PiWeb Reporting Webinar, Calypso 2020





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Agenda

- Om PiWeb
- Exempel på rapporter
- Frågor



Om PiWeb

- En "generisk" programvara
- Fokus på visualisering
- Sedan 2005
- Skalar från en-användare till fler-användare och på flera orter
- PiWeb Reporting är en del av Calypso
- PiWeb Reporting Plus är ett tillägg till Calypso
- Nätverkslösningar tillgängliga





Rapport eller analys?

- PiWeb Reporting är en rapporteringsprogramvara används för att skapa mätprotokoll
- Optionen PiWeb Reporting Plus, lägger till analysfunktionalitet
- Båda mjukvarorna är för en-användare och finns på din mätmaskinsdator eller offlinestation.





Exempel

- PiWeb Reporting en enkel anpassad rapport
- PiWeb Reporting Plus analysera kvalitet
- PiWeb Reporting Plus jämför en uppmätt detalj med referensdetalj
- PiWeb Reporting Plus gör en MSA typ 3
- PiWeb Reporting Plus manuell mätning
- PiWeb Reporting GearPro rapporter







En enkel anpassad rapport, orientering

• Nedskalad rapport med dedikerad information som används för datorinställning eller andra ändamål.



PiWeb Reporting – a simple custom report





En enkel anpassad rapport, skapa

Obs! För att kunna rapportera hållägen måste "additional report" ställs in på ON

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En enkel anpassad rapport, skapa en rapportmall.

- I definitionen av multipelprotokoll
- Välj mallen " New Protocol Landscape ".
- Klicka sedan på pennan för att redigera rapporten
- I användarmeddelandet väljer du alternativet att spara rapporten som specifik för mätplanen.
- Namnge rapporten
- Rapportredigeraren öppnas i nästa steg.



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En enkel anpassad rapport, rapportredigerare

- Klicka, dra och släpp objekt från fliken "dataprovider" på redigeringsytan
- När du släpper objekten på rapportsidan väljer du hur du vill att objektet ska visas
- Exempel: Bild Cad-modell eller General Cad-modell





En enkel anpassad rapport, testa rapporten

Använd uppspelningsknappen för att testa rapporten

En enkel anpassad rapport, information

- Skapas enklast från Calypso
- Kan väljas i PiWeb Reporting Plus (när mätplanen är vald)

PiWeb reporting plus		
6		
CALYPSO inspections	Reports	
Find P	 Inspection reports 	
ACV0818030C_1_PTO_kotelo_S31 200 characteristics, 2 measurements Created 11/24/2020 Modified 1/12/2021 Calypso 2019 PiWeb Calypso Inte 43 characteristics, 1 measurements Created 1/12/2021 Modified 1/12/2021	Image: Sector	
Created 4/13/2021 Modified 4/13/2021	 Generic reports My generic reports 	
Calypso 2020 MSA Type 3 9 characteristics, 50 measurements Created 4/8/2021 Modified 4/12/2021	ADVENTION: 1 PPD Jake, SHOT, MINT, TOOL, 1, SHOT, SHOT	ESS Cappor
Calypso 2020 PiWeb Calypso Inte 44 characteristics, 2 measurements Created 3/16/2021 Modified 3/16/2021	Nonzono Galillo eta Stati Maria	
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Analysera kvalitet, orientering

- Funktionen kan användas på vissa typer av rapportobjekt.
- En rapport med ett stapeldiagram visar status för alla valda mätningar (nedan)
- Om du grupperar data kommer rapporten bli annorlunda (höger)

🗌 То

Week 11, 2021 Week 12, 2021 Week 13, 2021

Analysera kvalitet, gruppering

- Gruppalternativet är tillgängligt i urval av mätningar
- Aktivera gruppering och välj attribut att gruppera efter.
- Rapporten kommer att visa förändringen
- Exemplet visar data grupperade efter kalendervecka.

ZEISS CALYPSO	Part name Catyps- 2020 PiWeb Syncronisation Drawing number 123456 Number of measurements 49 Percent of values out of limit 11.11 First pass quota 32.65	Measurements Last 3 months ► Approval ≢ Blocked
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Analysera kvalitet, vad ska man gruppera efter?

- PiWeb reporting i Calypso 7.0 (och äldre) stöder gruppering efter mätattribut.
- Om du vill använda gruppfunktionen för attribut som "Order" och "Maskinnummer" måste värden för attributen anges när du kör mätplanen.
- Aktivera användningen av attribut i "Multipelprotokoll
 - Välj rapporthuvudparametrar"

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		\checkmark	Part Number	
		\checkmark	Part type	Р 🗸
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Analysera kvalitet, ett grupperat stapeldiagram

- Nedan finns stapeldiagram grupperade efter tid/datum vecka...
- ... och grupperat efter ordernummer

Analysera kvalitet, en grupperad tabell

- Nedan finns en tabell och grupperad efter ordernummer
- Varje rad rapporterar flera mätningar

ISS	ZEISS CALYPSO	Part nameCalypso 20Drawing number123456Number of measurementsPercent of values out of limitFirst pass quota	20 PiWeb Syncronisation 62 6.84 33.87	Measuren Order nun ► Approv	nents Last 4 months nber al ≠ Blocked	, Grouped by
₽	First date	Order number		Measurments	Measurments within spec	% within spec
1	1/25/2021 1:19 PM	Order 234		4	1	25.00%
2	2/10/2021 12:15 PM	Order 235		16	5	31.25%
3	2/11/2021 12:18 PM	Order 236		12	6	50.00%
4	2/17/2021 8:10 PM	Order 237		8	3	37.50%
-	4/0/2021 12-20 DM	Order 238		22	6	27 27%

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Analysera kvalitet, öka detaljnivån från en grupperad tabell

- Ordernummer i de grupperade l\u00e4nkar till en lista med m\u00e4tt f\u00f6r det ordernumret
- Listan över mått länkar till standardprotokollet för att granska enskilda mätningar

ZEISS	ZEISS CALYPSO	l	Part name Drawing number Number of measure Percent of values or First pass quota	Calypso 2020 123456 ments 6/ ut of limit 6.8 33.	PiWeb Syncronisation 2 34 87	Measurer Order nur ► Approv	nents Last 4 month: nber al ≠ Blocked	s, Grouped by	
J	First date			Order number		Measurments	Measurments within spec	% within spec	
1	1/25/2021 1:19 PM			Order 234		4	1	25.00%	
2	2/10/2021 12:15 PM			Order 235		16	5	31.25%	
3	2/11/2021 12:18 PM			Order 236		12	6	50.00%	
4	2/17/2021 8:10 PM			Order 237		8	3	37.50%	
5	4/9/2021 12:29 PM			Order 238		22	6	27.27%	
		ZEISS	ZEISS Caly	/pso	Part name Drawing number Number of measure Percent of values o First pass quota	Calypso 202 123456 ements out of limit 6 3	0 PiWeb Syncroni: 8 3.94 7.50	sation Measur ► Appr ► Orde	ements Last 4 months oval ≠ Blocked er number = Order 237
			Time/Date	Part ident	Operator	CM	М Туре	Status	Measurement type
		1	2/11/2021 12:22 PM	399	Master	000000 - Pri	smo - Mikko123	0	Text
		2	2/11/2021 12:23 PM	400	Master	000000 - Pri	smo - Mikko123	0	Text
		3	2/11/2021 12:24 PM	401	Master	000000 - Pri	smo - Mikko123	•	Text
		4	2/11/2021 12:27 PM	402	Master	000000 - Pri	smo - Mikko123	•	Text
		5	2/11/2021 12:28 PM	403	Master	000000 - Pri	smo - Mikko123	•	Text
		6	2/11/2021 12:29 PM	404	Master	000000 - Pri	smo - Mikko123	•	Text
		7	2/11/2021 12:30 PM	405	Master	000000 - Pri	smo - Mikko123	0	Text

Master

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8

2/17/2021 8:10 PM

406

Analysera kvalitet, gruppering i trendprotokoll

- Linjediagramobjektet i trendprotokollet stödjer gruppering
- I exemplet grupperas data efter tillverkningsmaskin

ZEINS ZE	ISS (CALYPSO	Part name Order number Number of measure. Operator Time/Date	Calypso 2020 PiWe Order 238 25 Master 4/9/2021 12:29 PM	b Syncronisa	tion
Characteristic Nominal value	+Tol -Tol		Value pattern			
True Position 0.0000	1 0.0200 0.0000				Minimum Maximum Range Average value Stid dev. Cpk	0.0006 0.0123 0.018 0.0058 0.0058 0.97 0.94
True Position	1.Z					
-49.0000	0.0100 -0.0100			7 11 19 22 22 22 23	Minimum Maximum Range Average value Std dev. Cp Cpk	-49.0010 -48.9938 0.0072 -48.9972 0.0020 1.64 1.18
O Roundness2						
0.0000	0.0220 0.0000			7 10 19 20 21 22 23 24 25	Minimum Maximum Range Average value Std dev. Cp Cok	0.0202 0.0233 0.0031 0.0223 0.0009 3.93 -0.14
Ø Diameter2						
20.0000	0.1000 -0.1000			7 11 12 22 21 22 23 24 25	Minimum Maximum Range Average value Std dev. Cp	20.0229 20.0288 0.0059 20.0260 0.0017 20.04 14.82
2 Point Diame	ater1^Max				- Opr	
30.1000	0.0000 -0.1000	30.10 30.45 20.00	*******	•••••	Minimum Maximum Range Average value Std dev. Co	30.0457 30.0488 0.0032 30.0476 0.0008 20.23

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ZEISS ZE	EISS	CALYPSO	Part name Order number Number of measure Operator Time/Date	Calypso 2020 PiWe Order 238 25 Master 3/11/2021 4:12 PM	b Syncronis	ation
Characteristic Nominal value	s +Tol e -Tol		Value pattern			
+ True Position	n1					
0.0000	0.0200 0.0000	0.02 0.01 0.00 	20112 - Garda 2 38110 - Garda 3	1 1	Minimum Maximum Range Average value Std dev. Cp	0.0005 0.0123 0.0118 0.0058 0.0038 0.97 0.94
True Position	n1.Z					
-49.0000	0.0100 -0.0100	-16.00	20112 - Grda 2 2010 - Grda 3		Minimum Maximum Range Average value Std dev. Cp Cok	49.0010 48.9938 0.0072 48.9972 0.0020 1.64 1.18
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Ø Diameter2						
20.0000	0.1000 -0.1000	20.1	20112-Grab 2 20101-Grab 3		Minimum Maximum Range Average value Std dev. Cp Cok	20.0229 20.0288 0.0059 20.0250 0.0017 20.04 14.82
2 Point Dian	neter1^Max					1.1.1.1.1.
30.1000	0.0000	38.10			Minimum Maximum Range Average value	30.0457 30.0488 0.0032 30.0476
	-0.1000	30112	30182 - Grob 2 30183 - Grob 3		Cp	20.89

Jämför din mätning med en referensdetalj

- En äldre metod för att jämföra en detalj med en referensdetalj (produktionslikare)
- Vanligt för karosseriplåt
- PiWeb kan redovisa mätvärde, avvikelse från nominellt mått eller avvikelse från referensdetalj.

O Roundness1	0.0240	0.0000	0.1000	0.0000	0.0240 🔵		
Ø Diameter1	30.0256	30.0000	0.1000	0.0000	0.0256 🔵		
D Flatness1	0.0228	0.0000	0.0800	0.0000	0.0228 🔵		
True Position1	0.0011	0.0000	0.0200	0.0000	0.0011 🔵		na datan dha
True Position1.Z	-48.9994	-49.0000	0.0100	-0.0100	0.0006		
O Roundness2	0.0225	0.0000	0.0220	0.0000	0.0225 🛑		
	20.0234	20.0000	0.1000	-0.1000	0.0234 🔵		
Ø Point Diameter1^Max	30.0487	30.1000	0.0000	-0.1000	-0.0513 🔵		
2 Point Diameter1^Min	30.0028	30.1000	0.0000	-0.1000	-0.0972 🔵		

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Avvikelse från nominellt värde

- Nedan är "Deviation from nominal value" aktivt
- Diametervärdena redovisas som avvikelse från nominellt värde.

O Roundness1	0.0240	0.0000	0.1000	0.0000	0.0240 🔵	
Ø Diameter1	0.0256	0.0000	0.1000	0.0000	0.0256 🛑	
D Flatness1	0.0228	0.0000	0.0800	0.0000	0.0228 🔵	
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True Position1.Z	0.0006	0.0000	0.0100	-0.0100	0.0006	ու տես աներու միս,
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O Point Diameter1^Min	-0.0972	0.0000	0.0000	-0.1000	-0.0972 🛑	

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Measurements **⊞ ~** ₿ ~ Avvikelse från referensmätning Measurement selection for all pages Nedan är "Deviation from reference part" aktiv Last measurements Alla rapporterade avvikelser är jämfört med referensdetaljen. O By date By measurement attribute Dessutom kan du lägga till en allmän tolerans för hur mycket du O Direct selection tillåter avvikelse från originaldelen 20 🗘 measurements Last ¥ Blocked \sim Approval θ 0.0000 0.0000 0.1000 0.0000 0.0000 Roundness1 0 Ind. I 0.0000 -0.0005 Diameter -0.0005 0.0000 0.1000 Ø_ Single measurements... 0.0002 0.0000 0.0800 0.0000 0.0002 Flatness1 \square -0.0058 0.0000 -0.0058 True Position 0.0200 0.0000 Special evaluations Ð True Position1.Z -0.0029 0.0000 0.0100 -0.0100 -0.0029 No grouping -0.0007 0.0000 0.0220 0.0000 -0.0007 Roundness2 0 Measurements as deviations from Reference measurement Diamose Akin testi kommentti -0.0026 0.0000 0.1000 -0.1000 -0.0026 2 Point Diameter1^Max 1 measurements selecte 0.0011 0.0000 0.0000 -0.1000 0.0011 -0.03 Lower tolerance 2 Point Diameter1^Min -0.0023 0.0000 0.0000 -0.1000 -0.0023 Upper tolerance 0.03 🗘

En MSA typ 3, orientering

- Är en mätsystemanalys...
- ... vilket talar om för dig om mätprocessen är tillräckligt exakt.
- Typ 3 innebär att den är utformad för att utvärdera en CMM, där det inte finns någon distinkt operatörspåverkan av resultatet.
- Resultatet är ett %R&R-värde som definierar hur väl CMM:en repeterar med hänsyn till toleransen
- Rekommendationen är att mäta 25 delar 2 gånger.

	Number of identical workpieces	Number of apprai- sers	Number of repeat measurements
Minimum number	10	1 (automated)	2
Recommended value	25	1 (automated)	2
High precision study	25	1 (automated)	5

- I exemplet används "Order" för att ange "MSA Typ 3" (För att hitta mina mätningar)
- "Incremental part number" används för att ange detaljens id (1-25)
- Kontrollera att attributen du använder är standardattribut.

Input Parameter	
	User Master
Name	Value
Cavity	
Lot ID	Lot 11
Machine number	36182
Order	MSA Typ 3
Incremental Part Number	1
Test ID	MSA
Shift	Skift 1
Batch	2
	OK Cancel

MSA typ 3, kör mätningen

- 25 detaljer mäts två gånger vardera
- "Incremental part number" används för att ange vilken detalj som mäts.

MSA typ 3, skapa rapporten

- Välj din mätplan
- Välj rapporten "Gage R&R Type 3"
- I urvalet av mätningar filtrera på det "Order Number" du angett

PiWeb reporting plus		
6		
CALYPSO inspections	Reports	
Find P	AcceptProtocol : Acceptance protocol	Dashboard
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Calypso 2020 MSA Type 3 9 characteristics, 50 measurements Created 4/8/2021	Baseshow 2010 201 P/I 201 Edge Gap risk lange 6.01 8.74 9.24 9.25 9.05 9.00 List 1.09 8.74 2.55 4.05 9.01 100	Biological State Image Lange Image Lange <thimage< th=""></thimage<>
Moaimea 4/8/2021	Gage R&R Type-2 Study	Gage R&R Type-3 Study

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Special evaluati	ions		

MSA-typ 3, konfigurera rapporten Klicka på kugghjulet ٠ Konfigurera gemensamma parametrar Konfigurera parametrar för typ 3 ٠ **2131 NN** ZEISS PiWeb Gage R&R Type-3 Study 7.4.11.0 Performed by Pettersson, Tobias Performed checks R&R, EV, NDC Gage number 000000 - Prismo - Mikko123 Machine 36182 No. measurements 50

Measurement sys	tem analysis	×
Common	Statistics	
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Type 2	Measurement keys	
Туре 3	Appraiser Operator Part Id Part ident	
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Measurement syste	em analysis						×
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Type 2	Verification						
Туре 3	✓ number of parts		min	20 🗘	max	30 🗘	
	✓ number of trials		min	2 🗘	max	5 🗘	
	✓ Repeatability (EV)		partly capable	15.0 🗘 %	capable	15.0 🗘 %	
	🗹 Gage R&R		partly capable	30.0 🗘 %	capable	20.0 🗘 %	
	number of distinc	t classes (NDC)			capable	5 🗘	
					OK	Cancel	

En MSA typ 3, rapportsida 1

- På den första sidan visas alla dina egenskaper och kontroller om resultatet är acceptabelt eller inte.
- Rapporten tittar på resultatvariationen och jämför variationen med toleransvidden
- Resultatet är i %

Performed by Pe Performed checks R&	ttersson, Tobias R, EV						
Gage number 00 Machine 36 No. measurements 50	0000 - Prismo - I 182	Mikko123				.	¥
Characteristic Name	Variation Tolerances	EV	PV	%RE %PV	%EV	Result R&R	
2 Point Diameter1^Max	-0.1, 0	0.0044	0.003	2.59%	4.39%	acceptable	4.39%
2 Point Diameter1^Min	-0.1, 0	0.0041	0.003	2.88%	4.14%	acceptable	4.14%
Diameter1	0, +0.1000	0.0018	0.001	1.27%	1.56%	acceptable	1.569
Diameter2	± 0.1	0.0090	0.007	3.58%	4.51%	acceptable	4.519
Flatness1	-, +0.08	0.0056	0.004	4.75%	7.03%	acceptable	7.039
Roundness1	-, +0.1	0.0001	0.000	0.08%	0.12%	acceptable	0.129
Roundness2	-, +0.022	0.0058	0.004	19.15%	25.32%	not acceptable	5.329
True Position1	-, +0.02	0.0159	0.014	68.92%	79.39%	not acceptable	6
True Position1.Z	-, +0.02	0.0079	0.007	08.92%	39.69%	not acceptable	1.39

MSA typ 3, rapportsida 2-

- "Part variation" hur mycket till de 25 detaljerna varierar i % av toleranszonen. (Högre är bättre, vilket innebär att studien gäller för olika avvikelser snarare än en specifik avvikelse)
- Repeterbarhet % hur väl kan vi upprepa ett uppmätt värde. Jämfört med tröskelvärdet i konfigurationen.
- Detaljer i diagram och tabell

	Performe	d by Petterss	on, Tobias				
	Performed ch	ecks R&R, E	/				
	Gage nur	mber 000000	- Prismo - M	ikko123			
	Mac	hine 36182				T	يك
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Ch	tariatian Elatara				Tolerances -, +0.08		
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	Part varia	uon 0.00380	-	4./54%	Resolution	Number of parts	s 25 🌏
	Repeatat	anty 0.00003		7.035%	Average 0.0222	Number of trails	5 2 🔮
	Gage P	ten 0.00505		7.035%	Standard deviation 0,0010		
	Trial 1	Trial 2	x	R	+ 10% NF	- to% rer	
1 2 3 4 5 6 7	Trial 1 0.022567 0.021098 0.022789 0.022227 0.022210 0.022517 0.022728	Trial 2 0.022880 0.021095 0.022443 0.023335 0.022697 0.021965 0.020391	x 0.022723 0.021097 0.022616 0.022781 0.022404 0.022741 0.022741	R 0.000312 0.000003 0.000346 0.001108 0.000587 0.001551 0.002337	AN 101 - 1	1. UN.101	
1 2 3 4 5 6 7 8	Trial 1 0.022567 0.021098 0.02227 0.022210 0.022511 0.02255 0.02055	Trial 2 0.022880 0.021095 0.022443 0.023335 0.022697 0.021985 0.020391 0.022937	x 0.022723 0.021097 0.022616 0.022781 0.022404 0.022741 0.021580 0.021748	R 0.000312 0.000003 0.000346 0.001108 0.000587 0.001551 0.002337 0.002382	10 m m m m m m m m m m m m m m m m m m m	1.05 m	
1 2 3 4 5 6 7 8 9	Trial 1 0.022567 0.021098 0.02227 0.022210 0.022511 0.022555 0.022655 0.022621	Trial 2 0.022880 0.021095 0.022443 0.023335 0.022897 0.021985 0.020391 0.022937 0.022735	x 0.022723 0.021097 0.022616 0.022781 0.022404 0.022741 0.021560 0.021746 0.022679	R 0.000312 0.000003 0.000346 0.001108 0.000587 0.001551 0.002337 0.002382 0.000115			
1 2 3 4 5 6 7 8 9 10	Trial 1 0.022567 0.021098 0.022789 0.022217 0.022110 0.023517 0.02255 0.02255 0.022621 0.022621	Trial 2 0.022880 0.021095 0.022443 0.02335 0.022697 0.021695 0.020391 0.022937 0.022738 0.022738	x 0.022723 0.021097 0.022616 0.022781 0.022404 0.022741 0.021560 0.021746 0.022679 0.023225	R 0.000312 0.00003 0.000346 0.001108 0.000587 0.001551 0.002337 0.002382 0.000115 0.000990 0.000990	11 10, W	1. INA.	Yials.
1 2 3 4 5 6 7 8 9 10 11	Trial 1 0.022567 0.021098 0.022289 0.022227 0.022110 0.022515 0.02255 0.022621 0.02255 0.022621 0.022730 0.018820	Trial 2 0.022880 0.021095 0.022443 0.023335 0.022697 0.021665 0.020391 0.022937 0.022738 0.023720 0.022214	x 0.022723 0.021097 0.022616 0.022761 0.022741 0.021746 0.021746 0.022679 0.023225 0.020277	R 0.000312 0.00003 0.000340 0.00108 0.000587 0.001551 0.002337 0.002332 0.000115 0.000900 0.004194	1 10° M	1.000 H	f all trials.
1 2 3 4 5 6 7 8 9 10 11 11 12	Trial 1 0.022667 0.021098 0.022789 0.022217 0.022110 0.022817 0.022728 0.022555 0.022621 0.022621 0.022730 0.018820 0.022410	Trial 2 0.022880 0.021095 0.022443 0.023335 0.022897 0.021985 0.020391 0.022937 0.022738 0.023220 0.023221 0.023221	x 0.022723 0.021087 0.022816 0.022816 0.022781 0.022404 0.022740 0.022746 0.0221746 0.022679 0.023225 0.020717 0.022818 0.0220747	R 0.000312 0.0003 0.000346 0.00108 0.001551 0.002337 0.002337 0.002332 0.000115 0.000990 0.004194 0.000582	AN 1021 - 12		RFT R of all trials.
1 2 3 4 5 6 7 8 9 10 11 11 12 13	Trial 1 0.022667 0.021098 0.022227 0.022110 0.022817 0.022728 0.020555 0.022621 0.022621 0.022621 0.022730 0.018820 0.022410 0.0222410	Trial 2 0.022800 0.021095 0.022443 0.023335 0.022997 0.021985 0.022937 0.022736 0.022736 0.022736 0.0223214 0.023227 0.022814	x 0.022723 0.021097 0.022616 0.022741 0.022741 0.021746 0.021746 0.021746 0.02275 0.02275 0.0201746 0.022818 0.022036 0.022818 0.022038	R 0.000312 0.00003 0.000346 0.000587 0.001651 0.002337 0.002332 0.0001551 0.000290 0.0004194 0.000918 0.000518 0.000518	10 10 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1		10% RF] himum of all trais.
1 2 3 4 5 6 7 8 9 10 11 12 13 14 15	Trial 1 0.022667 0.021068 0.022290 0.022790 0.02210 0.022517 0.022517 0.022517 0.022517 0.022521 0.022730 0.022223 0.022521 0.022521 0.022521 0.022521 0.018820 0.018820	Trial 2 0.022880 0.021095 0.022443 0.022443 0.022443 0.022947 0.022947 0.022947 0.022947 0.022937 0.022720 0.022214 0.022227 0.022202	\$\overline{x}\$ 0.022723 0.021067 0.022816 0.022404 0.022404 0.022404 0.022404 0.022404 0.022404 0.021748 0.022818 0.0202818 0.021845	R 0.000312 0.00003 0.000346 0.001085 0.000587 0.001551 0.002337 0.002337 0.002337 0.002337 0.000516 0.000910 0.0004194 0.000818 0.001532 0.002150		Ганариананананананананананананананананана	[法主10% RF] d minimum of all trials.
1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16	Trial 1 0.022567 0.021068 0.022789 0.022110 0.022110 0.022110 0.022110 0.02257 0.022110 0.022512 0.022512 0.022512 0.022512 0.022728 0.022728 0.0225210 0.02252510 0.02252510	Trial 2 0.02280 0.021085 0.02443 0.023335 0.029897 0.02997 0.02937 0.0223720 0.022344 0.0223720 0.022342 0.022342 0.022342 0.022342 0.022344 0.022327 0.022344 0.022329 0.022329 0.022329 0.022314	x 0.022723 0.021097 0.022816 0.022781 0.022404 0.022404 0.022670 0.022679 0.022679 0.022679 0.022679 0.022679 0.022267 0.022038 0.022184 0.022184 0.022494 0.022184 0.022249 0.022184	R 0.000312 0.000030 0.000340 0.000587 0.001551 0.002382 0.002382 0.000115 0.000980 0.004194 0.000588 0.000588 0.002582 0.00258	11 100 M	4.00.00 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0	ddh (z ± 10% kF) m and minimum of all trials.
1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17	Trial 1 0.022667 0.021068 0.022728 0.022110 0.022728 0.022172 0.022172 0.022582 0.022622 0.022542 0.0225410 0.0225510 0.0225510 </td <td>Trial 2 0.022805 0.022443 0.023335 0.022697 0.022987 0.022987 0.022987 0.022937 0.022937 0.022937 0.022931 0.022814 0.022805 0.022806 0.022829 0.022292</td> <td>x 0.022723 0.02203 0.022616 0.022781 0.022404 0.022781 0.022404 0.022782 0.022782 0.022782 0.022782 0.022678 0.022878 0.0288 0.0288 0.0288 0.0288 0.0288 0.02</td> <td>R 0.000312 0.000030 0.000340 0.000340 0.000587 0.001551 0.002382 0.000115 0.000980 0.004194 0.000152 0.001592 0.002042 0.000159 0.000432</td> <td></td> <td></td> <td>ee widh [¢ ± 10% RF] imma and minimum of all trials.</td>	Trial 2 0.022805 0.022443 0.023335 0.022697 0.022987 0.022987 0.022987 0.022937 0.022937 0.022937 0.022931 0.022814 0.022805 0.022806 0.022829 0.022292	x 0.022723 0.02203 0.022616 0.022781 0.022404 0.022781 0.022404 0.022782 0.022782 0.022782 0.022782 0.022678 0.022878 0.0288 0.0288 0.0288 0.0288 0.0288 0.02	R 0.000312 0.000030 0.000340 0.000340 0.000587 0.001551 0.002382 0.000115 0.000980 0.004194 0.000152 0.001592 0.002042 0.000159 0.000432			ee widh [¢ ± 10% RF] imma and minimum of all trials.
1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18	Trial 1 0.022667 0.021088 0.022788 0.0222277 0.022728 0.022728 0.022521 0.022521 0.022521 0.022521 0.022521 0.022521 0.022621 0.022421 0.022421 0.022421 0.022421 0.022421 0.022421 0.022421 0.022422 0.0224223 0.022523 0.022523	Trial 2 0.02280 0.021085 0.022443 0.023335 0.022097 0.021985 0.022091 0.0223736 0.0223720 0.0223720 0.0223720 0.0223720 0.022327 0.022322 0.022826 0.0222218 0.022218 0.022190	x 0.022723 0.0220816 0.022404 0.022404 0.022781 0.022404 0.022781 0.022785 0.020717 0.022818 0.022088 0.022088 0.022249 0.022038 0.022249 0.022307 0.022249 0.022307 0.023507 0.025507 0.025507 0.025507 0.025507 0.025507 0.025507 00	R 0.000312 0.000246 0.0001108 0.000587 0.001581 0.002337 0.002382 0.000115 0.000980 0.0004194 0.000818 0.001532 0.00242 0.002159 0.002042 0.000159	11 10° IA		erance width $[\overline{x}\pm 10\% \text{ kF}]$ maximum of all trials.
1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19	Trial 1 0.022677 0.022789 0.022780 0.022170 0.022171 0.022172 0.022510 0.022527 0.022510 0.022520 0.022530 0.0226521 0.022523 0.021270 0.021270 0.022531 0.022533 0.022523 0.022523161 0.0224231	Trial 2 0.02280 0.021065 0.022443 0.023335 0.020091 0.021065 0.020091 0.0229730 0.022314 0.022802 0.022802 0.022802 0.022814 0.022814 0.022814 0.022802 0.022802 0.022802 0.022814 0.022802 0.022804 0.022805 0.022414 0.022414 0.022414 0.022414 0.022414 0.022414 0.022414 0.022414 0.022414 0.0224140	x 0.022763 0.0221087 0.022016 0.02241 0.02241 0.02241 0.02241 0.02241 0.02241 0.02241 0.02243 0.02243 0.02244 0.02245 0.02246 0.02248 0.02248 0.02248 0.022036 0.022036 0.022036 0.022037 0.022038 0.022037 0.022038 0.0220397 0.022311	R 0.000312 0.0000346 0.00108 0.001551 0.002337 0.002382 0.0001551 0.0002382 0.000194 0.0001532 0.0001532 0.000159 0.000159 0.000432 0.000432			s tolerance width [x ± 10%, RF] s een maximum and minimum of all trials.
1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20	Trial 1 0.022567 0.02108 0.022789 0.02227 0.022110 0.022111 0.022110 0.022128 0.022110 0.022120 0.02210 0.022410 0.021570 0.022410 0.02210 0.022523 0.022523 0.022523 0.022523 0.022523 0.022523 0.022650	Trial 2 0.02208 0.02108 0.02108 0.022443 0.02333 0.02997 0.02997 0.022937 0.022937 0.022937 0.022937 0.022937 0.022937 0.022937 0.022938 0.022929 0.022988 0.022291 0.02217 0.02217 0.02217 0.02217 0.02218 0.02217 0.022140 0.022178 0.022278	x 0 022728 0 022761 0 022816 0 022761 0 02244 0 021748 0 022241 0 022241 0 022243 0 022244 0 022244 0 022245 0 022248 0 022248 0 022248 0 022249 0 022249 0 022307 0 022307 0 022310 0 022340 0 022340	R 0.000312 0.000034 0.000108 0.001551 0.002337 0.002337 0.002332 0.000155 0.0004194 0.0004194 0.000153 0.001532 0.001532 0.002342 0.00159 0.000323 0.000432 0.0001701 0.000132			10% tolerance width [x ± 10% RF] railwes between maximum and minimum of all trials.
1 2 3 4 5 6 7 8 9 9 10 11 11 2 13 14 15 16 17 18 19 20 21	Trial 1 0.022667 0.021068 0.022728 0.022710 0.022710 0.022728 0.022551 0.0225821 0.0225410 0.0225410 0.0225410 0.0225410 0.0225410 0.0225410 0.0225410 0.0225410 0.0225410 0.0225410 0.0225410 0.0225410 0.022542 0.022543 0.0225410 0.0225410 0.022542 0.022543 0.022543 0.022543 0.022544 0.022544 0.022644 0.022642	Trial 2 0.02280 0.021095 0.022443 0.023335 0.02335 0.020977 0.021965 0.022377 0.0223720 0.0223720 0.0223720 0.0223720 0.022327 0.022327 0.022329 0.022329 0.022378 0.022490 0.023376 0.023376 0.023378 0.023374	x 0.022723 0.021067 0.022161 0.022140 0.022416 0.022414 0.022416 0.022419 0.022410 0.022410 0.022410 0.022410 0.022411 0.022411 0.022311 0.022311 0.022410	R 0.000312 0.00034 0.00034 0.001551 0.001551 0.002332 0.000115 0.000581 0.001552 0.0001532			ge = 10% beleance width [x = 10% FF] ge values trea between maximum and minimum of all trials.
1 2 3 4 5 6 7 8 9 9 10 11 11 2 13 14 15 16 17 18 19 20 21 22	Trial 1 0.022687 0.021089 0.022789 0.022170 0.022171 0.022172 0.022517 0.022517 0.022521 0.022521 0.022521 0.022521 0.022521 0.022521 0.022410 0.022420 0.022523 0.023533 0.022540 0.022404 0.022640 0.022640 0.022640 0.022640 0.021692	Trial 2 0.02280 0.021065 0.022443 0.02335 0.02097 0.021985 0.02091 0.022378 0.023720 0.023814 0.022882 0.022802 0.022804 0.022805 0.022806 0.022718 0.022870 0.022871 0.022970 0.022971 0.022971 0.022971 0.022971 0.022971 0.022971 0.022971 0.022971	x 0.022728 0.022781 0.022781 0.022416 0.022414 0.022470 0.022471 0.022479 0.022479 0.022479 0.022479 0.022479 0.022479 0.022479 0.022479 0.022340 0.022340 0.022340 0.022408 0.022408	R 0.000312 0.000034 0.000346 0.001551 0.002587 0.001551 0.002337 0.000155 0.000165 0.000165 0.000153 0.000153 0.000153 0.0001532 0.0001532 0.0001532 0.0001532 0.0001532 0.0001532 0.0001532 0.0001532 0.0001532 0.001532 0.001532 0.001532 0.001532 0.001532 0.001532 0.001532 0.001532 0.001532 0.00152 0.000152	11 ID IN		weage are 10% tolerance width [x ± 10% RF] weage rankes he area between maximum and minimum of all vials.
1 2 3 4 5 6 6 7 8 9 10 11 11 2 3 14 15 16 17 18 19 20 21 22 23	Trial 1 0.022567 0.022287 0.022789 0.022227 0.022178 0.022170 0.022517 0.022517 0.022517 0.02252 0.022510 0.022523 0.02253 0.021270 0.020824 0.021270 0.022523 0.022523 0.022523 0.022650 0.022650 0.022650 0.022650 0.022650 0.022650 0.022650 0.022650 0.022650 0.022650 0.022650 0.022650 0.022650 0.022650 <td>Trial 2 0.02280 0.021065 0.022443 0.02335 0.021065 0.02097 0.020987 0.022937 0.022937 0.022937 0.022937 0.022937 0.022937 0.022938 0.022802 0.022802 0.022802 0.022901 0.022915 0.022970 0.023121 0.0229718 0.022183</td> <td>x 0.022103 0.022103 0.022103 0.022103 0.02241 0.022741 0.022141 0.022143 0.022143 0.02244 0.02244 0.02245 0.02230 0.02248 0.02230 0.02240 0.02240 0.022279 0.02279 </td> <td>R 0.000312 0.000034 0.000346 0.001587 0.001581 0.002337 0.002337 0.000158 0.000194 0.000195 0.000195 0.000195 0.000195 0.000195 0.001532 0.001532 0.000158 0.000242 0.00158 0.000232 0.001429 0.000230 0.001429 0.000593</td> <td></td> <td></td> <td>average ± 10% tolerance width [x ± 10% KF] - Average values - The area between macmum and minimum of all trials.</td>	Trial 2 0.02280 0.021065 0.022443 0.02335 0.021065 0.02097 0.020987 0.022937 0.022937 0.022937 0.022937 0.022937 0.022937 0.022938 0.022802 0.022802 0.022802 0.022901 0.022915 0.022970 0.023121 0.0229718 0.022183	x 0.022103 0.022103 0.022103 0.022103 0.02241 0.022741 0.022141 0.022143 0.022143 0.02244 0.02244 0.02245 0.02230 0.02248 0.02230 0.02240 0.02240 0.022279 0.02279	R 0.000312 0.000034 0.000346 0.001587 0.001581 0.002337 0.002337 0.000158 0.000194 0.000195 0.000195 0.000195 0.000195 0.000195 0.001532 0.001532 0.000158 0.000242 0.00158 0.000232 0.001429 0.000230 0.001429 0.000593			average ± 10% tolerance width [x ± 10% KF] - Average values - The area between macmum and minimum of all trials.

- Det har funnits möjlighet att lägga till manuella egenskaper till Calypso i några år.
- Genom att lägga till ett resultatelement kan du mata in manuella värden när du kör mätplanen.
- Från och med Calypso 2020 tillåter PiWeb Reporting Plus manuell inmatning från rapporter
- Du behöver kunskap om rapportredigering för att kunna skapa de rapporter som behövs.

- Om du har en detalj som mäts helt manuellt kan du mata in mätresultat direkt i PiWeb Reporting Plus
- Det första steget är att skapa en mätplan i Calypso. Skapa funktioner och egenskaper.
- Gör en simulerad körning av mätplanen, det genererar en PiWeb Reporting Plus-databas för detaljen

	CALYPSO					
Part name Drawing number Order number Variant Company Department CMM Type CMM No. Operator Text	Calypso Manual meas 123456 MSA Typ 3 Grön Prismo 000000 Master	urments	Last 1 meas Approval : Part ident Time/Date Run No. measure No. values: r Measuremen	urements ≠ Blocked d values ed tt Duration	59 4/16/2021 3: Current Sele 7 ● 0 0:00:01.0	21 PM ction
Name	Measured v	alueNominal valu	Je +Tol	-Tol	Deviation +/-	
Ø Diameter_Circle3	12.	0280 12.0000	0.1000	-0.1000	0.0280 🔵 💷 🛌 💷	1
Ø Diameter_Circle4	12.	0286 12.0000	0.1000	-0.1000	0.0286 🔵 💷 🖿 🖿	1
Ø Diameter_Circle5	12.	0284 12.0000	0.1000	-0.1000	0.0284 🔵 💷 🛌 💷	1
Diameter_Circle6	12.	0240 12.0000	0.1000	-0.1000	0.0240 🔵 💷 🛌	1
Diameter_Circle7	12.	0251 12.0000	0.1000	-0.1000	0.0251 🔵 💷 💷	1
C Distance1_Y	41.	7255 41.6985	0.1500	-0.1500	0.0270 🔵 💷 🛌 📖	1
C Distance2_Y	41.	7229 41.6985	0.1500	-0.1500	0.0245 🔵 💷 🛌	1
Text		Event		Write change	a, Write measurement attr	butes, Lock

Manuella mätningar i PiWeb Reporting Plus.

Nästa steg är att skapa en rapport för datainmatning. Det finns olika sätt att arbeta med det, nedan är ett alternativ.

- I Calypso-inspektionsplanen väljer "New Protocol landcape" och redigerar den.

C Definition of Multiple Repo	rt		- 🗆 ×		
🗹 Multiple Reports Acti	ive				
Multiple Report					
	모	Mark characteris	ics		
Default PiWeb Report	ing v	Select report header pa	rameters		
Report Features ——					
New	~ 🗑				
PiWeb Reporting_1	[NewProtocol_Landscape.ptx]		^		
			~		
Output media for CN	IC run				
Settings					
Format	ZEISS templates - NewProtocol Landscane ntx		/		
	Ouesties	L	Endound		×
Characteristics	Question				^
Output Order	Onable to save ZEISS templa Observed the New ZEISS templa	ites.		!- 4 !- 4 4	
🗌 Hide (selec	Should the NewProtocol_Lan	uscape.ptx template be copied to	o the airectory for the gen	eric templates or to the measurement pl	an directory?
Exchange r Activate pla	Generic tem	lates Measurement	plan specific templates	Cancel	
	splay plots in report				
	opidy ploto in report				
		ОК	Cancel Help		

- Du måste ha viss erfarenhet/utbildning av rapportdesign.
- Lägg till navigeringshjälpen och protokollhuvudet i rapporten i verktygslådan.

ages	Search (Ctrl+W)							
Ē	> General 2							
	✓ Tables & Directories							
box (F2	Additional data table							
Toolt	😥 Measurement input 🗸 🔛 Measurement table 🗸							
*	Measurement input							
rovider (F3)	Measured data input table Table for manual input of measured data in PiWeb Monitor.							
📰 Data p	Navigation helper List of buttons allowing navigation between measurements, creation of new measurements and writing the changes to the determined.							
Properties (F4)	Protocol header Protocol header area containing fields such as measurement date/time, operator etc. that may be entered in PiWeb Monitor.							
	Table for manual measurement input							
ructure	Table for manually entering measured values for multiple characteristics (one column per measurement, one row per characteristic).							
ge st	Table for manual measurement input							
Pac	Table for manually entering measured values for multiple characteristics (one column per characteristic, one row per measurement).							

ZEISS ZEISS Botheses revision	Softwar	e		Part name Drawing number Order number Company Department CMM No.	Calypso Manual measurments 123456 Order number Company Department CMM Type - CMM No.	Part ident Time/Date Operator Text	If not empty Time/Date Operator Text
Navigation							
	<< <<	0	>> >>	Reset changes			
Status: No changes	Crea	te new mea	urement	Write changes			
Protocol header Time/Date				Approval			
Operator				Batch	Batch		
Approval				Order number	Order number		
Text				Description of the a	Measurement attribute		

- Lägg in en datainmatningstabell
- Det här är den enklaste formen av rapport för manuell inmatning av uppmätta värden.
- Spara rapporten, stäng designverktyget

> Ge	neral									
∨ Ta	 Tables & Directories 									
	dditional data table	Characteristic table	~							
👿 N	leasurement input 🛛 🗸	Measurement table	~							
	Measure	ment input								
-	Measured data input ta	able								
	Table for manual input o	f measured data in PiWeb	Monitor.							
	Navigation helper	nuigation between mosc	romonte							
- n.	Navigation helper List of buttons allowing creation of new measure database.	navigation between measu ements and writing the cha	urements, anges to the							
	Navigation helper List of buttons allowing creation of new measure database. Protocol header	navigation between measu ments and writing the cha	urements, anges to the							
	Navigation helper List of buttons allowing creation of new measure database. Protocol header Protocol header area co date/time, operator etc.	navigation between measu ments and writing the che ntaining fields such as mee that may be entered in PiN	urements, anges to the asurement Neb Monitor.							
	Navigation helper List of buttons allowing creation of new measure database. Protocol header Protocol header area co date/time, operator etc. Table for manual measu	navigation between measuments and writing the characteristic and writing the characteristic and the such as meat that may be entered in Piliterent input	urements, anges to the asurement Web Monitor.							
	Navigation helper List of buttons allowing creation of new measure database. Protocol header Protocol header area co date/time, operator etc. Table for manual measu Table for manual y enter characteristics (one colu characteristic).	navigation between measuments and writing the characteristic and writing the characteristic and the second	urements, anges to the asurement Web Monitor. nultiple : row per							
	Navigation helper List of buttons allowing creation of new measure database. Protocol header Protocol header area co date/time, operator etc. Table for manual measu Table for manually enter characteristics (one colu characteristic). Table for manual measu	navigation between measu ments and writing the cha ntaining fields such as mee that may be entered in Pil rement input ing measured values for m mn per measurement, one rement input	asurements, asurement Web Monitor. hultiple : row per							

ZEISS ZEISS Software revision			Part name Drawing number Order number Company Department CMM No.	Calypso Manual measurments 123456 Order number Company Department CMM Type - CMM No.	Part ident Time/Date Operator Text	
Navigation						
	<< << 0	>> >>	Reset changes			
Status: No changes	Create new me	asurement	Write changes			
Protocol header						
Time/Date			Approval			
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Text			Description of the a	Measurement attribute		
	7	Ĩ				
Measured data input			Measured value	Nom +Tol -Tol		
Inspection plan entity	: Name		Measured value	Nominal \${Qdb \${Qdb		
			Par	ie 1 of 2		
			1 48			

- Välj den manuella mätplanen i PiWeb Reporting Plus
- Välj den mall som du har utformat för indata av uppmätta värden
- Detta öppnar indatarapporten

- Med navigeringshjälpen kan du skapa en mätning och spara de värden du har angett
- Fylla i information om operator, ordernummer eller batch i **protokollhuvudet**
- Fyll i dina uppmätta värden i tabellen **Uppmätt** datainmatning

	Company Department CMM No.					Time/Date Operator Text	4/16/2021 3:48 PM User My measurement	
vigation	<< 2 >> >>	Reset changes						
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otocol header								
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C Distance1 Y		41 6500	41.698	0.150	-0.150			
C Distance2_Y		4.1600	41.698	0.150	-0.150 🔶	La L		
			-1					

- Att ska rapporter för manuell inmatning är vanlig rapportdesign
- Du har tillgång till en stor verktygslåda med olika verktyg och kan skapa rapporter för olika ändamål.

PiWeb Reporting – Gear data

PiWeb Reporting – Gear data

• With Calypso 7.0 and GearPro 6.4, you can create a consolidated PiWeb Report with measurement data and Gear data.

PiWeb Reporting – Gear data

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PiWeb Reporting – Gear data

Part name Drawing number Order number	PiWebGearData			Last 1 meas	urements		
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Flatness Datum B		0.0010	0.0000	0.0300	0.0000	0.0010	
GEAR PRO] ► Gear1 ►	Z24						
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ZEISS CA	LYPSO	Part name Order number Part ident Operator Time/Date	PlWebGearData 7 Master 5/6/2021 5:49 Pt	И
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		1. Contraction (1. Contraction)		
Text		Event	Write change last measure	s, Write measurement attributes, Look ment
		-	White changes,	Write measurement attributes, Approve last
		n.def.	measurement,	Submit leaf measurement

Vi hoppas att du kan dra nytta av webbinariet.

Vi kommer skicka ut presentationen och inspelningen.

ZEISS INNOVATION ROCKS SPRING 2021

Startar den 8 juni och du är inbjuden!

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Seeing beyond