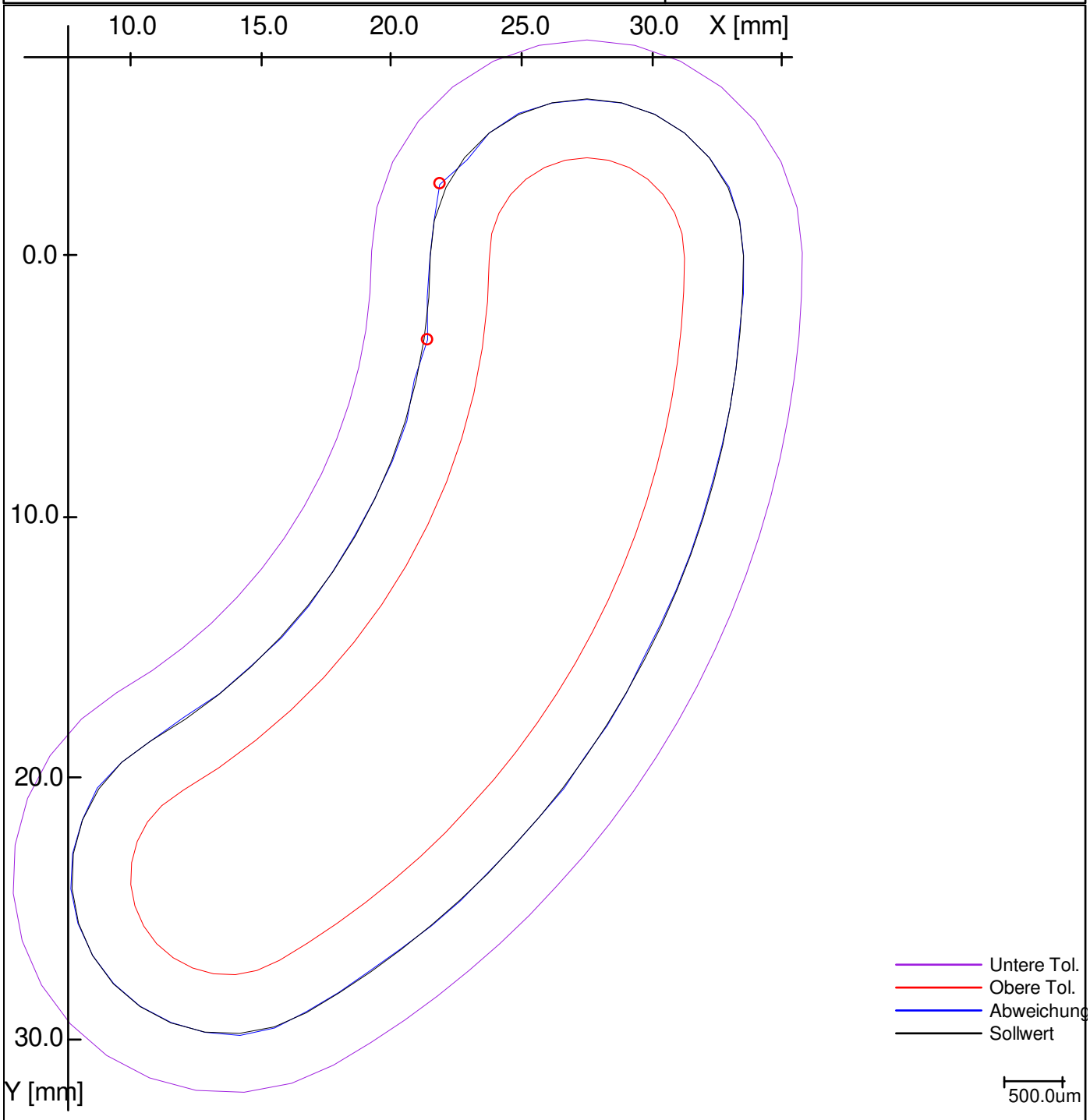
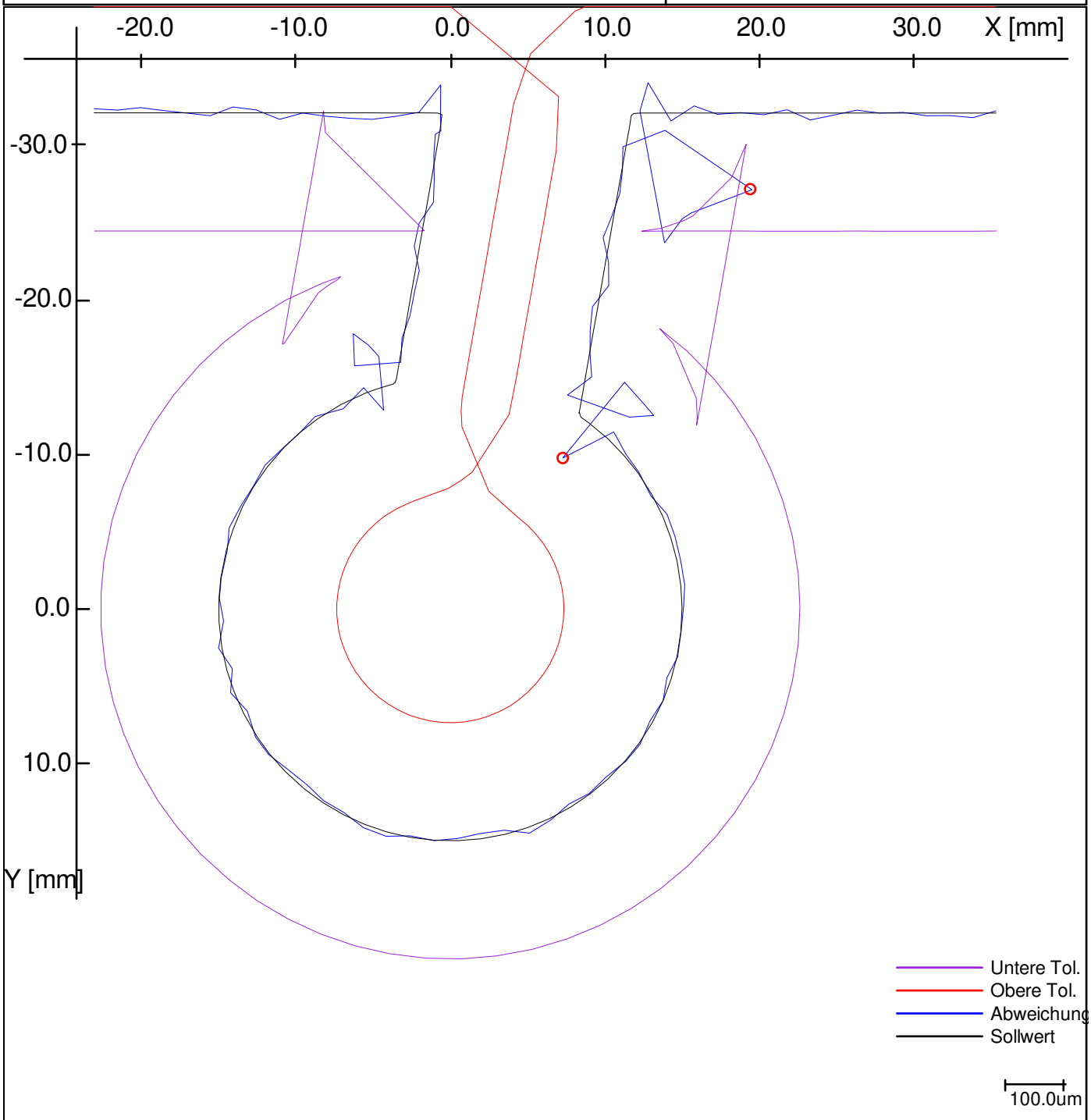
ZEISS Calypso 7.0.20	Carl Zeiss	Datum 24. Februar 2022 Auftrag 1	
		Abteilung: Prüfer Master Unterschrift:	
Teil-Nummer 9	KMG-Typ Prismo	Zeichnungsnummer 321654987 v 24	
Prüfplan mein_block		Curve form1	



		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	0,089	66	-0,500	0,500	65	-0,059	3	0,030

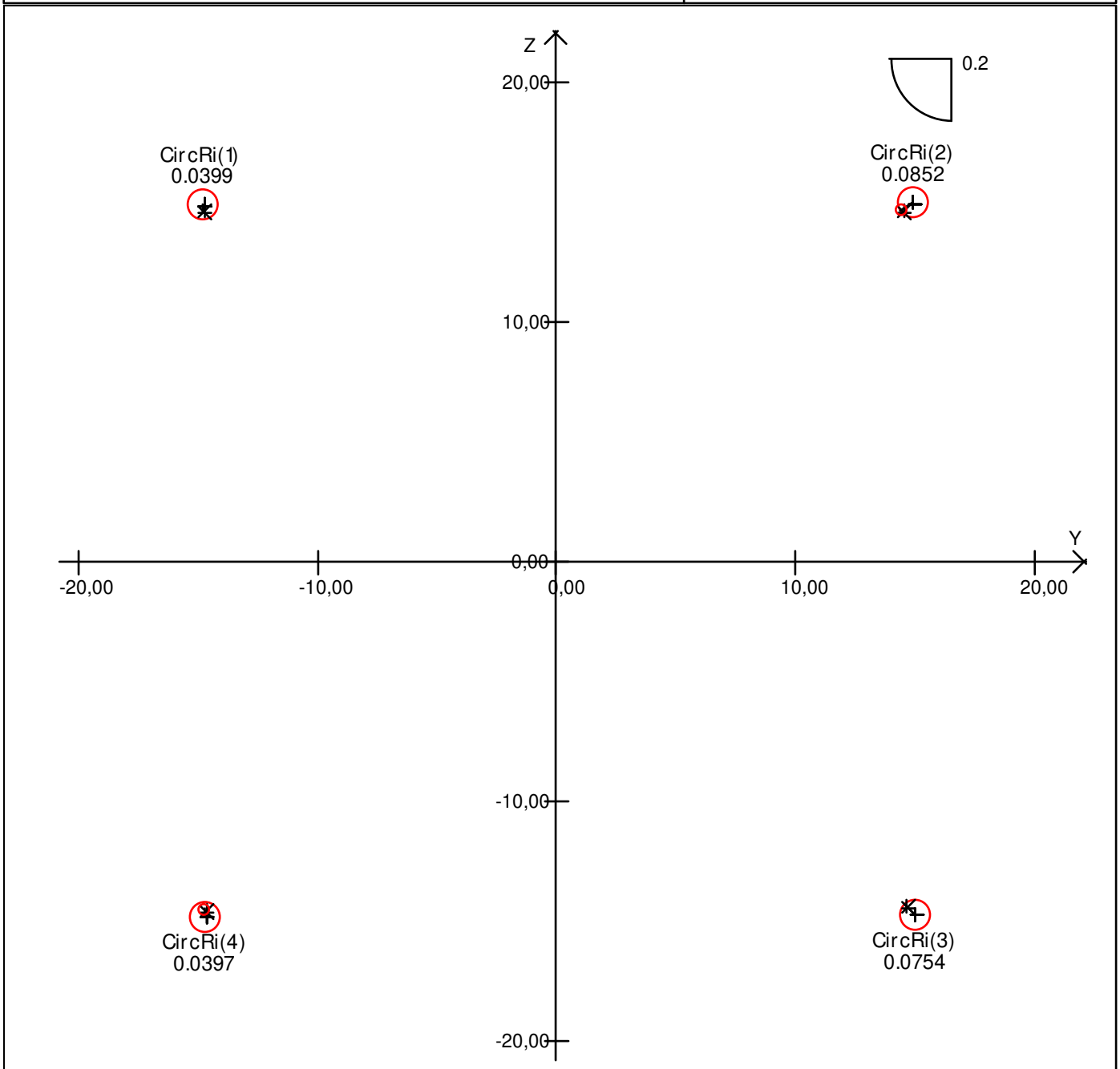
ZEISS Calypso 7.0.20	Carl Zeiss	Datum	24. Februar 2022
		Auftrag	1
		Abteilung:	
Teil-Nummer 9	KMG-Typ Prismo	Zeichnungsnummer 321654987 v 24	Prüfer Master
			Unterschrift:
Prüfplan mein_block		Curve form2	



		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.
0,047	0,314	124	-0,200	0,200	104	-0,240	86	0,074

ZEISS Calypso 7.0.20	Carl Zeiss	Datum 24. Februar 2022 Auftrag 1	
Teil-Nummer 9	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	-0.031 0.008 -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	0,040	0,100						
2	best Fit of bore pattern^2	0,085	0,100						
3	best Fit of bore pattern^3	0,075	0,100						
4	best Fit of bore pattern^4	0,040	0,100						

Messprotokoll ZEISS Calypso

WName
mein_block

Datum
24. Februar 2022

Zeichnungsnummer
321654987 v 24

Auftrag
1

Uhrzeit
11:23:05

Prüfer
Master

Teilnummer inkremental
9

KMG
Simulation

Blatt 1 von 3

Name	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<--|-->
Feature Angle_Angle point	ElWi	1.734	1.745	0.007	-0.007	-0.012	-0.005
Diameter_Cone Addition1	D	18.490	16.000	0.100	-0.100	2.490	2.390
Angle1	W	2.269	2.269	0.001	-0.001	0.000	----|
Angle One1	W1	-0.698	-0.698	0.002	-0.002	0.000	|----
Angle1betweenCirc	W	1.284	1.285	0.002	-0.002	0.000	----|
Projection Angle Two_Offset Plane1	W2	0.000	0.000	0.001	-0.001	0.000	----|
Angle Of Rotation1	DrehWi	3.141	3.142	0.001	-0.001	0.000	----|
Angle Two1	W2	-0.523	-0.524	0.002	-0.002	0.000	|----
Coaxiality1	Koa	0.493	0.000	0.060		0.493	0.433
Projection Angle One_Offset Plane1	W1	0.000	0.000	0.002	-0.002	0.000	----|
Cone Angle1	WK	0.524	0.524	0.009	-0.009	0.001	|----
Axial Runout1	Plan	0.182	0.000	0.050		0.182	0.132
Flatness1	Ebe	0.018	0.000	0.005		0.018	0.013
Straightness1	Ger	0.006	0.000	0.002		0.006	0.004
Cylindricity1	Zyl	0.012	0.000	0.007		0.012	0.005
Angularity1	Nei	0.023	0.000	0.015		0.023	0.008
Perpendicularity1	Rec	0.043	0.000	0.030		0.043	0.013
Angle of Inclination1	KippWi	0.698	0.698	0.017	-0.017	0.000	----|
Distance1	Dist	78.025	78.000	0.020	-0.020	0.025	0.005
Diameter_circle on cone	D	27.303	27.200	0.100	-0.100	0.103	0.003
Form1	Form	0.006	0.000	0.006		0.006	0.000
Y-value1	Y	-32.151	-32.000	0.150	-0.150	-0.151	-0.001
Parallelism1	Par	0.059	0.000	0.060		0.059	|----
Radial Runout1	Runl	0.485	0.000	0.500		0.485	|----
Concentricity1	Kon	0.847	0.000	0.900		0.847	|----
True Position1	Po2d	0.469	0.000	0.500		0.469	|----
Diameter2(4)	D	6.046	6.000	0.050	-0.050	0.046	|----
Diameter1	D	30.190	30.000	0.200	0.000	0.190	|----
Diameter Two1	D2	14.914	15.000	0.150	-0.100	-0.086	----|
Z-Value_Intersection Cyl-Cyl	Z	-32.970	-33.100	0.150	-0.150	0.130	|----
Z-Value_IntersectionCon-Cyl	Z	-32.970	-33.100	0.150	-0.150	0.130	|----
best Fit of bore pattern^2	Po2d	0.085	0.000	0.100		0.085	|----
Z-value_Intersection Cyl-Cyl1Alignment2	Z	-32.975	-33.096	0.150	-0.150	0.120	|----
Z-value_IntersectionCon-Cyl1Alignment2	Z	-32.976	-33.096	0.150	-0.150	0.120	|----
GDT Symmetrie1	Sym	0.159	0.000	0.200		0.159	|----

WName mein_block | Datum 24. Februar 2022

Prüfer Master | Blatt 2 | Uhrzeit 11:23:05

Name	id	actual	nominal	pos tol	neg tol	diff	<--|-->
best Fit of bore pattern^3	Po2d	0.075	0.000	0.100		0.075	|---
Roundness1(1)	Runh	0.007	0.000	0.010		0.007	|---
Roundness2(4)	Runh	0.007	0.000	0.010		0.007	|---
Roundness2(1)	Runh	0.005	0.000	0.010		0.005	|--
Diameter2(1)	D	6.025	6.000	0.050	-0.050	0.025	|--
best Fit of bore pattern^1	Po2d	0.040	0.000	0.100		0.040	|--
best Fit of bore pattern^4	Po2d	0.040	0.000	0.100		0.040	|--
X-value1	X	-9.743	-9.800	0.150	-0.150	0.057	|--
Diameter2(3)	D	6.018	6.000	0.050	-0.050	0.018	|--
Z-value1	Z	-33.068	-33.000	0.200	-0.200	-0.068	--|
3-D Polar Distance1	Dist3d	33.449	33.500	0.150	-0.150	-0.051	--|
Roundness2(3)	Runh	0.003	0.000	0.010		0.003	|--
X-value_Intersection1Plane-Plane	X	-51.753	-51.800	0.150	-0.150	0.047	|--
X-Value_Intersection3D Line-Circle	X	-16.346	-16.316	0.100	-0.100	-0.031	--|
Z-value_Intersection Plane-Cyl1Alignment2	Z	-33.061	-33.098	0.150	-0.150	0.037	|-
Y-Wert_IntersectionPlane-Circle1Alignment2	Y	17.490	17.466	0.100	-0.100	0.024	|-
Z-value_Intersection Plane-Cyl	Z	-33.067	-33.100	0.150	-0.150	0.033	|-
X-value_Intersection 3D Line-Plane	X	-9.595	-9.378	1.000	-1.000	-0.217	-|
Diameter_cone with two Probes	D	15.021	15.000	0.100	-0.100	0.021	|-
2-D Polar Distance1	Dist2d	21.021	21.000	0.100	-0.100	0.021	|-
X-Value_Intersection3D Line-Circle1Alignment2	X	-56.536	-56.507	0.150	-0.150	-0.029	-|
Roundness2(2)	Runh	0.002	0.000	0.010		0.002	|-
X-Value_Intersection 2D-Line-2D-Line1Alignment1	X	-28.166	-28.183	0.100	-0.100	0.017	|-
X-Value_Intersection 2D-Line-2D-Line	X	12.024	12.008	0.100	-0.100	0.016	|-
Diameter_Minimum2	D	11.985	12.000	0.100	-0.100	-0.015	-|
X-Value_IntersectionCircle-Circle	X	-7.915	-7.900	0.100	-0.100	-0.015	-|
X-value_Intersection 3D Line-Plane1Alignment2	X	-49.787	-49.572	1.500	-1.500	-0.215	-|
Radius_Radius-Point1	R	15.067	15.200	1.000	-1.000	-0.133	-|
Diameter2(2)	D	6.006	6.000	0.050	-0.050	0.006	|-
X-Value_IntersectionPlane-Cone	X	-0.006	0.000	0.050	-0.050	-0.006	-|
X-value_IntersectionCircle-Circle1Alignment2	X	-48.104	-48.091	0.150	-0.150	-0.013	-|
Durchmesser_Average2	D	11.992	12.000	0.100	-0.100	-0.008	-|
Y-value2	Y	6.892	6.900	0.100	-0.100	-0.008	-|
DiamToPRecal	D	54.989	55.000	0.150	-0.150	-0.011	-|
Radius1^4	R	5.962	6.000	0.500	-0.500	-0.038	-|
Radius1^2	R	6.035	6.000	0.500	-0.500	0.035	|-
Roundness1(4)	Runh	0.001	0.000	0.010		0.001	|
Z-value_Projection1	Z	-33.091	-33.100	0.150	-0.150	0.009	|-
X-Value_Intersection3D-Line-Cone	X	-0.003	0.000	0.050	-0.050	-0.003	-|
Z-Value_Point1withRef.Probe	Z	-10.005	-10.000	0.100	-0.100	-0.005	-|
Z-value_IntersectionPerpendicular-Plane1Alignment2	Z	-33.099	-33.091	0.150	-0.150	-0.008	-|
Cartesian Distance1	DistKart	25.005	25.000	0.100	-0.100	0.005	|-

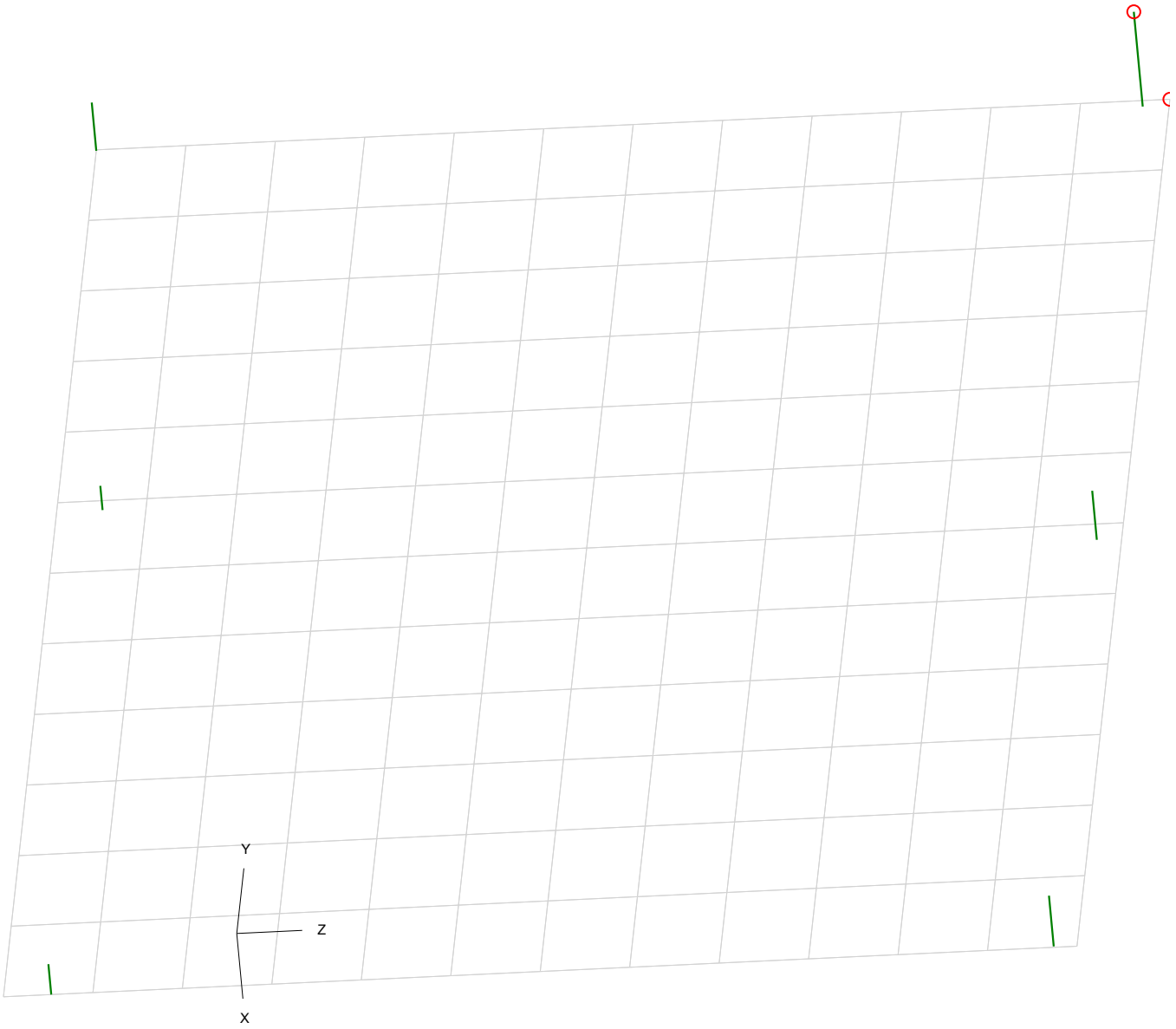
WName mein_block | Datum 24. Februar 2022

Prüfer Master | Blatt 3 | Uhrzeit 11:23:05

Name	id	actual	nominal	pos tol	neg tol	diff	<--|-->
Roundness1(3)	Runh	0.000	0.000	0.010		0.000	|
Diameter_Maximum1	D	12.004	12.000	0.100	-0.100	0.004	|-
Point spacing1	PktAbst	-0.003	0.000	0.101	-0.100	-0.003	-|
Roundness1(2)	Runh	0.000	0.000	0.010		0.000	|
Radius1^1	R	5.985	6.000	0.500	-0.500	-0.015	-|
X-value_IntersectionPlane-Cone1Alignment2	X	-40.195	-40.191	0.150	-0.150	-0.004	-|
Y-Wert_IntersectionPlane-Circle	Y	-14.643	-14.641	0.100	-0.100	-0.003	-|
Z-value_Perpendicular1	Z	-33.098	-33.100	0.150	-0.150	0.002	|-
X-Value_Intersection 2D-Line-Plane1	X	-28.164	-28.166	0.100	-0.100	0.001	|
X-Value_Intersection3D-Line-Cone1Alignment2	X	-40.194	-40.191	0.300	-0.300	-0.003	-|
X-value_Intersection3D-Line-Cyl1Alignment2	X	-40.190	-40.191	0.150	-0.150	0.002	|-
X-value_Intersection3D-3DLine1Alignment2	X	-40.190	-40.191	0.150	-0.150	0.002	|-
Z-Value_IntersectionPerpendicular-Plane	Z	-33.099	-33.100	0.150	-0.150	0.001	|
Radius Two1	R2	7.457	7.450	1.000	-1.000	0.007	|-
Radius1^3	R	6.003	6.000	0.500	-0.500	0.003	|-
X-Value_Intersection 2D-Line-Plane	X	12.025	12.025	0.100	-0.100	0.000	|
X-Value_Intersection3D-3DLine	X	0.000	0.000	0.050	-0.050	0.000	|
Curve form1 Toleranzform: Standard	KurvForm	0.089	0.000	0.500	-0.500	0.089	|-
X-Value_Intersection3D-Line-Cyl	X	0.000	0.000	0.030	-0.030	0.000	|
Curve form2 Toleranzform: Standard	KurvForm	0.314	0.000	0.200	-0.200	0.314	|-

Calypso 7.0.20	Carl Zeiss	Datum	24. Februar 2022
		Auftrag	1
Teil-Nummer 9	KMG-Typ Prismo	Zeichnungsnummer 321654987 v 24	Abteilung:
		Prüfer	Master
		Unterschrift:	
Prüfplanname mein_block			

1: Flatness1



10 µm
1000 : 1

Nr	Bezeichnung	Istwert [mm]	Toleranz [mm]	Anzahl Punkte	Vmess [mm/s]	Tasterradius [mm]	F.Typ	L-C	W/U
1	Flatness1	0,018	0,005	9	0.00	0,000			