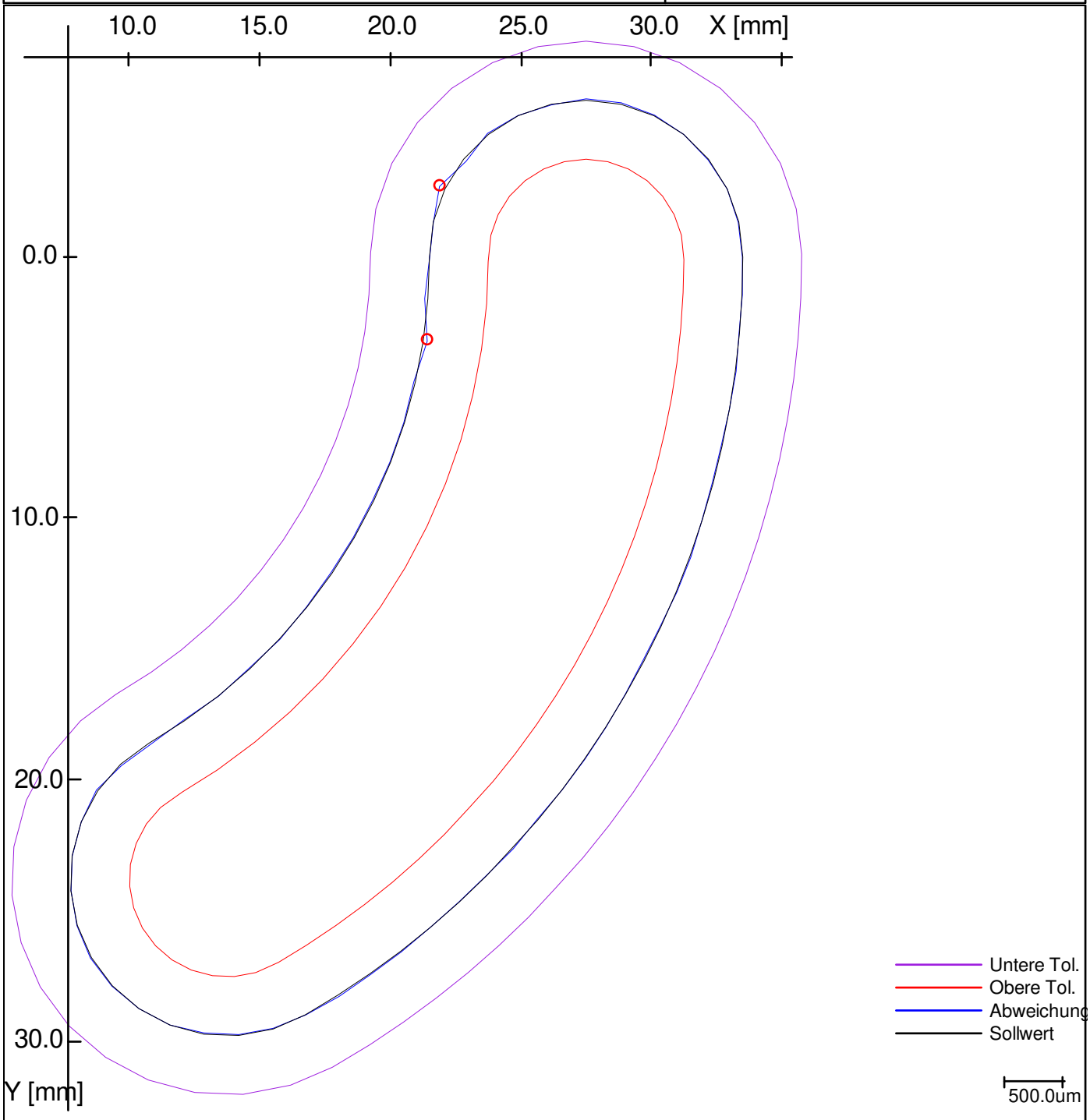
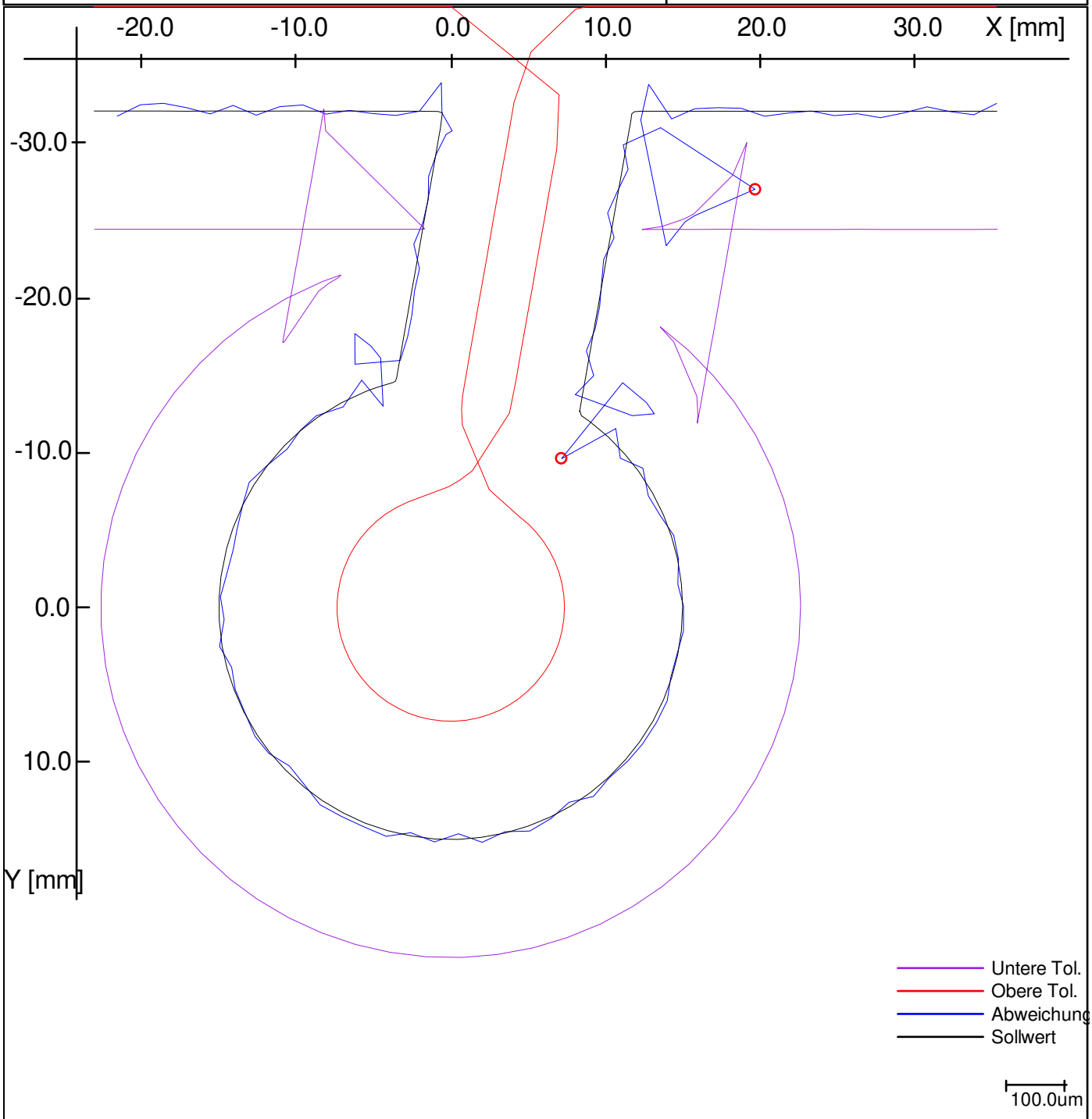
ZEISS Calypso 7.0.20	Carl Zeiss	Datum 24. Februar 2022 Auftrag 1	
		Abteilung: Prüfer Master Unterschrift:	
Teil-Nummer 8	KMG-Typ Prismo	Zeichnungsnummer 321654987 v 24	
Prüfplan mein_block		Curve form1	



		Translation	Rotation		
Einpassergebnis	X	0.000	0.000	Überhöhung	20
	Y	0.000	0.000	Kommentar	
	Z	0.000	0.000		

Sigma	Form	Anzahl	Untere Tol.	Obere Tol.	MinInd	Min Abweich.	MaxInd	Max Abweich.
0,011	0,085	66	-0,500	0,500	65	-0,051	3	0,034

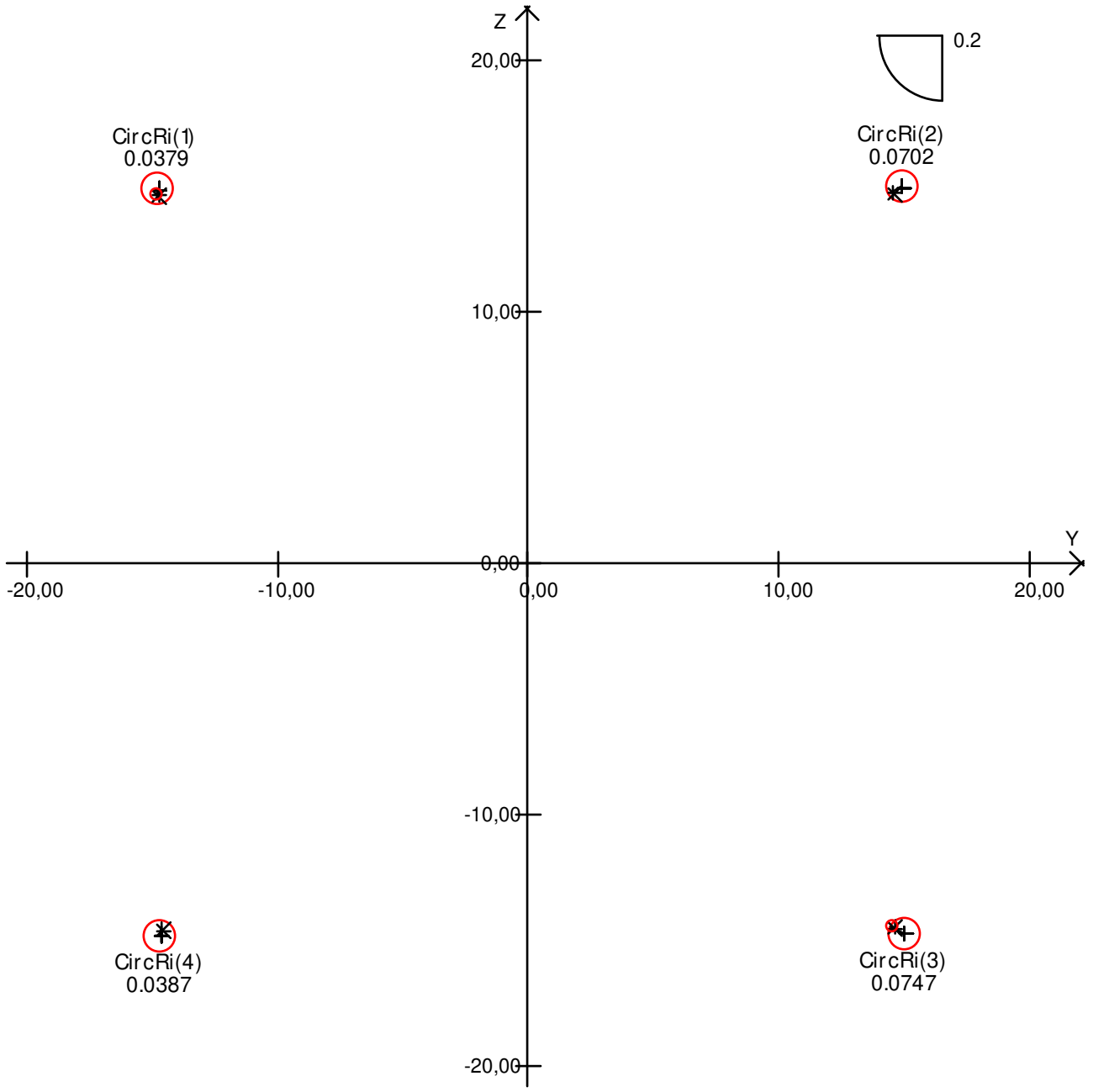
ZEISS Calypso 7.0.20	Carl Zeiss	Datum 24. Februar 2022 Auftrag 1	
		Abteilung: Prüfer Master Unterschrift:	
Teil-Nummer 8	KMG-Typ Prismo	Zeichnungsnummer 321654987 v 24	
Prüfplan mein_block		Curve form2	



		Translation	Rotation		
Einpassergebnis	X	0.000	0.000	Überhöhung	100
	Y	0.000	0.000	Kommentar	
	Z	0.000	0.000		

Sigma	Form	Anzahl	Untere Tol.	Obere Tol.	MinInd	Min Abweich.	MaxInd	Max Abweich.
0,048	0,323	124	-0,200	0,200	104	-0,245	86	0,079

ZEISS Calypso 7.0.20	Carl Zeiss	Datum 24. Februar 2022 Auftrag 1	
Teil-Nummer 8	KMG-Typ Prismo	Zeichnungsnummer 321654987 v 24	Abteilung: Prüfer Master Unterschrift:
Prüfplan mein_block			best Fit of bore pattern



Best Fit4 Gauß-2d-Einpassung	Y Z Winkel	-0.029 0.005 -0.002	Überhöhung	50

Nr	Bezeichnung	Istwert	Toleranz	Anzahl Pu	Vmess	Tasterradiu	F.Typ	L-C	W/U
1	best Fit of bore pattern^1	0,038	0,100						
2	best Fit of bore pattern^2	0,070	0,100						
3	best Fit of bore pattern^3	0,075	0,100						
4	best Fit of bore pattern^4	0,039	0,100						

Messprotokoll ZEISS Calypso

WName
mein_block

Datum
24. Februar 2022

Zeichnungsnummer
321654987 v 24

Auftrag
1

Uhrzeit
11:22:48

Prüfer
Master

Teilnummer inkremental
8

KMG
Simulation

Blatt 1 von 3

Name	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<--|-->
Feature Angle_Angle point	ElWi	1.736	1.745	0.007	-0.007	-0.009	-0.002
Angle Of Rotation1	DrehWi	3.141	3.142	0.001	-0.001	0.000	----|
Cone Angle1	WK	0.519	0.524	0.009	-0.009	-0.005	----|
Diameter_Cone Addition1	D	18.591	16.000	0.100	-0.100	2.591	2.491
Angle Two1	W2	-0.523	-0.524	0.002	-0.002	0.000	|----
Angle1betweenCirc	W	1.284	1.285	0.002	-0.002	0.000	----|
Projection Angle One_Offset Plane1	W1	0.000	0.000	0.002	-0.002	0.000	----|
Angle One1	W1	-0.698	-0.698	0.002	-0.002	0.000	|----
Angle1	W	2.269	2.269	0.001	-0.001	0.000	----|
Coaxiality1	Koa	0.501	0.000	0.060		0.501	0.441
Straightness1	Ger	0.007	0.000	0.002		0.007	0.005
Flatness1	Ebe	0.012	0.000	0.005		0.012	0.007
Projection Angle Two_Offset Plane1	W2	0.000	0.000	0.001	-0.001	0.000	----|
Axial Runout1	Plan	0.103	0.000	0.050		0.103	0.053
Cylindricity1	Zyl	0.011	0.000	0.007		0.011	0.004
Roundness2(3)	Runh	0.014	0.000	0.010		0.014	0.004
Angularity1	Nei	0.018	0.000	0.015		0.018	0.003
Perpendicularity1	Rec	0.034	0.000	0.030		0.034	0.004
Angle of Inclination1	KippWi	0.698	0.698	0.017	-0.017	0.000	----|
Radial Runout1	Runl	0.509	0.000	0.500		0.509	0.009
Diameter_circle on cone	D	27.299	27.200	0.100	-0.100	0.099	|----
Y-value1	Y	-32.148	-32.000	0.150	-0.150	-0.148	----|
Concentricity1	Kon	0.867	0.000	0.900		0.867	|----
True Position1	Po2d	0.478	0.000	0.500		0.478	|----
Diameter2(1)	D	6.045	6.000	0.050	-0.050	0.045	|----
Diameter Two1	D2	14.921	15.000	0.150	-0.100	-0.079	----|
Diameter1	D	30.183	30.000	0.200	0.000	0.183	|----
best Fit of bore pattern^3	Po2d	0.075	0.000	0.100		0.075	|---
Roundness2(2)	Runh	0.007	0.000	0.010		0.007	|---
best Fit of bore pattern^2	Po2d	0.070	0.000	0.100		0.070	|---
Parallelism1	Par	0.042	0.000	0.060		0.042	|---
GDT Symmetrie1	Sym	0.138	0.000	0.200		0.138	|---
Roundness1(4)	Runh	0.006	0.000	0.010		0.006	|---
Roundness1(3)	Runh	0.006	0.000	0.010		0.006	|---
Z-Value_Intersection Cyl-Cyl	Z	-33.018	-33.100	0.150	-0.150	0.082	|---

WName mein_block | Datum 24. Februar 2022

Prüfer Master | Blatt 2 | Uhrzeit 11:22:48

Name	id	actual	nominal	pos tol	neg tol	diff	<--|-->
Z-Value_IntersectionCon-Cyl	Z	-33.018	-33.100	0.150	-0.150	0.082	|---
Z-value_Intersection Cyl-Cyl1Alignment2	Z	-33.024	-33.096	0.150	-0.150	0.072	|--
Z-value_IntersectionCon-Cyl1Alignment2	Z	-33.024	-33.096	0.150	-0.150	0.072	|--
Diameter2(3)	D	6.023	6.000	0.050	-0.050	0.023	|--
Roundness1(2)	Runh	0.004	0.000	0.010		0.004	|--
Diameter2(4)	D	6.021	6.000	0.050	-0.050	0.021	|--
X-value1	X	-9.741	-9.800	0.150	-0.150	0.059	|--
best Fit of bore pattern^4	Po2d	0.039	0.000	0.100		0.039	|--
best Fit of bore pattern^1	Po2d	0.038	0.000	0.100		0.038	|--
Z-value1	Z	-33.070	-33.000	0.200	-0.200	-0.070	--|
Diameter_cone with two Probes	D	15.034	15.000	0.100	-0.100	0.034	|--
3-D Polar Distance1	Dist3d	33.450	33.500	0.150	-0.150	-0.050	--|
X-Value_Intersection3D Line-Circle	X	-16.345	-16.316	0.100	-0.100	-0.030	--|
X-value_Intersection1Plane-Plane	X	-51.757	-51.800	0.150	-0.150	0.043	|--
Roundness1(1)	Runh	0.003	0.000	0.010		0.003	|--
Y-Wert_IntersectionPlane-Circle1Alignment2	Y	17.493	17.466	0.100	-0.100	0.027	|--
X-Value_IntersectionCircle-Circle	X	-7.926	-7.900	0.100	-0.100	-0.026	--|
X-Value_Intersection3D Line-Circle1Alignment2	X	-56.542	-56.507	0.150	-0.150	-0.035	-|
Diameter2(2)	D	6.011	6.000	0.050	-0.050	0.011	|-
Z-value_Intersection Plane-Cyl1Alignment2	Z	-33.066	-33.098	0.150	-0.150	0.032	|-
X-Value_Intersection 2D-Line-Plane1	X	-28.186	-28.166	0.100	-0.100	-0.021	-|
X-value_IntersectionCircle-Circle1Alignment2	X	-48.122	-48.091	0.150	-0.150	-0.031	-|
Z-value_Intersection Plane-Cyl	Z	-33.070	-33.100	0.150	-0.150	0.030	|-
Diameter_Minimum2	D	11.980	12.000	0.100	-0.100	-0.020	-|
X-value_Intersection 3D Line-Plane	X	-9.575	-9.378	1.000	-1.000	-0.197	-|
Form1	Form	0.001	0.000	0.006		0.001	|
X-Value_Intersection 2D-Line-Plane	X	12.010	12.025	0.100	-0.100	-0.015	-|
Roundness2(4)	Runh	0.001	0.000	0.010		0.001	|
2-D Polar Distance1	Dist2d	21.014	21.000	0.100	-0.100	0.014	|-
Distance1	Dist	77.997	78.000	0.020	-0.020	-0.003	-|
Z-Value_IntersectionPerpendicular-Plane	Z	-33.080	-33.100	0.150	-0.150	0.020	|-
X-value_Intersection 3D Line-Plane1Alignment2	X	-49.769	-49.572	1.500	-1.500	-0.197	-|
Radius_Radius-Point1	R	15.071	15.200	1.000	-1.000	-0.129	-|
Durchmesser_Average2	D	11.988	12.000	0.100	-0.100	-0.012	-|
Radius1^4	R	5.958	6.000	0.500	-0.500	-0.042	-|
Z-value_IntersectionPerpendicular-Plane1Alignment2	Z	-33.080	-33.091	0.150	-0.150	0.011	|-
X-Value_Intersection 2D-Line-2D-Line1Alignment1	X	-28.190	-28.183	0.100	-0.100	-0.007	-|
Radius1^2	R	6.036	6.000	0.500	-0.500	0.036	|-
Cartesian Distance1	DistKart	25.007	25.000	0.100	-0.100	0.007	|-
Point spacing1	PktAbst	-0.006	0.000	0.101	-0.100	-0.006	-|
Y-value2	Y	6.894	6.900	0.100	-0.100	-0.006	-|
Diameter_Maximum1	D	11.995	12.000	0.100	-0.100	-0.005	-|

WName mein_block | Datum 24. Februar 2022

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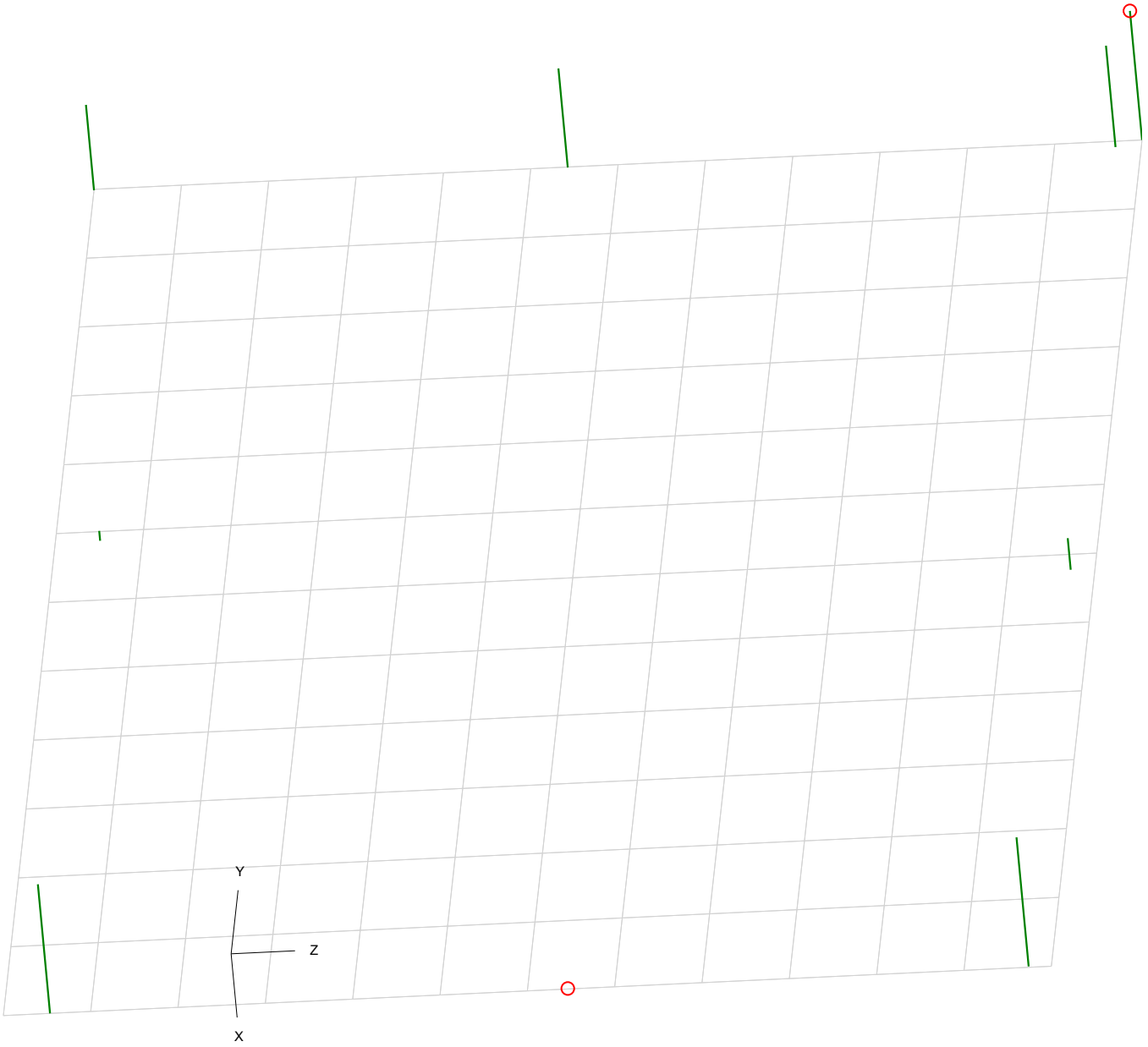
Name	id	actual	nominal	pos tol	neg tol	diff	<--|-->
X-value_IntersectionPlane-Cone1Alignment2	X	-40.198	-40.191	0.150	-0.150	-0.007	-|
X-value_Intersection3D-Line-Cyl1Alignment2	X	-40.196	-40.191	0.150	-0.150	-0.005	-|
X-value_Intersection3D-3DLine1Alignment2	X	-40.196	-40.191	0.150	-0.150	-0.005	-|
X-Value_IntersectionPlane-Cone	X	-0.002	0.000	0.050	-0.050	-0.002	-|
X-Value_Intersection3D-Line-Cone1Alignment2	X	-40.200	-40.191	0.300	-0.300	-0.009	-|
DiamToPRecal	D	54.995	55.000	0.150	-0.150	-0.005	-|
Z-value_Projection1	Z	-33.096	-33.100	0.150	-0.150	0.004	|-
Radius1^1	R	5.989	6.000	0.500	-0.500	-0.011	-|
Radius1^3	R	6.011	6.000	0.500	-0.500	0.011	|-
X-Value_Intersection 2D-Line-2D-Line	X	12.006	12.008	0.100	-0.100	-0.002	-|
Y-Wert_IntersectionPlane-Circle	Y	-14.642	-14.641	0.100	-0.100	-0.002	-|
Radius Two1	R2	7.461	7.450	1.000	-1.000	0.011	|-
Z-Value_Point1withRef.Probe	Z	-10.001	-10.000	0.100	-0.100	-0.001	|
X-Value_Intersection3D-Line-Cone	X	0.000	0.000	0.050	-0.050	0.000	|
Roundness2(1)	Runh	0.000	0.000	0.010		0.000	|
Z-value_Perpendicular1	Z	-33.100	-33.100	0.150	-0.150	0.000	|
X-Value_Intersection3D-3DLine	X	0.000	0.000	0.050	-0.050	0.000	|
X-Value_Intersection3D-Line-Cyl	X	0.000	0.000	0.030	-0.030	0.000	|
Curve form2 Toleranzform: Standard	KurvForm	0.323	0.000	0.200	-0.200	0.323	|-
Curve form1 Toleranzform: Standard	KurvForm	0.085	0.000	0.500	-0.500	0.085	|-

Calypso 7.0.20	Carl Zeiss	Datum	24. Februar 2022
		Auftrag	1
Teil-Nummer 8	KMG-Typ Prismo	Zeichnungsnummer 321654987 v 24	Abteilung:
			Prüfer Master
			Unterschrift:
Prüfplanname mein_block			

1: Flatness1



10 µm
2000 : 1

Nr	Bezeichnung	Istwert [mm]	Toleranz [mm]	Anzahl Punkte	Vmess [mm/s]	Tasterradius [mm]	F.Typ	L-C	W/U
1	Flatness1	0,012	0,005	9	0.00	0,000			