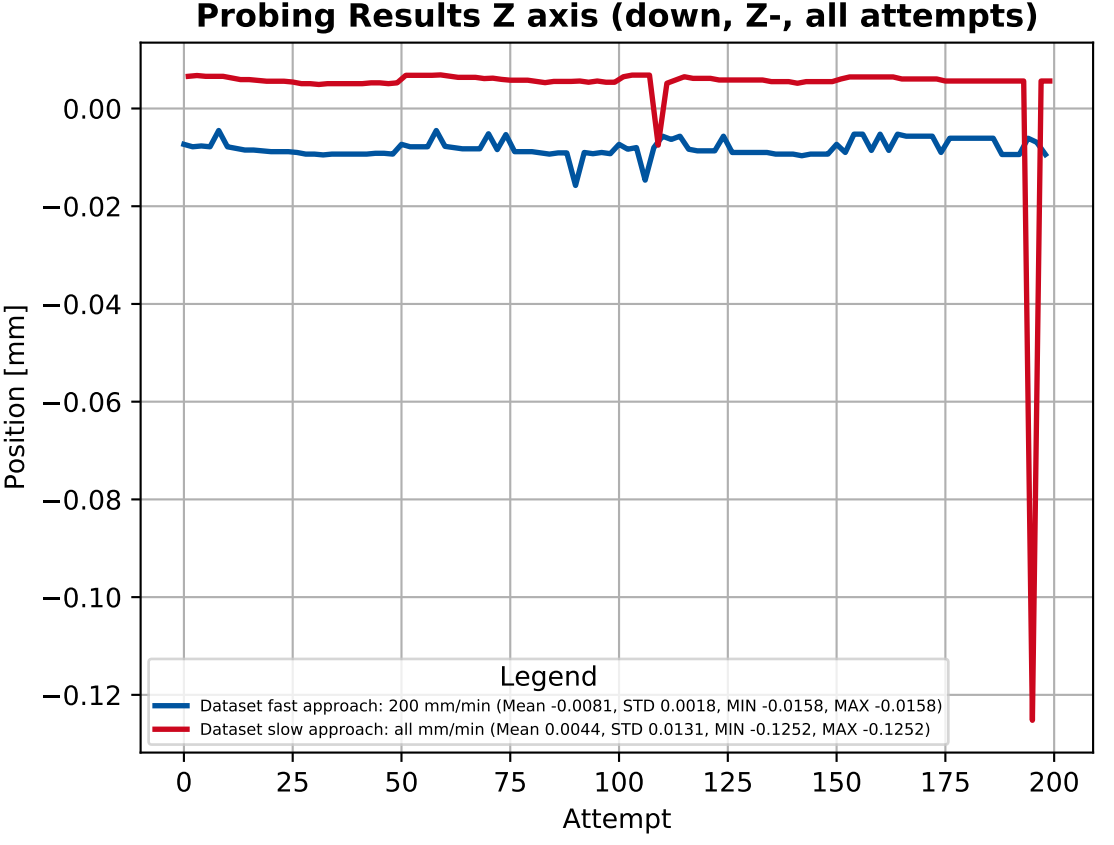
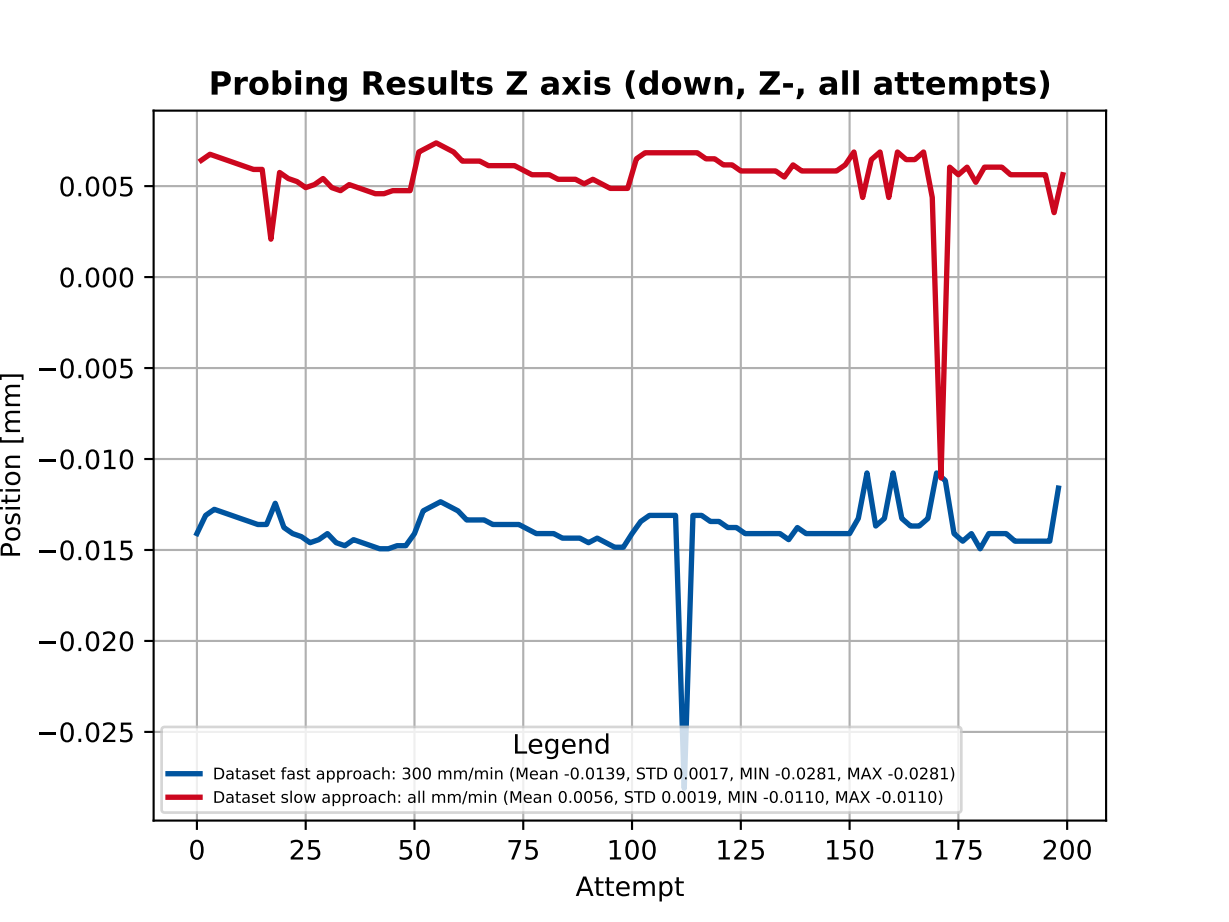
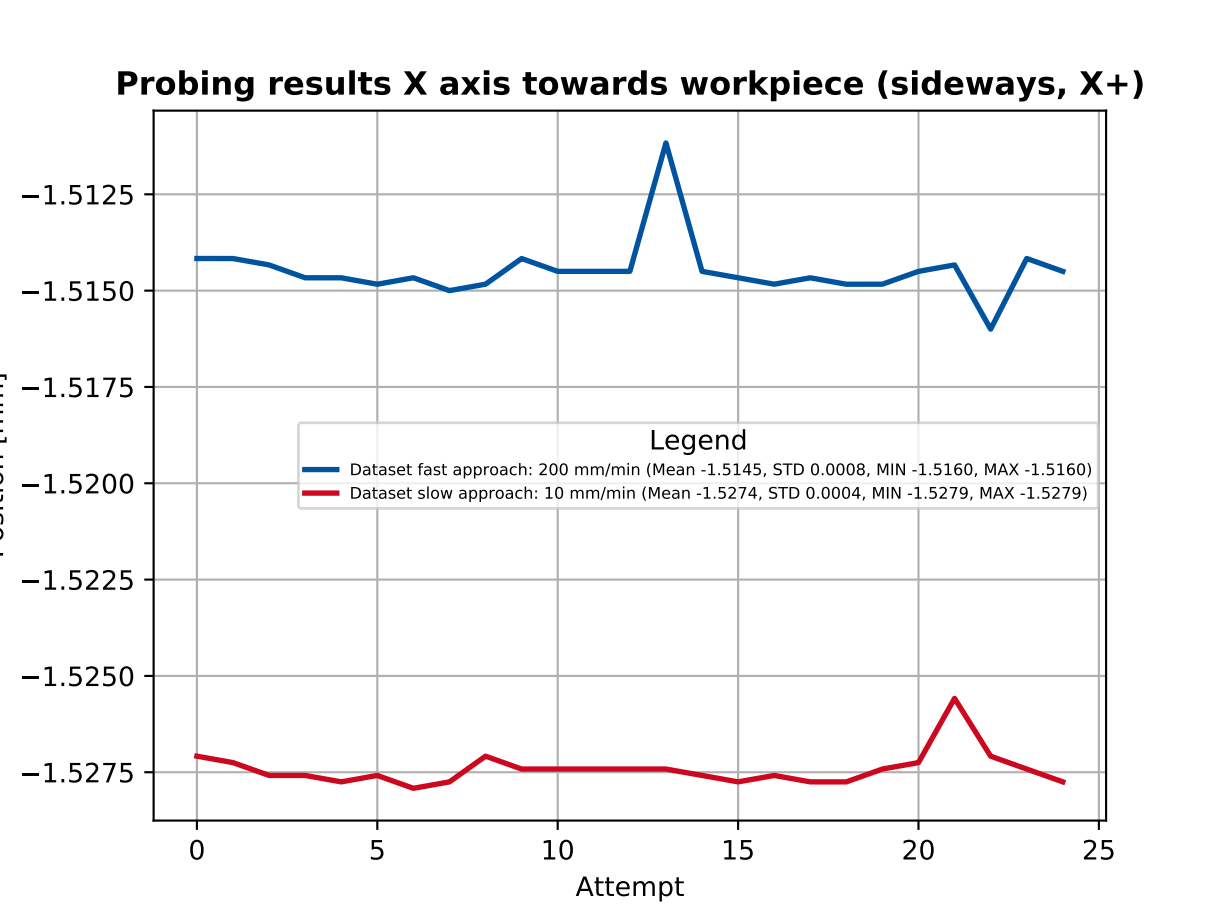
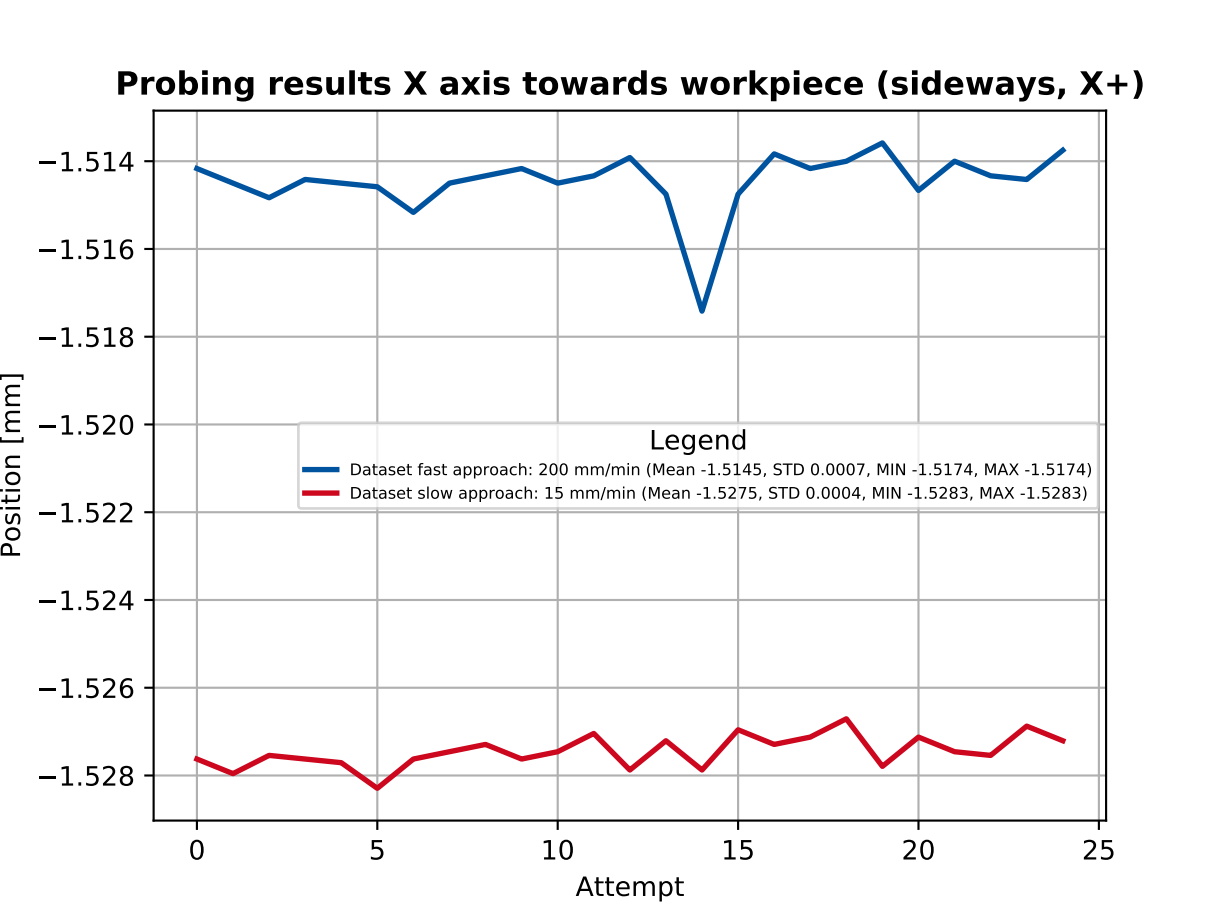

Probing Results X axis (sideways, X+, all attempts)
Legend
Dataset fast approach: 200 mm/min (Mean -1.5146, STD 0.0015, MIN -1.5174, MAX -1.5174)
Dataset slow approach: all mm/min (Mean -1.5266, STD 0.0010, MIN -1.5283, MAX -1.5283)
−1.505
−1.510
−1.515
−1.520
−1.525
Position [mm]
0
25
50
75
100
125
150
175
200
Attempt

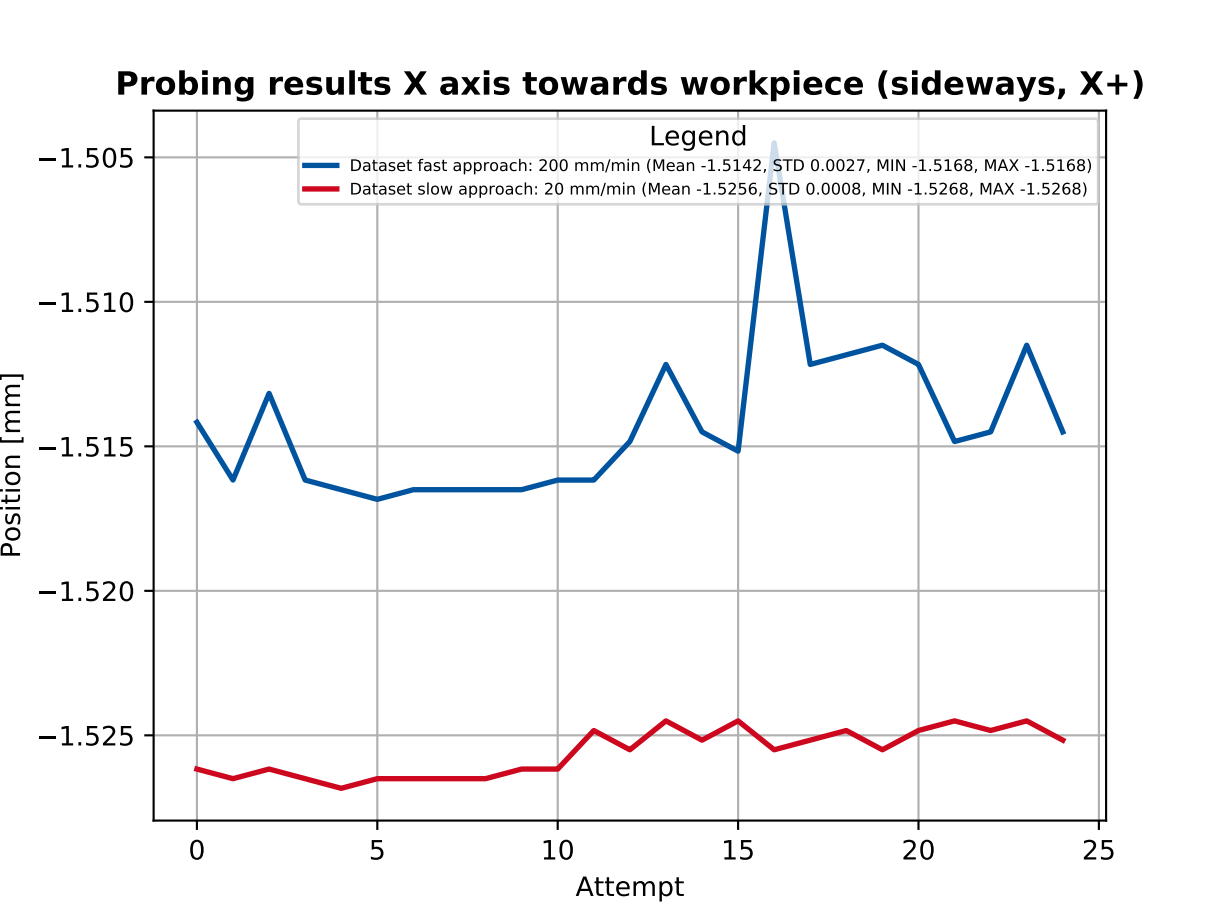

Probing Results X axis (sideways, X+, all attempts)
Position [mm]
−1.505
−1.510
−1.515
−1.520
−1.525
0
25
50
75
100
125
150
175
200
Attempt
Legend
Dataset fast approach: 300 mm/min (Mean -1.5042, STD 0.0018, MIN -1.5088, MAX -1.5088)
Dataset slow approach: all mm/min (Mean -1.5266, STD 0.0011, MIN -1.5282, MAX -1.5282)


Probing Results Z axis (down, Z-, all attempts)
0.00
−0.02
−0.04
−0.06
−0.08
−0.10
−0.12
Position [mm]
0
25
50
75
100
125
150
175
200
Attempt
Legend
Dataset fast approach: 200 mm/min (Mean -0.0081, STD 0.0018, MIN -0.0158, MAX -0.0158)
Dataset slow approach: all mm/min (Mean 0.0044, STD 0.0131, MIN -0.1252, MAX -0.1252)

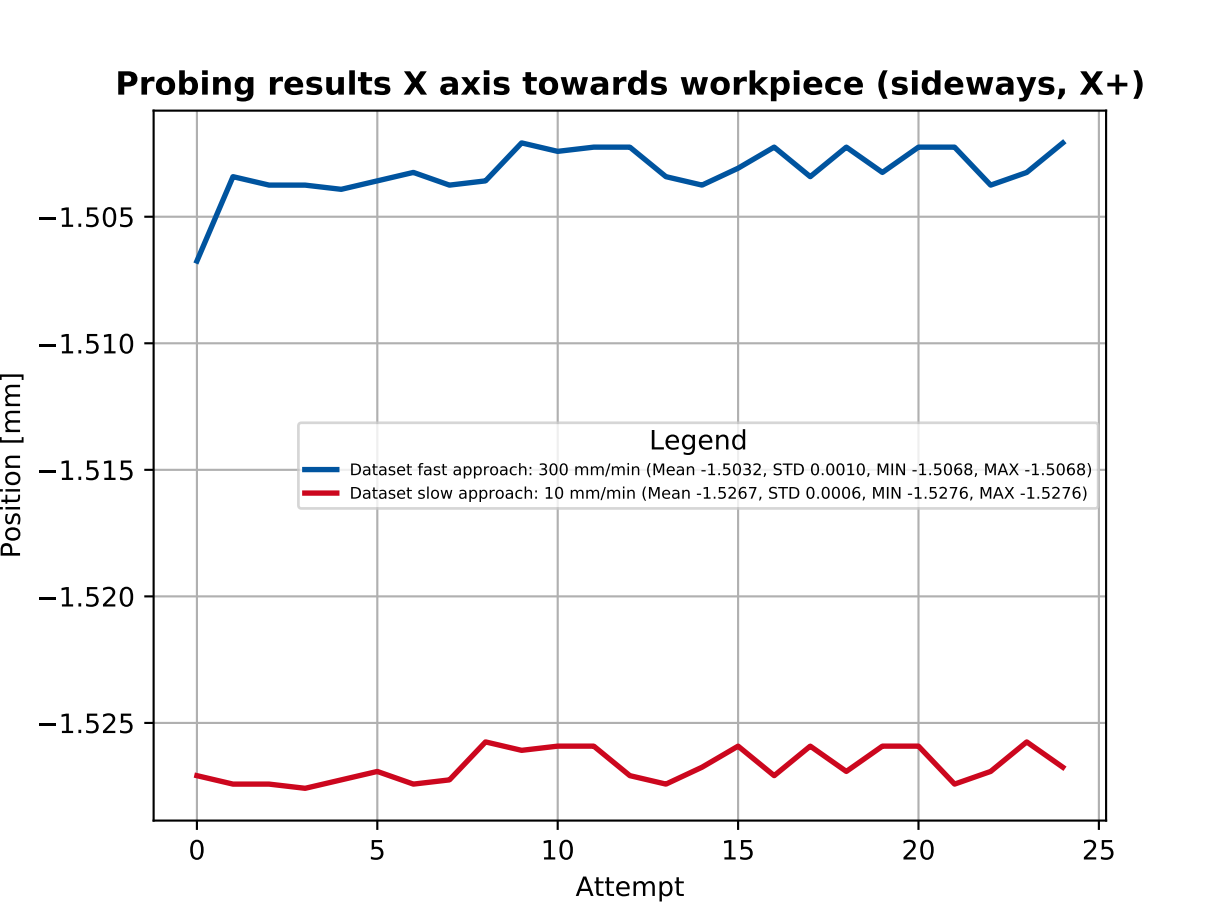

Probing Results Z axis (down, Z-, all attempts)
Position [mm]
0.005
0.000
−0.005
−0.010
−0.015
−0.020
−0.025
0
25
50
75
100
125
150
175
200
Attempt
Legend
Dataset fast approach: 300 mm/min (Mean -0.0139, STD 0.0017, MIN -0.0281, MAX -0.0281)
Dataset slow approach: all mm/min (Mean 0.0056, STD 0.0019, MIN -0.0110, MAX -0.0110)

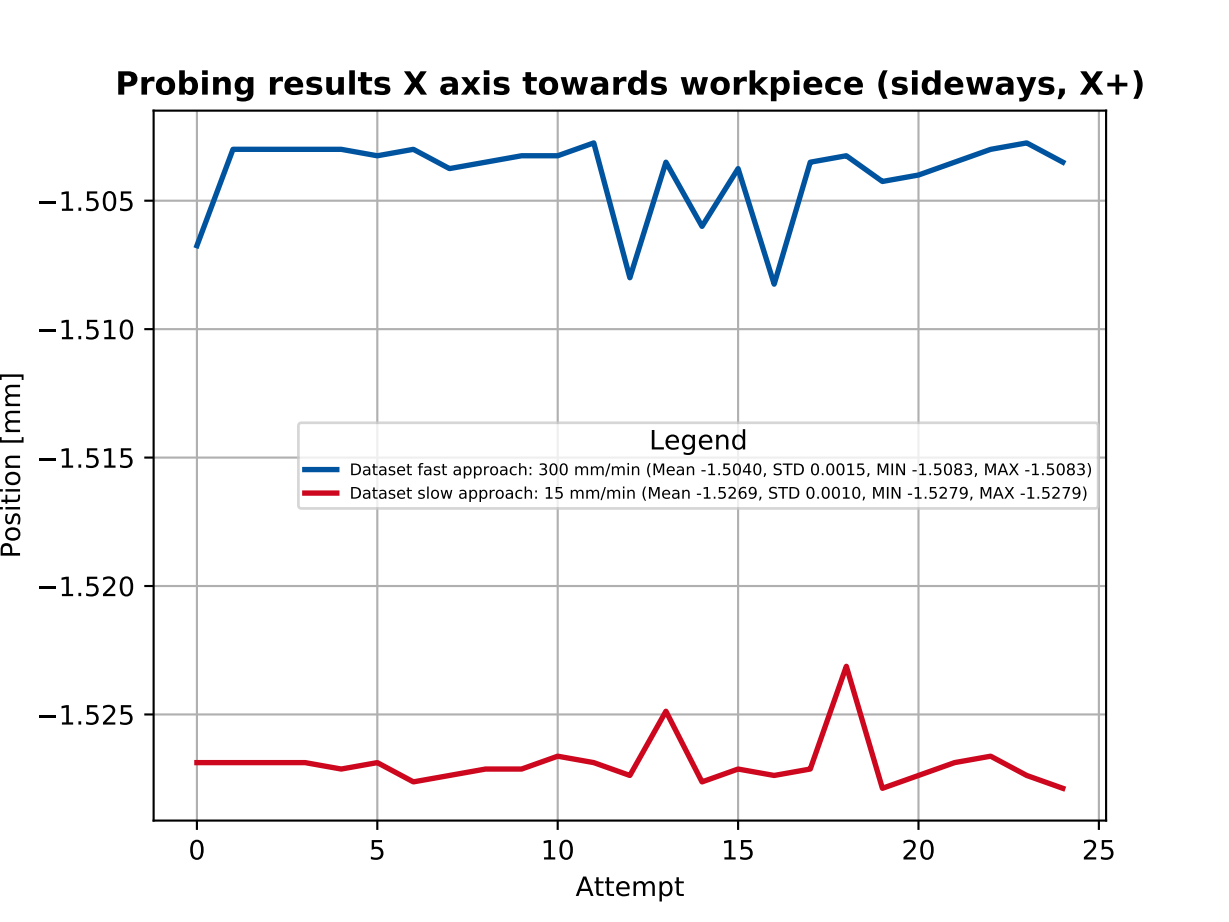

Probing results X axis towards workpiece (sideways, X+)
−1.5125
−1.5150
−1.5175
−1.5200
−1.5225
−1.5250
−1.5275
Position [mm]
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 200 mm/min (Mean -1.5145, STD 0.0008, MIN -1.5160, MAX -1.5160)
Dataset slow approach: 10 mm/min (Mean -1.5274, STD 0.0004, MIN -1.5279, MAX -1.5279)

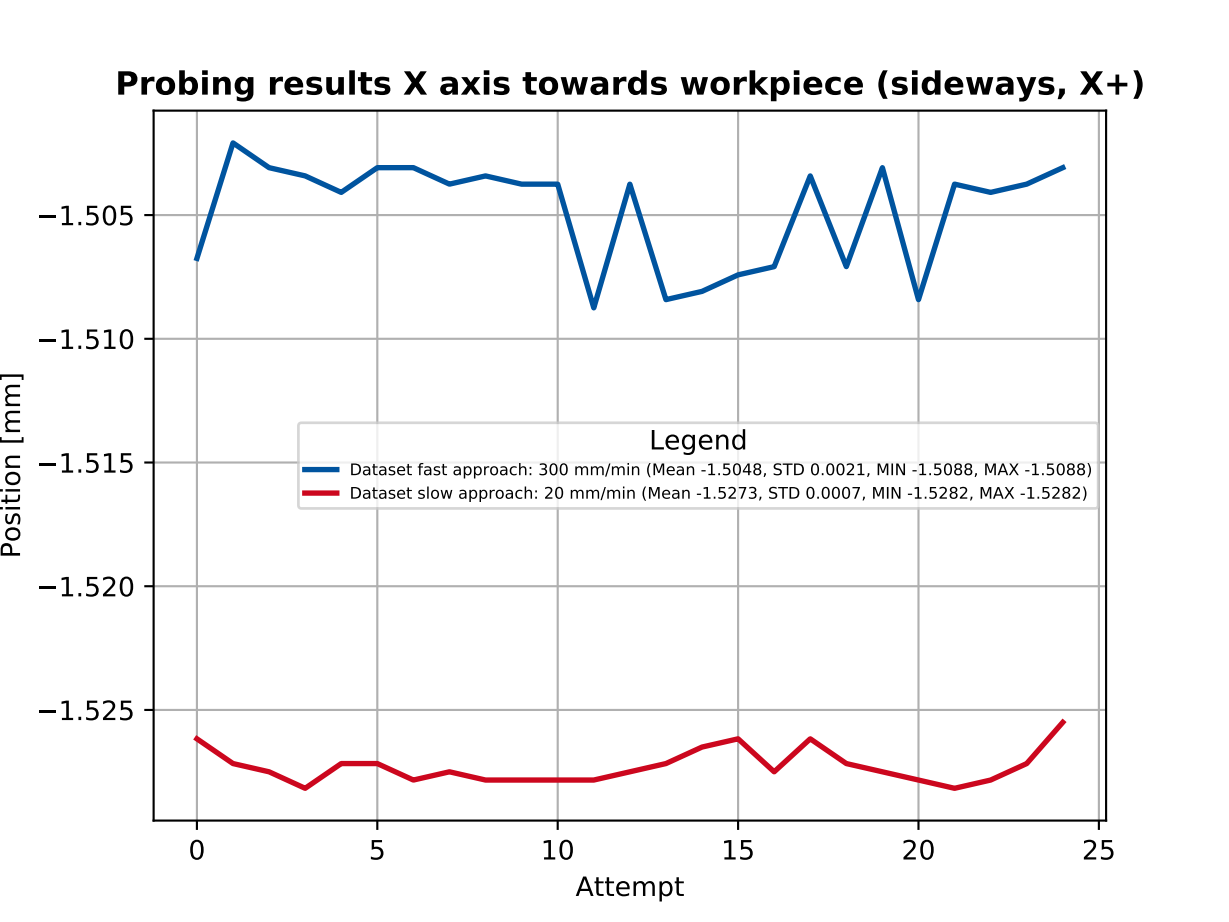

Probing results X axis towards workpiece (sideways, X+)
Position [mm]
−1.514
−1.516
−1.518
−1.520
−1.522
−1.524
−1.526
−1.528
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 200 mm/min (Mean -1.5145, STD 0.0007, MIN -1.5174, MAX -1.5174)
Dataset slow approach: 15 mm/min (Mean -1.5275, STD 0.0004, MIN -1.5283, MAX -1.5283)

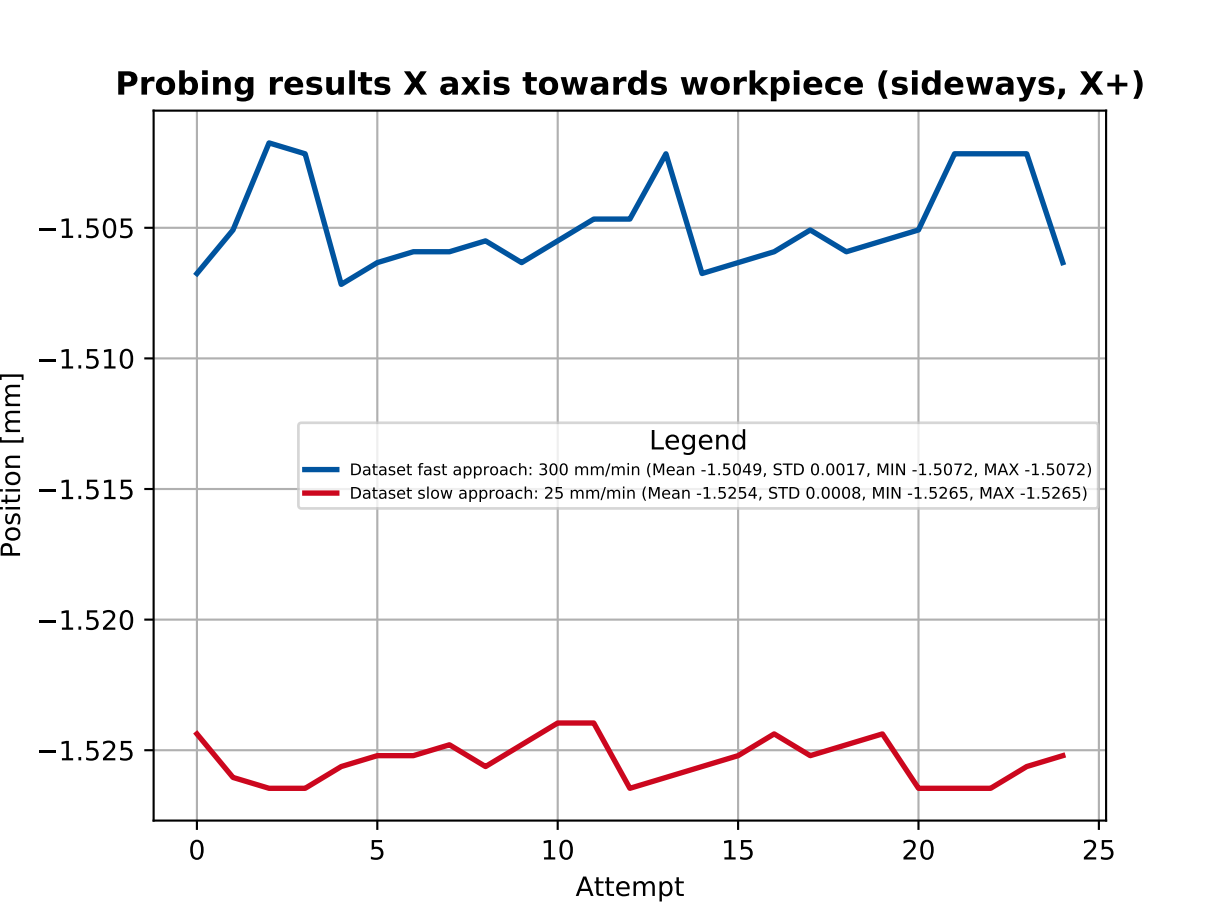

Probing results X axis towards workpiece (sideways, X+)
Legend
Dataset fast approach: 200 mm/min (Mean -1.5142, STD 0.0027, MIN -1.5168, MAX -1.5168)
Dataset slow approach: 20 mm/min (Mean -1.5256, STD 0.0008, MIN -1.5268, MAX -1.5268)
−1.505
−1.510
−1.515
−1.520
−1.525
Position [mm]
0
5
10
15
20
25
Attempt

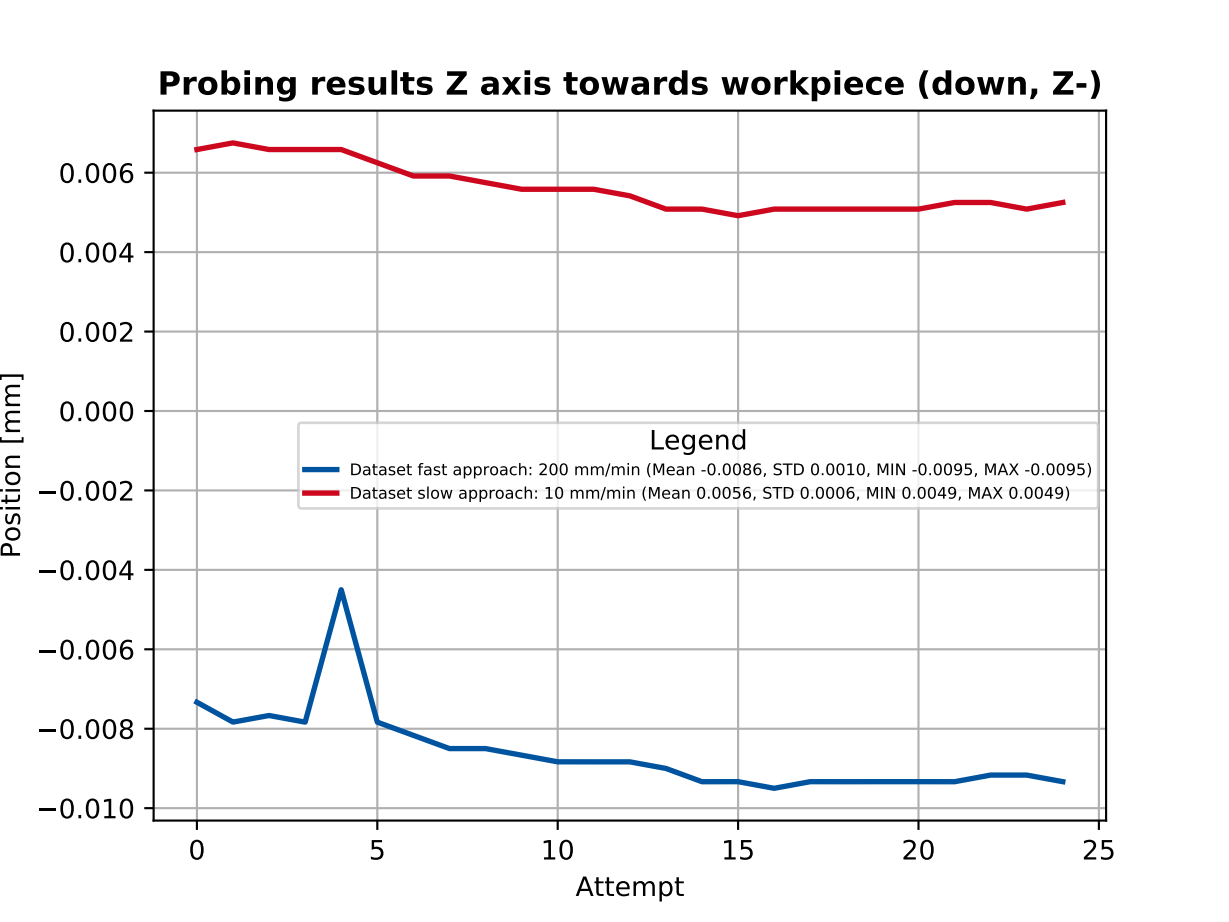
Probing results X axis towards workpiece (sideways, X+)
−1.512
−1.514
−1.516
−1.518
−1.520
−1.522
−1.524
−1.526
Position [mm]
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 200 mm/min (Mean -1.5153, STD 0.0007, MIN -1.5163, MAX -1.5163)
Dataset slow approach: 25 mm/min (Mean -1.5258, STD 0.0004, MIN -1.5265, MAX -1.5265)

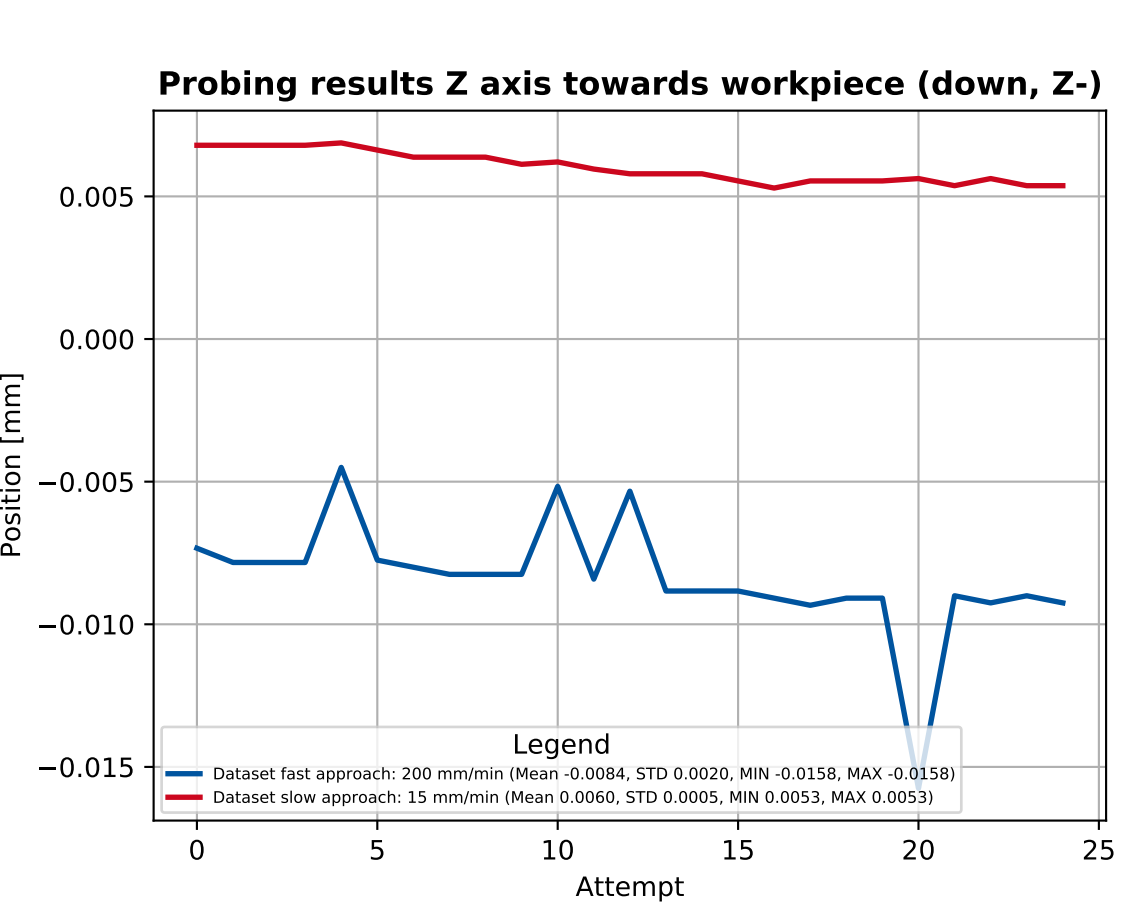

Probing results X axis towards workpiece (sideways, X+)
Position [mm]
−1.505
−1.510
−1.515
−1.520
−1.525
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 300 mm/min (Mean -1.5032, STD 0.0010, MIN -1.5068, MAX -1.5068)
Dataset slow approach: 10 mm/min (Mean -1.5267, STD 0.0006, MIN -1.5276, MAX -1.5276)

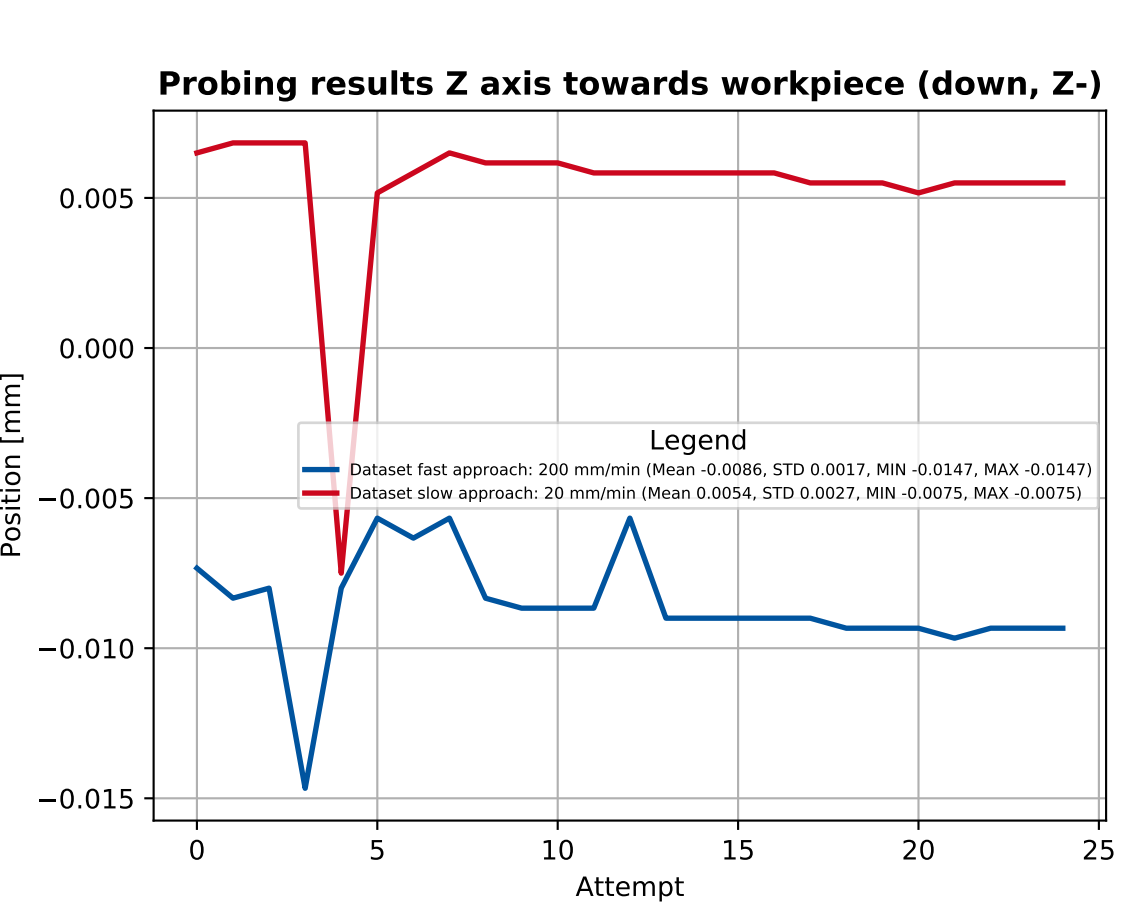

Probing results X axis towards workpiece (sideways, X+)
Position [mm]
−1.505
−1.510
−1.515
−1.520
−1.525
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 300 mm/min (Mean -1.5040, STD 0.0015, MIN -1.5083, MAX -1.5083)
Dataset slow approach: 15 mm/min (Mean -1.5269, STD 0.0010, MIN -1.5279, MAX -1.5279)

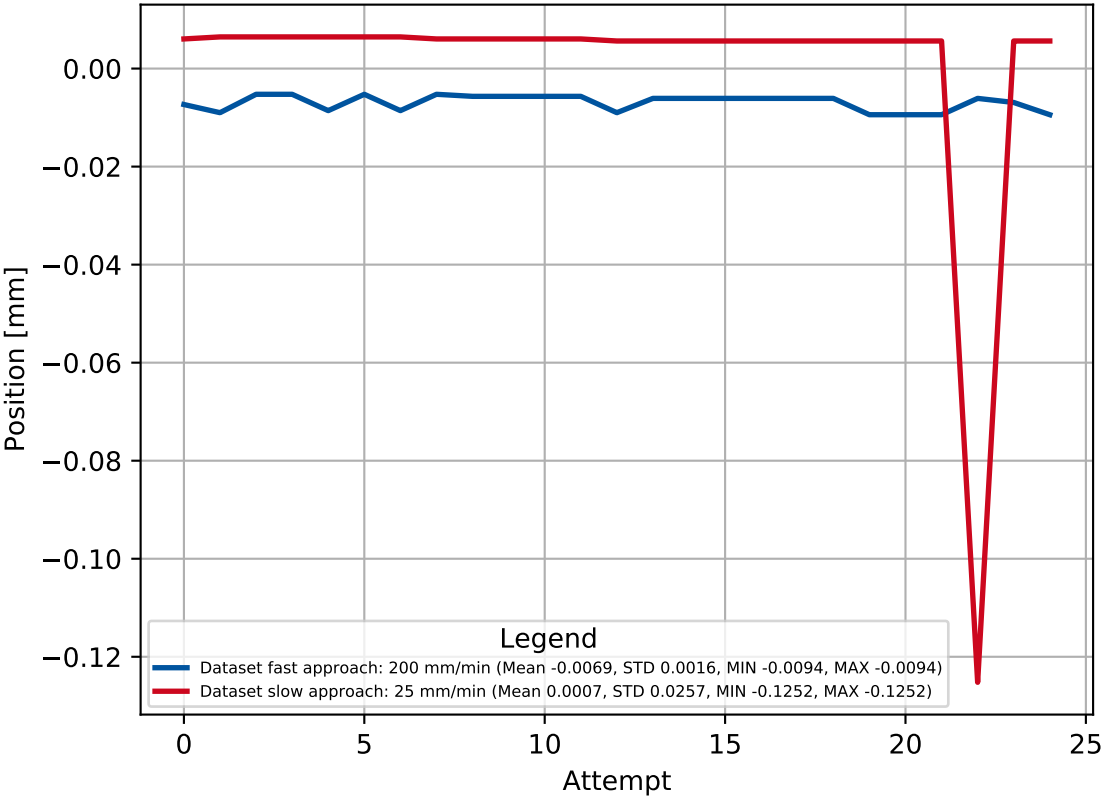

Probing results X axis towards workpiece (sideways, X+)
Position [mm]
−1.505
−1.510
−1.515
−1.520
−1.525
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 300 mm/min (Mean -1.5048, STD 0.0021, MIN -1.5088, MAX -1.5088)
Dataset slow approach: 20 mm/min (Mean -1.5273, STD 0.0007, MIN -1.5282, MAX -1.5282)

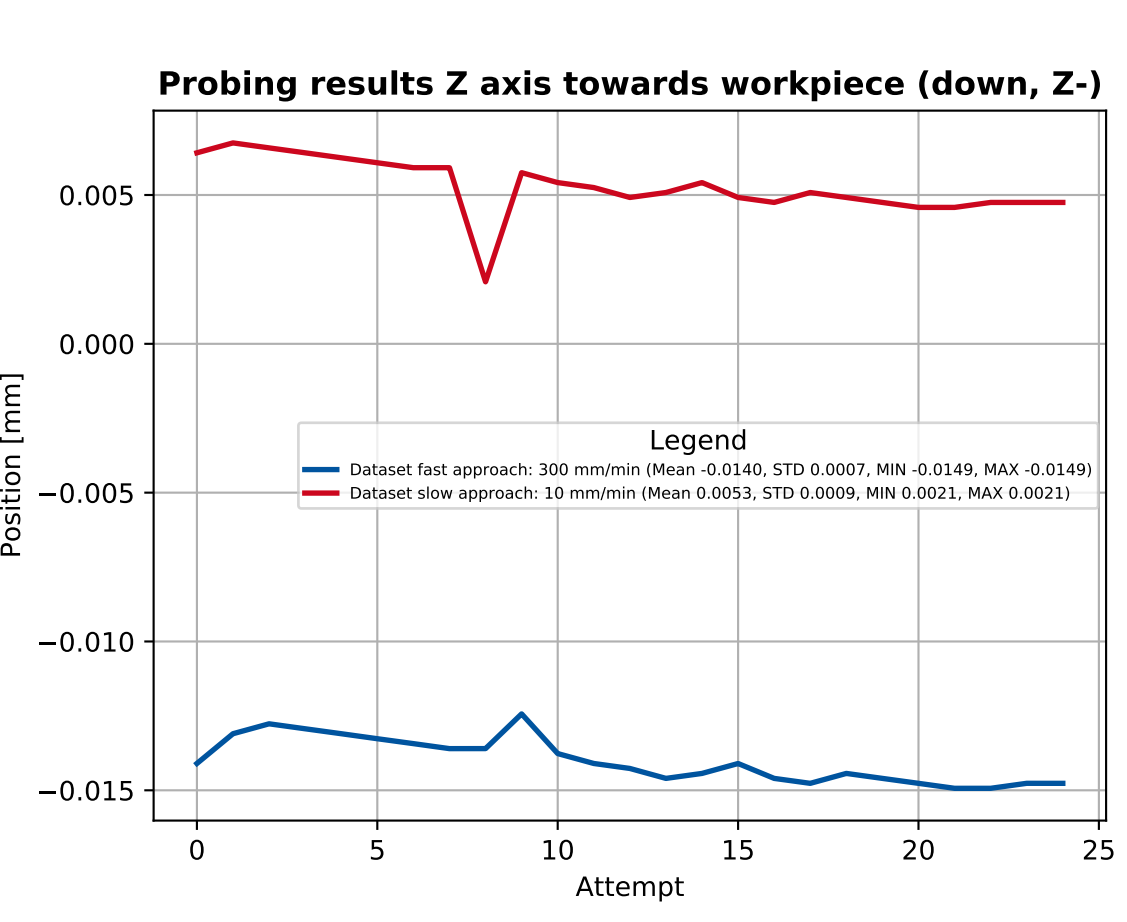

Probing results X axis towards workpiece (sideways, X+)
Position [mm]
−1.505
−1.510
−1.515
−1.520
−1.525
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 300 mm/min (Mean -1.5049, STD 0.0017, MIN -1.5072, MAX -1.5072)
Dataset slow approach: 25 mm/min (Mean -1.5254, STD 0.0008, MIN -1.5265, MAX -1.5265)

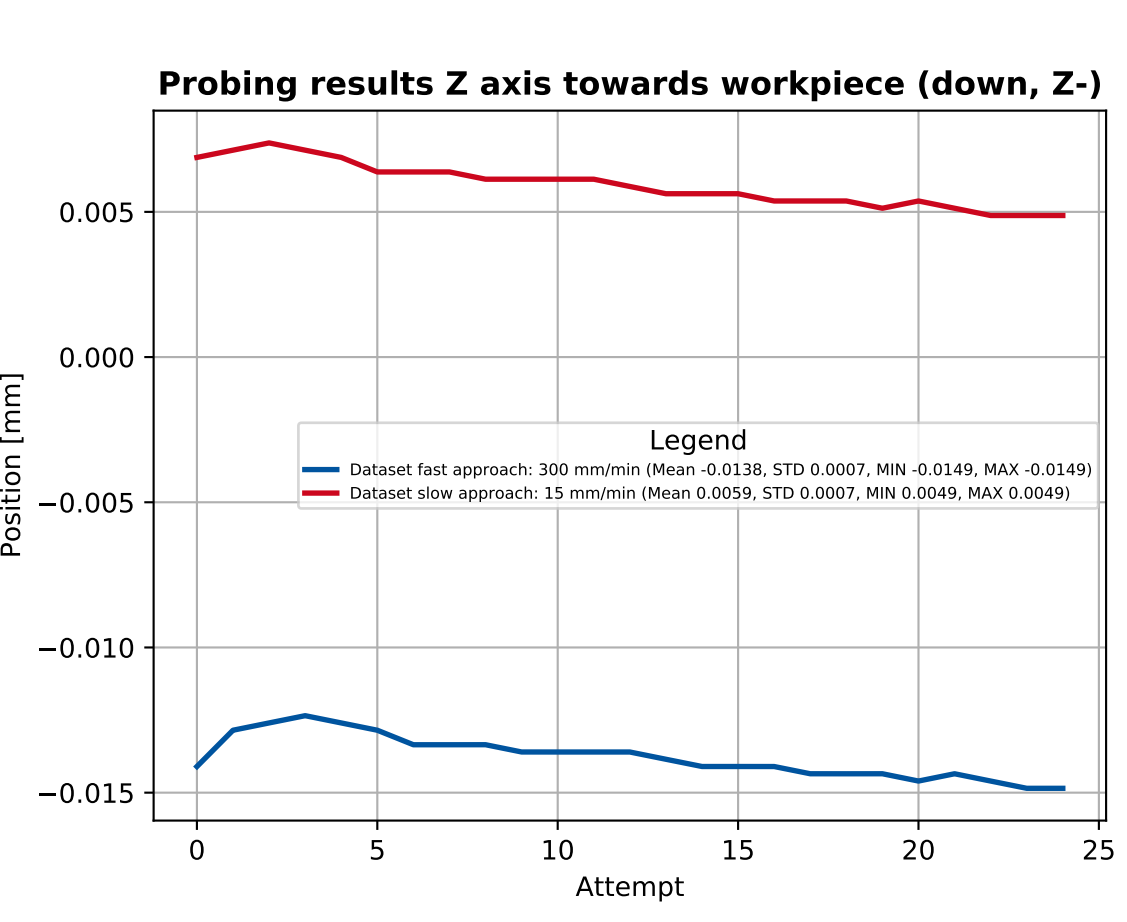

Probing results Z axis towards workpiece (down, Z-)
0.006
0.004
0.002
0.000
−0.002
−0.004
−0.006
−0.008
−0.010
Position [mm]
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 200 mm/min (Mean -0.0086, STD 0.0010, MIN -0.0095, MAX -0.0095)
Dataset slow approach: 10 mm/min (Mean 0.0056, STD 0.0006, MIN 0.0049, MAX 0.0049)

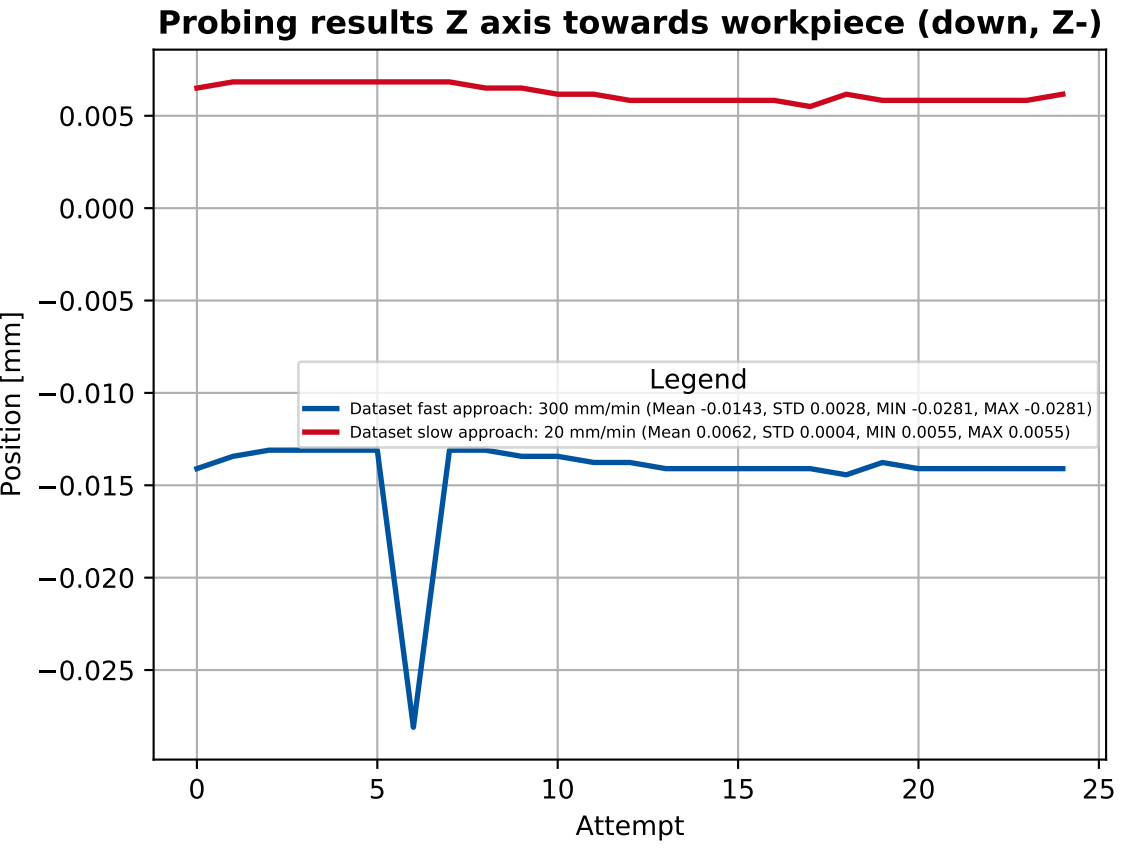

Probing results Z axis towards workpiece (down, Z-)
0.005
0.000
−0.005
−0.010
−0.015
Position [mm]
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 200 mm/min (Mean -0.0084, STD 0.0020, MIN -0.0158, MAX -0.0158)
Dataset slow approach: 15 mm/min (Mean 0.0060, STD 0.0005, MIN 0.0053, MAX 0.0053)

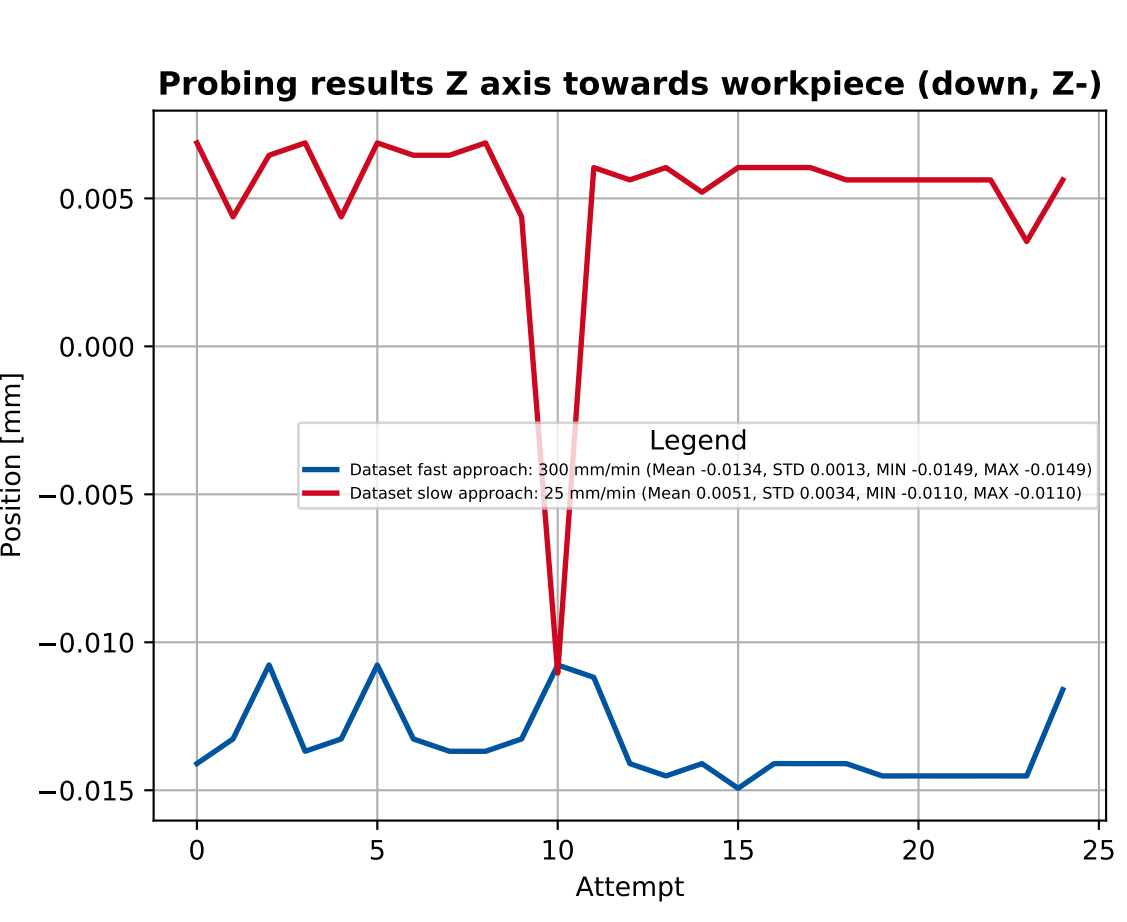

Probing results Z axis towards workpiece (down, Z-)
Position [mm]
0.005
0.000
−0.005
−0.010
−0.015
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 200 mm/min (Mean -0.0086, STD 0.0017, MIN -0.0147, MAX -0.0147)
Dataset slow approach: 20 mm/min (Mean 0.0054, STD 0.0027, MIN -0.0075, MAX -0.0075)

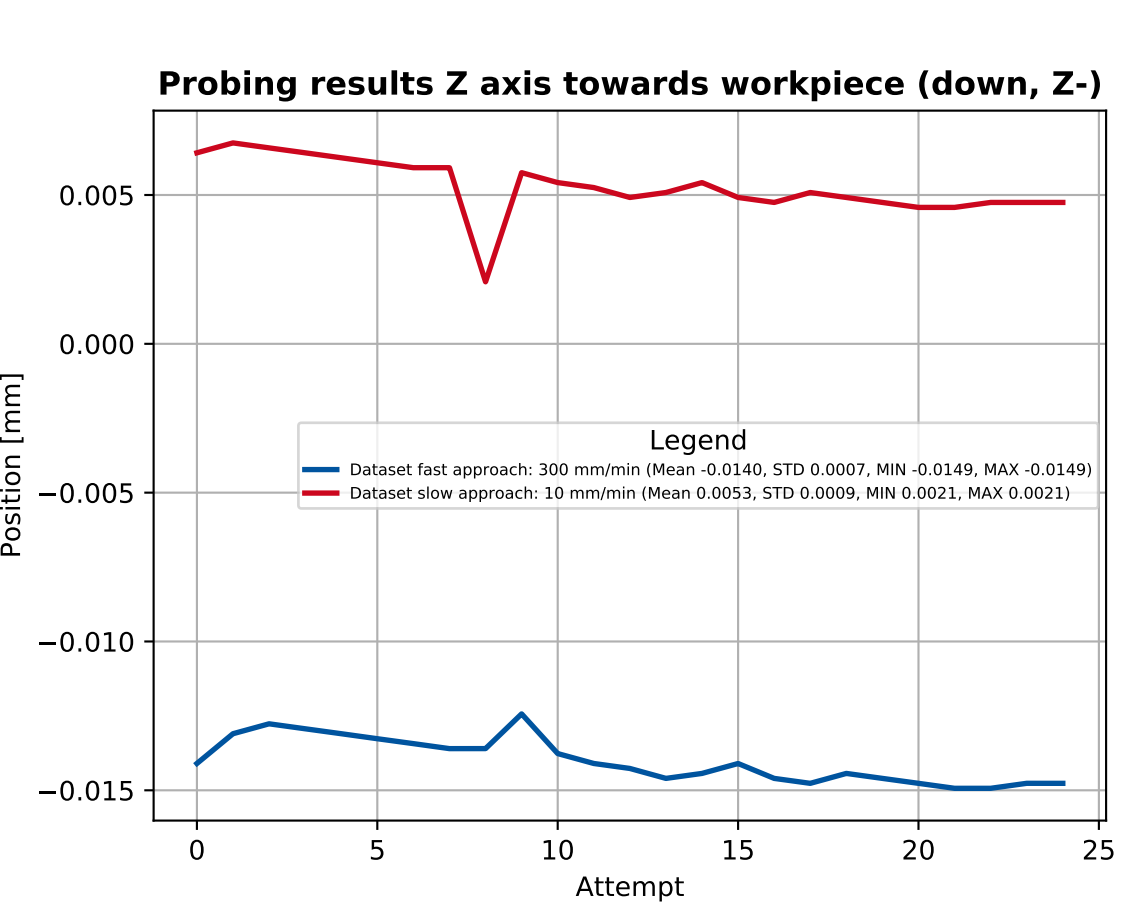

Probing results Z axis towards workpiece (down, Z-)
0.00
−0.02
−0.04
−0.06
−0.08
−0.10
−0.12
Position [mm]
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 200 mm/min (Mean -0.0069, STD 0.0016, MIN -0.0094, MAX -0.0094)
Dataset slow approach: 25 mm/min (Mean 0.0007, STD 0.0257, MIN -0.1252, MAX -0.1252)

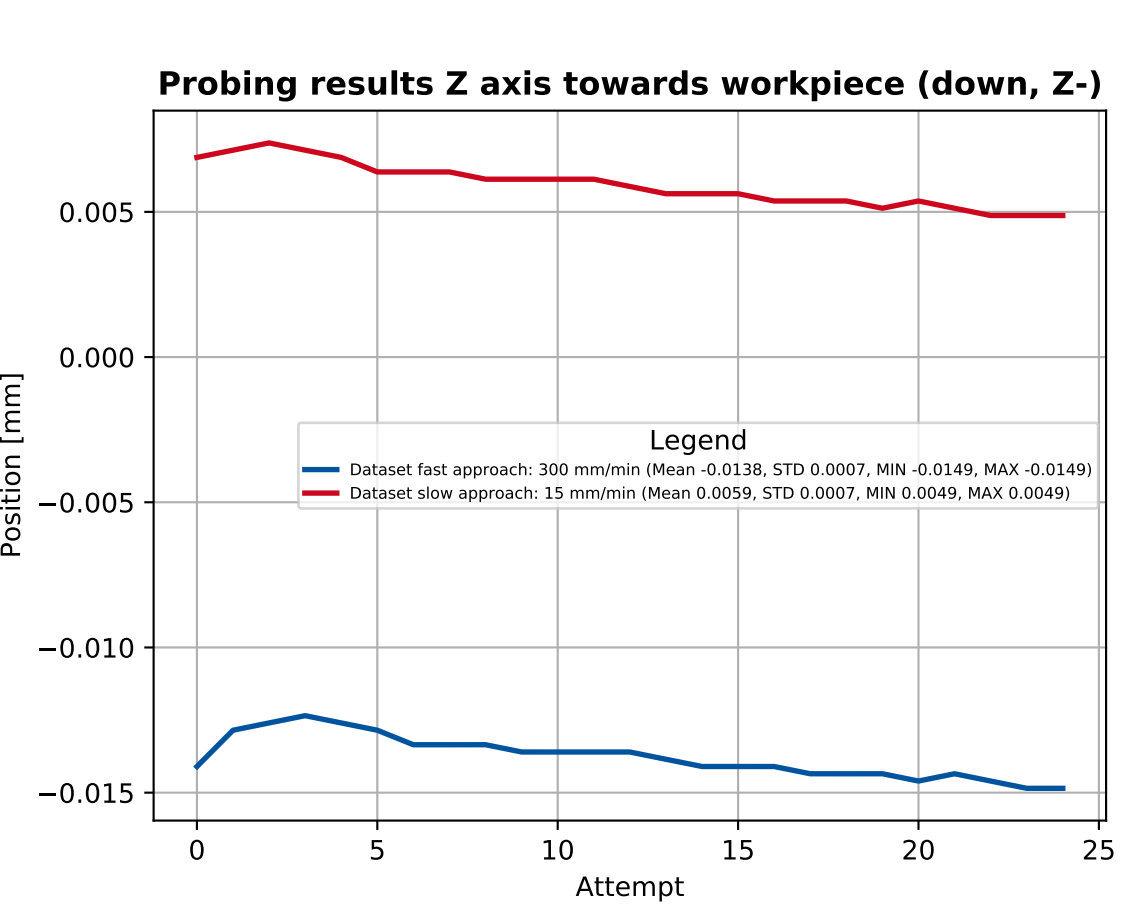

Probing results Z axis towards workpiece (down, Z-)
0.005
0.000
−0.005
−0.010
−0.015
Position [mm]
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 300 mm/min (Mean -0.0140, STD 0.0007, MIN -0.0149, MAX -0.0149)
Dataset slow approach: 10 mm/min (Mean 0.0053, STD 0.0009, MIN 0.0021, MAX 0.0021)

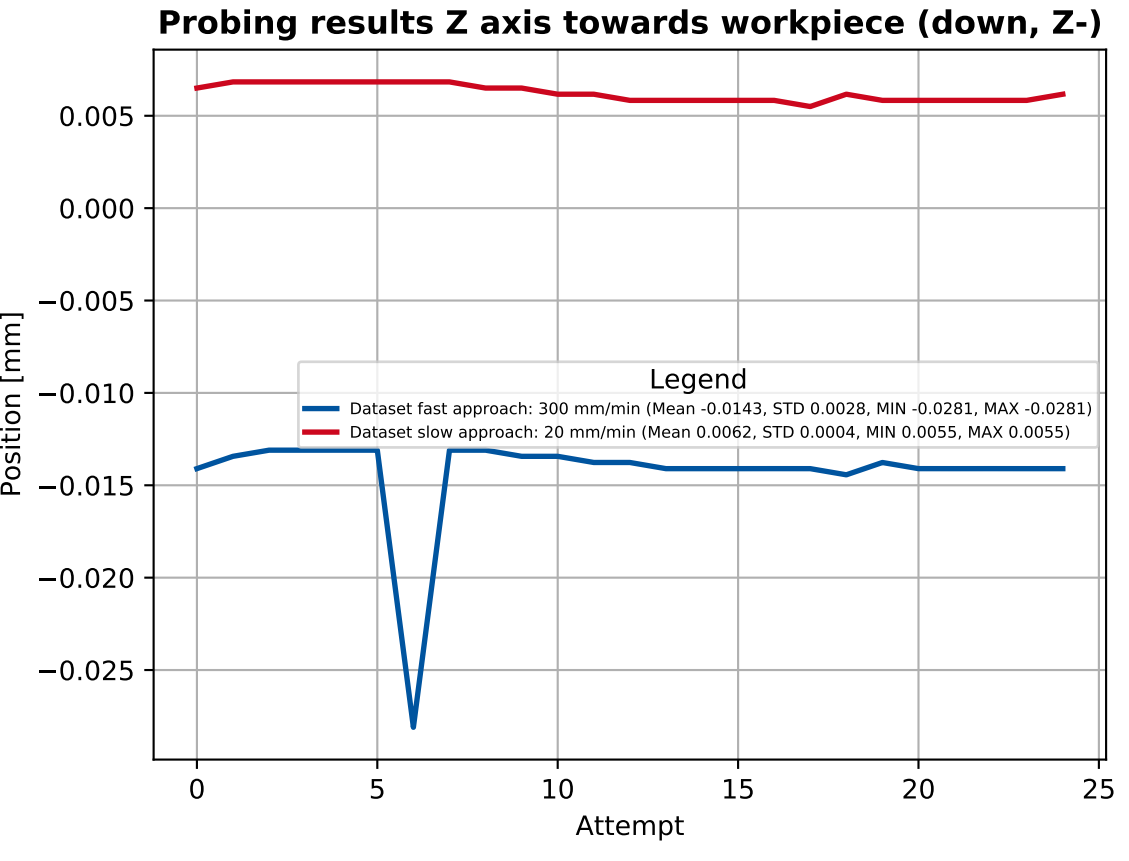

Probing results Z axis towards workpiece (down, Z-)
0.005
0.000
−0.005
−0.010
−0.015
Position [mm]
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 300 mm/min (Mean -0.0138, STD 0.0007, MIN -0.0149, MAX -0.0149)
Dataset slow approach: 15 mm/min (Mean 0.0059, STD 0.0007, MIN 0.0049, MAX 0.0049)

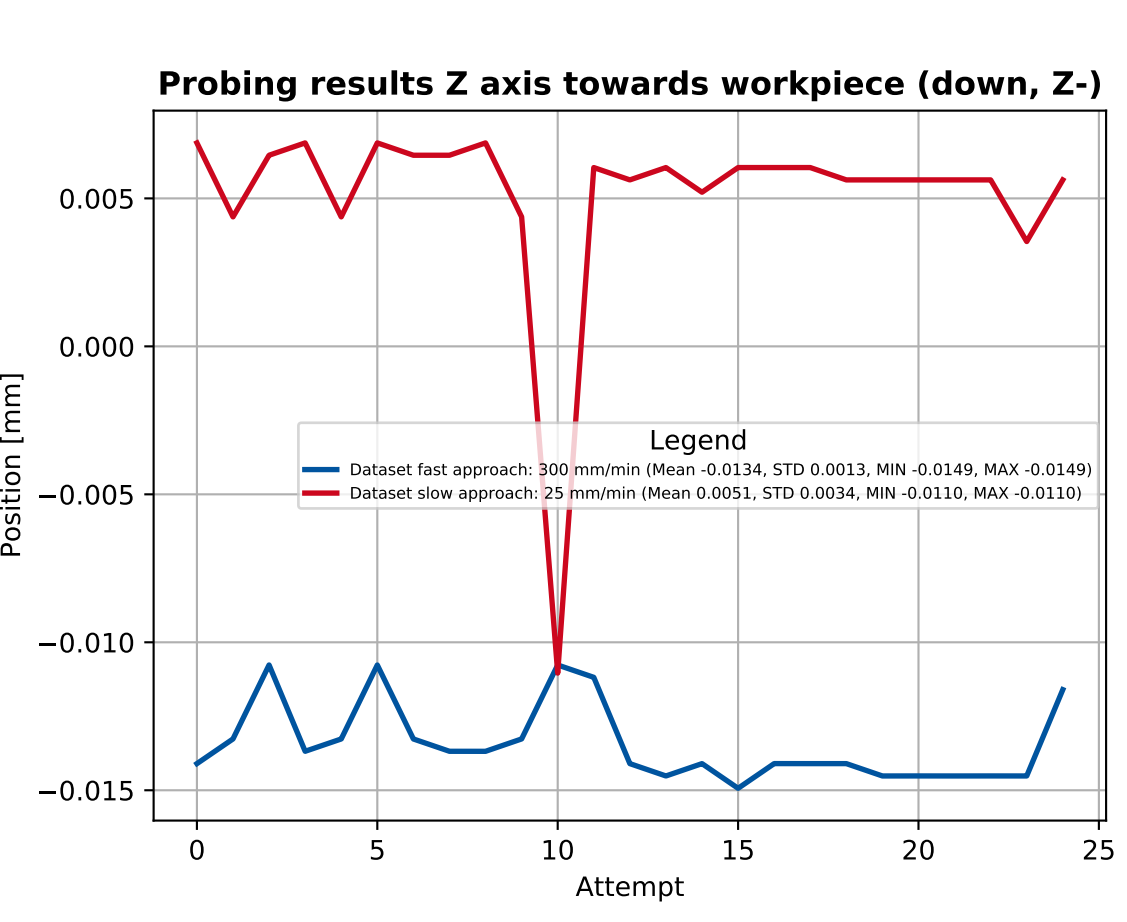

Probing results Z axis towards workpiece (down, Z-)
0.005
0.000
−0.005
−0.010
−0.015
−0.020
−0.025
Position [mm]
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 300 mm/min (Mean -0.0143, STD 0.0028, MIN -0.0281, MAX -0.0281)
Dataset slow approach: 20 mm/min (Mean 0.0062, STD 0.0004, MIN 0.0055, MAX 0.0055)


Probing results Z axis towards workpiece (down, Z-)
Position [mm]
0.005
0.000
−0.005
−0.010
−0.015
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 300 mm/min (Mean -0.0134, STD 0.0013, MIN -0.0149, MAX -0.0149)
Dataset slow approach: 25 mm/min (Mean 0.0051, STD 0.0034, MIN -0.0110, MAX -0.0110)


Probing results Z axis towards workpiece (down, Z-)
0.005
0.000
−0.005
−0.010
−0.015
Position [mm]
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 300 mm/min (Mean -0.0140, STD 0.0007, MIN -0.0149, MAX -0.0149)
Dataset slow approach: 10 mm/min (Mean 0.0053, STD 0.0009, MIN 0.0021, MAX 0.0021)


Probing results Z axis towards workpiece (down, Z-)
0.005
0.000
−0.005
−0.010
−0.015
Position [mm]
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 300 mm/min (Mean -0.0138, STD 0.0007, MIN -0.0149, MAX -0.0149)
Dataset slow approach: 15 mm/min (Mean 0.0059, STD 0.0007, MIN 0.0049, MAX 0.0049)


Probing results Z axis towards workpiece (down, Z-)
0.005
0.000
−0.005
−0.010
−0.015
−0.020
−0.025
Position [mm]
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 300 mm/min (Mean -0.0143, STD 0.0028, MIN -0.0281, MAX -0.0281)
Dataset slow approach: 20 mm/min (Mean 0.0062, STD 0.0004, MIN 0.0055, MAX 0.0055)


Probing results Z axis towards workpiece (down, Z-)
Position [mm]
0.005
0.000
−0.005
−0.010
−0.015
0
5
10
15
20
25
Attempt
Legend
Dataset fast approach: 300 mm/min (Mean -0.0134, STD 0.0013, MIN -0.0149, MAX -0.0149)
Dataset slow approach: 25 mm/min (Mean 0.0051, STD 0.0034, MIN -0.0110, MAX -0.0110)