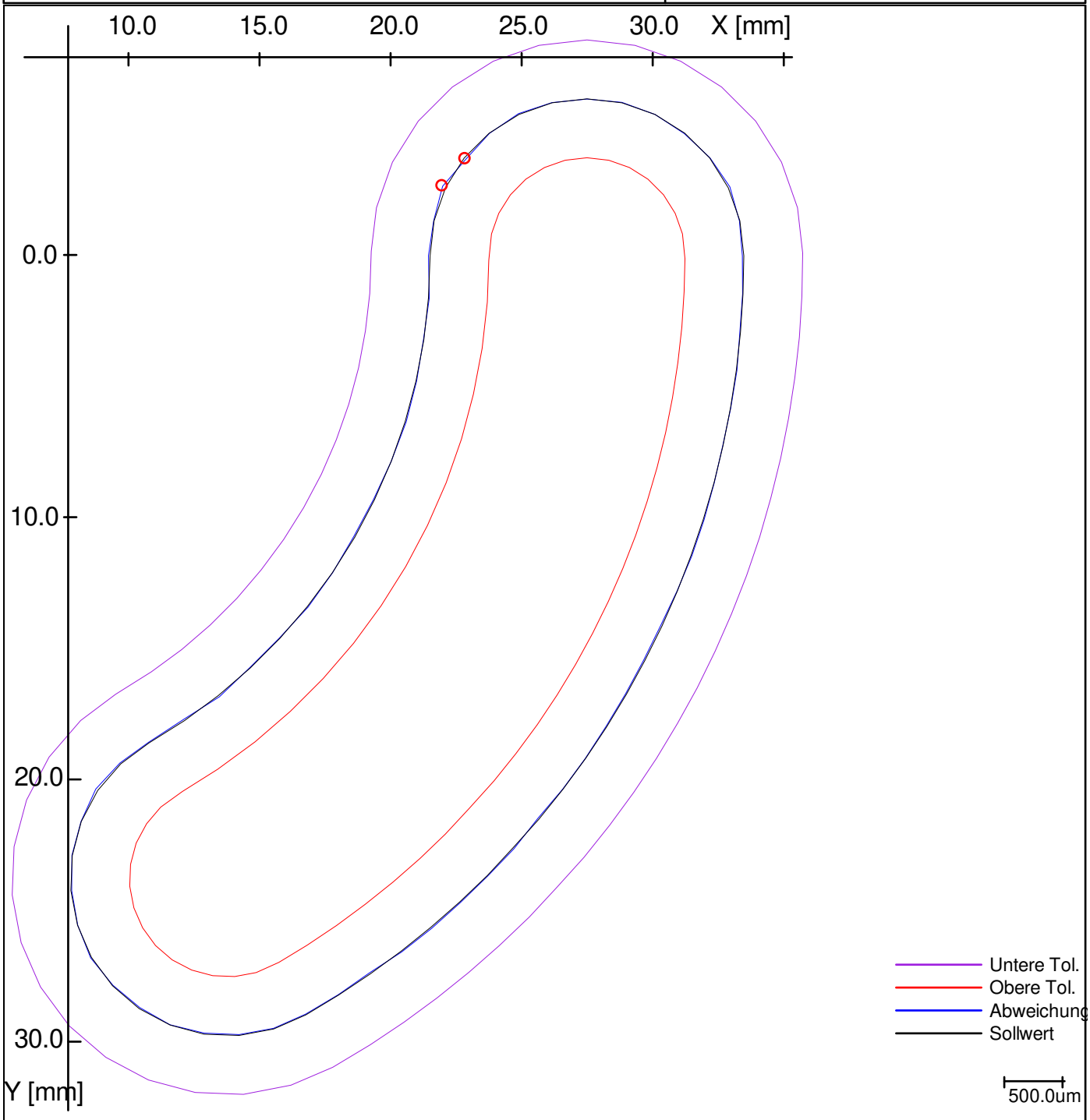
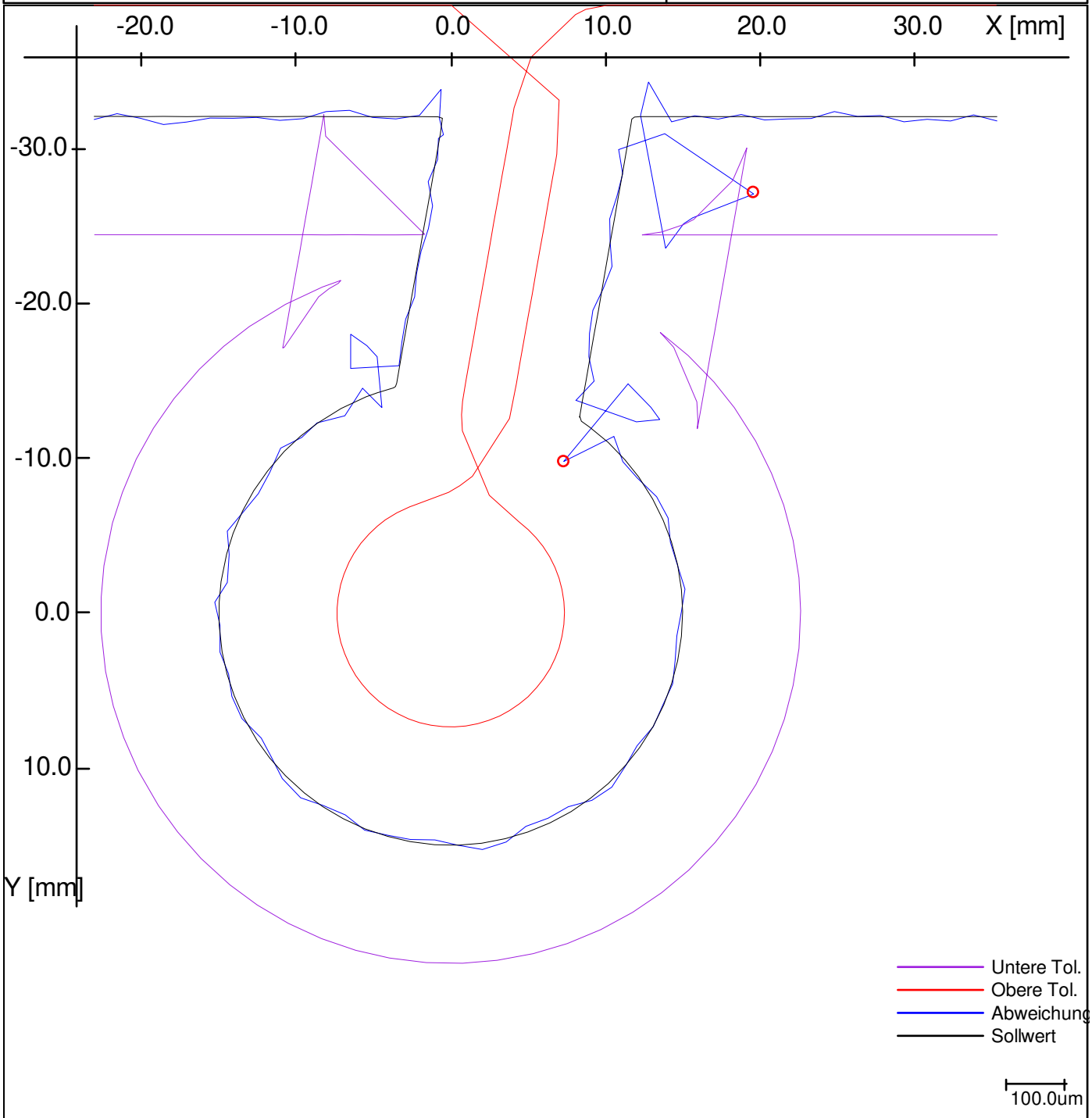
ZEISS Calypso 7.0.20	Carl Zeiss	Datum 24. Februar 2022 Auftrag 1	
		Abteilung: Prüfer Master Unterschrift:	
Teil-Nummer 7	KMG-Typ Prismo	Zeichnungsnummer 321654987 v 24	
Prüfplan mein_block		Curve form1	



		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.
0,009	0,047	66	-0,500	0,500	65	-0,029	64	0,018

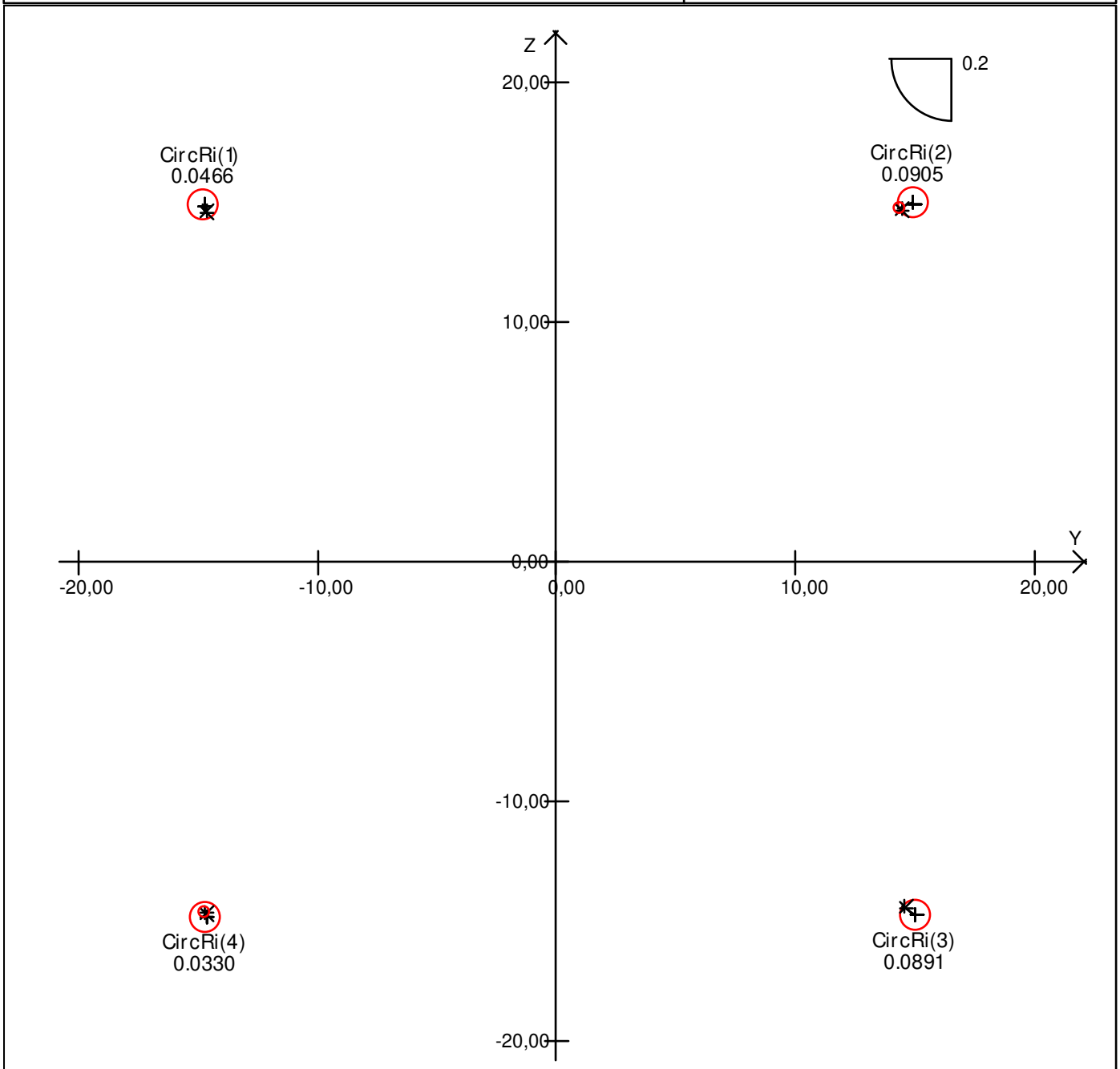
ZEISS Calypso 7.0.20	Carl Zeiss	Datum 24. Februar 2022 Auftrag 1	
Teil-Nummer 7	KMG-Typ Prismo	Zeichnungsnummer 321654987 v 24	Abteilung: Prüfer Master Unterschrift:
Prüfplan mein_block			Curve form2



		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.
0,049	0,315	124	-0,200	0,200	104	-0,242	86	0,073

ZEISS Calypso 7.0.20	Carl Zeiss	Datum 24. Februar 2022 Auftrag 1	
Teil-Nummer 7	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	-0.040 0.004 -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	0,047	0,100						
2	best Fit of bore pattern^2	0,091	0,100						
3	best Fit of bore pattern^3	0,089	0,100						
4	best Fit of bore pattern^4	0,033	0,100						

Messprotokoll ZEISS Calypso

WName
mein_block

Datum
24. Februar 2022

Zeichnungsnummer
321654987 v 24

Auftrag
1

Uhrzeit
11:22:31

Prüfer
Master

Teilnummer inkremental
7

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	-0.010	-0.003
Diameter_Cone Addition1	D	18.512	16.000	0.100	-0.100	2.512	2.412
Angle1	W	2.269	2.269	0.001	-0.001	0.000	----|
Angle1betweenCirc	W	1.284	1.285	0.002	-0.002	0.000	----|
Angle One1	W1	-0.698	-0.698	0.002	-0.002	0.000	|----
Angle Of Rotation1	DrehWi	3.141	3.142	0.001	-0.001	0.000	----|
Angle Two1	W2	-0.524	-0.524	0.002	-0.002	0.000	----|
Projection Angle One_Offset Plane1	W1	0.000	0.000	0.002	-0.002	0.000	----|
Straightness1	Ger	0.014	0.000	0.002		0.014	0.012
Projection Angle Two_Offset Plane1	W2	0.000	0.000	0.001	-0.001	0.000	----|
Coaxiality1	Koa	0.324	0.000	0.060		0.324	0.264
Perpendicularity1	Rec	0.111	0.000	0.030		0.111	0.081
Axial Runout1	Plan	0.181	0.000	0.050		0.181	0.131
Cylindricity1	Zyl	0.016	0.000	0.007		0.016	0.009
Cone Angle1	WK	0.523	0.524	0.009	-0.009	0.000	----|
Flatness1	Ebe	0.009	0.000	0.005		0.009	0.004
Angle of Inclination1	KippWi	0.698	0.698	0.017	-0.017	0.000	----|
Roundness1(3)	Runh	0.015	0.000	0.010		0.015	0.005
Distance1	Dist	78.030	78.000	0.020	-0.020	0.030	0.010
Roundness2(3)	Runh	0.014	0.000	0.010		0.014	0.004
Y-value1	Y	-32.211	-32.000	0.150	-0.150	-0.211	-0.061
Form1	Form	0.008	0.000	0.006		0.008	0.002
Diameter_circle on cone	D	27.319	27.200	0.100	-0.100	0.119	0.019
Roundness2(4)	Runh	0.011	0.000	0.010		0.011	0.001
Angularity1	Nei	0.016	0.000	0.015		0.016	0.001
Parallelism1	Par	0.059	0.000	0.060		0.059	|----
True Position1	Po2d	0.482	0.000	0.500		0.482	|----
Concentricity1	Kon	0.842	0.000	0.900		0.842	|----
GDT Symmetrie1	Sym	0.185	0.000	0.200		0.185	|----
best Fit of bore pattern^2	Po2d	0.091	0.000	0.100		0.091	|----
best Fit of bore pattern^3	Po2d	0.089	0.000	0.100		0.089	|----
Diameter1	D	30.182	30.000	0.200	0.000	0.182	|----
Diameter Two1	D2	14.924	15.000	0.150	-0.100	-0.076	----|
Roundness2(1)	Runh	0.007	0.000	0.010		0.007	|---
Radial Runout1	Runl	0.319	0.000	0.500		0.319	|---

WName mein_block | Datum 24. Februar 2022

Prüfer Master | Blatt 2 | Uhrzeit 11:22:31

Name	id	actual	nominal	pos tol	neg tol	diff	<--|-->
Z-Value_Intersection Cyl-Cyl	Z	-33.018	-33.100	0.150	-0.150	0.082	|---
Z-Value_IntersectionCon-Cyl	Z	-33.018	-33.100	0.150	-0.150	0.082	|---
Diameter2(3)	D	6.026	6.000	0.050	-0.050	0.026	|---
Z-value_Intersection Cyl-Cyl1Alignment2	Z	-33.020	-33.096	0.150	-0.150	0.076	|---
Z-value_IntersectionCon-Cyl1Alignment2	Z	-33.020	-33.096	0.150	-0.150	0.076	|---
X-value1	X	-9.726	-9.800	0.150	-0.150	0.074	|--
best Fit of bore pattern^1	Po2d	0.047	0.000	0.100		0.047	|--
Roundness2(2)	Runh	0.004	0.000	0.010		0.004	|--
Diameter2(4)	D	6.019	6.000	0.050	-0.050	0.019	|--
Z-value1	Z	-33.075	-33.000	0.200	-0.200	-0.075	--|
Diameter2(2)	D	6.018	6.000	0.050	-0.050	0.018	|--
X-Value_Intersection3D Line-Circle	X	-16.351	-16.316	0.100	-0.100	-0.035	--|
Roundness1(2)	Runh	0.003	0.000	0.010		0.003	|--
best Fit of bore pattern^4	Po2d	0.033	0.000	0.100		0.033	|--
Diameter2(1)	D	6.016	6.000	0.050	-0.050	0.016	|--
Roundness1(1)	Runh	0.003	0.000	0.010		0.003	|--
3-D Polar Distance1	Dist3d	33.459	33.500	0.150	-0.150	-0.041	--|
X-Value_Intersection3D Line-Circle1Alignment2	X	-56.546	-56.507	0.150	-0.150	-0.040	--|
Diameter_cone with two Probes	D	15.024	15.000	0.100	-0.100	0.024	|-
X-value_Intersection1Plane-Plane	X	-51.763	-51.800	0.150	-0.150	0.037	|-
Y-Wert_IntersectionPlane-Circle1Alignment2	Y	17.489	17.466	0.100	-0.100	0.023	|-
X-Value_IntersectionPlane-Cone	X	-0.011	0.000	0.050	-0.050	-0.011	-|
Z-value_Intersection Plane-Cyl1Alignment2	Z	-33.066	-33.098	0.150	-0.150	0.032	|-
Cartesian Distance1	DistKart	24.979	25.000	0.100	-0.100	-0.021	-|
X-Value_IntersectionCircle-Circle	X	-7.919	-7.900	0.100	-0.100	-0.019	-|
X-Value_Intersection3D-Line-Cone	X	-0.009	0.000	0.050	-0.050	-0.009	-|
X-value_Intersection 3D Line-Plane	X	-9.559	-9.378	1.000	-1.000	-0.181	-|
Diameter_Minimum2	D	11.983	12.000	0.100	-0.100	-0.017	-|
Z-value_Intersection Plane-Cyl	Z	-33.075	-33.100	0.150	-0.150	0.025	|-
X-Value_Intersection 2D-Line-Plane1	X	-28.181	-28.166	0.100	-0.100	-0.016	-|
Z-Value_IntersectionPerpendicular-Plane	Z	-33.077	-33.100	0.150	-0.150	0.023	|-
X-value_IntersectionCircle-Circle1Alignment2	X	-48.114	-48.091	0.150	-0.150	-0.023	-|
2-D Polar Distance1	Dist2d	21.013	21.000	0.100	-0.100	0.013	|-
Durchmesser_Average2	D	11.987	12.000	0.100	-0.100	-0.013	-|
X-value_Intersection 3D Line-Plane1Alignment2	X	-49.757	-49.572	1.500	-1.500	-0.185	-|
Radius_Radius-Point1	R	15.085	15.200	1.000	-1.000	-0.115	-|
X-Value_Intersection 2D-Line-Plane	X	12.014	12.025	0.100	-0.100	-0.011	-|
X-value_IntersectionPlane-Cone1Alignment2	X	-40.206	-40.191	0.150	-0.150	-0.015	-|
Diameter_Maximum1	D	11.991	12.000	0.100	-0.100	-0.009	-|
Z-value_IntersectionPerpendicular-Plane1Alignment2	Z	-33.077	-33.091	0.150	-0.150	0.014	|-
Y-value2	Y	6.892	6.900	0.100	-0.100	-0.008	-|
Radius1^4	R	5.964	6.000	0.500	-0.500	-0.036	-|

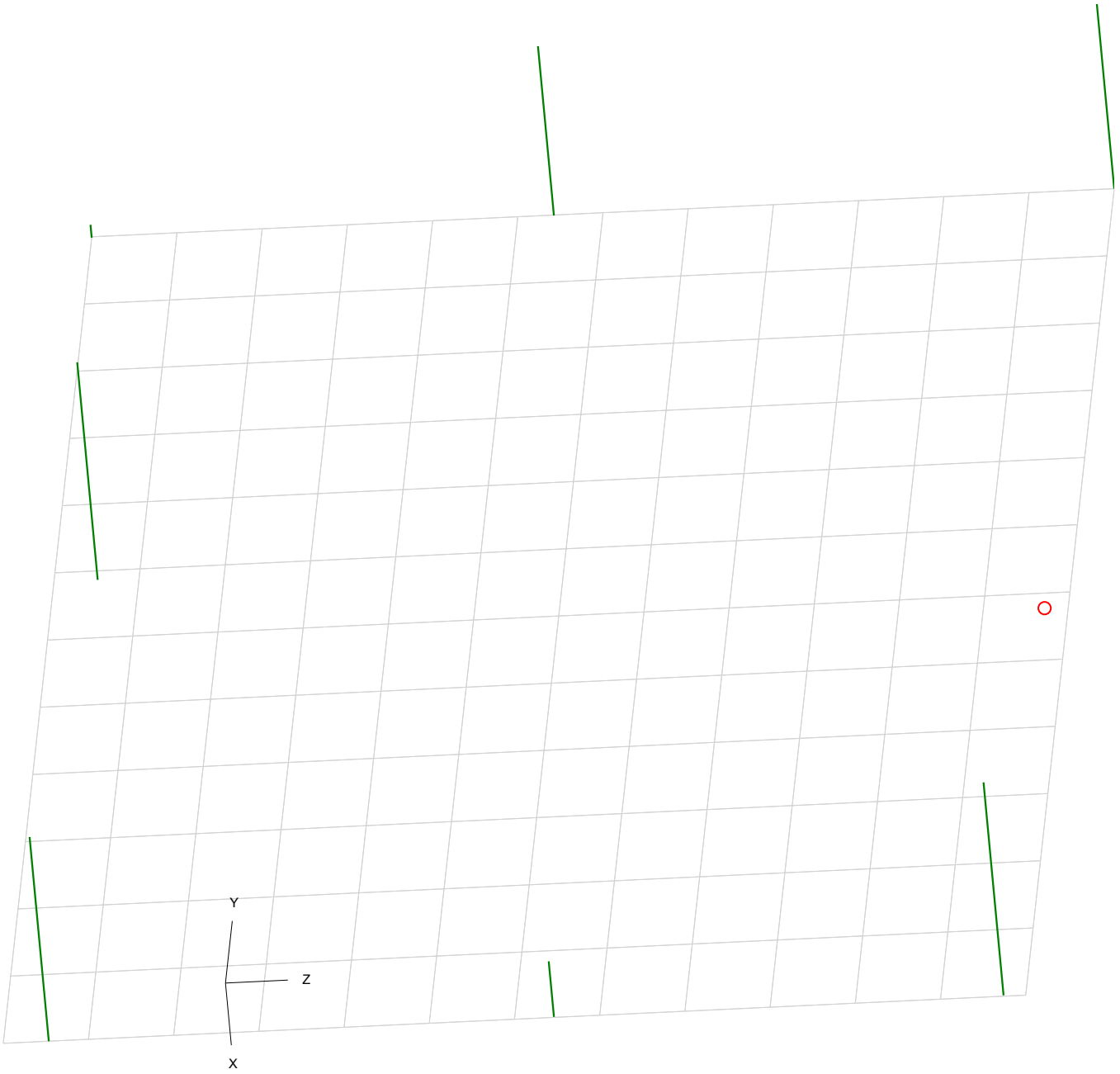
WName mein_block | Datum 24. Februar 2022

Prüfer Master | Blatt 3 | Uhrzeit 11:22:31

Name	id	actual	nominal	pos tol	neg tol	diff	<--|-->
Radius1^2	R	6.032	6.000	0.500	-0.500	0.032	|-
Radius1^1	R	5.974	6.000	0.500	-0.500	-0.026	-|
Z-Value_Point1withRef.Probe	Z	-9.995	-10.000	0.100	-0.100	0.005	|-
Z-value_Projection1	Z	-33.095	-33.100	0.150	-0.150	0.005	|-
Radius1^3	R	6.015	6.000	0.500	-0.500	0.015	|-
X-Value_Intersection3D-Line-Cone1Alignment2	X	-40.200	-40.191	0.300	-0.300	-0.008	-|
X-value_Intersection3D-3DLine1Alignment2	X	-40.195	-40.191	0.150	-0.150	-0.004	-|
X-value_Intersection3D-Line-Cyl1Alignment2	X	-40.195	-40.191	0.150	-0.150	-0.004	-|
X-Value_Intersection 2D-Line-2D-Line1Alignment1	X	-28.186	-28.183	0.100	-0.100	-0.002	-|
Point spacing1	PktAbst	-0.002	0.000	0.101	-0.100	-0.002	-|
X-Value_Intersection 2D-Line-2D-Line	X	12.010	12.008	0.100	-0.100	0.002	|-
DiamToPRecal	D	55.003	55.000	0.150	-0.150	0.003	|-
Y-Wert_IntersectionPlane-Circle	Y	-14.643	-14.641	0.100	-0.100	-0.002	-|
Radius Two1	R2	7.462	7.450	1.000	-1.000	0.012	|-
Z-value_Perpendicular1	Z	-33.098	-33.100	0.150	-0.150	0.002	|-
Roundness1(4)	Runh	0.000	0.000	0.010		0.000	|
Curve form1 Toleranzform: Standard	KurvForm	0.047	0.000	0.500	-0.500	0.047	|-
Curve form2 Toleranzform: Standard	KurvForm	0.315	0.000	0.200	-0.200	0.315	|-
X-Value_Intersection3D-Line-Cyl	X	0.000	0.000	0.030	-0.030	0.000	|
X-Value_Intersection3D-3DLine	X	0.000	0.000	0.050	-0.050	0.000	|

ZEISS	Calypso 7.0.20	Carl Zeiss	Datum	24. Februar 2022
			Auftrag	1
Teil-Nummer 7	KMG-Typ Prismo	Zeichnungsnummer 321654987 v 24	Abteilung:	
			Prüfer	Master
			Unterschrift:	
Prüfplanname mein_block				

1: Flatness1



2 µm
5000 : 1

Nr	Bezeichnung	Istwert [mm]	Toleranz [mm]	Anzahl Punkte	Vmess [mm/s]	Tasterradius [mm]	F.Typ	L-C	W/U
1	Flatness1	0,009	0,005	9	0.00	0,000			