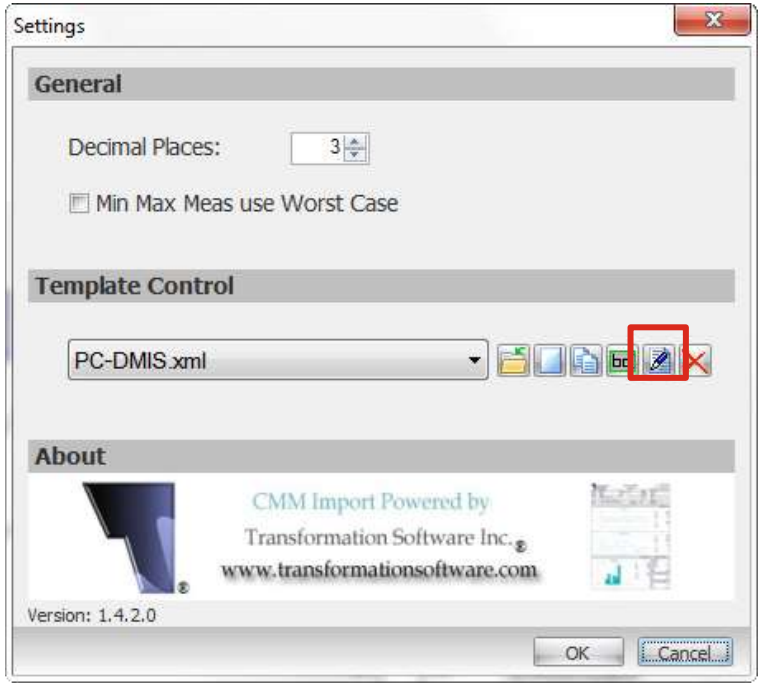
CMM Data Import

Copy, Edit, Modify

- Select the Template which is closed the out from your CMM Machine.
- Make a copy
- Then click on ‘Edit’ to edit the template.



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CMM Template Editor

- Below you will see the examples of editing the default templates as per your CMM output.
- We have tried to cover almost all the types of output which we get from CMM machines.

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CMM Templates

Keyence IM 6120

- CSV File
- Multiple parts inspected per file

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CMM Templates

Keyence IM 6120

- Since it's a brand new template based on a *.csv result file, we start by modifying the CSV.xml template

	A	B	C	D	E	F	G	H	I	J
1	ST	D3								
2	SE	7C413005	3.52	8B						
3	DA	1/23/2015 8:49	EB							
4	MS	4333-517-1.RevB	8A							
5	LO	C7								
6	SC	1	AF							
7	CH	JRM	CC							
8	IT	1	0.1873	inch	LN-LN002	0.188	0.005	-0.005	OK	5C
9	IT	2	0.5096	inch	LN-LN004	0.51	0.001	-0.001	OK	4D
10	IT	3	0.4344	inch	LN-LN005	0.435	0.001	-0.001	OK	50
11	IT	4	0.3606	inch	LN-LN003	0.36	0.005	-0.005	OK	54
12	IT	5	0.0452	inch	LN-LN006	0.045	0.002	-0.002	OK	4E
13	IT	6	0.0286	inch	LN-LN007	0.0275	0.0015	-0.0015	OK	62
14	IT	7	0.3123	inch	LN-LN008	0.3125	0.0005	-0.0005	OK	58
15	IT	8	0.289	inch	LN-LN014	0.29	0.002	-0.002	OK	5A
16	IT	9	0.3123	inch	LN-LN009	0.3125	0.0005	-0.0005	OK	5B
17	IT	10	0.2623	inch	LN-LN013	0.263	0.001	-0.001	OK	7A
18	IT	11	0.3123	inch	LN-LN010	0.3125	0.0005	-0.0005	OK	7C
19	IT	12	0.4083	inch	LN-LN011	0.409	0.005	-0.005	OK	86
20	IT	13	0.4165	inch	LN-LN012	0.417	0.001	-0.001	OK	80
21	EN	BF								
22	ST	D3								
23	SE	7C413005	3.52	8B						
24	DA	1/23/2015 8:51	DC							
25	MS	4333-517-1.RevB	8A							
26	LO	C7								
27	SC	2	B0							
28	CH	JRM	CC							
29	IT	1	0.1868	inch	LN-LN002	0.188	0.005	-0.005	OK	60
30	IT	2	0.5092	inch	LN-LN004	0.51	0.001	-0.001	OK	49
31	IT	3	0.4347	inch	LN-LN005	0.435	0.001	-0.001	OK	53
32	IT	4	0.3603	inch	LN-LN003	0.36	0.005	-0.005	OK	51
33	IT	5	0.045	inch	LN-LN006	0.045	0.002	-0.002	OK	4C
34	IT	6	0.0283	inch	LN-LN007	0.0275	0.0015	-0.0015	OK	5F
35	IT	7	0.3123	inch	LN-LN008	0.3125	0.0005	-0.0005	OK	58
36	IT	8	0.2892	inch	LN-LN014	0.29	0.002	-0.002	OK	5C
37	IT	9	0.3123	inch	LN-LN009	0.3125	0.0005	-0.0005	OK	5B
38	IT	10	0.2624	inch	LN-LN013	0.263	0.001	-0.001	OK	7B

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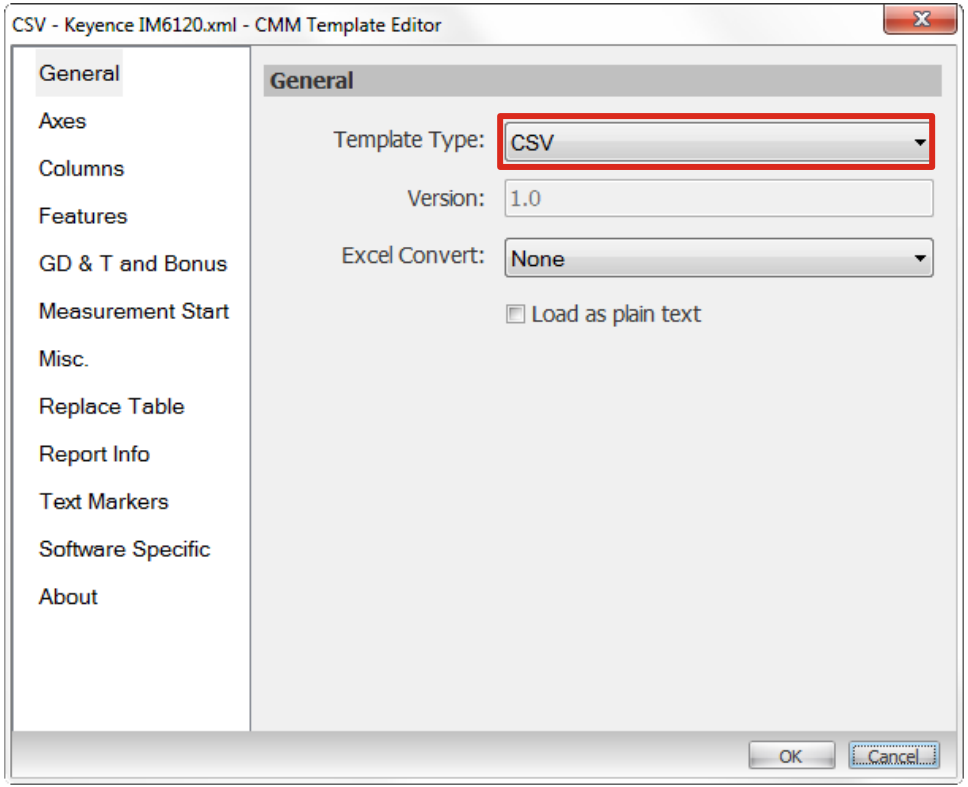
CMM Templates

Keyence IM 6120

- Since it's a brand new template based on a *.csv result file, we start by modifying the CSV.xml template



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CMM Templates

Keyence IM 6120

- Each result (in this case, only dimensions) is indicated by **IT**

	A	B	C	D	E	F	G	H	I	J
1	ST	D3								
2	SE	7C413005	3.52	8B						
3	DA	1/23/2015 8:49	EB							
4	MS	4333-517-1.RevB	8A							
5	LO	C7								
6	SC	1	AF							
7	CH	JRM	CC							
8	IT	1	0.1873	inch	LN-LN002	0.188	0.005	-0.005	OK	5C
9	IT	2	0.5096	inch	LN-LN004	0.51	0.001	-0.001	OK	4D
10	IT	3	0.4344	inch	LN-LN005	0.435	0.001	-0.001	OK	50
11	IT	4	0.3606	inch	LN-LN003	0.36	0.005	-0.005	OK	54
12	IT	5	0.0452	inch	LN-LN006	0.045	0.002	-0.002	OK	4E
13	IT	6	0.0286	inch	LN-LN007	0.0275	0.0015	-0.0015	OK	62
14	IT	7	0.3123	inch	LN-LN008	0.3125	0.0005	-0.0005	OK	58
15	IT	8	0.289	inch	LN-LN014	0.29	0.002	-0.002	OK	5A
16	IT	9	0.3123	inch	LN-LN009	0.3125	0.0005	-0.0005	OK	5B
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18	IT	11	0.3123	inch	LN-LN010	0.3125	0.0005	-0.0005	OK	7C
19	IT	12	0.4083	inch	LN-LN011	0.409	0.005	-0.005	OK	86
20	IT	13	0.4165	inch	LN-LN012	0.417	0.001	-0.001	OK	80
21	EN	BF								
22	ST	D3								
23	SE	7C413005	3.52	8B						
24	DA	1/23/2015 8:51	DC							
25	MS	4333-517-1.RevB	8A							
26	LO	C7								
27	SC	2	B0							
28	CH	JRM	CC							
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30	IT	2	0.5092	inch	LN-LN004	0.51	0.001	-0.001	OK	49
31	IT	3	0.4347	inch	LN-LN005	0.435	0.001	-0.001	OK	53
32	IT	4	0.3603	inch	LN-LN003	0.36	0.005	-0.005	OK	51
33	IT	5	0.045	inch	LN-LN006	0.045	0.002	-0.002	OK	4C
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36	IT	8	0.2892	inch	LN-LN014	0.29	0.002	-0.002	OK	5C
37	IT	9	0.3123	inch	LN-LN009	0.3125	0.0005	-0.0005	OK	5B
38	IT	10	0.2624	inch	LN-LN013	0.263	0.001	-0.001	OK	7B

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CMM Templates

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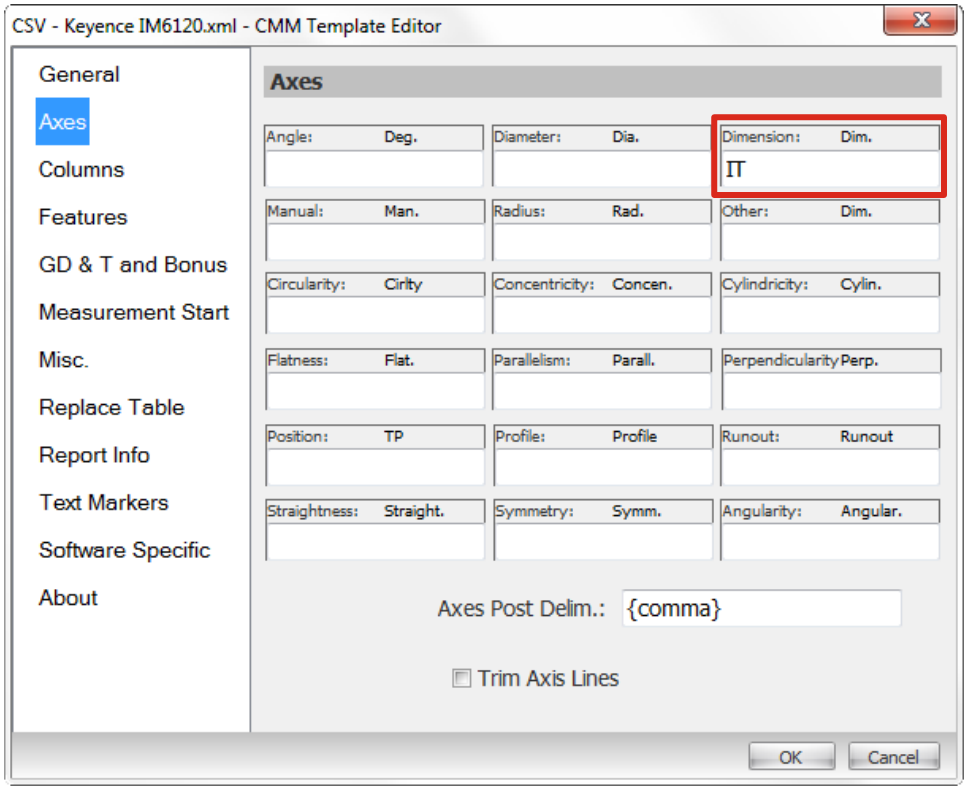
- Each result (in this case, only dimensions) is indicated by **IT**
- Dimensions, Angle, Diameter, etc… could by indicated by other denominators: X, Y, etc… in this case, it's a simple 2D CMM.



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CMM Templates

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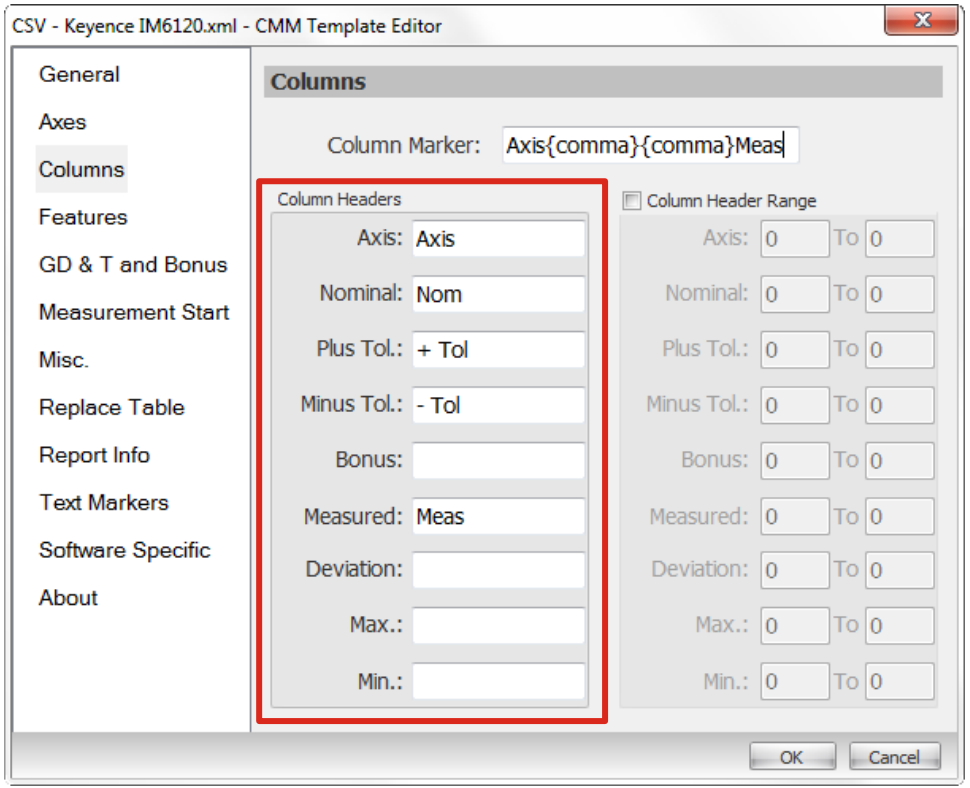
- Column Headers need to be indicated to allow the software to parse the results



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- In this case, no column header is indicated in the csv file…

	A	B	C	D	E	F	G	H	I	J
1	ST	D3								
2	SE	7C413005	3.52	8B						
3	DA	1/23/2015 8:49	EB							
4	MS	4333-517-1.RevB	8A							
5	LO	C7								
6	SC	1	AF							
7	CH	JRM	CC							
8	IT	1	0.1873	inch	LN-LN002	0.188	0.005	-0.005	OK	5C
9	IT	2	0.5096	inch	LN-LN004	0.51	0.001	-0.001	OK	4D
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23	SE	7C413005	3.52	8B						
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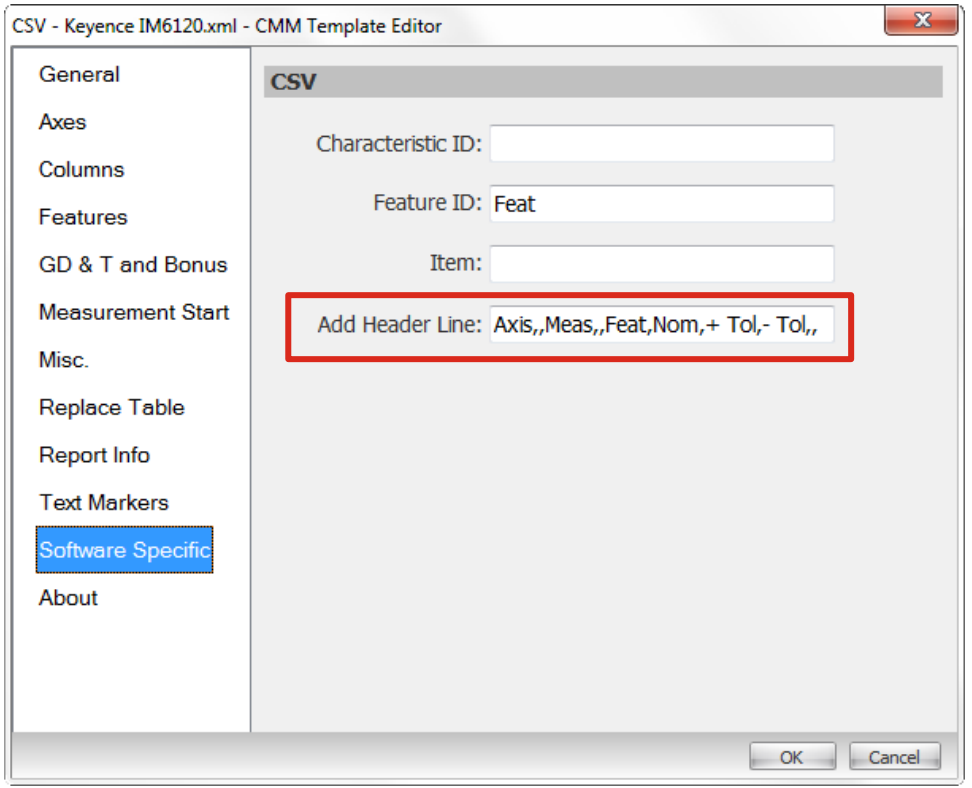
CMM Templates

Keyence IM 6120

- That's why they need to be specified in "software specific"
- The syntax need to match the one used in Columns
- Axis,,Meas,,Feat,Nom,+ Tol,- Tol,,

*Matches the "syntax" in the *.csv file (if opened with a NotePad)*

IT,1,0.1873,inch,LN-LN002,0.1880,0.0050,-0.0050,OK,5C,



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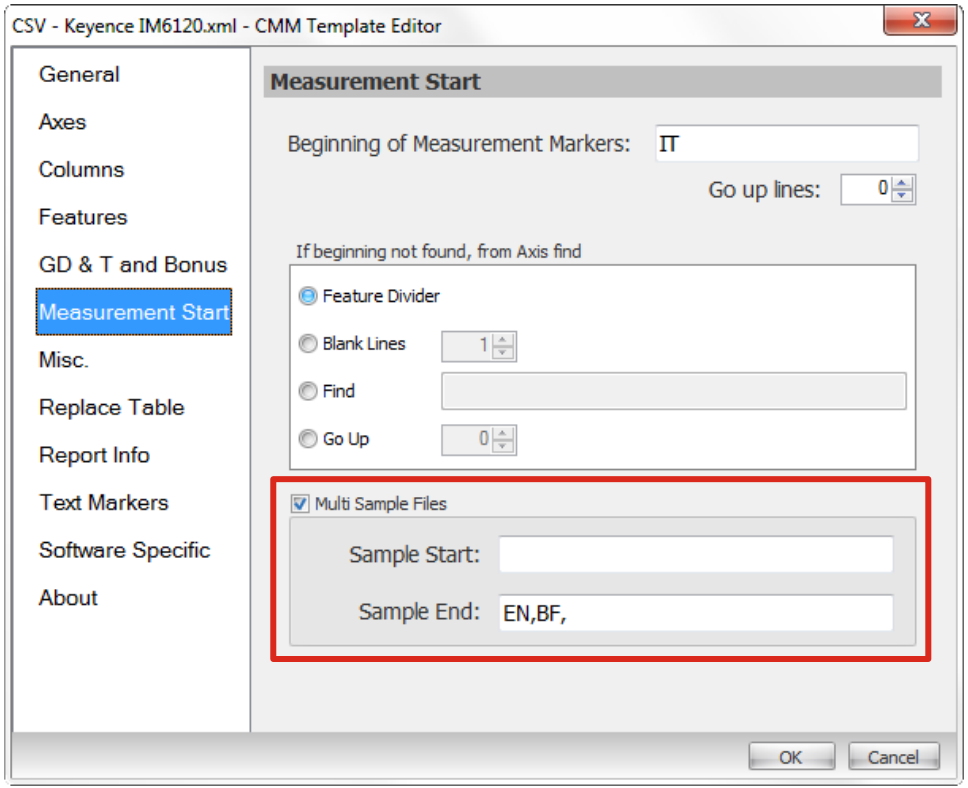
CMM Templates

Keyence IM 6120

- Since they are multiple parts inspected per files (or samples), the “Multi Sample Files” is Checked and the **Sample End** is specified.



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CMM Templates

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	A	B	C	D	E	F	G	H	I	J
1	ST	D3								
2	SE	7C413005	3.52	8B						
3	DA	1/23/2015 8:49	EB							
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13	IT	6	0.0286	inch	LN-LN007	0.0275	0.0015	-0.0015	OK	62
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15	IT	8	0.289	inch	LN-LN014	0.29	0.002	-0.002	OK	5A
16	IT	9	0.3123	inch	LN-LN009	0.3125	0.0005	-0.0005	OK	5B
17	IT	10	0.2623	inch	LN-LN013	0.263	0.001	-0.001	OK	7A
18	IT	11	0.3123	inch	LN-LN010	0.3125	0.0005	-0.0005	OK	7C
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21	EN	BF								
22	ST	D3								
23	SE	7C413005	3.52	8B						
24	DA	1/23/2015 8:51	DC							
25	MS	4333-517-1.RevB	8A							
26	LO	C7								
27	SC	2	B0							
28	CH	JRM	CC							
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34	IT	6	0.0283	inch	LN-LN007	0.0275	0.0015	-0.0015	OK	5F
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37	IT	9	0.3123	inch	LN-LN009	0.3125	0.0005	-0.0005	OK	5B
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CMM Templates

PolyWorks

- *.txt or *.rtf file

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CMM Templates

PolyWorks

- Since we have a PolyWorks template, we start by copying and editing default PolyWorks.xml Template

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CMM Templates

PolyWorks

- The files appear to be exported as a CSV-tab delimited file type, as such the default PolyWorks.xml template need to be changed to use the CSV engine.

PolyWorks Results.txt - Notepad

File Edit Format View Help

Feature

Name	Control	Nom	Meas	UpTol	LoTol	TZ Size	Dev	Test	
slot 1	Length	17.450	17.311	0.500	-0.500		-0.139	Pass	
slot 1	Width	11.000	10.901	0.500	-0.500		-0.099	Pass	
23.700	Z Distance		23.700	23.717	0.500	-0.500		0.017	Pass
slot 2	Length	17.450	17.262	0.500	-0.500		-0.188	Pass	
slot 2	Width	11.000	10.966	0.500	-0.500		-0.034	Pass	
23.7 (2)	Z Distance		23.700	23.671	0.500	-0.500		-0.029	Pass
slot 3	Length	17.450	17.291	0.500	-0.500		-0.159	Pass	
slot 3	Width	11.000	10.988	0.500	-0.500		-0.012	Pass	
23.7 (3)	Z Distance		23.700	23.709	0.500	-0.500		0.009	Pass
slot 4	Length	17.450	17.242	0.500	-0.500		-0.208	Pass	
slot 4	Width	11.000	10.984	0.500	-0.500		-0.016	Pass	
23.7 (4)	Z Distance		23.700	23.671	0.500	-0.500		-0.029	Pass
slot 5	Length	12.000	11.854	0.500	-0.500		-0.146	Pass	
slot 5	Width	8.000	7.912	0.500	-0.500		-0.088	Pass	
63	X Distance		63.000	63.406	0.500	-0.500		0.406	Pass
slot 6	Length	12.000	11.897	0.500	-0.500		-0.103	Pass	
slot 6	Width	8.000	7.957	0.500	-0.500		-0.043	Pass	
143	X Distance		143.000	143.428	0.500	-0.500		0.428	Pass
slot 7	Length	12.000	11.831	0.500	-0.500		-0.169	Pass	
slot 7	Width	8.000	7.520	0.500	-0.500		-0.480	Pass	
223	X Distance		223.000	223.483	0.500	-0.500		0.483	Pass
slot 8	Length	12.000	11.886	0.500	-0.500		-0.114	Pass	
slot 8	Width	8.000	7.877	0.500	-0.500		-0.123	Pass	
319.400	X Distance		319.400	319.823	0.500	-0.500		0.423	Pass
circle 1	Diameter				5.378	0.500	-0.500		
109.500	Y Distance		109.500	109.519	0.500	-0.500		0.019	Pass
circle 2	Diameter				5.312	0.500	-0.500		
260.500	Y Distance		260.500	260.502	0.500	-0.500		0.002	Pass
circle 3	Diameter				5.135	0.500	-0.500		
411.500	Y Distance		411.500	411.446	0.500	-0.500		-0.054	Pass
34	Y Distance		34.000	34.040	0.500	-0.500		0.040	Pass
185	Y Distance		185.000	184.880	0.500	-0.500		-0.120	Pass
336	Y Distance		336.000	335.927	0.500	-0.500		-0.073	Pass
487	Y Distance		487.000	486.698	0.500	-0.500		-0.302	Pass
585.500	Y Distance		585.500	585.579	0.500	-0.500		0.079	Pass
67.400	Y Distance		67.400	67.195	0.500	-0.500		-0.205	Pass
151.600	Y Distance		151.600	151.657	0.500	-0.500		0.057	Pass
218.400	Y Distance		218.400	218.252	0.500	-0.500		-0.148	Pass
302.600	Y Distance		302.600	302.583	0.500	-0.500		-0.017	Pass
369.400	Y Distance		369.400	369.184	0.500	-0.500		-0.216	Pass
453.600	Y Distance		453.600	453.552	0.500	-0.500		-0.048	Pass
30	Z Distance		30.000	30.273	0.500	-0.500		0.273	Pass
34 (2)	Z Distance		34.000	34.100	0.500	-0.500		0.100	Pass

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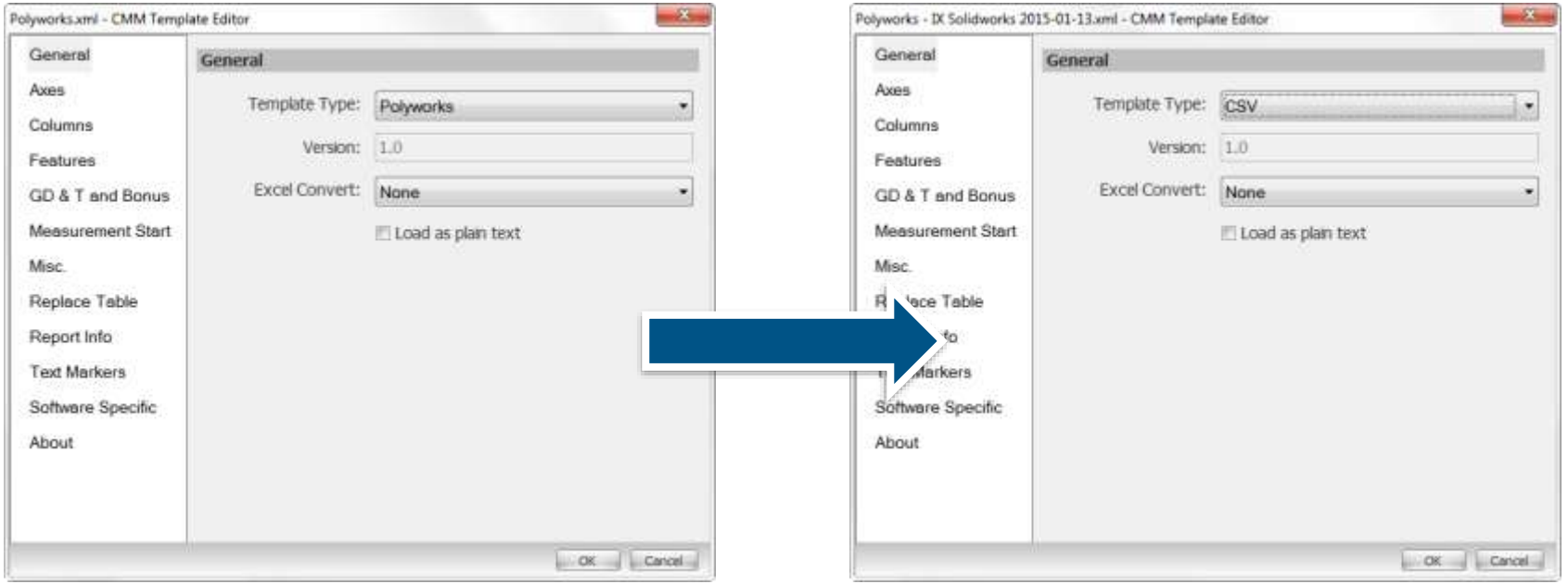
CMM Templates

PolyWorks



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CMM Templates

PolyWorks

- The Axes appear to be correct

PolyWorks Results.txt - Notepad

File Edit Format View Help

Feature

Name	Control	Nom	Meas	UpTol	LoTol	TZ Size	Dev	Test		
slot 1	Length	17.450	17.311	0.500	-0.500		-0.139	Pass		
slot 1	Width	11.000	10.901	0.500	-0.500		-0.099	Pass		
23.700	Z Distance		23.700	23.717	0.500	-0.500		0.017	Pass	
slot 2	Length	17.450	17.262	0.500	-0.500		-0.188	Pass		
slot 2	Width	11.000	10.966	0.500	-0.500		-0.034	Pass		
23.7 (2)	Z Distance		23.700	23.671	0.500	-0.500		-0.029	Pass	
slot 3	Length	17.450	17.291	0.500	-0.500		-0.159	Pass		
slot 3	Width	11.000	10.988	0.500	-0.500		-0.012	Pass		
23.7 (3)	Z Distance		23.700	23.709	0.500	-0.500		0.009	Pass	
slot 4	Length	17.450	17.242	0.500	-0.500		-0.208	Pass		
slot 4	Width	11.000	10.984	0.500	-0.500		-0.016	Pass		
23.7 (4)	Z Distance		23.700	23.671	0.500	-0.500		-0.029	Pass	
slot 5	Length	12.000	11.854	0.500	-0.500		-0.146	Pass		
slot 5	Width	8.000	7.912	0.500	-0.500		-0.088	Pass		
63	X Distance		63.000	63.406	0.500	-0.500		0.406	Pass	
slot 6	Length	12.000	11.897	0.500	-0.500		-0.103	Pass		
slot 6	Width	8.000	7.957	0.500	-0.500		-0.043	Pass		
143	X Distance		143.000	143.428	0.500	-0.500		0.428	Pass	
slot 7	Length	12.000	11.831	0.500	-0.500		-0.169	Pass		
slot 7	Width	8.000	7.520	0.500	-0.500		-0.480	Pass		
223	X Distance		223.000	223.483	0.500	-0.500		0.483	Pass	
slot 8	Length	12.000	11.886	0.500	-0.500		-0.114	Pass		
slot 8	Width	8.000	7.877	0.500	-0.500		-0.123	Pass		
319.400	X Distance		319.400	319.823	0.500	-0.500		0.423	Pass	
circle 1	Diameter				5.378	0.500	-0.500			
109.500	Y Distance		109.500	109.519	0.500	-0.500		0.019	Pass	
circle 2	Diameter				5.312	0.500	-0.500			
260.500	Y Distance		260.500	260.502	0.500	-0.500		0.002	Pass	
circle 3	Diameter				5.135	0.500	-0.500			
411.500	Y Distance		411.500	411.446	0.500	-0.500		-0.054	Pass	
34	Y Distance		34.000	34.040	0.500	-0.500		0.040	Pass	
185	Y Distance		185.000	184.880	0.500	-0.500		-0.120	Pass	
336	Y Distance		336.000	335.927	0.500	-0.500		-0.073	Pass	
487	Y Distance		487.000	486.698	0.500	-0.500		-0.302	Pass	
585.500	Y Distance		585.500	585.579	0.500	-0.500		0.079	Pass	
67.400	Y Distance		67.400	67.195	0.500	-0.500		-0.205	Pass	
151.600	Y Distance		151.600	151.657	0.500	-0.500		0.057	Pass	
218.400	Y Distance		218.400	218.252	0.500	-0.500		-0.148	Pass	
302.600	Y Distance		302.600	302.583	0.500	-0.500		-0.017	Pass	
369.400	Y Distance		369.400	369.184	0.500	-0.500		-0.216	Pass	
453.600	Y Distance		453.600	453.552	0.500	-0.500		-0.048	Pass	
30	Z Distance		30.000	30.273	0.500	-0.500		0.273	Pass	
34 (2)	Z Distance		34.000	34.100	0.500	-0.500		0.100	Pass	

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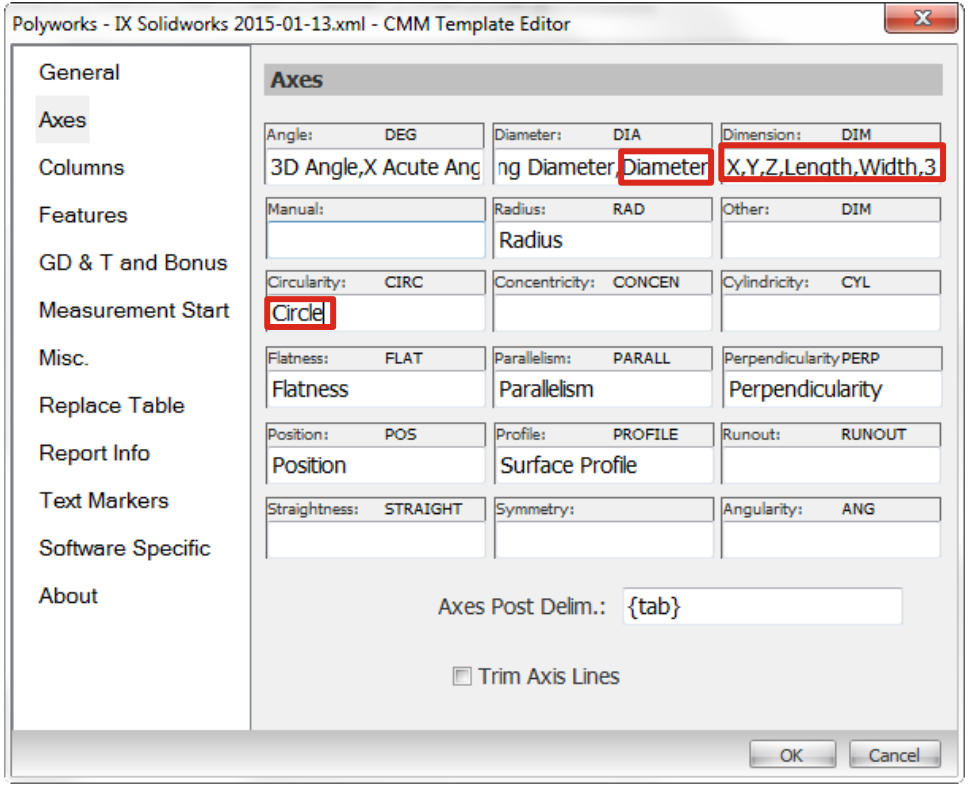
CMM Templates

PolyWorks

- The Axes appear to be correct



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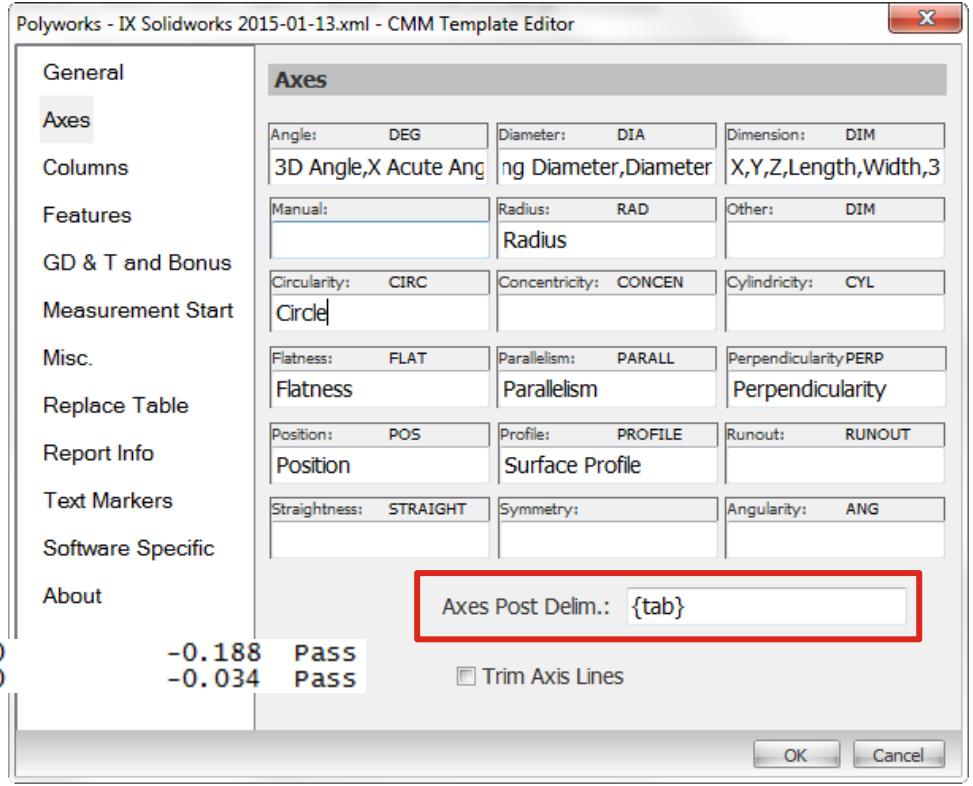
PolyWorks

- The delimiter however had to be changed to **{tab}** since each value is separated this way in the *.txt file.

```
slot 2   Length   17.450   17.262   0.500   -0.500          -0.188   Pass
slot 2   Width    11.000   10.966   0.500   -0.500          -0.034   Pass
```



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CMM Templates

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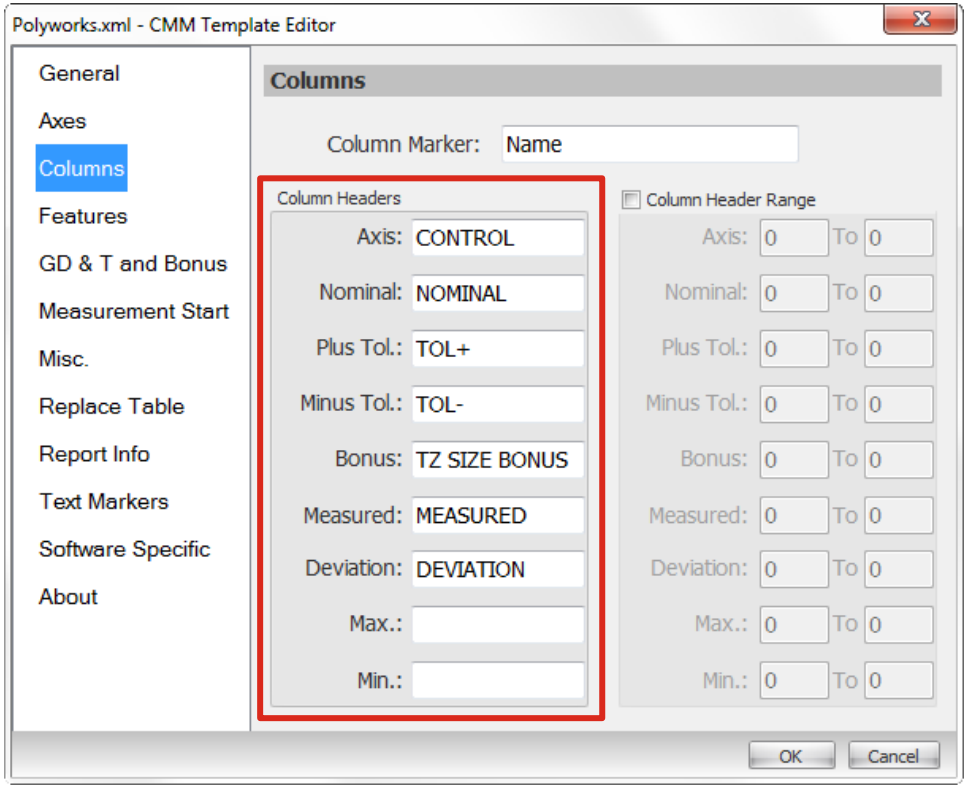
- Column Headers are incorrect and need to be updated



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CMM Templates

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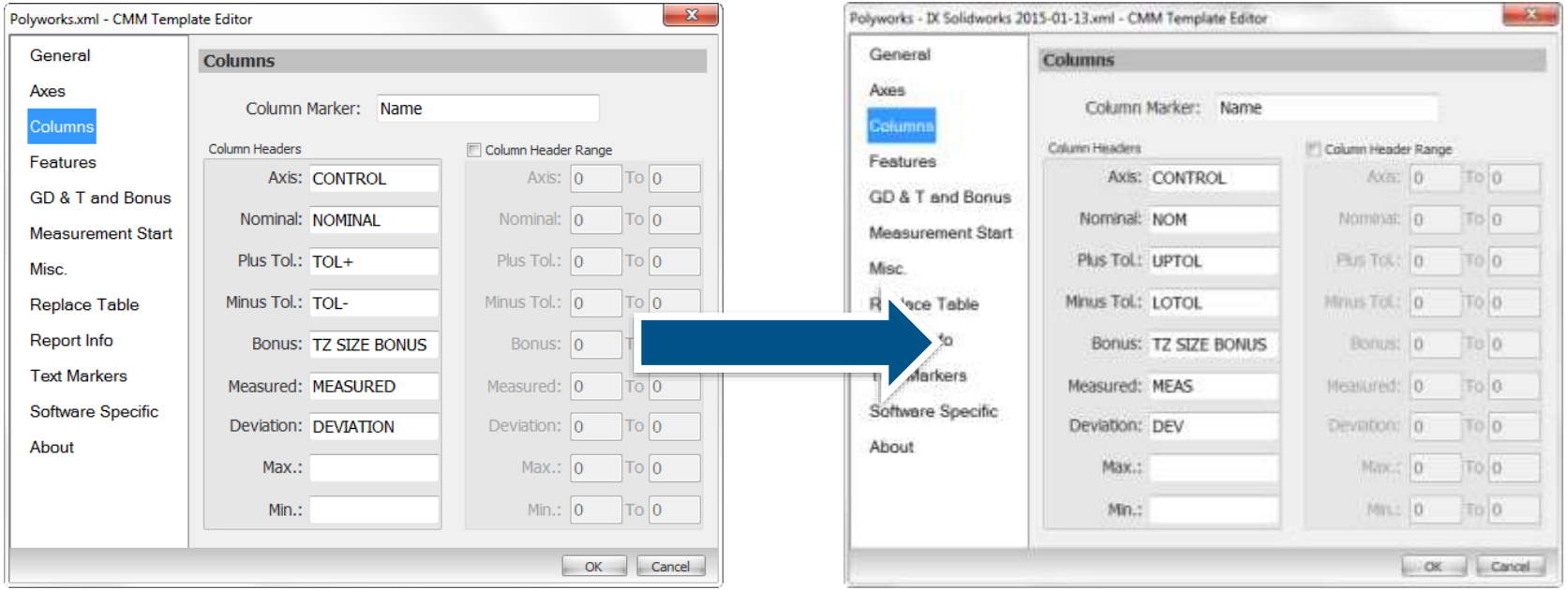

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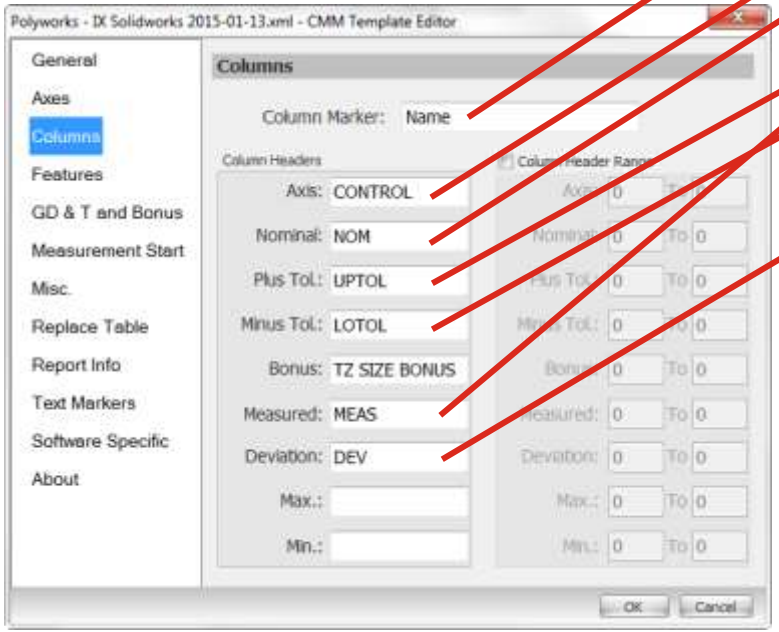
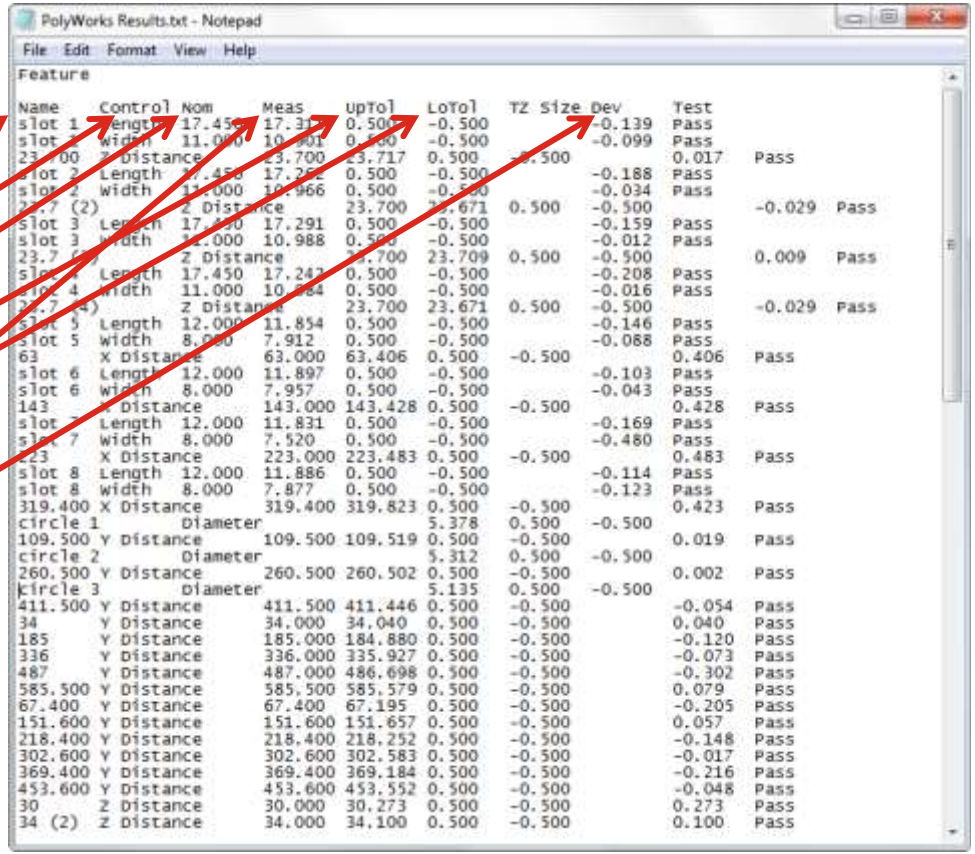
CMM Templates

PolyWorks





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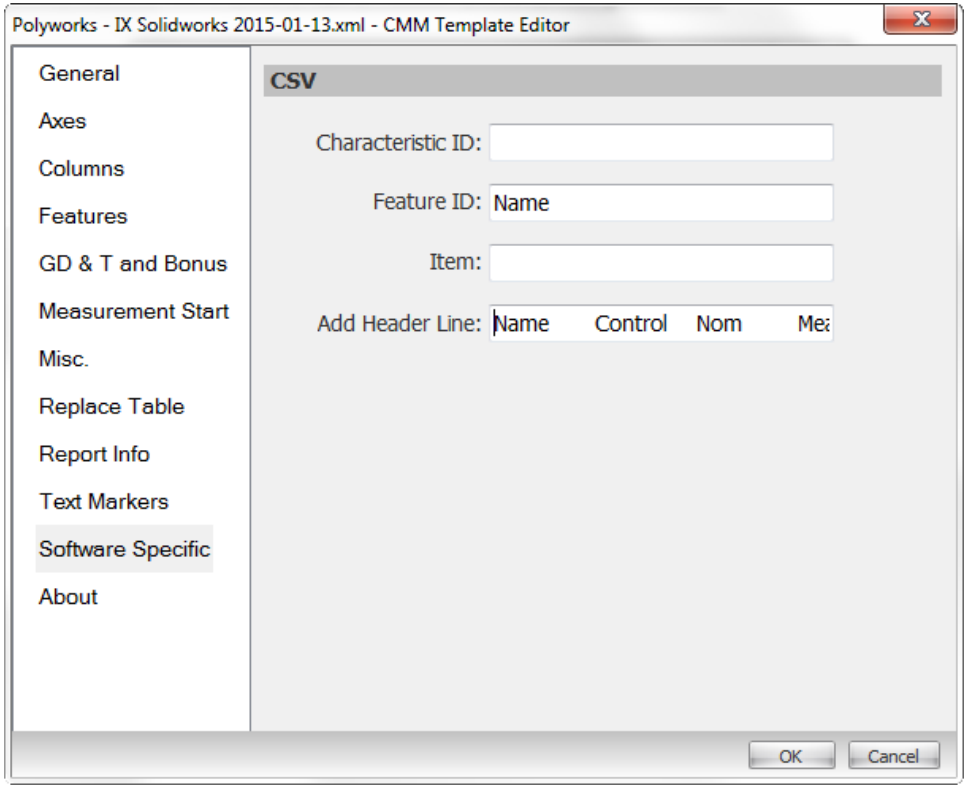
CMM Templaets

PolyWorks

- Column headers are re-specified here as well as Feature ID



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CMM Templaets

Calypso

- All the templates provided are generated and formatted with **English** values stored for the Axes identifiers.
- Users in non-English locales might need to add their **language specific terms**.
- Editing the Axes identifiers is also necessary from time to time when CMM programmers come up with unique terminology to identify annotation types.

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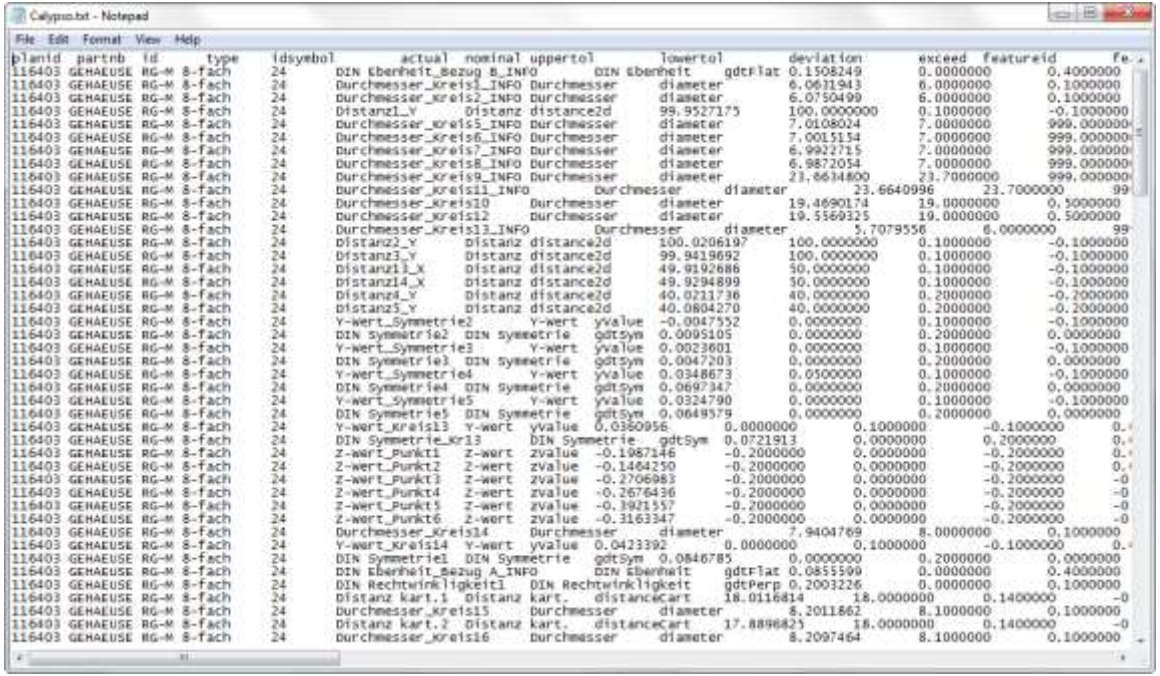
CMM Templaets

Calypso

- Sometimes visualizing the columns is difficult in *.txt format as some of them “shift”.
- Try to open the *.txt in MS Excel to clearly identify column headers, axes identifiers, etc…



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CMM Templates

Calypso

- Column Headers
- Axes (idsymbol)

A	B	C	D	E	F	G	H	I	J
planid	partnb	id	type	idsymbol	actual	nominal	uppertol	lowertol	deviation
116403 GEHAEUSE RG-M 8-fach	24	DIN Ebenheit_Bezug B_INFO	DIN Ebenheit	gdtFlat	0.1508249	0	0.4	0	0.1508249
116403 GEHAEUSE RG-M 8-fach	24	Durchmesser_Kreis1_INFO	Durchmesser	diameter	6.0631943	6	0.1	-0.1	0.0631943
116403 GEHAEUSE RG-M 8-fach	24	Durchmesser_Kreis2_INFO	Durchmesser	diameter	6.0750499	6	0.1	-0.1	0.0750499
116403 GEHAEUSE RG-M 8-fach	24	Distanz1_Y	Distanz	distance2d	99.9527175	100	0.1	-0.1	-0.0472825
116403 GEHAEUSE RG-M 8-fach	24	Durchmesser_Kreis5_INFO	Durchmesser	diameter	7.0108024	7	999	-0.2	0.0108024
116403 GEHAEUSE RG-M 8-fach	24	Durchmesser_Kreis6_INFO	Durchmesser	diameter	7.0015154	7	999	-0.2	0.0015154
116403 GEHAEUSE RG-M 8-fach	24	Durchmesser_Kreis7_INFO	Durchmesser	diameter	6.9922715	7	999	-0.2	-0.0077285
116403 GEHAEUSE RG-M 8-fach	24	Durchmesser_Kreis8_INFO	Durchmesser	diameter	6.9872054	7	999	-0.2	-0.0127946
116403 GEHAEUSE RG-M 8-fach	24	Durchmesser_Kreis9_INFO	Durchmesser	diameter	23.66348	23.7	999	-0.3	-0.03652
116403 GEHAEUSE RG-M 8-fach	24	Durchmesser_Kreis11_INFO	Durchmesser	diameter	23.6640996	23.7	999	-0.3	-0.0359004
116403 GEHAEUSE RG-M 8-fach	24	Durchmesser_Kreis10	Durchmesser	diameter	19.4690174	19	0.5	-999	0.4690174
116403 GEHAEUSE RG-M 8-fach	24	Durchmesser_Kreis12	Durchmesser	diameter	19.5569325	19	0.5	-999	0.5569325

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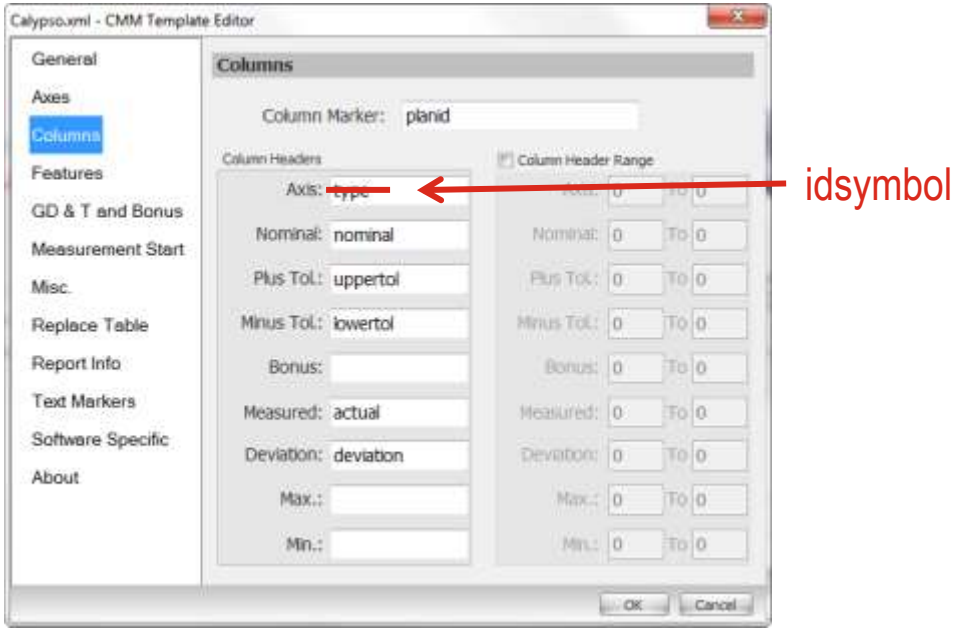
CMM Templates

Calypso



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CMM Templates

Open DMIS

```
  #####  Start Automatique: C:\SEQUENCES\KMS\MECANIQUE\YMM-2 28 002-240 Rev-G- Dessus Optique et Palpeurs      2015
NOUVELLE_PIECE
Palpeur spherique dia  0.6814442
 FT      0.0039     0.0000     0.0050     0.0000     0.0039                ++++   Flat_Pl_Sup_PALS
  X     37.5387    37.5400     0.0000    -0.0050    -0.0013                ++     H2_37.54_PALS
  Y     78.0084    78.0000     0.0000    -0.0050     0.0084     0.0084      >>>>   I5_78_PALS
 FT      0.0010     0.0000     0.0050     0.0000     0.0010                +      Flat_Pl_FERM_PALS
  Z      0.8179     0.8200     0.0000    -0.0020    -0.0021    -0.0001   <<<<    K2_0.820_PALS
  D      1.8005     1.8000     0.0040     0.0000     0.0005                ----   42_Ø
 FT      0.0016     0.0000     0.0100     0.0000     0.0016                   +   42_FT
  X    -16.4274    16.4238     0.0100    -0.0100     0.0037                   ++  42_X-p
  Y     10.4993    10.5000     0.0100    -0.0100    -0.0007                  -   42_Y-p
  X      0.0075     0.0000     0.0200     0.0000     0.0075                   -   42_Loc-p
  D      1.8003     1.8000     0.0040     0.0000     0.0003                ----   44_Ø
 FT      0.0015     0.0000     0.0100     0.0000     0.0015                   +   44_FT
  X    -11.7347    11.7312     0.0100    -0.0100     0.0034                   ++  44_X-p
  Y     10.4998    10.5000     0.0100    -0.0100    -0.0002                  -   44_Y-p
  X      0.0069     0.0000     0.0200     0.0000     0.0069                  --   44_Loc-p
  D      1.8004     1.8000     0.0040     0.0000     0.0004                ----   45_Ø
 FT      0.0014     0.0000     0.0100     0.0000     0.0014                   +   45_FT
  X     -7.0425     7.0388     0.0100    -0.0100     0.0037                   ++  45_X-p
  Y    -10.5009    10.5000     0.0100    -0.0100     0.0009                   +   45_Y-p
  X      0.0076     0.0000     0.0200     0.0000     0.0076                   -   45_Loc-p
  D      1.8004     1.8000     0.0040     0.0000     0.0004                ----   47_Ø
 FT      0.0016     0.0000     0.0100     0.0000     0.0016                   +   47_FT
  X     -2.3492     2.3462     0.0100    -0.0100     0.0029                   ++  47_X-p
  Y    -10.5009    10.5000     0.0100    -0.0100     0.0009                   +   47_Y-p
  X      0.0062     0.0000     0.0200     0.0000     0.0062                  --   47_Loc-p
  D      1.8006     1.8000     0.0040     0.0000     0.0006                 ---   50_Ø
 FT      0.0019     0.0000     0.0100     0.0000     0.0019                   +   50_FT
  X      2.3434     2.3462     0.0100    -0.0100    -0.0029                  --   50_X-p
  Y     10.5005    10.5000     0.0100    -0.0100     0.0005                   +   50_Y-p
  X      0.0058     0.0000     0.0200     0.0000     0.0058                  --   50_Loc-p
  D      1.8008     1.8000     0.0040     0.0000     0.0008                 ---   52_Ø
 FT      0.0021     0.0000     0.0100     0.0000     0.0021                   +   52_FT
  X      7.0356     7.0388     0.0100    -0.0100    -0.0031                  --   52_X-p
  Y     10.4997    10.5000     0.0100    -0.0100    -0.0003                  -   52_Y-p
  X      0.0063     0.0000     0.0200     0.0000     0.0063                  --   52_Loc-p
  D      1.8007     1.8000     0.0040     0.0000     0.0007                 ---   53_Ø
 FT      0.0014     0.0000     0.0100     0.0000     0.0014                   +   53_FT
```

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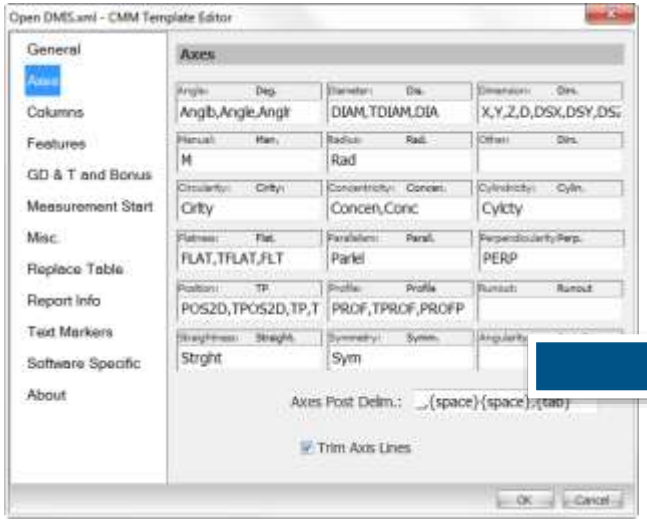
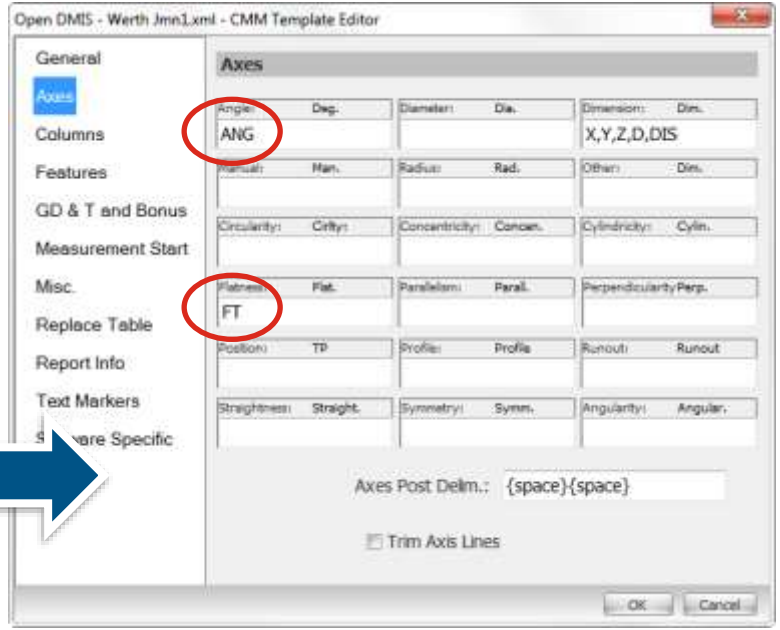
CMM Templates

Open DMIS

- Axes needs to be changed to match result file





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CMM Templates

Open DMIS

- Column are not separated by “Tabulations” but simply “Spaces”
- This is fixed by defining a “range”

Emp 2-7							
X	0.9718	0.9738	0.0000	-0.0040	-0.0020	+	K2_0.9738_PALC
X	-0.0045	0.0000	0.0020	-0.0020	-0.0045	-0.0025 <<<<	K2_0.9738_Loc_PALC
Ang	15.0297°	15.0000°	0.5000°	-0.5000°	0.0297°	+	L2_15_Deg_PALC
X	0.7974	0.8000	0.0000	-0.0040	-0.0026	--	L1_0.8_FERM_PALC
X	-0.0039	0.0000	0.0020	-0.0020	-0.0039	-0.0019 <<<<	L1_0.8_FERM_Loc_PAL
X	0.8399	0.8435	0.0000	-0.0040	-0.0036	----	FERM_Haut_PALC
X	-0.0042	0.0000	0.0020	-0.0020	-0.0042	-0.0022 <<<<	FERM_Haut_Loc_PALC
X	0.8921	0.8955	0.0000	-0.0040	-0.0034	---	FERM_Milieu_PALC
X	-0.0041	0.0000	0.0020	-0.0020	-0.0041	-0.0021 <<<<	FERM_Milieu_Loc_PAL
X	0.9441	0.9475	0.0000	-0.0040	-0.0034	---	FERM_Bas_PALC
X	-0.0043	0.0000	0.0020	-0.0020	-0.0043	-0.0023 <<<<	FERM_Bas_Loc_PALC
X	-0.0023	0.0000	0.0100	-0.0100	-0.0023	-	L4_D0.6H5_AV_X_PALC
Y	-1.4314	1.4300	0.0100	-0.0100	0.0014	+	L4_D0.6H5_AV_Y_PALC
D	0.6011	0.6000	0.0040	0.0000	0.0011	--	L4_D0.6H5_AV_PALC
FT	0.0015	0.0000	0.0040	0.0000	0.0015	++	L4_D0.6H5_AV_Fd_PAL
Dis	0.0027	0.0000	0.0100	-0.0100	0.0027	++	L4_D0.6H5_AV_Loc_PA
X	-0.0024	0.0000	0.0100	-0.0100	-0.0024	-	L4_D0.6H5_AR_X_PALC
Y	1.4284	1.4300	0.0100	-0.0100	-0.0016	-	L4_D0.6H5_AR_Y_PALC
D	0.6023	0.6000	0.0040	0.0000	0.0023	+	L4_D0.6H5_AR_PALC
FT	0.0008	0.0000	0.0040	0.0000	0.0008	+	L4_D0.6H5_AR_Fd_PAL
Dis	0.0029	0.0000	0.0100	-0.0100	0.0029	++	L4_D0.6H5_AR_Loc_PA

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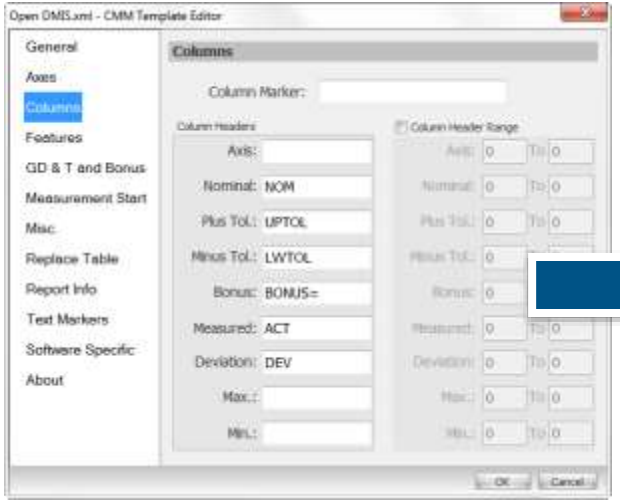
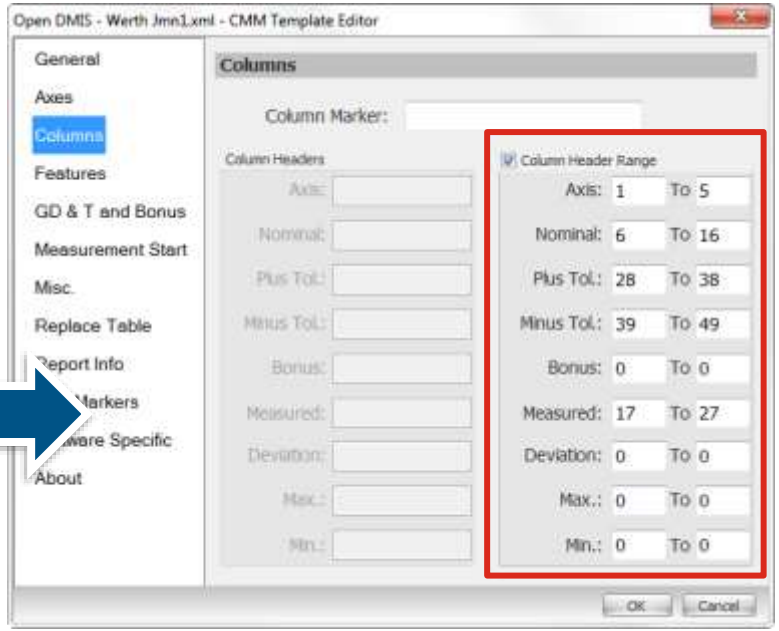
CMM Templates

Open DMIS

- Column Headers defined using a Range





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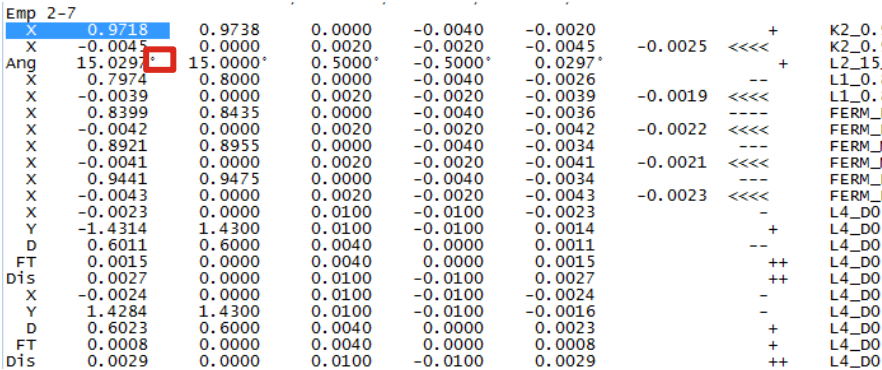
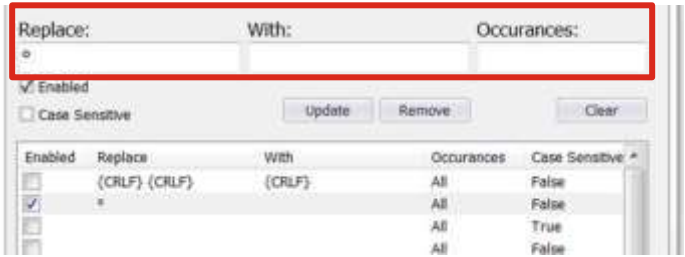
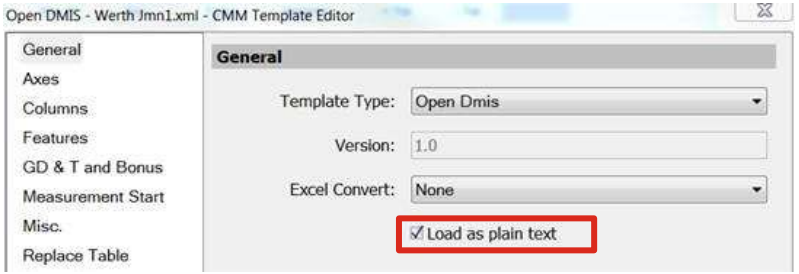
Open DMIS

- To remove the degree “°” symbols, use the replace table
- To replace the unicode characters, the “load as plain text” option need to be checked







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CMM Templates

Faro Cam2

Faro Cam 2 Results.txt - Notepad

File Edit Format View Help

Omeco				10 jul 2014 11:00		
Informações da sessão						
Descrição	RIOSTRA TECHO					
Peça N°	03000740					
Revisão	00					
Pedido de venda	2942					
N° do Relatório	740-01-001					
N° do Equipamento	810-02-13-11238					
Operador	XXX XXX					
1.5 - Ø16 ± 0.3mm		Leituras:4.				
	actual	nominal	deviation	low tol	up tol	out
Centro.x	637,786mm			-0,500mm	0,500mm	
Centro.y	43,880mm			-0,500mm	0,500mm	
Centro.z	0,588mm			-0,500mm	0,500mm	
Diâmetro	16,271mm	16,000mm	0,271mm	-0,500mm	0,500mm	0,000mm

CAM2 Measure Inspection Report 1/1

FARO

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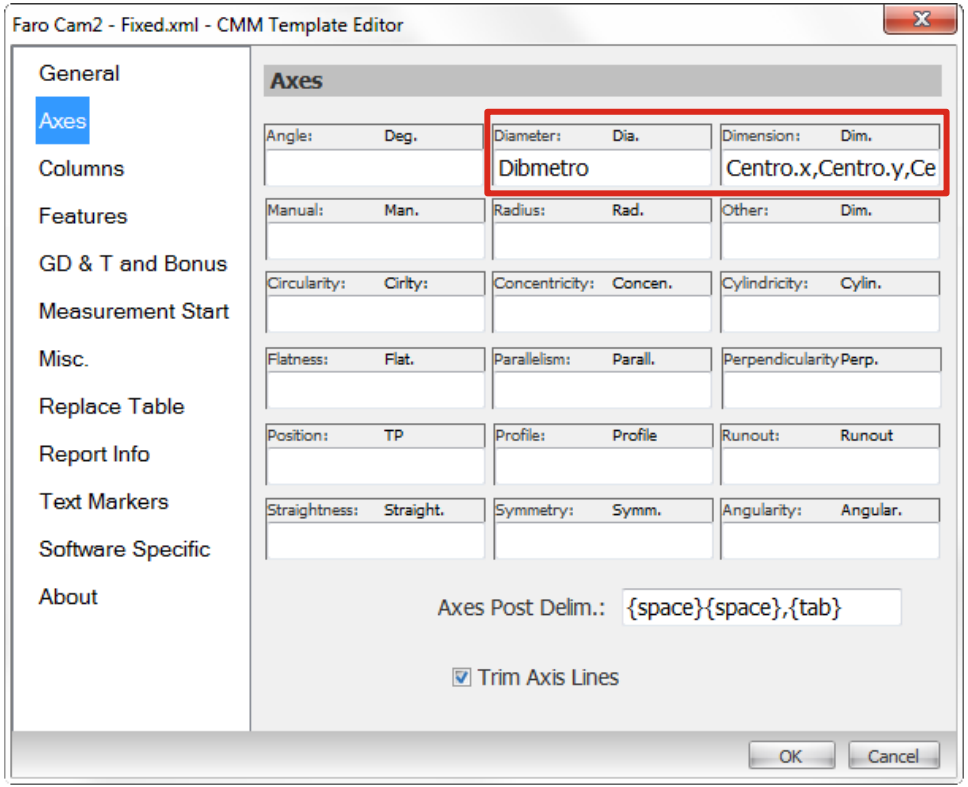
CMM Templates

Faro Cam2

- Some of the Axes identifiers are in Spanish on the result file. They need to be updated in the CMM template.



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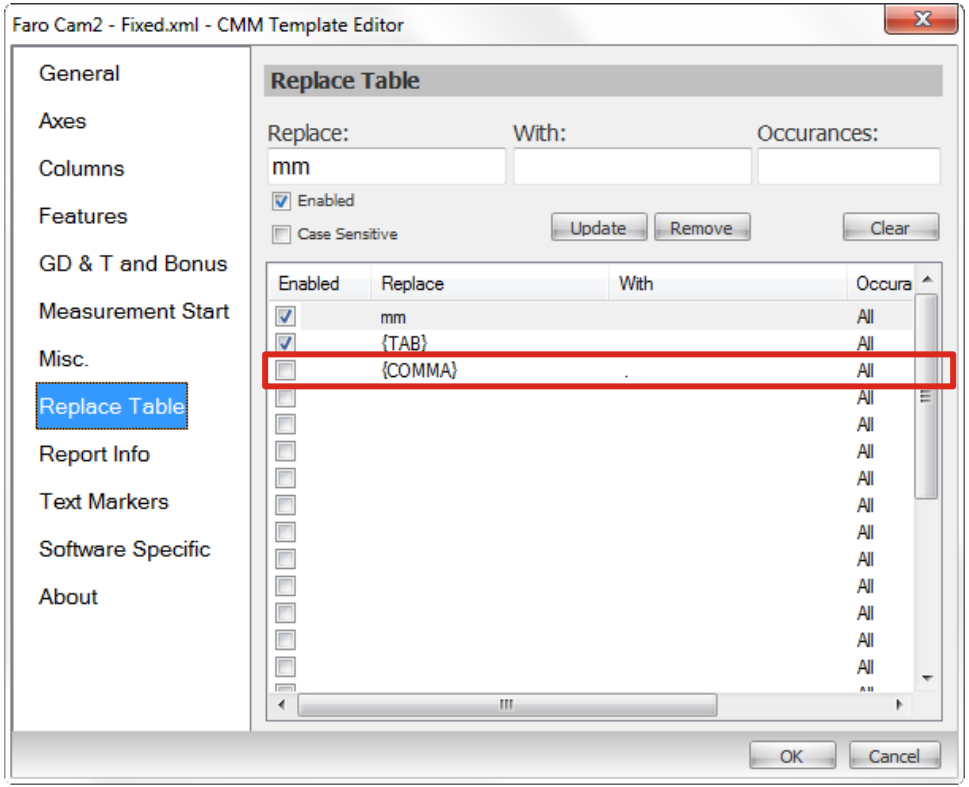
CMM Templates

Faro Cam2

- The result files uses value indicated using a regional setting with Euro formatting. (i.e. 123,45). If you are using a North American English regional setting, you need to **replace** the “comma” by a “dot”



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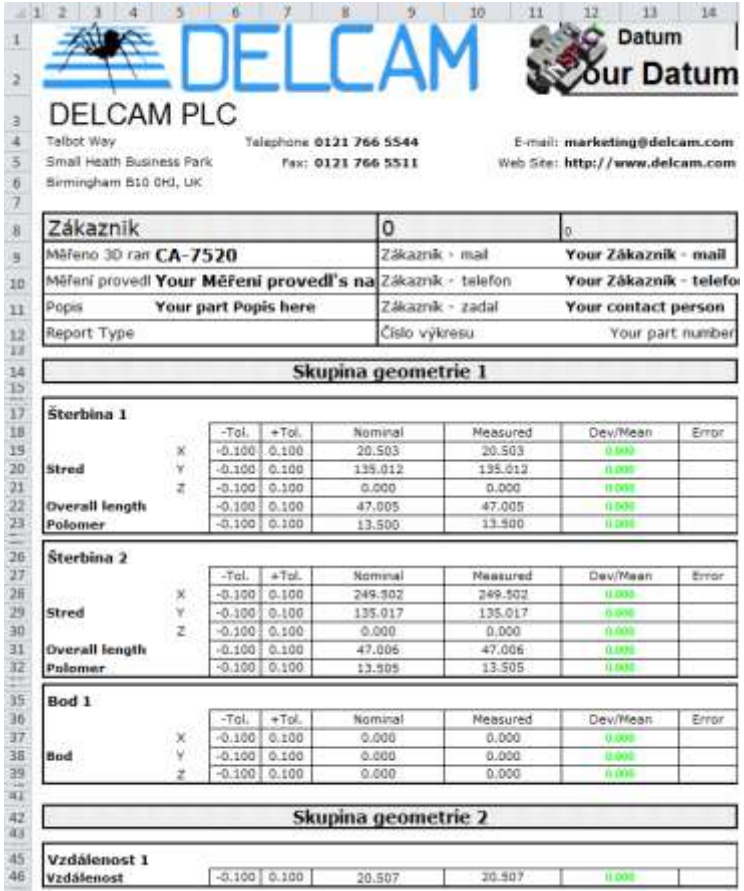
CMM Templates

PowerInspect

- The *.xls file can't be opened

- The solution is to save the *.xls as a *.txt file.



DELCAM

Datum

ur Datum

DELCAM PLC

Talbot Way
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Birmingham B10 0HJ, UK

Telephone 0121 766 5544
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E-mail: marketing@delcam.com
Web Site: http://www.delcam.com

Zákazník	0	0
Měřeno 3D ran CA-7520	Zákazník - mail	Your Zákazník - mail
Měření provedl Your Měření provedl's na	Zákazník - telefon	Your Zákazník - telefo
Popis Your part Popis here	Zákazník - zadal	Your contact person
Report Type	Číslo výkresu	Your part number

Skupina geometrie 1

Šterbina 1

		-Tol.	+Tol.	Nominal	Measured	Dev/Mean	Error
	X	-0.100	0.100	20.503	20.503	0.000	
Stred	Y	-0.100	0.100	135.012	135.012	0.000	
	Z	-0.100	0.100	0.000	0.000	0.000	
Overall length		-0.100	0.100	47.005	47.005	0.000	
Polomer		-0.100	0.100	13.500	13.500	0.000	

Šterbina 2

		-Tol.	+Tol.	Nominal	Measured	Dev/Mean	Error
	X	-0.100	0.100	249.502	249.502	0.000	
Stred	Y	-0.100	0.100	135.017	135.017	0.000	
	Z	-0.100	0.100	0.000	0.000	0.000	
Overall length		-0.100	0.100	47.006	47.006	0.000	
Polomer		-0.100	0.100	13.505	13.505	0.000	

Bod 1

		-Tol.	+Tol.	Nominal	Measured	Dev/Mean	Error
	X	-0.100	0.100	0.000	0.000	0.000	
Bod	Y	-0.100	0.100	0.000	0.000	0.000	
	Z	-0.100	0.100	0.000	0.000	0.000	

Skupina geometrie 2

Vzdálenost 1							
Vzdálenost		-0.100	0.100	20.507	20.507	0.000	

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CMM Templates

PowerInspect

- The Axes identifiers are also in Czech in the report so the template need to be updated accordingly

Šterbina 2

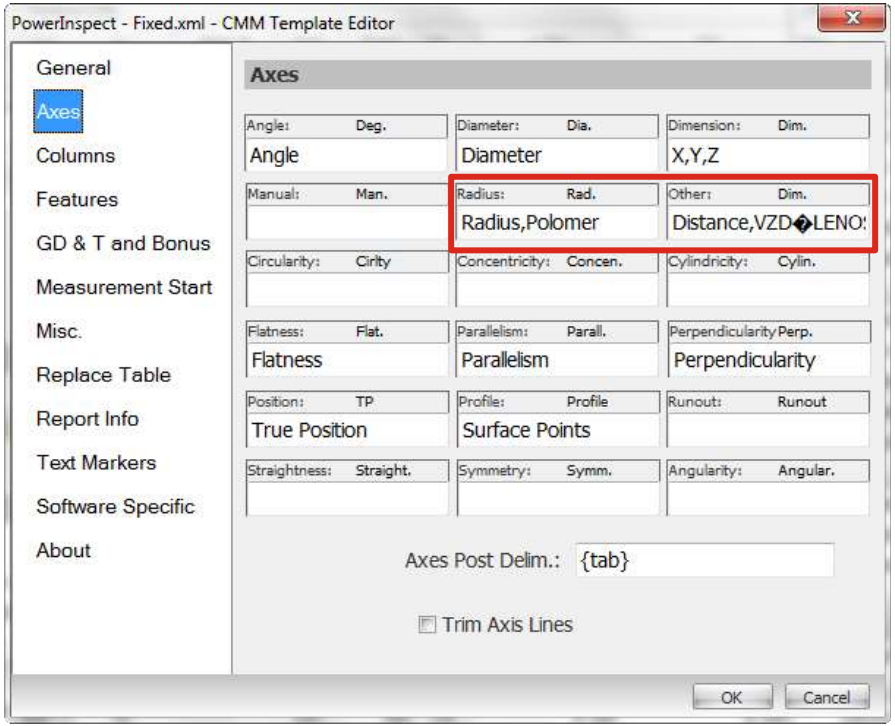
		-Tol.	+Tol.	Nominal	Measured	Dev/Mean	Error
	X	-0.100	0.100	249.502	249.502	0.000	
Stred	Y	-0.100	0.100	135.017	135.017	0.000	
	Z	-0.100	0.100	0.000	0.000	0.000	
Overall length		-0.100	0.100	47.006	47.006	0.000	
Polomer		-0.100	0.100	13.505	13.505	0.000	

Bod 1

		-Tol.	+Tol.	Nominal	Measured	Dev/Mean	Error
	X	-0.100	0.100	0.000	0.000	0.000	
Bod	Y	-0.100	0.100	0.000	0.000	0.000	
	Z	-0.100	0.100	0.000	0.000	0.000	

Skupina geometrie 2

	-Tol.	+Tol.	Nominal	Measured	Dev/Mean	Error
Vzdálenost 1						
Vzdálenost	-0.100	0.100	20.507	20.507	0.000	



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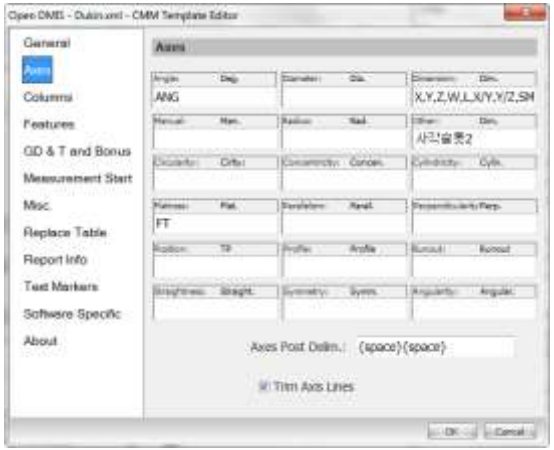
CMM Templates

Dukin

- Another example of Axes identifiers not updated to match CMM result files



Inspection Report

Inspector	Checked	Approved
/	/	/

품 명		품 번	
측정일시		측 정 자	
의뢰부서		온 도	

No.	Item	Actual	Nominal	Up Tol	Low Tol	Deviation	Evaluation
2	평면1						
	Z	165.6330					
	X/Z	0.0340					
	Y/Z	-0.1220					
	SMmf	8P	0.0620	0.1070	-0.0960	0.2030	
4	사각슬롯1						
	X	383.7700					
	Y	147.2860					
	Z	-1.8710					
	W	79.4970					
	L	221.3340					
	Y/X	-0.9240					
	SMmf	6P	0.0060	0.0070	-0.0080	0.0150	
6	평면2						
	Z	-0.0190					
	X/Z	0.0080					
	Y/Z	0.0480					
	평면도	0.2610	0.0000				Total
	SMmf	12P	0.0770	0.1390	-0.1220	0.2610	
8	사각슬롯2						

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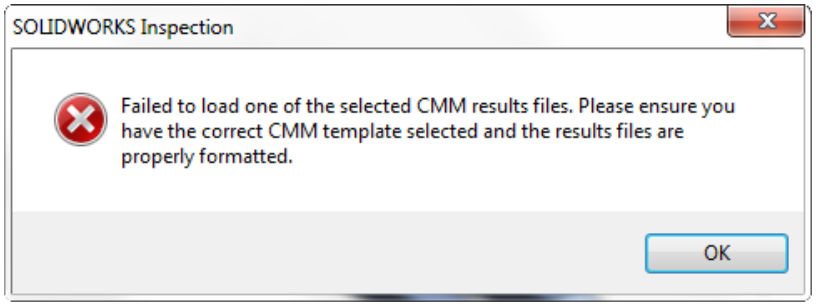
CMM Templates

Calypso

- Error when trying to import the files in **SW2015SP1.1**

- The same file opens in SW2015SP2.1.
- Make sure you are running the **latest version**! We are constantly improving the CMM Module!



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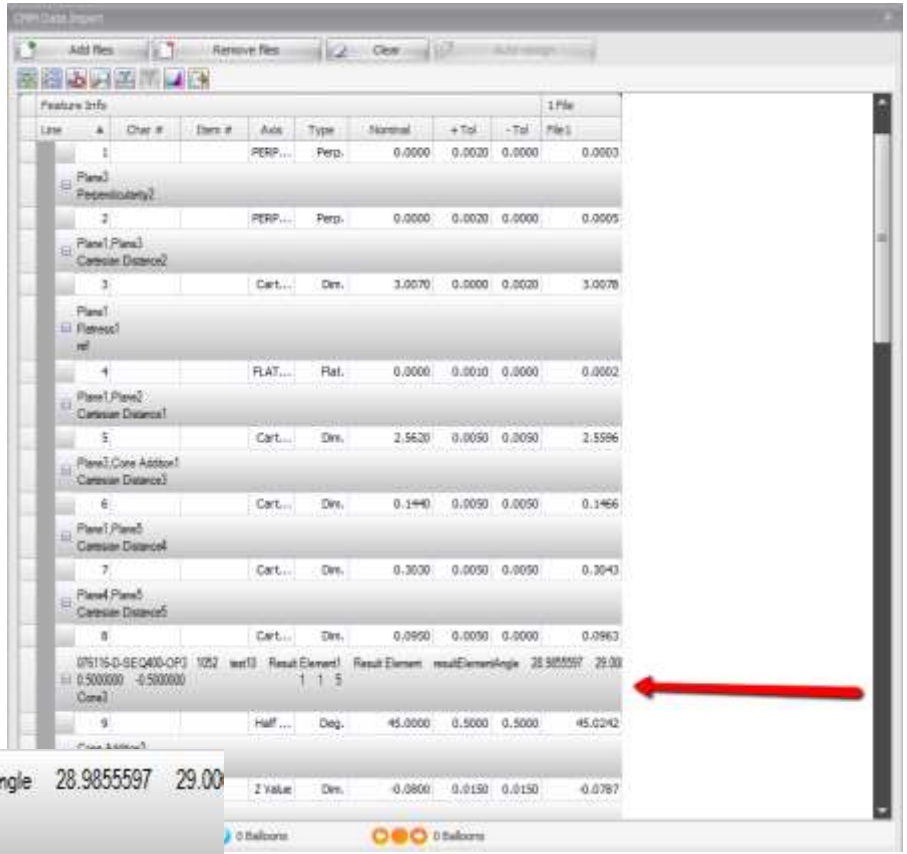
CMM Templates

Calypso

- Some of the Axes are not parsed properly!



076116-D-SEQ400-OP3 1052 test10 Result Element1 Result Element resultElementAngle 28.9855597 29.00
0.5000000 -0.5000000 1 1 5
Cone3

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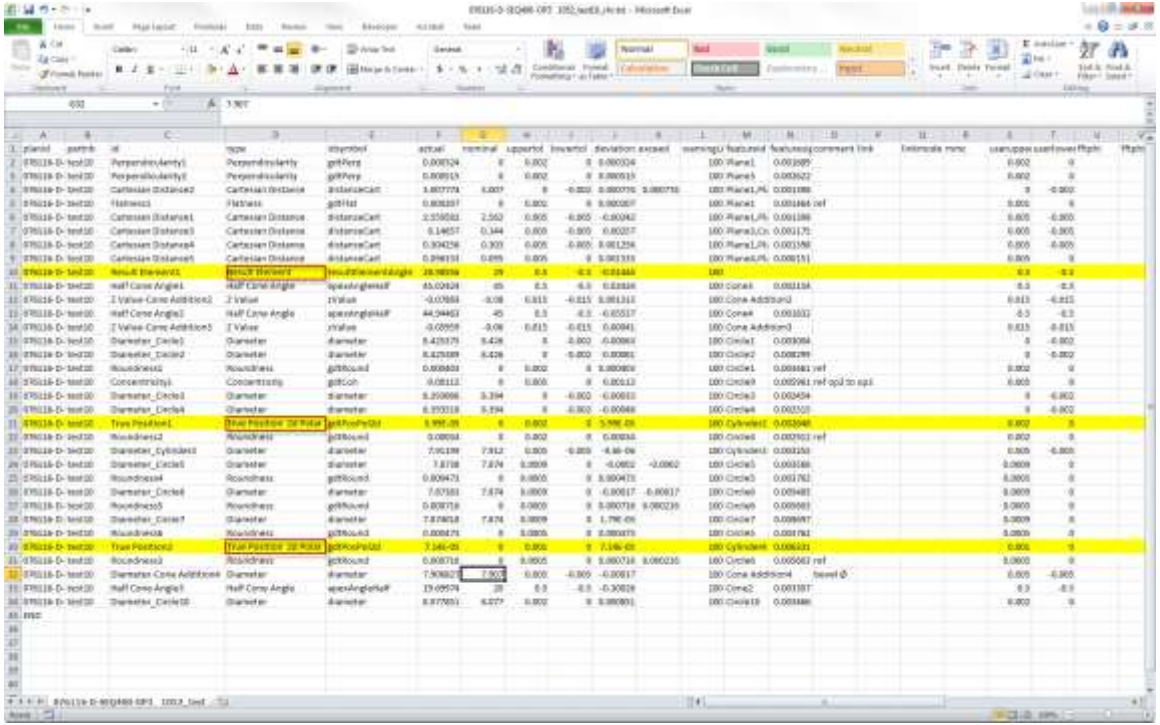
CMM Templates

Calypso

- Open the file in Excel for added clarity and find the Axes that are not parsed.



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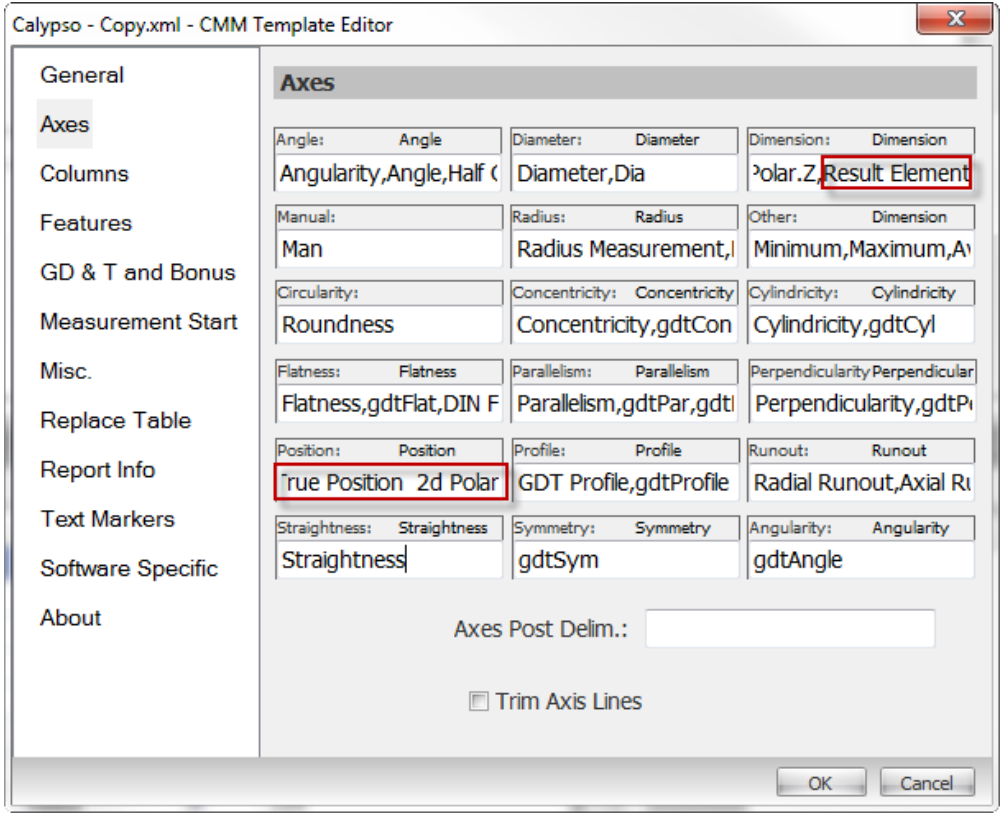
CMM Templates

Calypso

- Modify the default template to add those Axes. Make sure your are typing the exact same value!
- For example:

True Position 2d Polar

2 “spaces” !



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CMM Templates

ATOS Professional GOM

- CSV File

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CMM Templates

ATOS Professional GOM

- Since it's a brand new template based on a *.csv result file, we start by modifying the CSV.xml template

```
Element,Property,Nominal,Actual,Tol -,Tol +,Dev,Check,Out
 Rozm?r 1,Ø,12.00,12.05,0.00,0.20,0.05,0.05,
 Rozm?r 4,R,53.00,52.95,-0.30,0.30,-0.05,-0.05,
 Rozm?r 5,LY,19.50,19.38,-0.20,0.20,-0.12,-0.12,
 Rozm?r 6,LY,24.50,24.32,-0.20,0.20,-0.18,-0.18,
 Rozm?r 7,LY,31.50,31.42,-0.30,0.30,-0.08,-0.08,
 Rozm?r 8,LY,12.50,12.40,-0.15,0.15,-0.10,-0.10,
 Rozm?r 9,LX,5.00,4.90,-0.10,0.10,-0.10,-0.10,
 Rozm?r 10,Ø,84.00,84.13,-0.30,0.30,0.13,0.13,
 Rozm?r 11,Ø,76.00,75.88,-0.30,0.30,-0.12,-0.12,
 Rozm?r 12,Ø,53.00,53.21,-0.30,0.30,0.21,0.21,
 Rozm?r 13,LY,5.00,5.08,-0.10,0.10,0.08,0.08,
 Rozm?r 14,LY,10.00,9.93,-0.20,0.20,-0.07,-0.07,
 Rozm?r 15,Ø,60.00,60.15,-0.30,0.30,0.15,0.15,
 Rozm?r 16,R,48.00,47.70,-0.30,0.30,-0.30,-0.30,
 Rozm?r 17,R,5.00,5.05,-0.10,0.10,0.05,0.05,
 Rozm?r 18,R,5.00,5.10,-0.10,0.10,0.10,0.10,
 Rozm?r 19,LY,3.00,3.07,-0.10,0.10,0.07,0.07,
 Rozm?r 20,R,8.00,7.82,-0.20,0.20,-0.18,-0.18,
 Rozm?r 21,R,4.00,4.10,-0.10,0.10,0.10,0.10,
 Rozm?r 22,R,2.00,2.02,-0.10,0.10,0.02,0.02,
 Rozm?r 23,R,53.00,52.96,-0.30,0.30,-0.04,-0.04,
 Rozm?r 2,AngleXZ,120.00Degree sign,120.00Degree sign,-0.20Degree
sign,0.20Degree sign,0.00Degree sign,0.00,
 Rozm?r 3,AngleXZ,120.00Degree sign,120.06Degree sign,-0.20Degree
sign,0.20Degree sign,0.06Degree sign,0.06,
 Rozm?r 24,AngleXY,47.47Degree sign,47.27Degree sign,-0.30Degree
sign,0.30Degree sign,-0.20Degree sign,-0.20,
```

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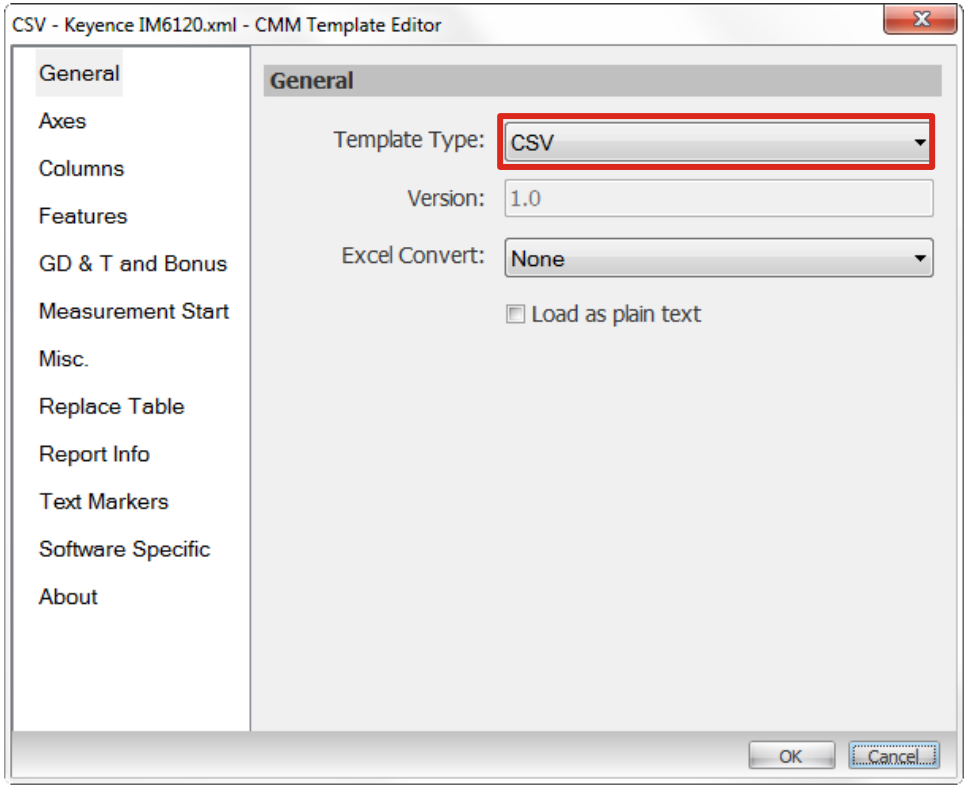
CMM Templates

ATOS Professional GOM

- Since it's a brand new template based on a *.csv result file, we start by modifying the CSV.xml template



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CMM Templates

ATOS Professional GOM

- We start by filling out the Axes. They are indicated in the column "**Property**"

```
Element,Property,Nominal,Actual,Tol -,Tol +,Dev,Check,Out
 Rozm?r 1,Ø,12.00,12.05,0.00,0.20,0.05,0.05,
 Rozm?r 4,R,53.00,52.95,-0.30,0.30,-0.05,-0.05,
 Rozm?r 5,LY,19.50,19.38,-0.20,0.20,-0.12,-0.12,
 Rozm?r 6,LY,24.50,24.32,-0.20,0.20,-0.18,-0.18,
 Rozm?r 7,LY,31.50,31.42,-0.30,0.30,-0.08,-0.08,
 Rozm?r 8,LY,12.50,12.40,-0.15,0.15,-0.10,-0.10,
 Rozm?r 9,LX,5.00,4.90,-0.10,0.10,-0.10,-0.10,
 Rozm?r 10,Ø,84.00,84.13,-0.30,0.30,0.13,0.13,
 Rozm?r 11,Ø,76.00,75.88,-0.30,0.30,-0.12,-0.12,
 Rozm?r 12,Ø,53.00,53.21,-0.30,0.30,0.21,0.21,
 Rozm?r 13,LY,5.00,5.08,-0.10,0.10,0.08,0.08,
 Rozm?r 14,LY,10.00,9.93,-0.20,0.20,-0.07,-0.07,
 Rozm?r 15,Ø,60.00,60.15,-0.30,0.30,0.15,0.15,
 Rozm?r 16,R,48.00,47.70,-0.30,0.30,-0.30,-0.30,
 Rozm?r 17,R,5.00,5.05,-0.10,0.10,0.05,0.05,
 Rozm?r 18,R,5.00,5.10,-0.10,0.10,0.10,0.10,
 Rozm?r 19,LY,3.00,3.07,-0.10,0.10,0.07,0.07,
 Rozm?r 20,R,7.00,7.82,-0.20,0.20,-0.18,-0.18,
 Rozm?r 21,R,4.00,4.10,-0.10,0.10,0.10,0.10,
 Rozm?r 22,R,2.00,2.02,-0.10,0.10,0.02,0.02,
 Rozm?r 23,R,53.00,52.96,-0.30,0.30,-0.04,-0.04,
 Rozm?r 2,AngleXZ,120.00Degree sign,120.00Degree sign,-0.20Degree
sign,0.20Degree sign,0.00Degree sign,0.00,
 Rozm?r 3,AngleXZ,120.00Degree sign,120.06Degree sign,-0.20Degree
sign,0.20Degree sign,0.06Degree sign,0.06,
 Rozm?r 24,AngleXY,47.47Degree sign,47.27Degree sign,-0.30Degree
sign,0.30Degree sign,-0.20Degree sign,-0.20,
```

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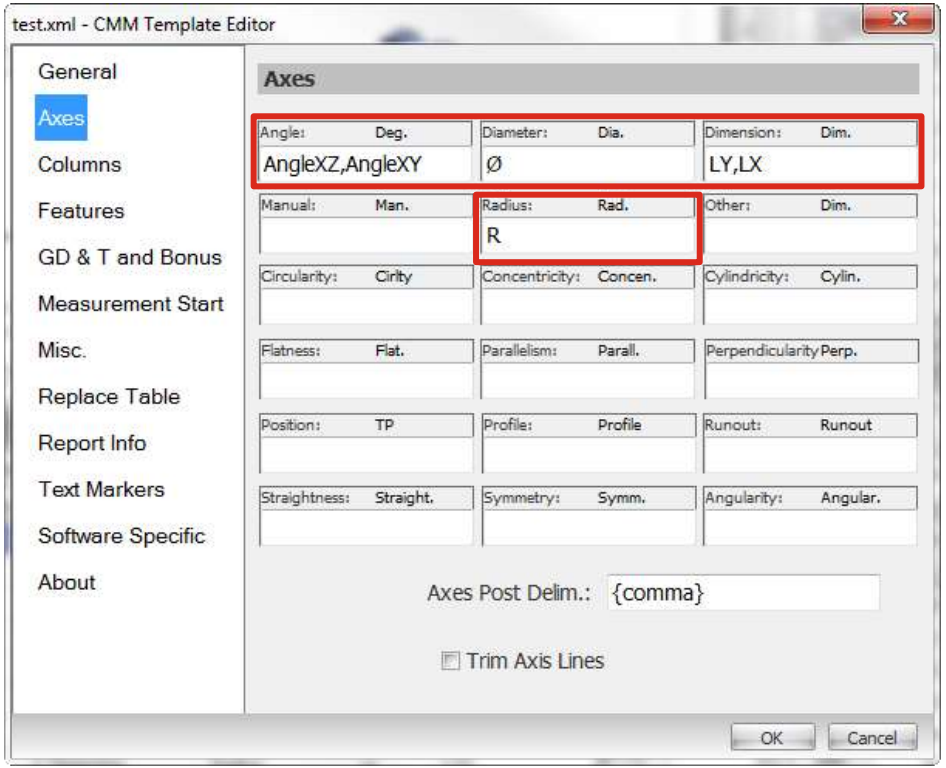
CMM Templates

ATOS Professional GOM

- We start by filling out the Axes. They are indicated in the column "**Property**": LY, LX, R, etc…



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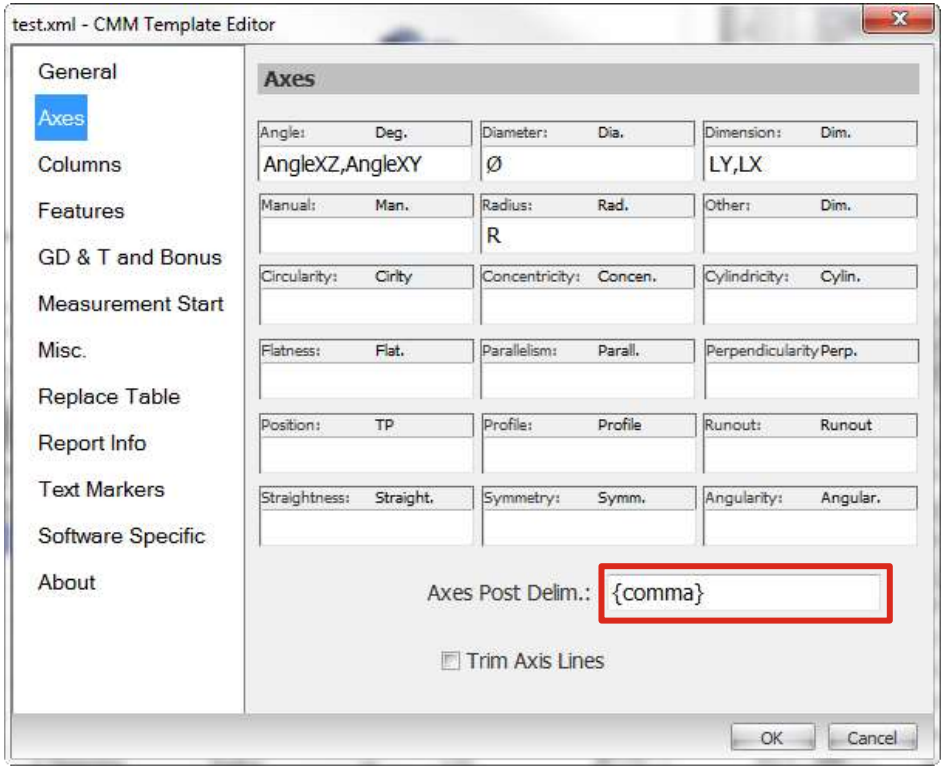
CMM Templates

ATOS Professional GOM

- Since results are delimited with “,” we indicate this in **Axes Post Delim** with **“{comma}”**

```
Element,Property,Nominal,Actual,Tol -,Tol +,Dev,Check,Out
 Rozm?r 1,Ø,12.00,12.05,0.00,0.20,0.05,0.05,
```



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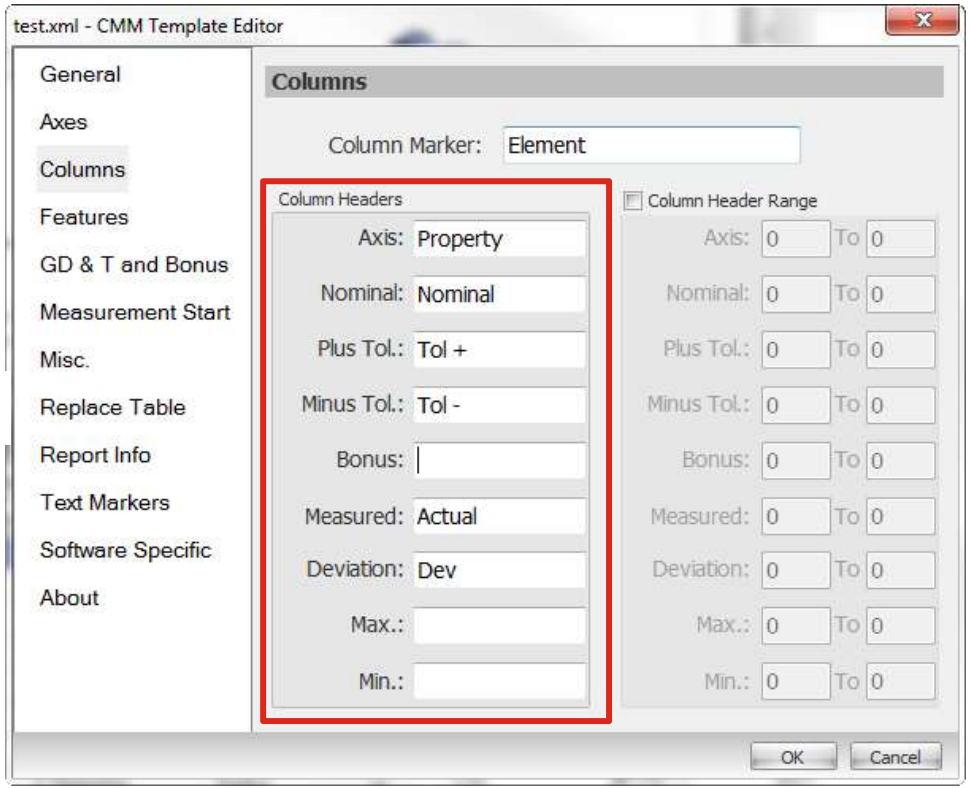
CMM Templates

ATOS Professional GOM

- Column Headers need to be indicated to allow the software to parse the results

```
Element,Property,Nominal,Actual,Tol -,Tol +,Dev,Check,Out
 Rozm?r 1,Ø,12.00,12.05,0.00,0.20,0.05,0.05,
```



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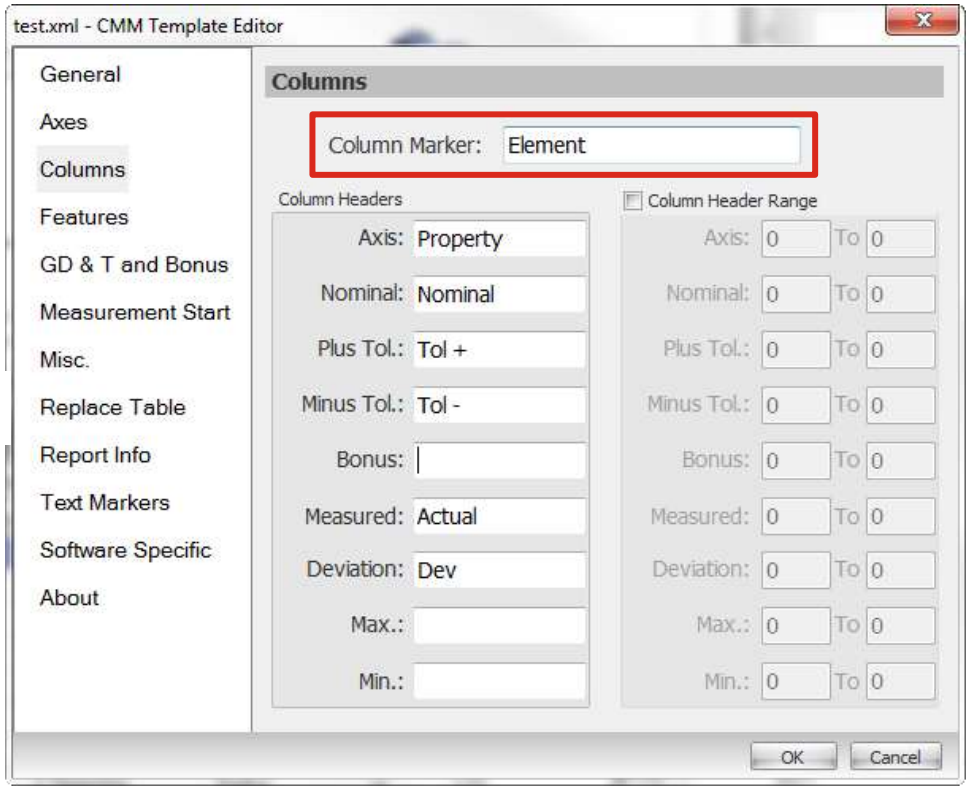
CMM Templates

ATOS Professional GOM

- Don’t forget the **Column Marker!**

```
Element,Property,Nominal,Actual,Tol -,Tol +,Dev,Check,Out
 Rozm?r 1,Ø,12.00,12.05,0.00,0.20,0.05,0.05,
```



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CMM Templates

ATOS Professional GOM

- To extract the results properly, some strings also need to be replaced
- We simply remove "**Degree sign**"

```
Element,Property,Nominal,Actual,Tol -,Tol +,Dev,Check,Out
 Rozm?r 1,Ø,12.00,12.05,0.00,0.20,0.05,0.05,
 Rozm?r 4,R,53.00,52.95,-0.30,0.30,-0.05,-0.05,
 Rozm?r 5,LY,19.50,19.38,-0.20,0.20,-0.12,-0.12,
 Rozm?r 6,LY,24.50,24.32,-0.20,0.20,-0.18,-0.18,
 Rozm?r 7,LY,31.50,31.42,-0.30,0.30,-0.08,-0.08,
 Rozm?r 8,LY,12.50,12.40,-0.15,0.15,-0.10,-0.10,
 Rozm?r 9,LX,5.00,4.90,-0.10,0.10,-0.10,-0.10,
 Rozm?r 10,Ø,84.00,84.13,-0.30,0.30,0.13,0.13,
 Rozm?r 11,Ø,76.00,75.88,-0.30,0.30,-0.12,-0.12,
 Rozm?r 12,Ø,53.00,53.21,-0.30,0.30,0.21,0.21,
 Rozm?r 13,LY,5.00,5.08,-0.10,0.10,0.08,0.08,
 Rozm?r 14,LY,10.00,9.93,-0.20,0.20,-0.07,-0.07,
 Rozm?r 15,Ø,60.00,60.15,-0.30,0.30,0.15,0.15,
 Rozm?r 16,R,48.00,47.70,-0.30,0.30,-0.30,-0.30,
 Rozm?r 17,R,5.00,5.05,-0.10,0.10,0.05,0.05,
 Rozm?r 18,R,5.00,5.10,-0.10,0.10,0.10,0.10,
 Rozm?r 19,LY,3.00,3.07,-0.10,0.10,0.07,0.07,
 Rozm?r 20,R,8.00,7.82,-0.20,0.20,-0.18,-0.18,
 Rozm?r 21,R,4.00,4.10,-0.10,0.10,0.10,0.10,
 Rozm?r 22,R,2.00,2.02,-0.10,0.10,0.02,0.02,
 Rozm?r 23,R,53.00,52.96,-0.30,0.30,-0.04,-0.04,
 Rozm?r 2,AngleXZ,120.00Degree sign,120.00Degree sign,-0.20Degree
sign,0.20Degree sign,0.00Degree sign,0.00,
 Rozm?r 3,AngleXZ,120.00Degree sign,120.06Degree sign,-0.20Degree
sign,0.20Degree sign,0.06Degree sign,0.06,
 Rozm?r 24,AngleXY,47.47Degree sign,47.27Degree sign,-0.30Degree
sign,0.30Degree sign,-0.20Degree sign,-0.20,
```

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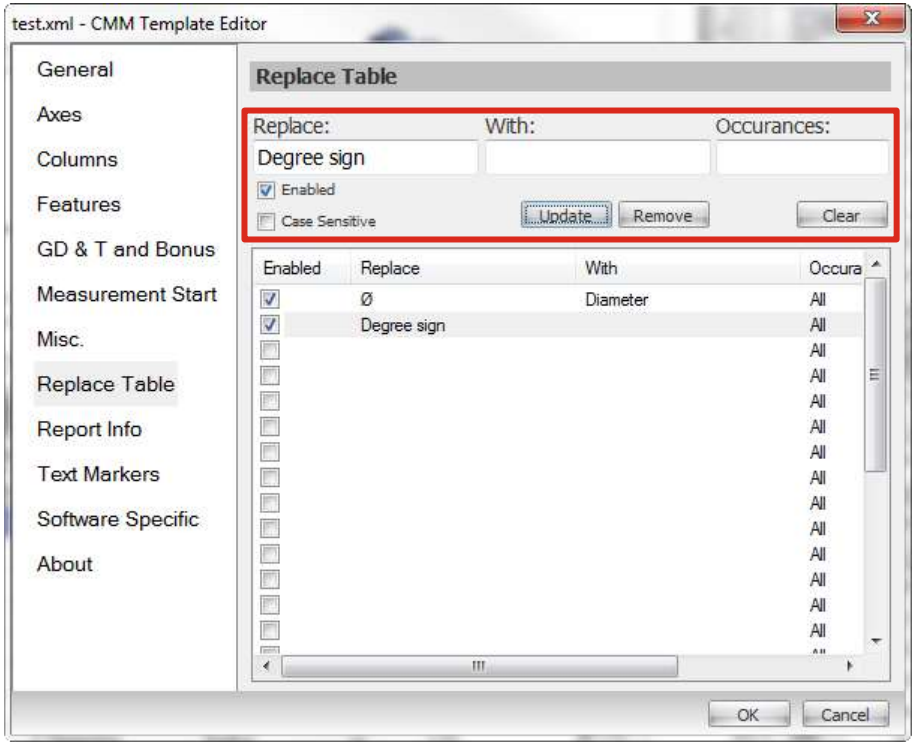
CMM Templates

ATOS Professional GOM

- To extract the results properly, some strings also need to be replaced
- We simply remove “**Degree sign**”



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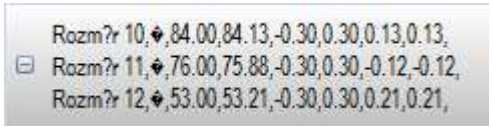
- The diameter symbol Ø however can't be used as an Axes and prevent the diameter results from being extracted




```
Element,Property,Nominal,Actual,Tol -,Tol +,Dev,Check,Out
 Rozm?r 1,Ø,12.00,12.05,0.00,0.20,0.05,0.05,
 Rozm?r 4,R,53.00,52.95,-0.30,0.30,-0.05,-0.05,
 Rozm?r 5,LY,19.50,19.38,-0.20,0.20,-0.12,-0.12,
 Rozm?r 6,LY,24.50,24.32,-0.20,0.20,-0.18,-0.18,
 Rozm?r 7,LY,31.50,31.42,-0.30,0.30,-0.08,-0.08,
 Rozm?r 8,LY,12.50,12.40,-0.15,0.15,-0.10,-0.10,
 Rozm?r 9,LX,5.00,4.90,-0.10,0.10,-0.10,-0.10,
 Rozm?r 10,Ø,84.00,84.13,-0.30,0.30,0.13,0.13,
 Rozm?r 11,Ø,76.00,75.88,-0.30,0.30,-0.12,-0.12,
 Rozm?r 12,Ø,53.00,53.21,-0.30,0.30,0.21,0.21,
 Rozm?r 13,LY,5.00,5.08,-0.10,0.10,0.08,0.08,
 Rozm?r 14,LY,10.00,9.93,-0.20,0.20,-0.07,-0.07,
 Rozm?r 15,Ø,60.00,60.15,-0.30,0.30,0.15,0.15,
 Rozm?r 16,R,48.00,47.70,-0.30,0.30,-0.30,-0.30,
 Rozm?r 17,R,5.00,5.05,-0.10,0.10,0.05,0.05,
 Rozm?r 18,R,5.00,5.10,-0.10,0.10,0.10,0.10,
 Rozm?r 19,LY,3.00,3.07,-0.10,0.10,0.07,0.07,
 Rozm?r 20,R,8.00,7.82,-0.20,0.20,-0.18,-0.18,
 Rozm?r 21,R,4.00,4.10,-0.10,0.10,0.10,0.10,
 Rozm?r 22,R,2.00,2.02,-0.10,0.10,0.02,0.02,
 Rozm?r 23,R,53.00,52.96,-0.30,0.30,-0.04,-0.04,
 Rozm?r 2,AngleXZ,120.00Degree sign,120.00Degree sign,-0.20Degree
sign,0.20Degree sign,0.00Degree sign,0.00,
 Rozm?r 3,AngleXZ,120.00Degree sign,120.06Degree sign,-0.20Degree
sign,0.20Degree sign,0.06Degree sign,0.06,
 Rozm?r 24,AngleXY,47.47Degree sign,47.27Degree sign,-0.30Degree
sign,0.30Degree sign,-0.20Degree sign,-0.20,
```

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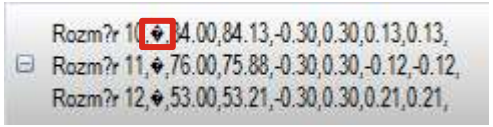
- This indicate an text encoding issue: You **can't** replace this Ø symbol using the table so either the CMM Programmer change the CMM program to indicate Dia or Diameter instead of Ø in the CMM results OR the results files are encoded using Unicode or Utf8 (Not ANSI!)



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- This can be done using NotePad!

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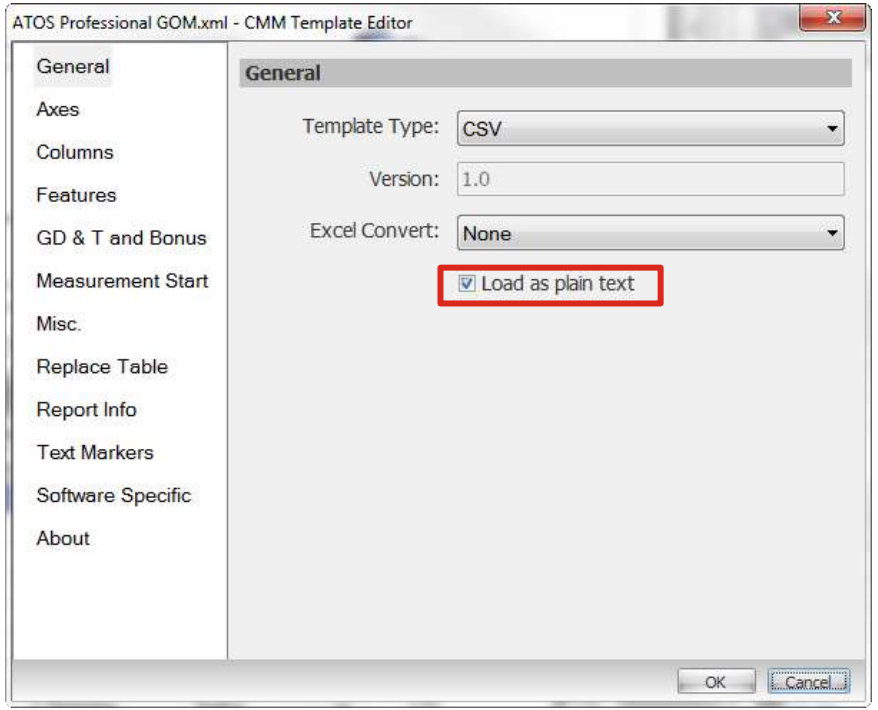
- However, the best and easiest way to use unicode characters it to simply turn this option on!



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- After all this, the CMM results can be imported properly…

Feature Info								1 File
Line	...	...	Axis	Type	No...	+ Tol	- Tol	File1
Char: 1								
1			Di...	Dia.	12.00	0.20	0.00	12.05
2			R	Rad.	53.00	0.30	0.30	52.95
3			LY	Dim.	19.50	0.20	0.20	19.38
4			LY	Dim.	24.50	0.20	0.20	24.32
5			LY	Dim.	31.50	0.30	0.30	31.42
6			LY	Dim.	12.50	0.15	0.15	12.40
7			LX	Dim.	5.00	0.10	0.10	4.90
8			Di...	Dia.	84.00	0.30	0.30	84.13
9			Di...	Dia.	76.00	0.30	0.30	75.88
10			Di...	Dia.	53.00	0.30	0.30	53.21
11			LY	Dim.	5.00	0.10	0.10	5.08
12			LY	Dim.	10.00	0.20	0.20	9.93
13			Di...	Dia.	60.00	0.30	0.30	60.15
14			R	Rad.	48.00	0.30	0.30	47.70
15			R	Rad.	5.00	0.10	0.10	5.05
16			R	Rad.	5.00	0.10	0.10	5.10
17			LY	Dim.	3.00	0.10	0.10	3.07
18			R	Rad.	8.00	0.20	0.20	7.82
19			R	Rad.	4.00	0.10	0.10	4.10
20			R	Rad.	2.00	0.10	0.10	2.02
21			R	Rad.	53.00	0.30	0.30	52.96
22			An...	Deg.	120.00	0.20	0.20	120.00
23			An...	Deg.	120.00	0.20	0.20	120.06
24			An...	Deg.	47.47	0.30	0.30	47.27

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Nikon Metrology

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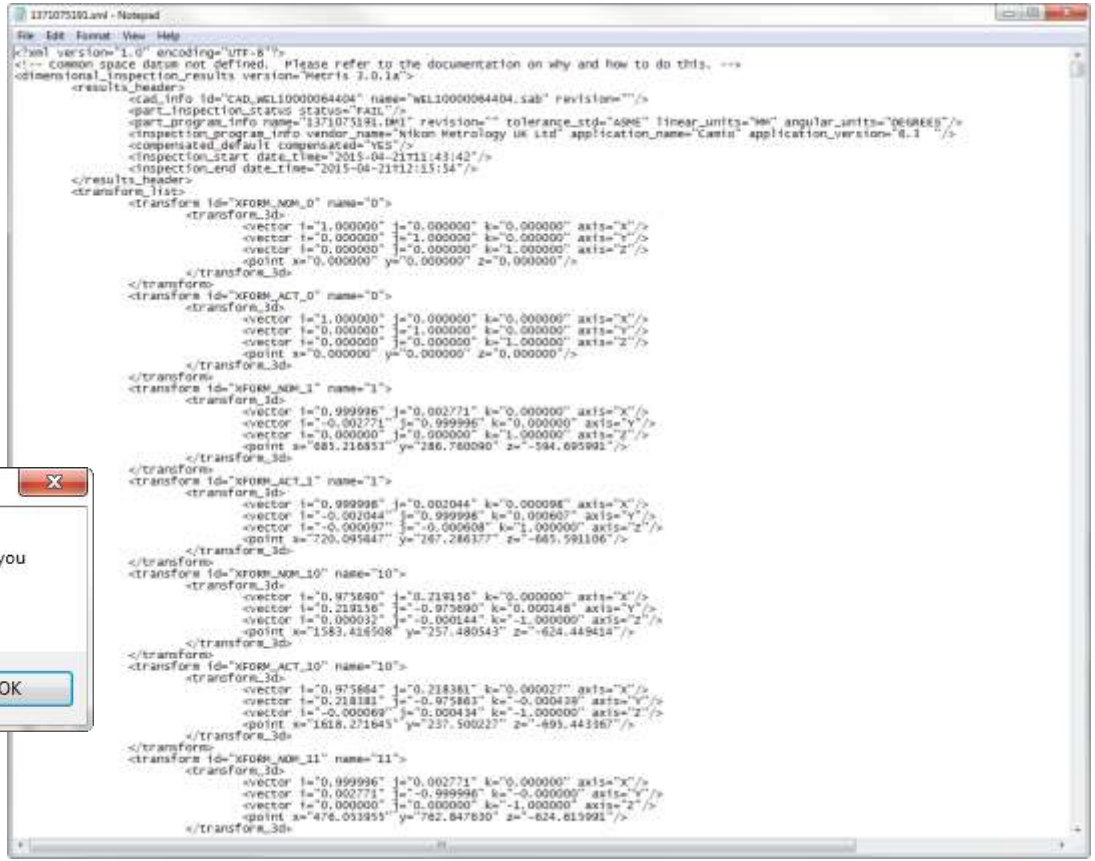
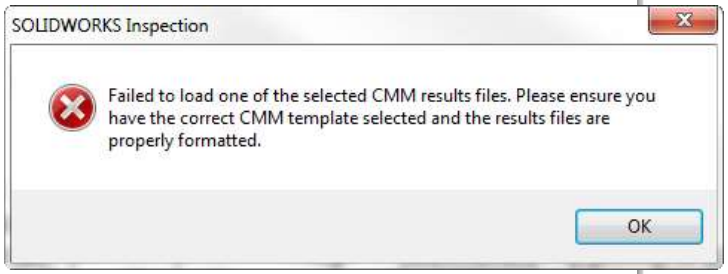
Nikon Metrology

- Camio XML result file impossible to load





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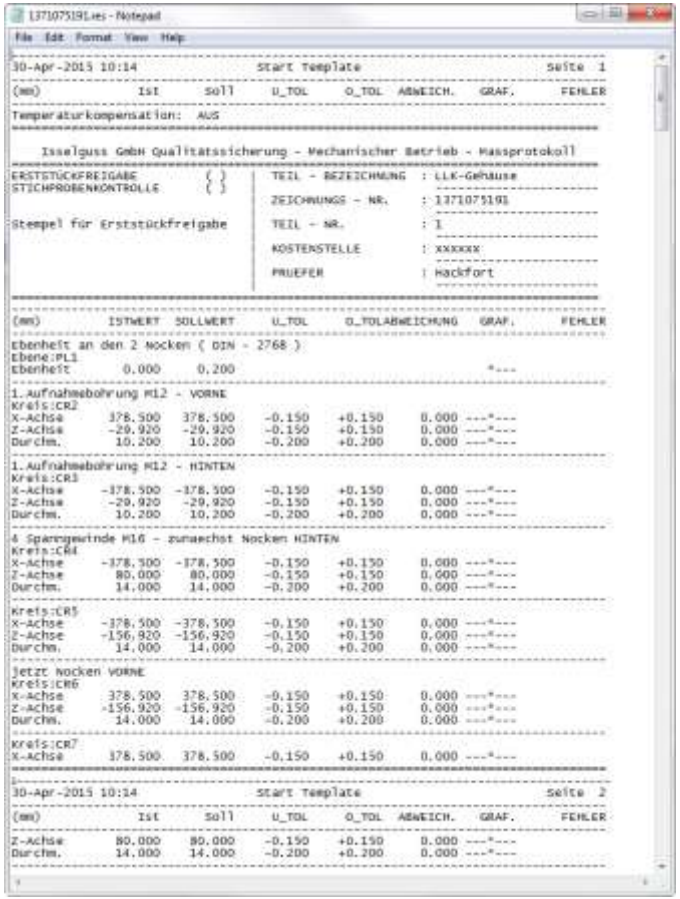
Nikon Metrology

- Customer send more files, one of them looks similar to PC-DMIS type result files!
- Result file is very well structured!



```
1371075191.res - Notepad
File  Edit  Format  View  Help

30-Apr-2015 10:14                    Start Template                          Seite  1
(mm)              Ist        Soll      U_TOL     O_TOL  ABWEICH.    GRAF.      FEHLER
Temperaturkompensation:  AUS

    Isselguss GmbH Qualitätssicherung - Mechanischer Betrieb - Massprotokoll

ERSTSTÜCKFREIGABE          ( )     TEIL - BEZEICHNUNG  : LLK-Gehäuse
STICHPROBENKONTROLLE       ( )     ZEICHNUNGS - NR.    : 1371075191
Stempel für Erststückfreigabe      TEIL - NR.          : 1
                                   KOSTENSTELLE        : xxxxxx
                                   PRUEFER             : Hackfort

(mm)          ISTWERT  SOLLWERT     U_TOL     O_TOLABWEICHUNG   GRAF.      FEHLER
Ebenheit an den 2 Nocken ( DIN - 2768 )
Ebene:PL1
Ebenheit        0.000     0.200                                    *---
1.Aufnahmebohrung M12 - VORNE
Kreis:CR2
X-Achse       378.500   378.500    -0.150    +0.150     0.000 ---*---
Z-Achse       -29.920   -29.920    -0.150    +0.150     0.000 ---*---
Durchm.        10.200    10.200    -0.200    +0.200     0.000 ---*---
1.Aufnahmebohrung M12 - HINTEN
Kreis:CR3
X-Achse      -378.500  -378.500    -0.150    +0.150     0.000 ---*---
Z-Achse       -29.920   -29.920    -0.150    +0.150     0.000 ---*---
Durchm.        10.200    10.200    -0.200    +0.200     0.000 ---*---
4 Spannzwinde M16 - zunaechst Nocken HINTEN
Kreis:CR4
X-Achse      -378.500  -378.500    -0.150    +0.150     0.000 ---*---
Z-Achse        80.000    80.000    -0.150    +0.150     0.000 ---*---
Durchm.        14.000    14.000    -0.200    +0.200     0.000 ---*---
Kreis:CR5
X-Achse      -378.500  -378.500    -0.150    +0.150     0.000 ---*---
Z-Achse      -156.920  -156.920    -0.150    +0.150     0.000 ---*---
Durchm.        14.000    14.000    -0.200    +0.200     0.000 ---*---
jetzt Nocken VORNE
Kreis:CR6
X-Achse       378.500   378.500    -0.150    +0.150     0.000 ---*---
Z-Achse      -156.920  -156.920    -0.150    +0.150     0.000 ---*---
Durchm.        14.000    14.000    -0.200    +0.200     0.000 ---*---
Kreis:CR7
X-Achse       378.500   378.500    -0.150    +0.150     0.000 ---*---

30-Apr-2015 10:14                    Start Template                          Seite  2
(mm)              Ist        Soll      U_TOL     O_TOL  ABWEICH.    GRAF.      FEHLER
Z-Achse        80.000    80.000    -0.150    +0.150     0.000 ---*---
Durchm.        14.000    14.000    -0.200    +0.200     0.000 ---*---
```

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