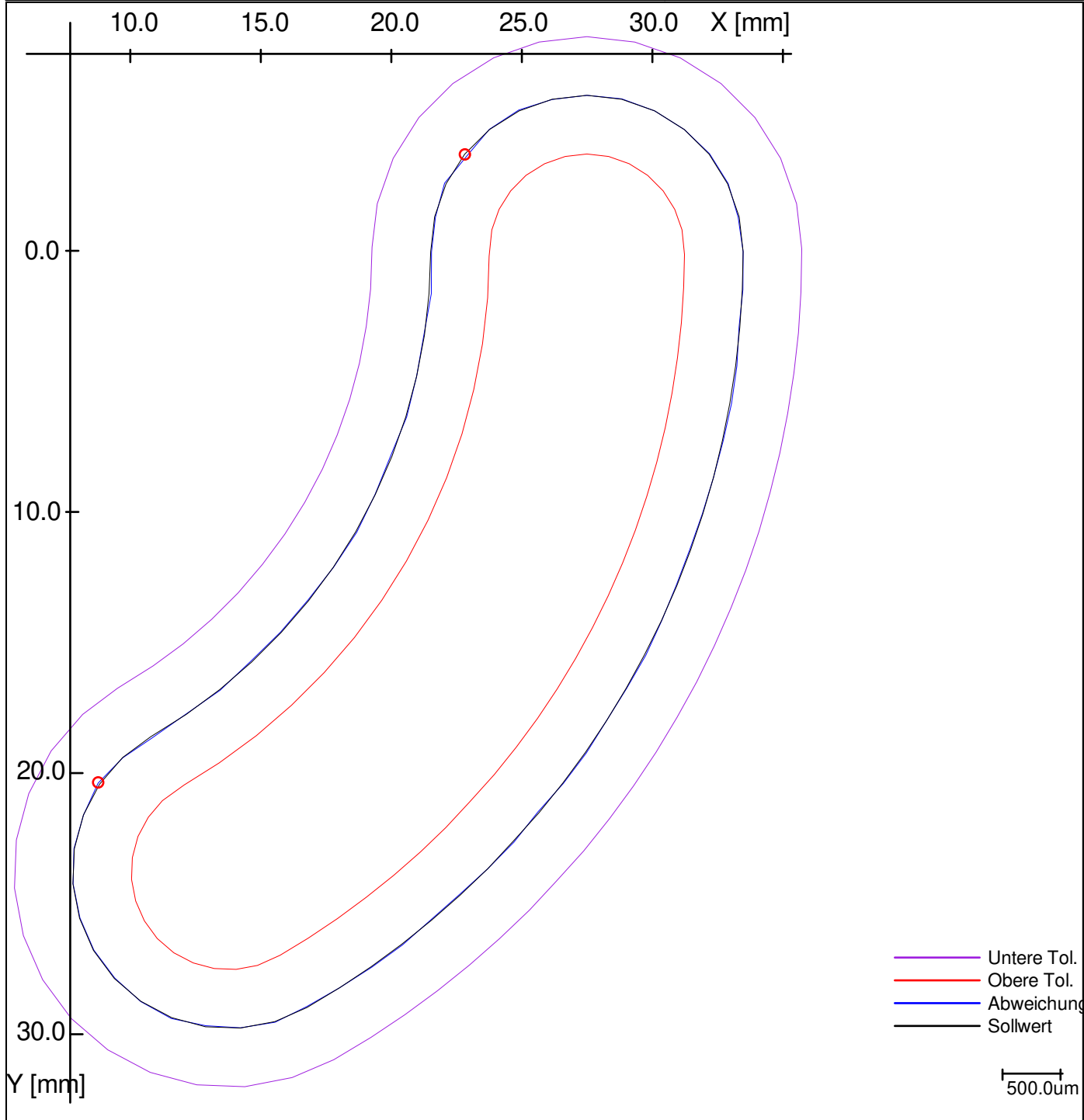
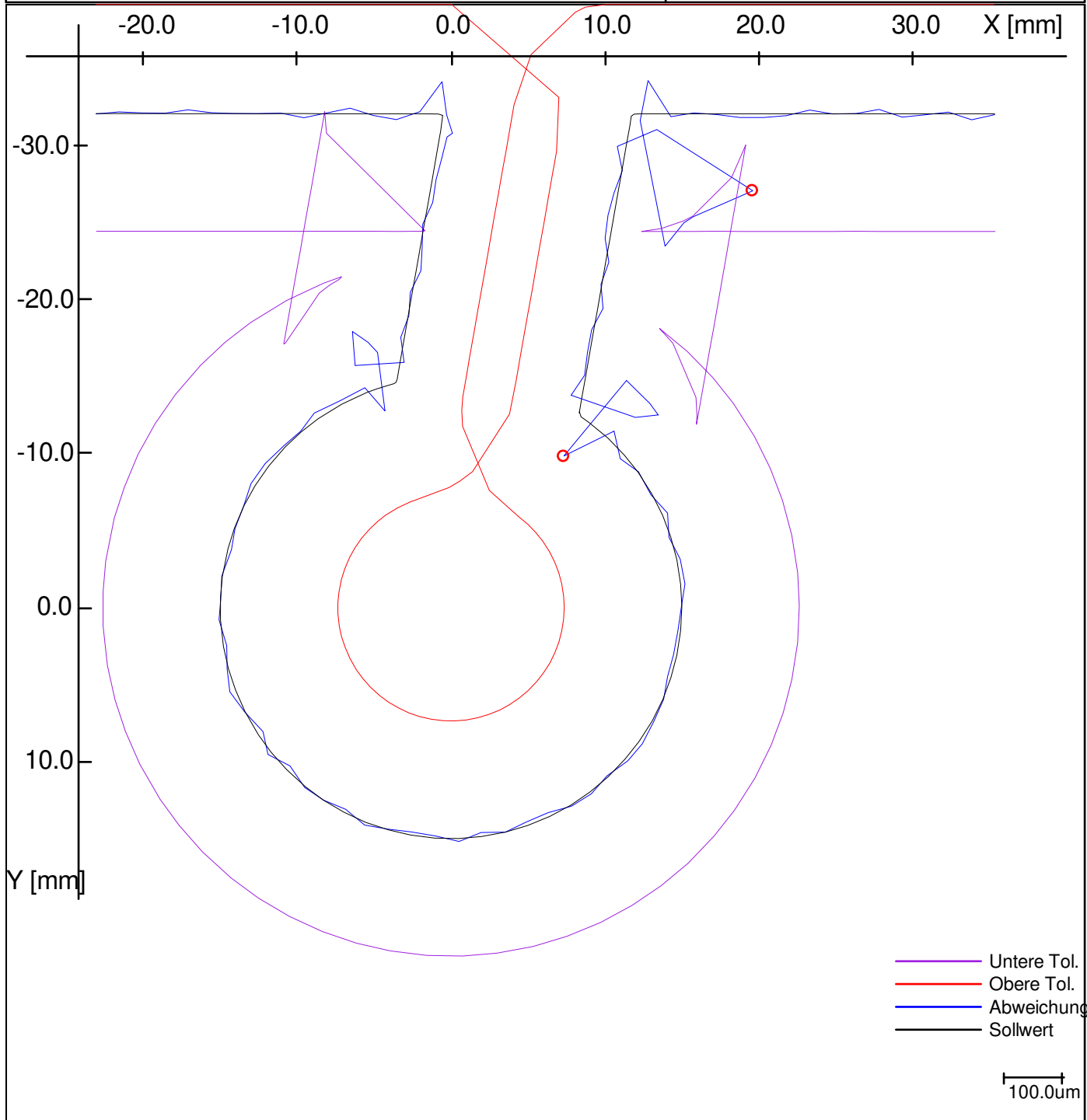


 Calypso 7.2.0401		Carl Zeiss		Datum 20. Dezember 2021	
				Auftrag 1	
Teil-Nummer 9		KMG-Typ Prismo		Zeichnungsnummer 321654987 v 24	
				Abteilung: Prüfer Unterschrift:	
				Master	
Prüfplan mein_block				Curve form1	



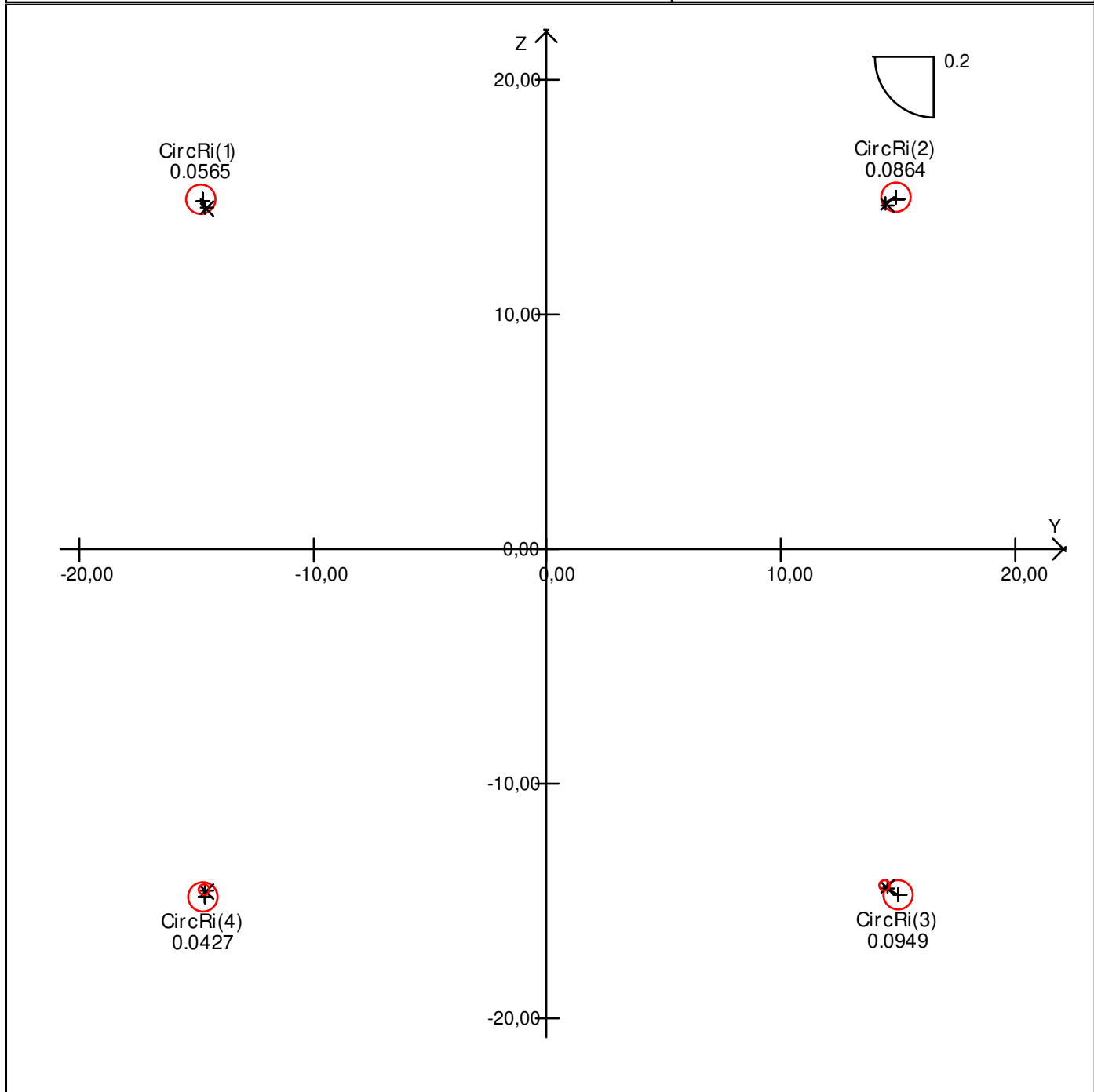
Einpassergebnis		Translation	Rotation	Überhöhung					20
		X	0.000	0.000	Kommentar				
		Y	0.000	0.000					
		Z	0.000	0.000					
Sigma	Form	Anzahl	Untere Tol.	Obere Tol.	MinInd	Min Abweich.	MaxInd	Max Abweich.	
0,008	0,039	66	-0,500	0,500	17	-0,016	64	0,024	

		Calypso 7.2.0401		Carl Zeiss		Datum Auftrag		20. Dezember 2021 1	
Teil-Nummer 9		KMG-Typ Prismo		Zeichnungsnummer 321654987 v 24		Abteilung: Prüfer Unterschrift: Master			
Prüfplan mein_block						Curve form2			



Einpassergebnis				Translation		Rotation		Überhöhung		100		
X				0.000		0.000		Kommentar				
Y				0.000		0.000						
Z				0.000		0.000						
Sigma		Form		Anzahl	Untere Tol.		Obere Tol.		MinInd	Min Abweich.	MaxInd	Max Abweich.
0,049		0,314		124	-0,200		0,200		104	-0,242	86	0,071

		Calypso 7.2.0401	<h1>Carl Zeiss</h1>		Datum 20. Dezember 2021
					Auftrag 1
Teil-Nummer 9	KMG-Typ Prismo	Zeichnungsnummer 321654987 v 24		Abteilung: Prüfer Master	
Prüfplan mein_block				best Fit of bore pattern	



Best Fit4		Y	-0.034	Überhöhung		50			
Gauß-2d-Einpassung		Z Winkel	-0.011 -0.002						
Nr	Bezeichnung	Istwert	Toleranz	Anzahl Pu	Vmess	Tasterradiu	F.Typ	L-C	W/U
1	best Fit of bore pattern^1	0,056	0,100						
2	best Fit of bore pattern^2	0,086	0,100						
3	best Fit of bore pattern^3	0,095	0,100						
4	best Fit of bore pattern^4	0,043	0,100						

# Messprotokoll ZEISS Calypso



WName  
mein\_block

Datum  
20. Dezember 2021

Zeichnungsnummer  
321654987 v 24

Auftrag  
1

Uhrzeit  
07:03:40

Prüfer  
Master

Teilnummer inkremental  
9

KMG  
Simulation

Blatt von  
1 3

Name	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
Feature Angle_Angle point	EIWi	1.735	1.745	0.007	-0.007	-0.010	-0.003
Diameter_Cone Addition1	D	18.497	16.000	0.100	-0.100	2.497	2.397
Angle1	W	2.269	2.269	0.001	-0.001	0.000	----
Angle Of Rotation1	DrehWi	3.141	3.142	0.001	-0.001	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 One1	W1	-0.698	-0.698	0.002	-0.002	0.000	----
Coaxiality1	Koa	0.388	0.000	0.060		0.388	0.328
Angle Two1	W2	-0.523	-0.524	0.002	-0.002	0.000	----
Axial Runout1	Plan	0.225	0.000	0.050		0.225	0.175
Cone Angle1	WK	0.524	0.524	0.009	-0.009	0.001	----
Perpendicularity1	Rec	0.124	0.000	0.030		0.124	0.094
Straightness1	Ger	0.007	0.000	0.002		0.007	0.005
Flatness1	Ebe	0.017	0.000	0.005		0.017	0.012
Projection Angle One_Offset Plane1	W1	0.000	0.000	0.002	-0.002	0.000	----
Cylindricity1	Zyl	0.010	0.000	0.007		0.010	0.003
Roundness1(1)	Runh	0.014	0.000	0.010		0.014	0.004
Roundness1(3)	Runh	0.014	0.000	0.010		0.014	0.004
Angularity1	Nei	0.019	0.000	0.015		0.019	0.004
Form1	Form	0.007	0.000	0.006		0.007	0.001
Diameter_circle on cone	D	27.303	27.200	0.100	-0.100	0.103	0.003
True Position1	Po2d	0.477	0.000	0.500		0.477	----
best Fit of bore pattern^3	Po2d	0.095	0.000	0.100		0.095	----
Concentricity1	Kon	0.850	0.000	0.900		0.850	----
best Fit of bore pattern^2	Po2d	0.086	0.000	0.100		0.086	----
Diameter1	D	30.184	30.000	0.200	0.000	0.184	----
Angle of Inclination1	KippWi	0.698	0.698	0.017	-0.017	0.000	----
Z-value_Intersection Cyl-Cyl1Alignment2	Z	-33.219	-33.096	0.150	-0.150	-0.123	----
Z-value_IntersectionCon-Cyl1Alignment2	Z	-33.219	-33.096	0.150	-0.150	-0.123	----
Diameter Two1	D2	14.925	15.000	0.150	-0.100	-0.075	----
Radial Runout1	Runl	0.385	0.000	0.500		0.385	----
Diameter2(1)	D	6.038	6.000	0.050	-0.050	0.038	----
Diameter2(3)	D	6.037	6.000	0.050	-0.050	0.037	---
Z-Value_Intersection Cyl-Cyl	Z	-33.211	-33.100	0.150	-0.150	-0.111	---
Z-Value_IntersectionCon-Cyl	Z	-33.211	-33.100	0.150	-0.150	-0.111	---



Name	id	actual	nominal	pos tol	neg tol	diff	<-- -->
Parallelism1	Par	0.044	0.000	0.060		0.044	---
Roundness1(2)	Runh	0.006	0.000	0.010		0.006	---
Roundness2(2)	Runh	0.006	0.000	0.010		0.006	---
best Fit of bore pattern^1	Po2d	0.056	0.000	0.100		0.056	---
GDT Symmetrie1	Sym	0.110	0.000	0.200		0.110	---
Diameter2(2)	D	6.023	6.000	0.050	-0.050	0.023	--
X-value1	X	-9.733	-9.800	0.150	-0.150	0.067	--
best Fit of bore pattern^4	Po2d	0.043	0.000	0.100		0.043	--
3-D Polar Distance1	Dist3d	33.438	33.500	0.150	-0.150	-0.062	--
Y-Wert_IntersectionPlane-Circle1Alignment2	Y	17.507	17.466	0.100	-0.100	0.041	--
Roundness1(4)	Runh	0.004	0.000	0.010		0.004	--
Roundness2(1)	Runh	0.004	0.000	0.010		0.004	--
Roundness2(4)	Runh	0.004	0.000	0.010		0.004	--
Diameter_cone with two Probes	D	15.034	15.000	0.100	-0.100	0.034	--
Z-value1	Z	-33.068	-33.000	0.200	-0.200	-0.068	--
X-Value_Intersection3D Line-Circle	X	-16.342	-16.316	0.100	-0.100	-0.026	--
X-value_Intersection1Plane-Plane	X	-51.762	-51.800	0.150	-0.150	0.038	--
Z-value_Intersection Plane-Cyl	Z	-33.067	-33.100	0.150	-0.150	0.033	-
Roundness2(3)	Runh	0.002	0.000	0.010		0.002	-
Z-value_Intersection Plane-Cyl1Alignment2	Z	-33.067	-33.098	0.150	-0.150	0.031	-
X-value_Intersection 3D Line-Plane	X	-9.575	-9.378	1.000	-1.000	-0.197	-
Diameter2(4)	D	6.010	6.000	0.050	-0.050	0.010	-
Y-value1	Y	-32.025	-32.000	0.150	-0.150	-0.025	-
X-Value_IntersectionCircle-Circle	X	-7.917	-7.900	0.100	-0.100	-0.017	-
Distance1	Dist	78.003	78.000	0.020	-0.020	0.003	-
Diameter_Minimum2	D	11.984	12.000	0.100	-0.100	-0.016	-
X-Value_Intersection 2D-Line-Plane	X	12.009	12.025	0.100	-0.100	-0.016	-
X-Value_Intersection3D Line-Circle1Alignment2	X	-56.527	-56.507	0.150	-0.150	-0.021	-
Durchmesser_Average2	D	11.986	12.000	0.100	-0.100	-0.014	-
X-Value_IntersectionPlane-Cone	X	-0.006	0.000	0.050	-0.050	-0.006	-
Radius_Radius-Point1	R	15.074	15.200	1.000	-1.000	-0.126	-
X-value_Intersection 3D Line-Plane1Alignment2	X	-49.760	-49.572	1.500	-1.500	-0.187	-
X-Value_Intersection 2D-Line-Plane1	X	-28.177	-28.166	0.100	-0.100	-0.011	-
Diameter_Maximum1	D	11.989	12.000	0.100	-0.100	-0.011	-
X-value_IntersectionCircle-Circle1Alignment2	X	-48.103	-48.091	0.150	-0.150	-0.012	-
Z-Value_Point1withRef.Probe	Z	-9.992	-10.000	0.100	-0.100	0.008	-
Radius1^4	R	5.965	6.000	0.500	-0.500	-0.035	-
2-D Polar Distance1	Dist2d	21.007	21.000	0.100	-0.100	0.007	-
Cartesian Distance1	DistKart	24.993	25.000	0.100	-0.100	-0.007	-
Radius1^2	R	6.034	6.000	0.500	-0.500	0.034	-
DiamToPRecal	D	54.992	55.000	0.150	-0.150	-0.008	-
X-Value_Intersection3D-Line-Cone	X	-0.003	0.000	0.050	-0.050	-0.003	-



Name	id	actual	nominal	pos tol	neg tol	diff	<-- -->
Y-Wert_IntersectionPlane-Circle	Y	-14.636	-14.641	0.100	-0.100	0.005	-
X-Value_Intersection 2D-Line-2D-Line1Alignment1	X	-28.179	-28.183	0.100	-0.100	0.004	-
Z-value_Projection1	Z	-33.106	-33.100	0.150	-0.150	-0.006	-
Z-value_IntersectionPerpendicular-Plane1Alignment2	Z	-33.096	-33.091	0.150	-0.150	-0.006	-
X-value_Intersection3D-Line-Cyl1Alignment2	X	-40.186	-40.191	0.150	-0.150	0.005	-
X-value_Intersection3D-3DLine1Alignment2	X	-40.186	-40.191	0.150	-0.150	0.005	-
Y-value2	Y	6.897	6.900	0.100	-0.100	-0.003	-
Z-Value_IntersectionPerpendicular-Plane	Z	-33.096	-33.100	0.150	-0.150	0.004	-
Radius1^1	R	5.992	6.000	0.500	-0.500	-0.008	-
Radius Two1	R2	7.463	7.450	1.000	-1.000	0.013	-
X-value_IntersectionPlane-Cone1Alignment2	X	-40.192	-40.191	0.150	-0.150	-0.001	
X-Value_Intersection 2D-Line-2D-Line	X	12.007	12.008	0.100	-0.100	-0.001	
Radius1^3	R	5.998	6.000	0.500	-0.500	-0.002	-
Z-value_Perpendicular1	Z	-33.100	-33.100	0.150	-0.150	0.000	
Point spacing1	PktAbst	0.000	0.000	0.101	-0.100	0.000	
X-Value_Intersection3D-Line-Cone1Alignment2	X	-40.191	-40.191	0.300	-0.300	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 form1 Toleranzform: Standard	KurvForm	0.039	0.000	0.500	-0.500	0.039	-
Curve form2 Toleranzform: Standard	KurvForm	0.314	0.000	0.200	-0.200	0.314	-



Calypso  
7.2.0401

Carl Zeiss

Datum  
Auftrag

20. Dezember 2021  
1

Teil-Nummer  
9

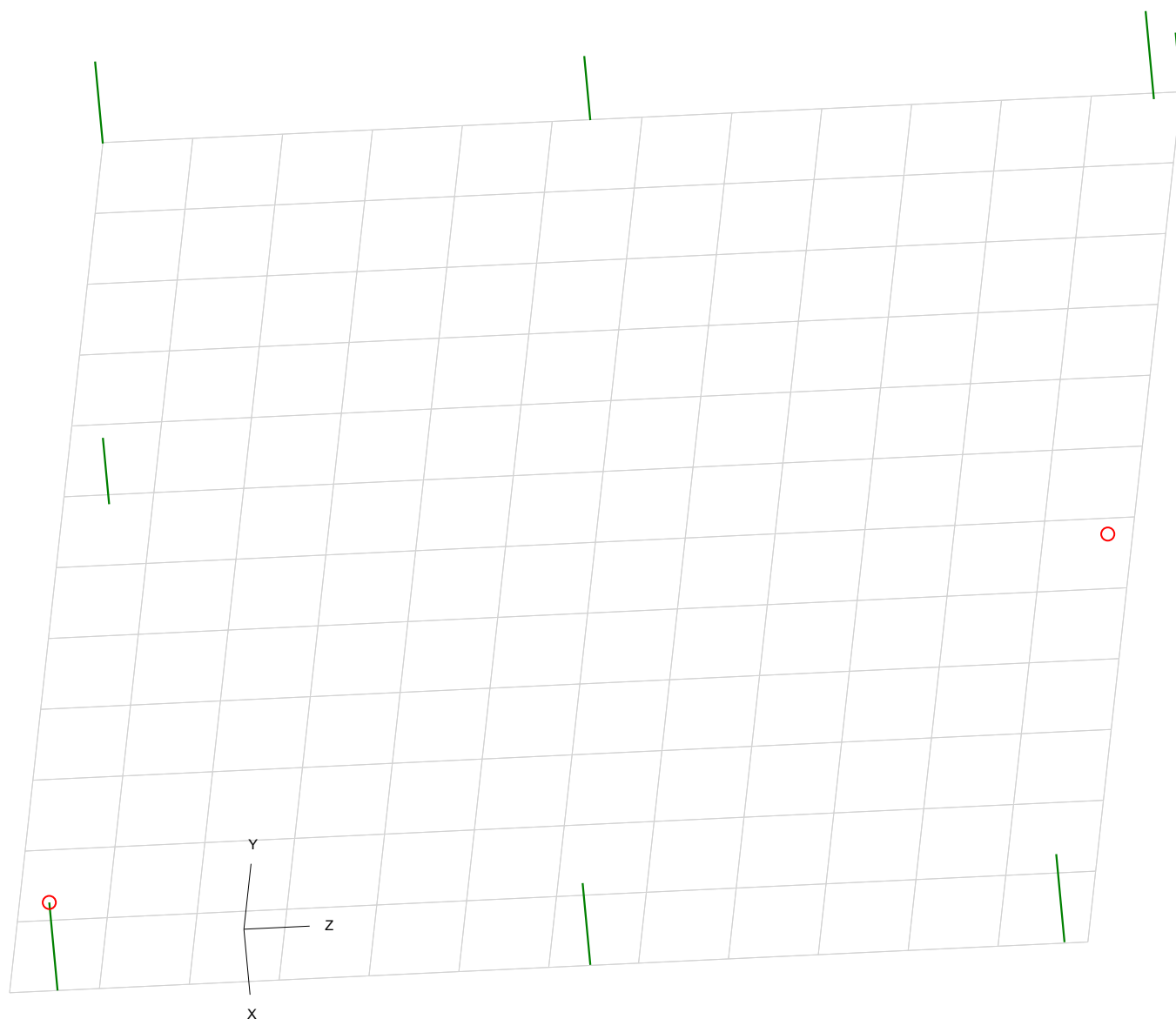
KMG-Typ  
Prismo

Zeichnungsnummer  
321654987 v 24

Abteilung:  
Prüfer  
Unterschrift: Master

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	0,017	0,005	9	0.00	0,000			