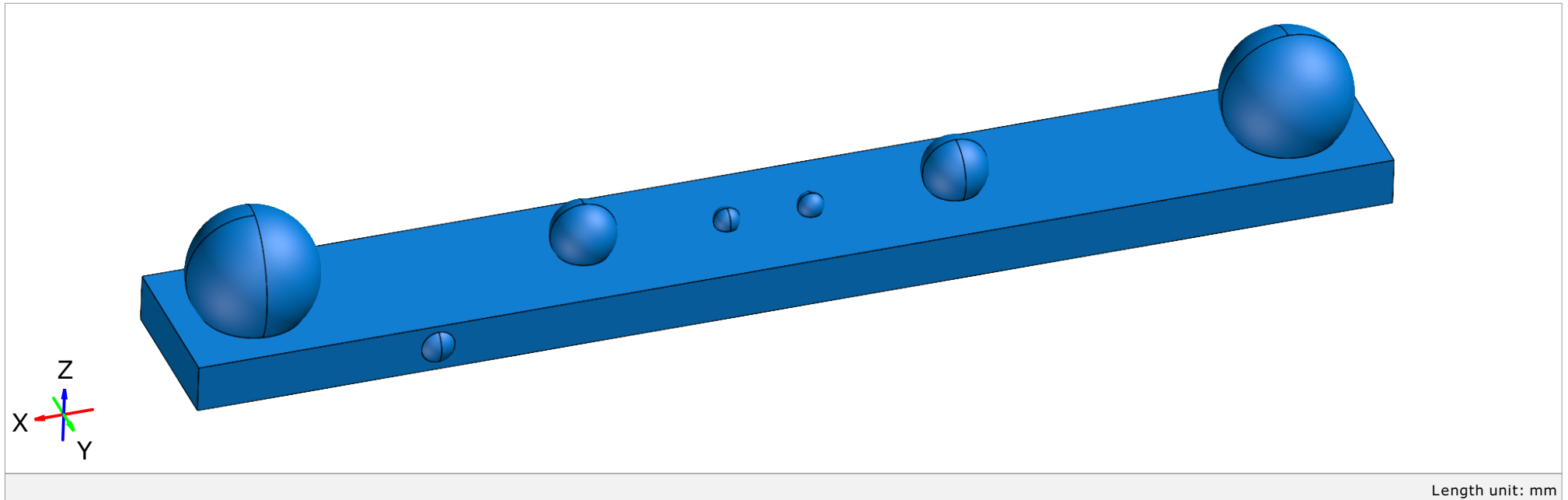


CAD Model - Nominal dimension



Inspector: Lakshman Kumar Ramesh

Company: Technicka Univerzita v Liberci

Department: KSA

Location: Liberec

Date: 18-04-2021

Project: Acceptance Test

Part:

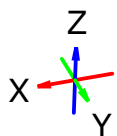
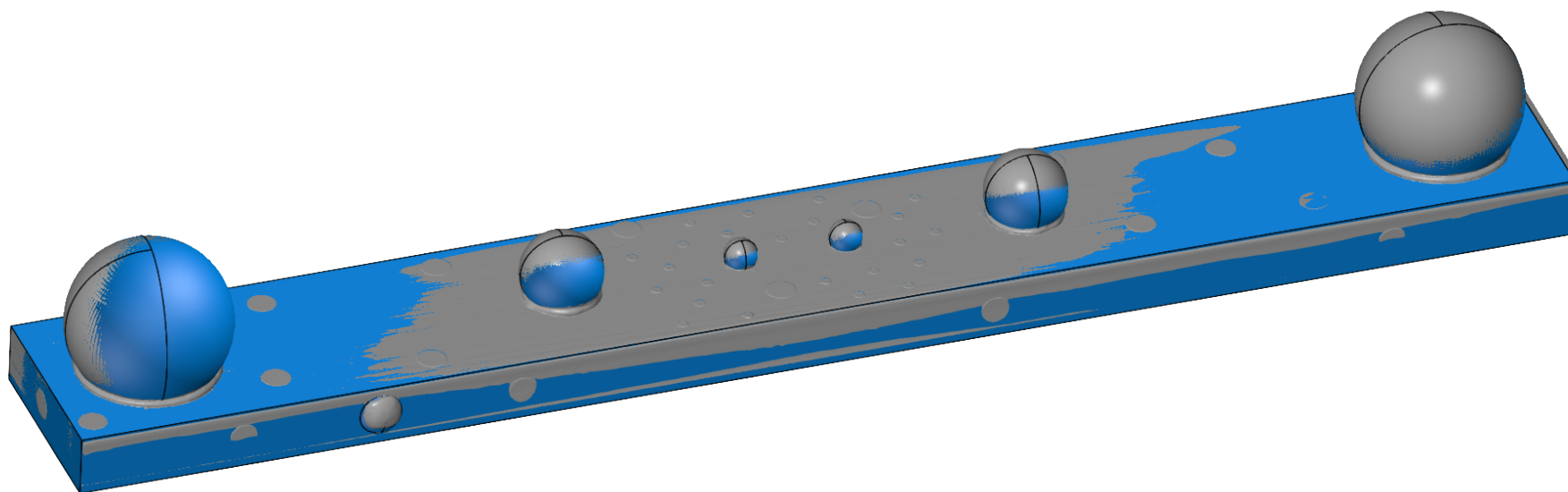
Part no.: Etalon_03

Version: ATOS III Triple Scan

Charge no.: 03_FullMV

System: GOM Inspect Professional 2019

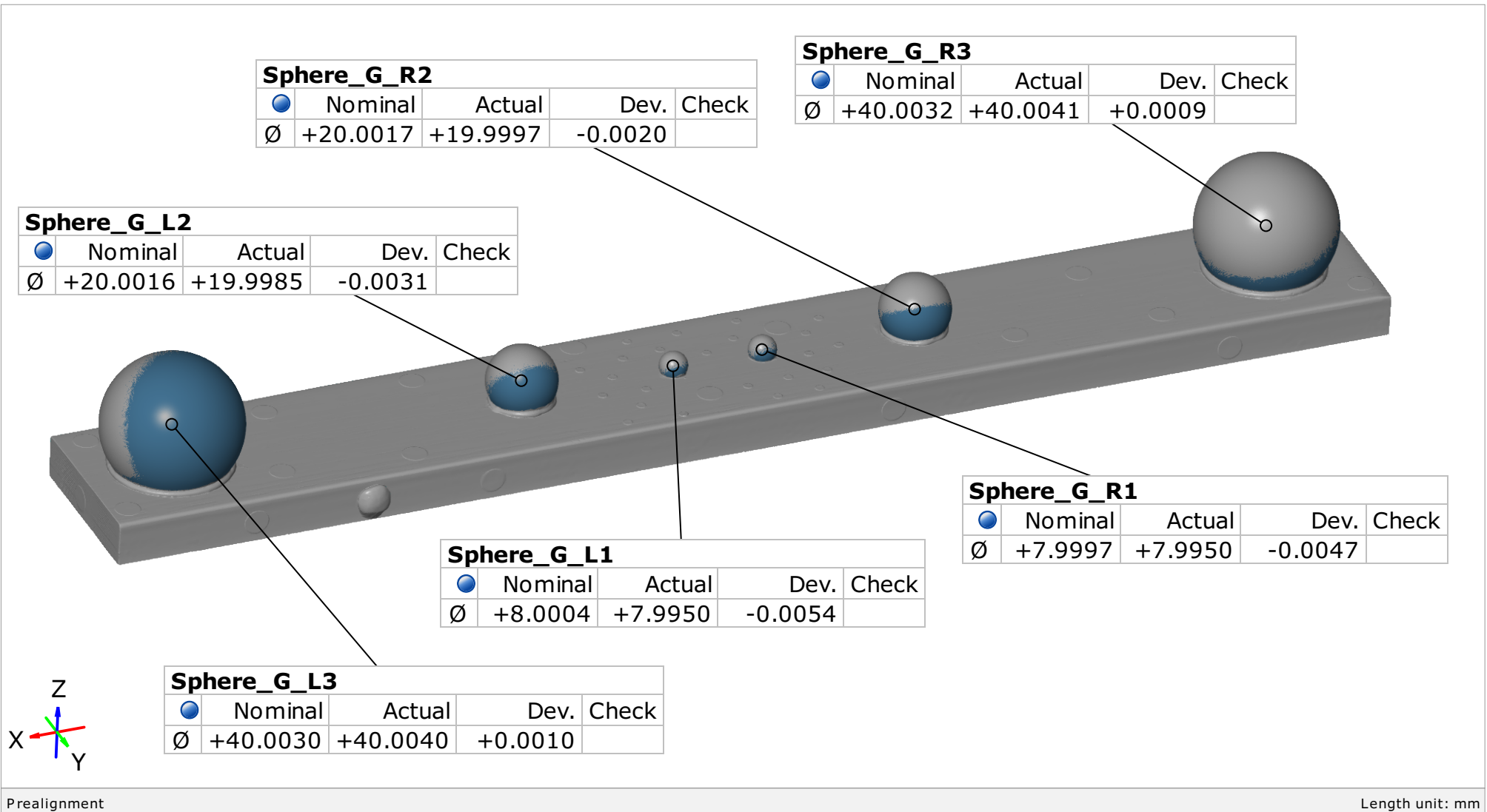
CAD (blue) and Mesh (gray) - ATOS III Triple Scan



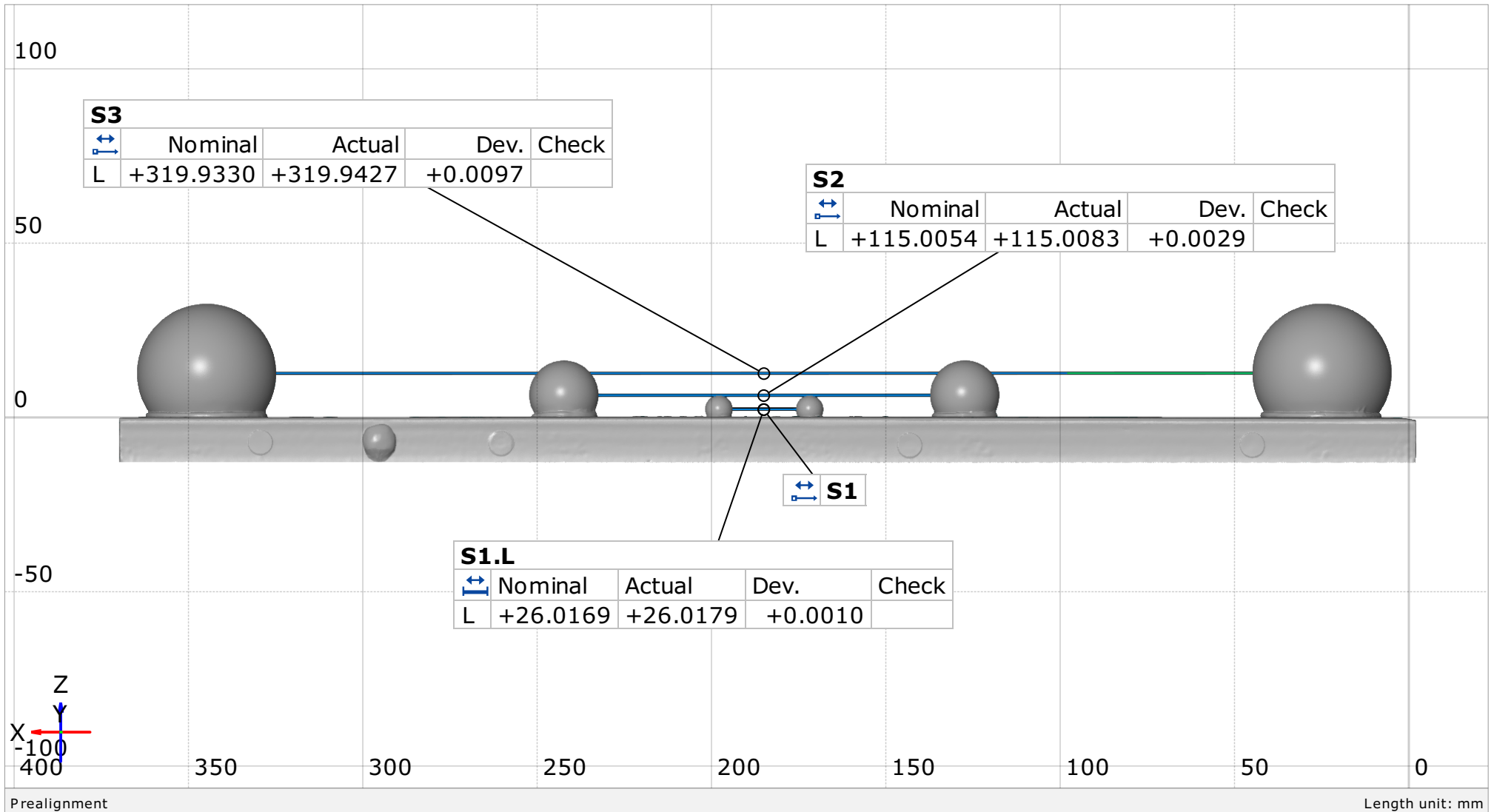
Prealignment

Length unit: mm

Probing Error Size - ATOS III Triple Scan



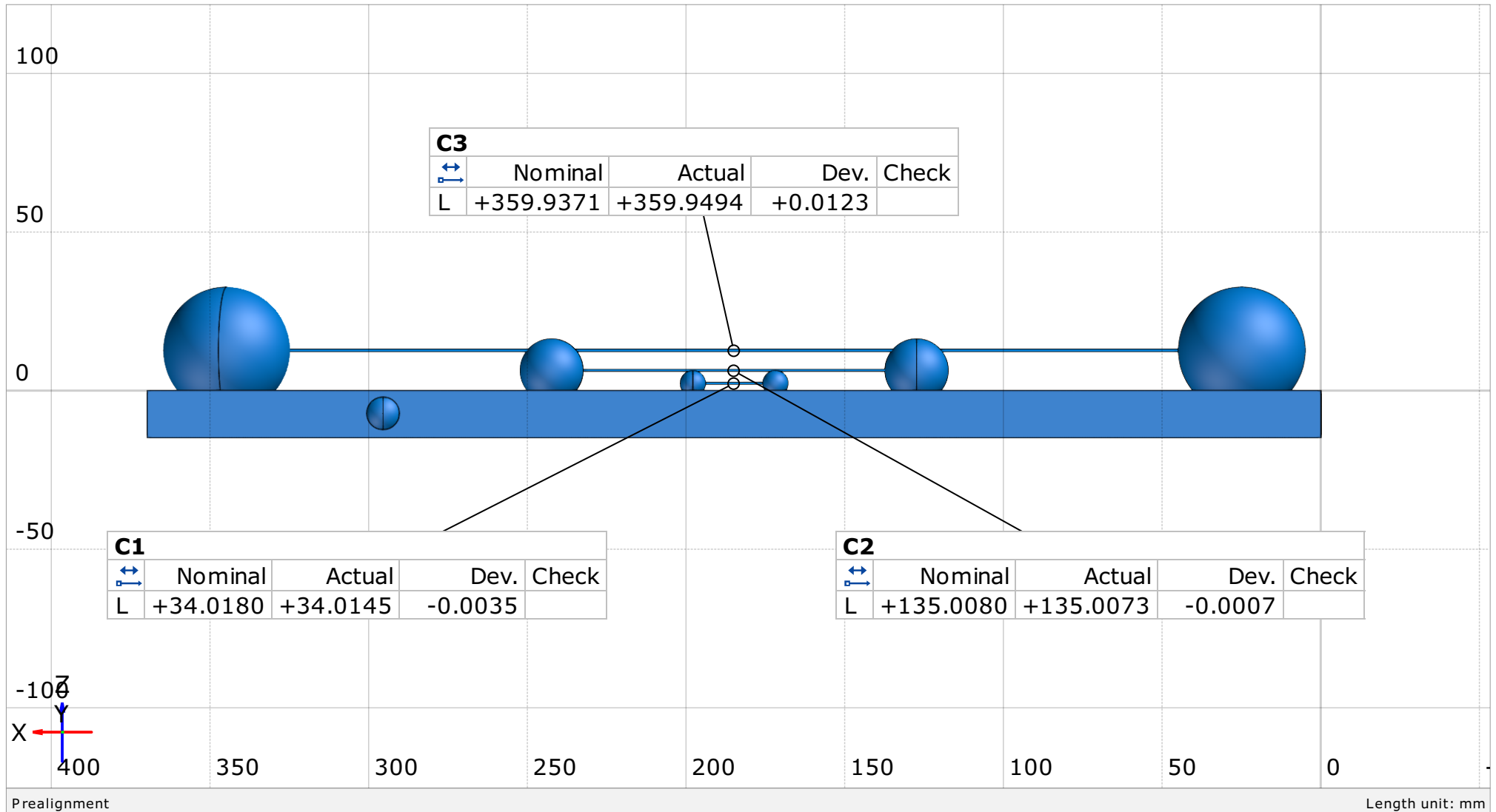
Spacing between Spheres - ATOS III Triple Scan



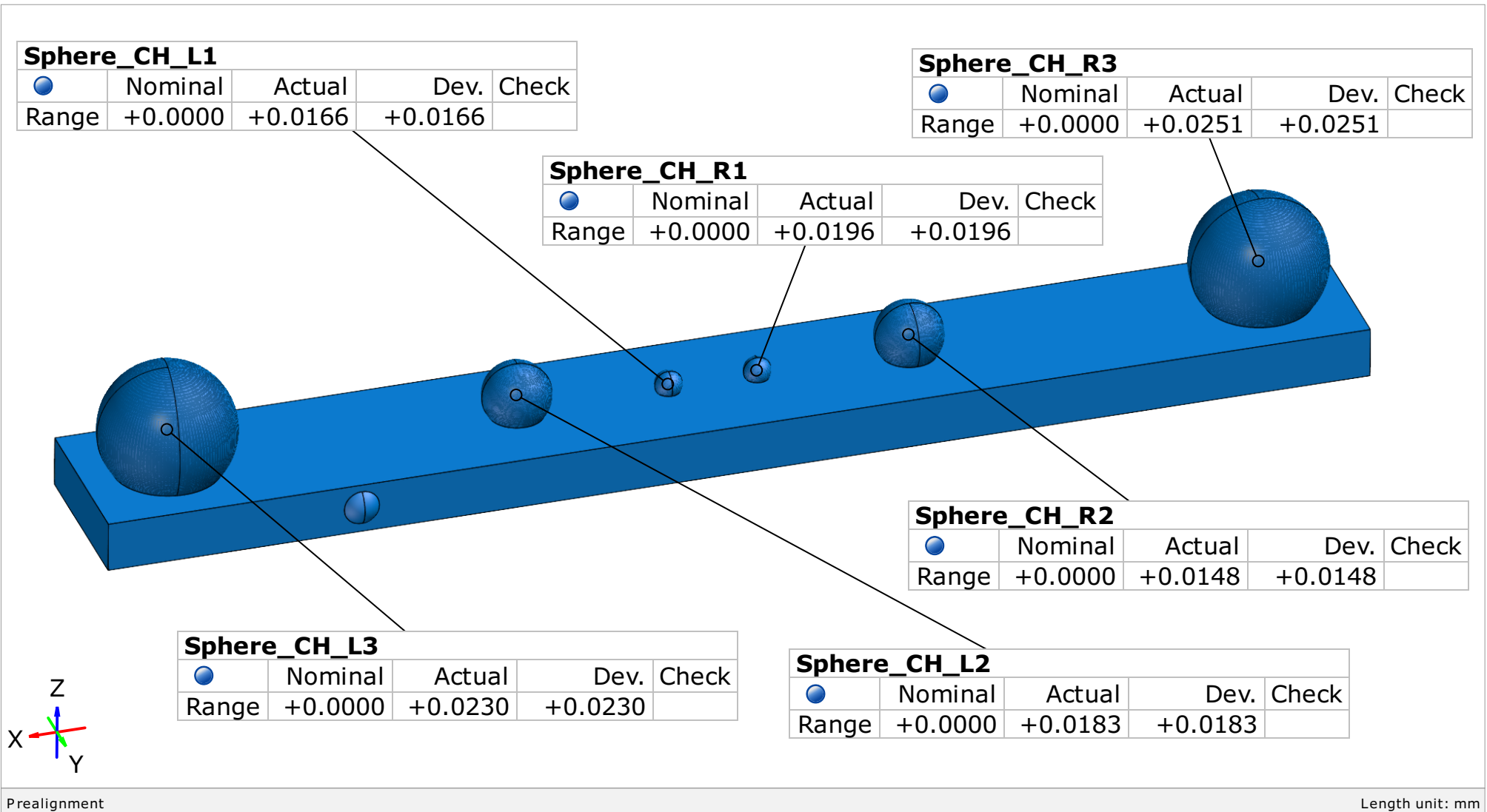
Prealignment

Length unit: mm

Length Measurement Error - ATOS III Triple Scan



Probing Error Form - ATOS III Triple Scan



Acceptance Test Parameters- ATOS III Triple Scan

Element	Datum	Property	Nominal	Actual	Tol -	Tol +	Dev	Check	Out
 S3		L	+319.9330	+319.9427			+0.0097		
 S2		L	+115.0054	+115.0083			+0.0029		
 S1		L	+26.0169	+26.0179			+0.0010		
 C3		L	+359.9371	+359.9494			+0.0123		
 C2		L	+135.0080	+135.0073			-0.0007		
 C1		L	+34.0180	+34.0145			-0.0035		
 Sphere_G_R3		Ø	+40.0032	+40.0041			+0.0009		
 Sphere_G_R2		Ø	+20.0017	+19.9997			-0.0020		
 Sphere_G_R1		Ø	+7.9997	+7.9950			-0.0047		
 Sphere_G_L3		Ø	+40.0030	+40.0040			+0.0010		
 Sphere_G_L2		Ø	+20.0016	+19.9985			-0.0031		
 Sphere_G_L1		Ø	+8.0004	+7.9950			-0.0054		
 Sphere_CH_R3		Range	+0.0000	+0.0251			+0.0251		
 Sphere_CH_R2		Range	+0.0000	+0.0148			+0.0148		
 Sphere_CH_R1		Range	+0.0000	+0.0196			+0.0196		
 Sphere_CH_L3		Range	+0.0000	+0.0230			+0.0230		
 Sphere_CH_L2		Range	+0.0000	+0.0183			+0.0183		
 Sphere_CH_L1		Range	+0.0000	+0.0166			+0.0166		

Prealignment

Length unit: mm