

METROTOM Check

Test piece for METROTOM 1500

Operating Instructions



Read the following information first!

- Please read these operating instructions before using the test piece.
- For your own safety, always keep all relevant accompanying documents ready to hand.

All rights pertaining to changes in the CT and its options, the program packages and the pertaining documents reserved.

Unless expressly authorized, the dissemination or duplication of this document as well as the utilization and communication of its contents are prohibited. Violations shall result in claims for damages.

All rights reserved, particularly when patents are issued or utility models registered.

This manual is subject to change and the CT described therein as well as its components are subject to technical modifications.

All product names are registered trademarks or trademarks of the respective owners.

Contact

Carl Zeiss
Business Group
Industrielle Messtechnik GmbH
73446 Oberkochen, Germany

Table of contents

Preface

About these operating instructions Preface 1

Marking elements Preface 2

Chapter 1 Introduction

General specifications 1-2

Delivery package 1-2

System requirements 1-2

Warranty 1-2

Security 1-3

Intended use 1-3

Safety instructions 1-3

Chapter 2 Description

What is the purpose of the METROTOM Check? 2-2

Components 2-3

Test piece 2-3

Clamping device 2-4

Files for evaluation 2-5

Chapter 3 Technical data

Specifications 3-2

Chapter 4 Operation

CT measurement 4-2

Notes	4-2
Preparing a CT measurement	4-3
Performing a CT measurement	4-6
Evaluation with CALYPSO	4-7
General procedure	4-7
Preparation	4-7
Performing the evaluation	4-9
Creating a diagram for the sphere distance error length measuring error	4-25

Chapter 5 Care

Care and storage	5-2
-------------------------------	------------



Preface

About these operating instructions

These operating instructions describe the handling of the METROTOM Check test piece. The test piece is an optional accessory for the METROTOM 1500 CT scanner.

These operating Instructions address operators and users of the METROTOM 1500 CT scanner.

Marking elements

The texts may be displayed differently in this document. Examples and the meaning of the representation type are described below:

Example	Meaning
<i>not</i>	Words to be emphasized are represented in <i>italics</i> . The italicized print is sometimes used to mark a subheading, e.g. <i>Type of measurement</i> :
<i>Main switch</i>	Any reference to operator's controls in the text is highlighted typographically.
Tolerance field	Designation of subdomains in software windows.
Cancel	Marking of buttons
RETURN	Keys of the keyboard are represented as small capitals.
"InstallShield Wizard completed"	Software messages
File → Open	Representation of menu items
Code	Source code
... \Calypso\opt \om\protform	File and directories
CALYPSO	Product name
ZEISS	Company name
CAUTION! The measuring table must be clean.	Safety instruction embedded in the text.
[1]	Representation of position numbers in texts

1

Introduction

This chapter contains:

General specifications	1-2
Security.....	1-3

General specifications

Delivery package

The delivery package of the METROTOM Check includes:

- Test piece with holder in transport case
- USB stick containing:
 - Operating instructions
 - Parameter overview
 - Calibration certificate
 - CALYPSO measurement plan
 - Nominal value file
 - Excel evaluation file
 - Report header file

System requirements

Use of the METROTOM Check requires the following prerequisites:

CMM	METROTOM 1500 CT scanner
Data system	Computer with Windows 10 operating system
Measuring software	CALYPSO 2019
Programs	Microsoft Excel

Warranty

With regard to warranty, the same conditions as for the CT scanner apply.

- Observe the corresponding information in the operating instructions for the METROTOM 1500.

Security

Intended use

The METROTOM Check allows you to monitor the accuracy of the METROTOM 1500 CT scanner.

Monitoring requires a test piece to be set up on the rotary table of the CT scanner and a CT measurement to be performed. The test piece may only be used for this purpose.

Reasonably foreseeable misuse

The test piece must not be used for purposes contrary to the information given in these operating instructions.

Safety instructions

Basic safety instructions

The test piece is used on a CT scanner.

- Please observe the safety instructions for the use of the CT scanner. See METROTOM operating instructions.

Precautions



Damage to the calibrated styli by strong impacts

When styli are damaged, the CT scanner check cannot be performed correctly.

- Handle the test piece with the utmost care.
- Do not drop the test piece and do not subject it to impact loads.

2

Description

This chapter contains:

What is the purpose of the METROTOM Check?.....	2-2
Components.....	2-3

What is the purpose of the METROTOM Check?

The METROTOM Check is used to monitor the sphere center distance error SD according to VDI/VDE 2617 (Accuracy of coordinate measuring machines; parameters and their inspection) page 13 and VDI/VDE 2630 (Computed tomography in dimensional metrology) page 1.3. In connection with the separately available P-Check, it allows you to monitor the length measuring error E of the METROTOM 1500 CT scanner.

Purpose of monitoring

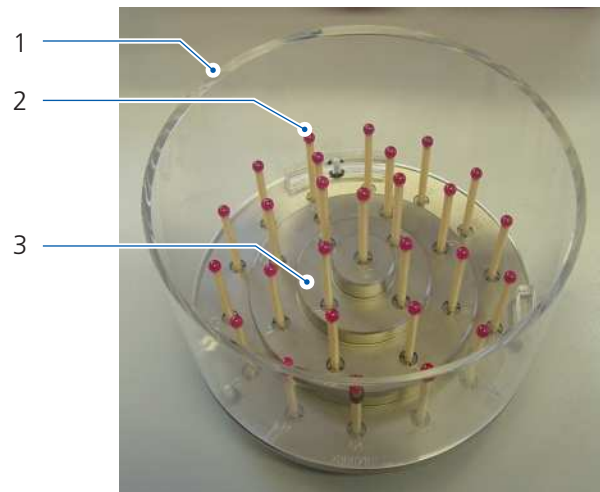
The monitoring function guarantees the compliance of the CT scanner with the limit values requested by the operator.

How often is monitoring necessary?

The operator is responsible for the monitoring of the CT scanner, which has to take place at appropriate intervals.

Components

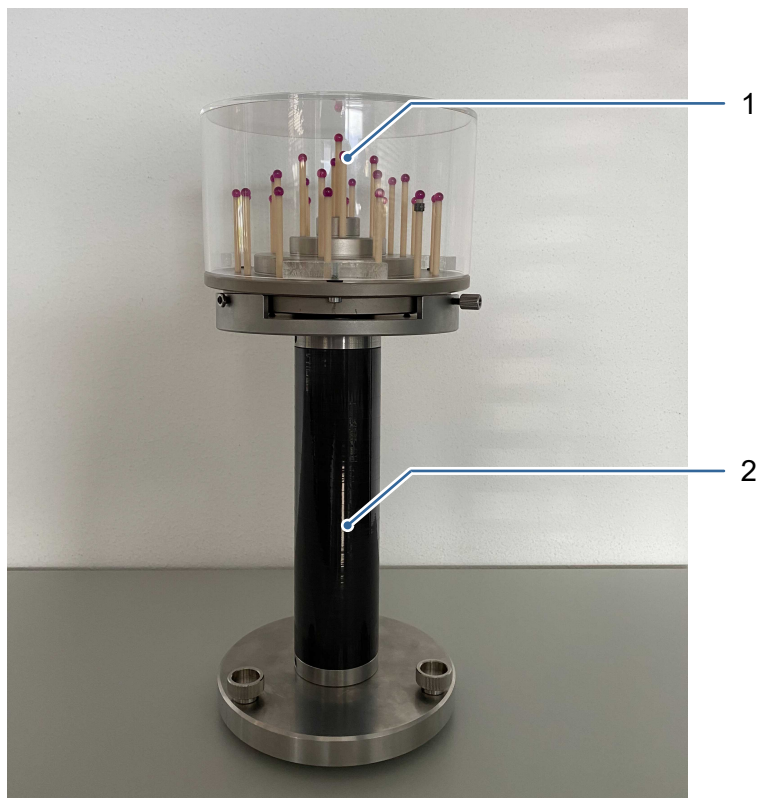
Test piece



- 1 Acrylic glass cover
- 2 Ruby precision sphere; 27 spheres in total; diameter of each sphere: 5 mm
- 3 Base body made of rigid Invar

Clamping device

The supplied clamping device makes it possible to mount the test piece on the rotary table.



- 1 Test piece
- 2 Clamping device

NOTE

To avoid damage to the test piece, you should adjust the height only if there is no test piece fastened on the clamping device.

Files for evaluation

Special files are required for evaluation of the measurement results. These are stored on the supplied USB stick.

- CALYPSO measurement plan
- Report header files
- Nominal value file for the test piece
- **Excel** evaluation table

Detailed information ➤ See [↔ 4-7]

3

Technical data

This chapter contains:

Specifications.....	3-2
---------------------	-----

Specifications

Test piece

Calibration	Calibrated according to DKD standards with certificate
-------------	--------------------------------------------------------

Weight	3.0 kg
--------	--------

Base body material	Invar
--------------------	-------

Base body expansion coefficient	$1.3 \times 10^{-6} \text{ 1/K}$
---------------------------------	----------------------------------

Base body density	8.1 g/cm^3
-------------------	----------------------

Ball shaft material	Ceramic
---------------------	---------

Sphere material	Ruby
-----------------	------

Protective cover material	Acrylic glass
---------------------------	---------------

Clamping device (not height-adjustable)

Weight	3.5 kg
--------	--------

Column material	CFRP
-----------------	------

Receptacle material	Stainless steel
---------------------	-----------------

4

Operation

This chapter contains:

CT measurement.....	4-2
Evaluation with CALYPSO.....	4-7

CT measurement

Notes

METROTOM operating instructions

To perform a CT measurement, you must be familiar with the METROTOM operating instructions and comply with them.

Temperature influence

The temperature of the test piece may differ from that of the CT scanner's positioning system during storage, transport, and installation.

- 1 Before starting the measurement run, allow the test piece to acclimatize to room temperature.
- 2 Measure the temperature of the test piece and enter it in the CALYPSO measuring software when performing the evaluation.

NOTE

The protective cover must not be removed under any circumstances. It is not necessary to clean the spheres.

Preparing a CT measurement

Preconditions for a CT measurement

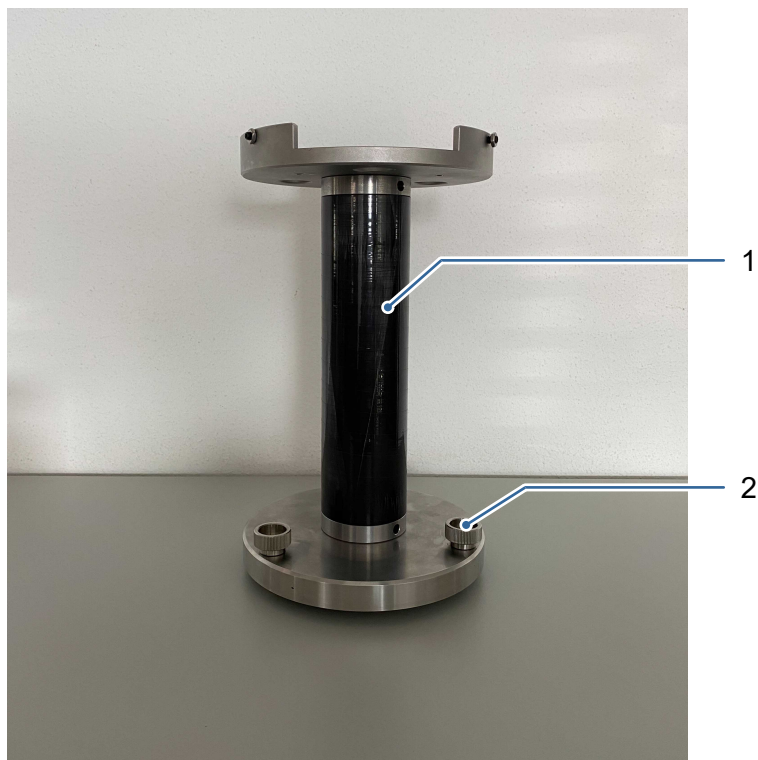
Qualification procedure

Prior to the CT measurement, you must perform a geometric qualification and an axis qualification. See METROTOM operating instructions.

Setting up the test piece

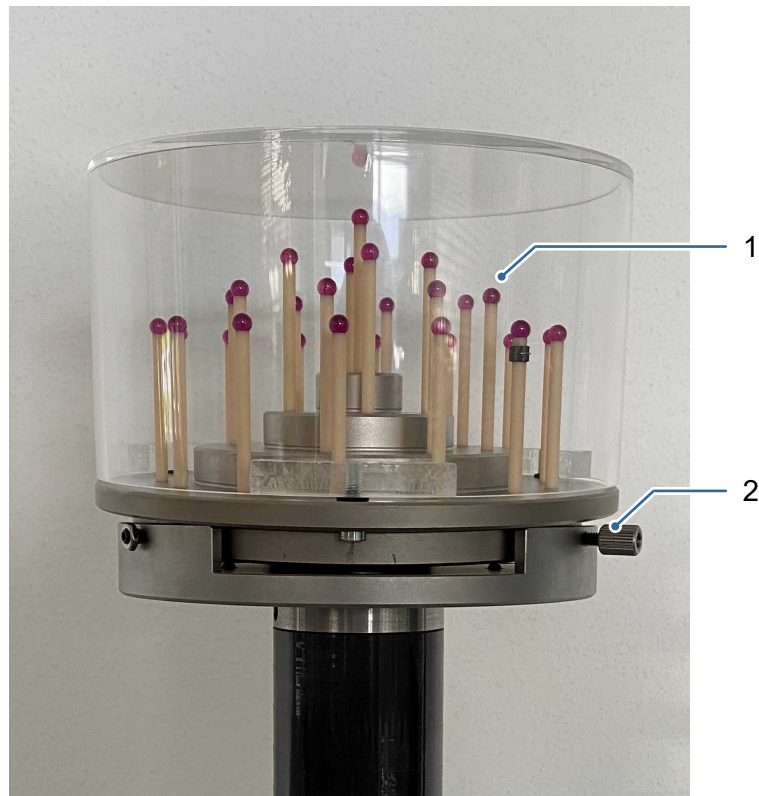
- 1 Move to the loading position.
- 2 Clean the clamping surface of the rotary table and the clamping device.
- 3 Place the clamping device onto the rotary table and fasten it with three screws.

Do not tighten the screws too much.



- 1 Clamping device
- 2 Screws for screwing on the rotary table; three screws in total
- 4 Clean the test piece.
- 5 Place the test piece onto the clamping device and fasten it with the screw.

Any orientation of the test piece is possible. Sphere 1, which forms the zero point of the base alignment in CALYPSO, is marked by a ring on its shaft. This allows the sphere to be detected in the reconstructed CT volume data.



- 1 Test piece
- 2 Screw for fastening the test piece

6 Measure temperature of test piece on Invar base body.



Damage caused by X-ray radiation.

X-ray radiation may damage the temperature measuring device.

- Remove the temperature measuring device from the interior of the radiation protection enclosure before switching the X-ray tube on.

7 Move the test piece into position.

8 Close the loading door.

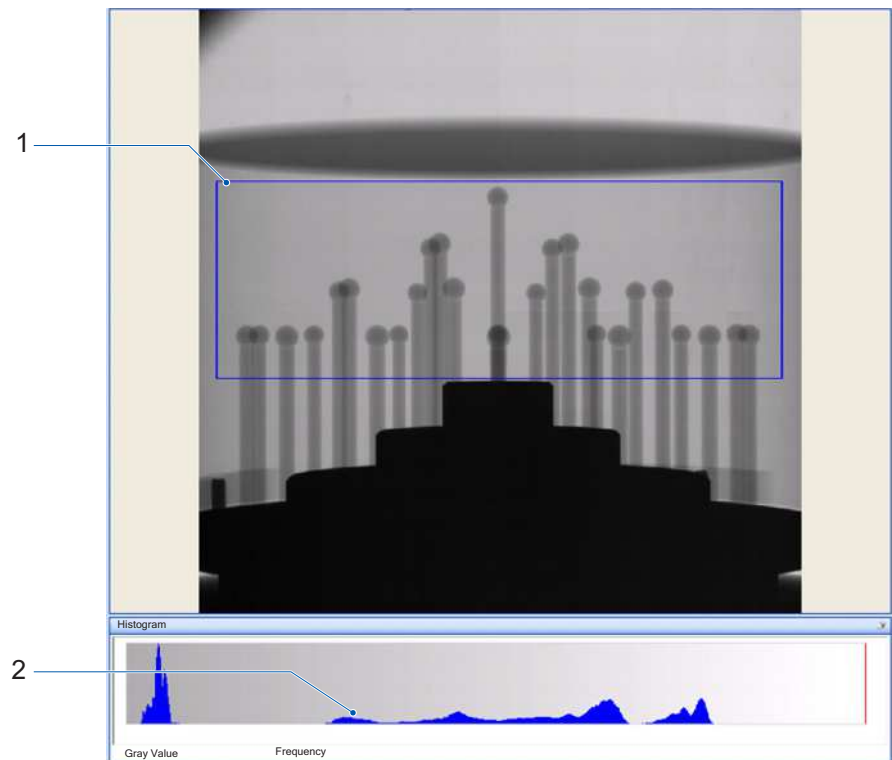
Making settings

The values for the measurement can be found in the document named *Parameter values*. The current parameter values of the test pieces for the respective METROTOM CMM can be viewed and downloaded on the ZEISS Portal. The parameters valid at the time of delivery can be found in the corresponding document on the supplied USB stick.

Setting the reconstruction area

The reconstruction area must be selected in such a way that all spheres are located within the reconstruction area during a complete rotation of the rotary table. The distance between the spheres and the frame of the reconstruction area should be at least 20 pixels. This applies to the horizontal and vertical directions.

However, the base body should not be located within the reconstruction area. The acrylic glass cover may be located in the reconstruction area.



1 Reconstruction frame

2 Histogram

- Drag the frame for the reconstruction area as large as possible so that all spheres are located within the frame.

Make sure that the base body is not located within the reconstruction area.

Adapting the histogram

The histogram is used to ensure good illumination of the detector. In particular, the detector must never be overexposed, as this would falsify the measurement results. If in doubt, adjust the detector parameters.

- Change the parameters of the X-ray tube if the gray scale values are outside the specified range.
- If the detector is overexposed, either:
 - the power of the source must be decreased, or
 - the exposure time of the detector must be increased, or
 - the sensitivity of the detector must be decreased.

Performing a CT measurement

After the preparatory measures have been carried out, the CT measurement can be carried out.

- Carry out the CT measurement according to the information given in the METROTOM operating instructions.

Evaluation with CALYPSO

General procedure

The evaluation comprises the following steps:

- Open measurement plan.
- Check the nominal values of the characteristics.
- Import the CT volume data.
- Visualize the CT volume data.
- Perform a manual alignment by probing.
- Activate temperature compensation.
- Run the measurement plan.
- Evaluate the measuring results.

The results are shown in a measurement report and a length measuring error diagram.

Preparation

A measurement plan, report header files, a nominal value file and the corresponding evaluation table are required for the evaluation. These files are stored on the USB stick supplied and must be copied to the hard disk.

Folder and file to be copied	Medium	Directory
Measurement plan <i>METRO-TOM_CHECK_PL</i>	USB stick	<i>\METROTOM_CHECK\Pruefplan\</i>
	Hard drive	<i>... \Calypso\home\om\workarea\inspections\</i>
Evaluation table <i>METRO-TOM_CHECK_PR</i>	USB stick	<i>\METROTOM_CHECK\Auswertetabelle\</i>
	Hard drive	<i>... \Calypso\home\om\workarea\results</i>
<i>userfields.ini</i> file and <i>CT calibration</i> folder	USB stick	<i>\METROTOM_CHECK\Protokollkopf-Dateien</i>
	Hard drive	<i>... \Calypso\opt\om\protform</i>

Using the correct nominal values of the test piece

For the evaluation, the nominal values of the test piece must be entered in CALYPSO. The file with the nominal values is stored in the directory of the »METROTOM_CHECK_PL« measurement plan. The name of the file starts with »Kalibrierwerte_Metrotom_Check«. Example: Kalibrierwerte_Metrotom_Check_29029101B_360_2010-05.txt.

NOTE

The »METROTOM_CHECK_PL« measurement plan contains files which are not saved if the measurement plan is saved with another name and (or) saved in another directory via **File Save as**. In this case, the file with the nominal values and the »inspection_post_load.bat« file must be copied manually from the previous measurement plan to the newly saved measurement plan.

The file with the nominal values always has to be replaced with a current version after the test piece is recalibrated.

Disabling write protection

The METROTOM Check measurement plan cannot be run when write protection is enabled.

- Disable the write protection of the copied files.

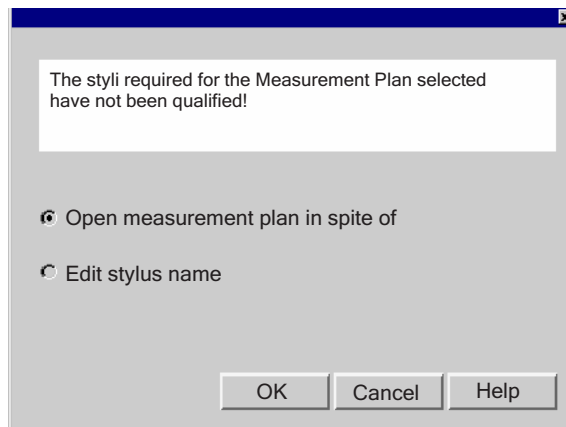
Performing the evaluation

Preparing the measurement plan



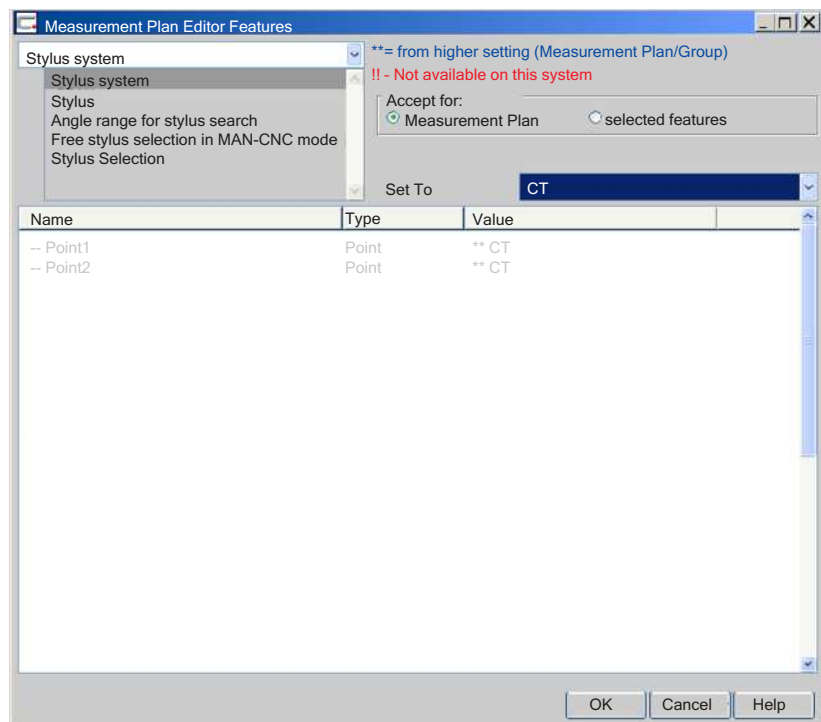
- 1 Start CALYPSO.
- 2 Open the »METROTOM_CHECK_PL« measurement plan.

When the measurement plan is loaded for the first time, the following message may be displayed:

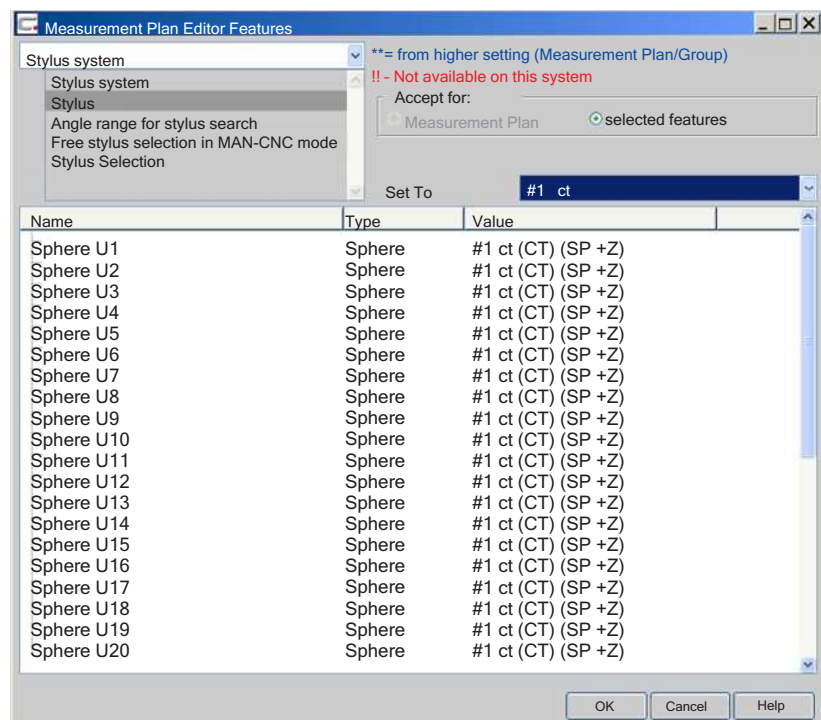


- 3 Select **Open plan as it is**.
- 4 Click **OK**.
- 5 After opening the measurement plan, save it once via **File → Save**.
This is required to ensure that the measurement plan is updated to a new revision.
- 6 Select **Resources → Measurement Plan Editor Features** to open the Features editor.

The following window opens:



- 7 Select »Measurement plan« under **Stylus system** and select a suitable stylus system, e.g. «CT».



- 8 Select a suitable stylus, e.g. «#1 ct», under **Stylus**.

Checking the nominal values of the characteristics

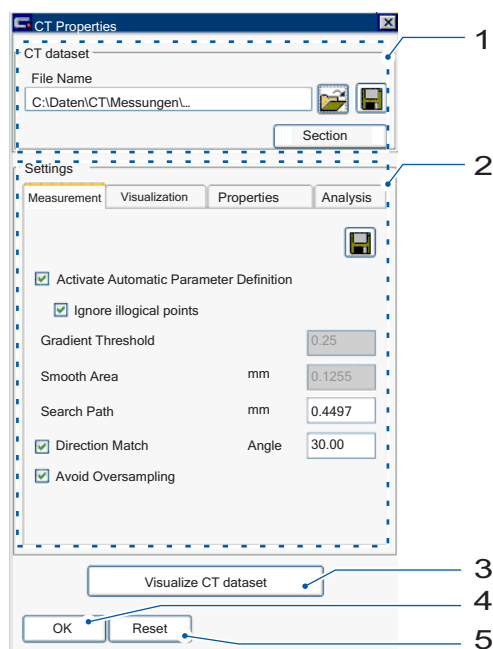
The calibrated nominal values of the sphere center point distances of the test piece are loaded from a file into the measurement plan. To ensure correct evaluation, it is important to save the correct nominal value file in the directory of the measurement plan. ➤ See [⇨ 4-8]

Importing CT volume data



- 1 Click the red button for CT volume data in the window showing the preparation functions.

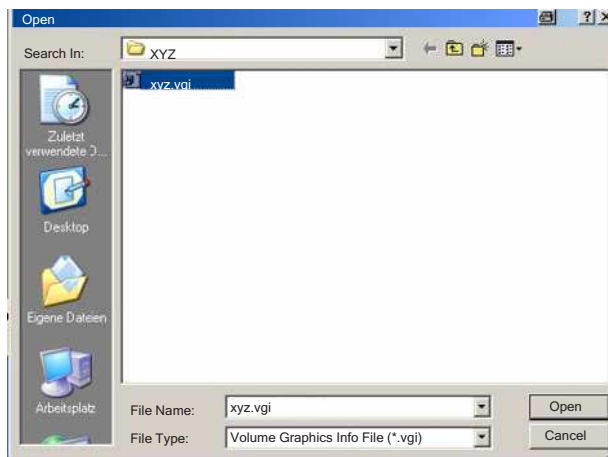
The following window opens.



- 1 Opens a file
- 2 Settings for the CT volume data
The »Properties« tab under »Settings« is only available when CT volume data has been loaded.
- 3 Visualizes the CT volume data
- 4 Applying settings
- 5 Returns to CALYPSO without applying the settings



- 2 Click the button shown here.



- 3 Select the «*.uint16_scv» **file type**.
- 4 Select the directory and the file.
- 5 Click **Open**.

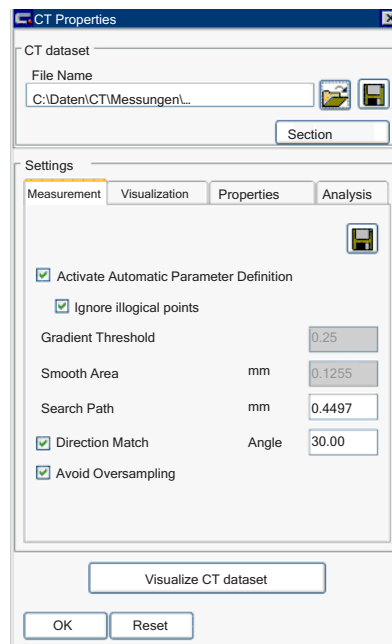
While the data is being imported from network sources, a local copy is created; this may take several minutes. It is recommended to copy the data to a local hard disk beforehand to save time.

A message is displayed after the data has been imported. The message is displayed immediately if no CT volume data has been imported before. The message is displayed with a delay if the old CT volume data has to be deleted first to ensure that the new CT volume data can be imported.

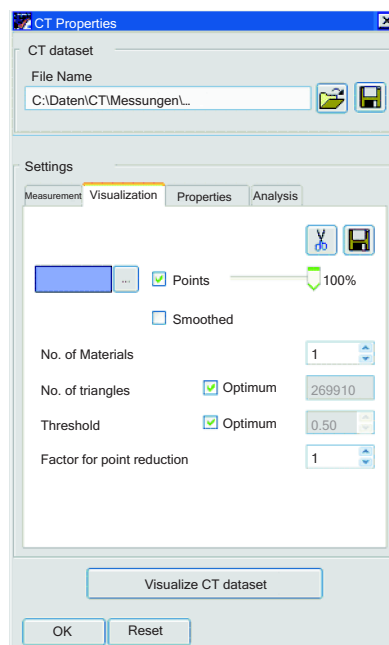


- 6 Click **OK**.

Visualizing CT volume data



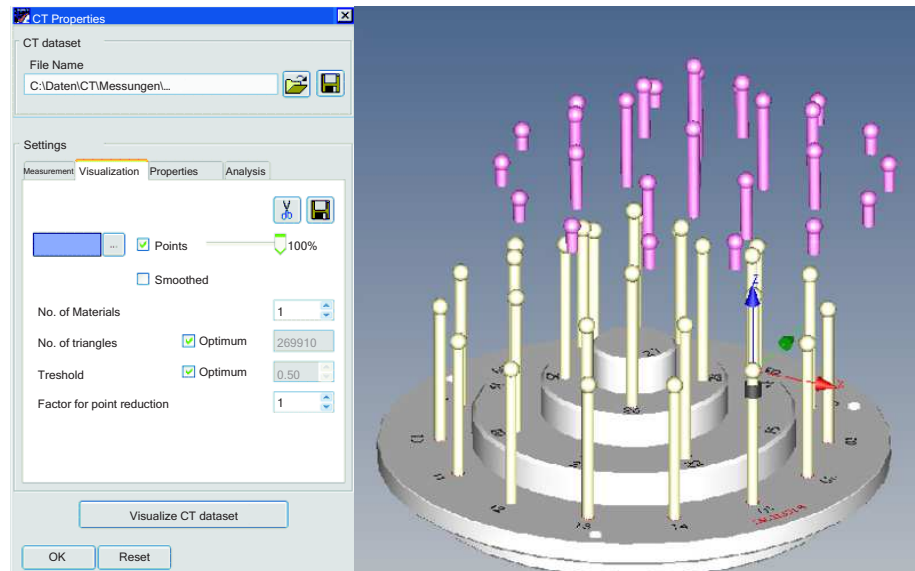
- 1 Select all options on the »Measurement« index card.
- 2 Switch to the »Visualization« index card.



- 3 Select the color to be used to represent the CT volume data on the »Visualization« index card.
- 4 Click **Visualize CT volume data**.

The visualization of the CT volume data can take a few minutes.

The visualized surface must be aligned with the CAD data to compensate for any existing offsets (see the following chapter ➤ *Aligning CT volume data* [⇒ 4-15]).

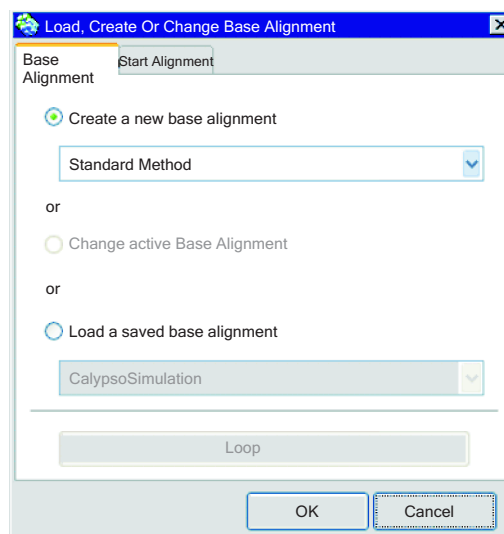


Aligning CT volume data

When CT volume data is loaded for the first time, its alignment does not correspond to the alignment of the CAD model. This, however, is required for running the measurement plan automatically. Therefore, you must first perform a manual alignment.

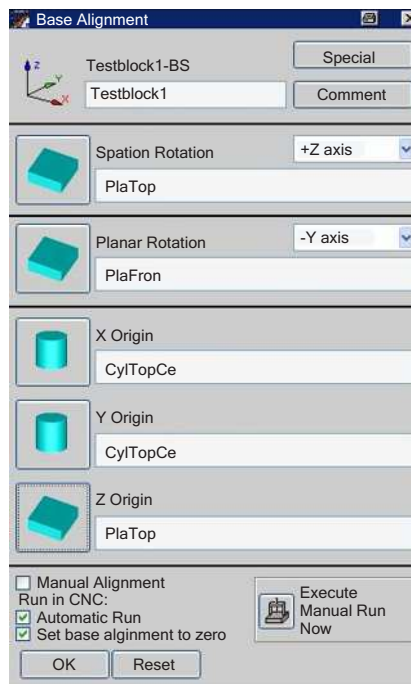


- 1 In the list of prerequisites, click the Base/Start Alignment button.
If a base alignment has already been defined, the button is green. The following window opens. The »Base Alignment« tab is in the foreground.



- 2 Select the **Change active base alignment** option.
- 3 Click **OK**.

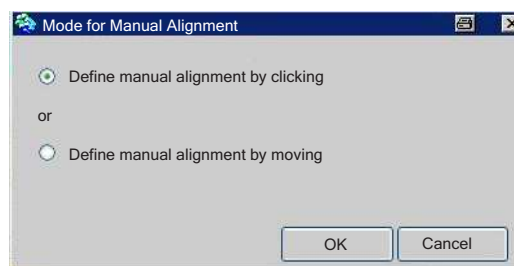
The following window opens:



4 Activate the **Automatic Run** and **Set Base Alignment to zero** functions.

5 Then click the **Execute Manual Run Now** button.

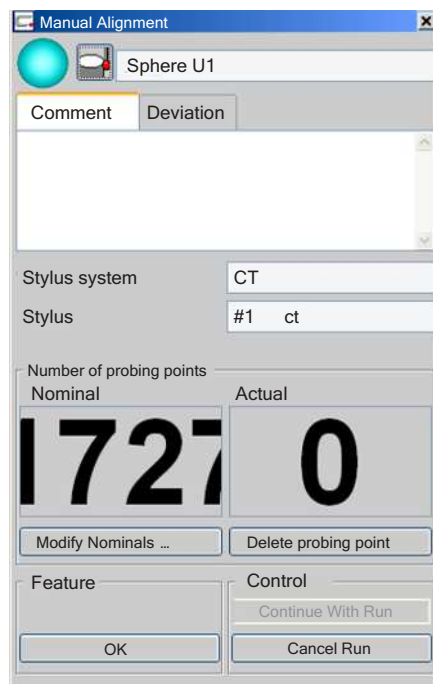
The following window opens:



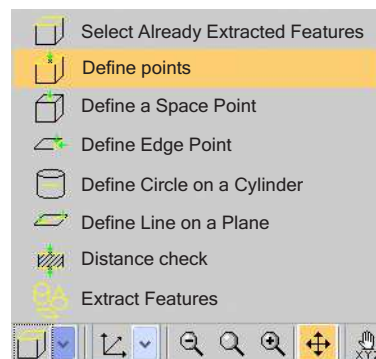
6 Select **Define manual alignment by clicking**.

7 Click **OK**.

The following window shows the feature to be probed.



- 8** Select the Define points mode before you select the probing points.



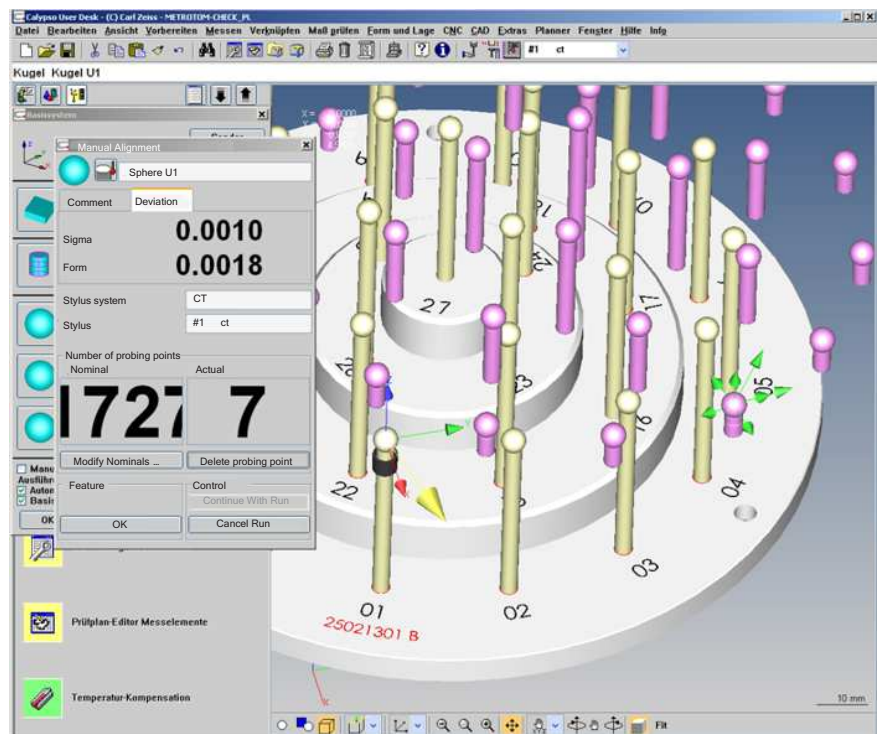
- 9 On the CT volume data, click several points of the «Kugel U1» feature requested by CALYPSO.

The appropriate feature in the CAD model is marked by a ring on the shaft.

- Take care to spread the probing points as evenly as possible.

The probing points are marked as green dots.

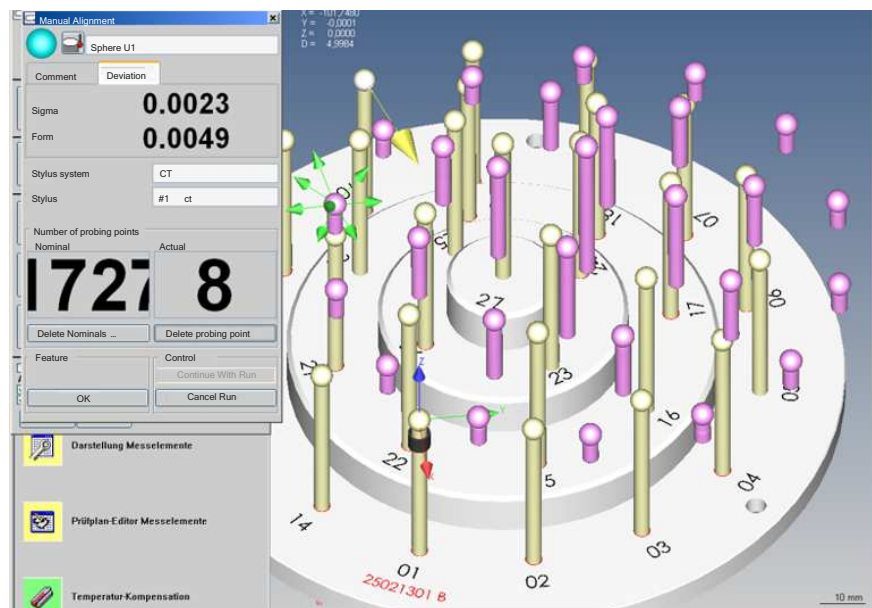
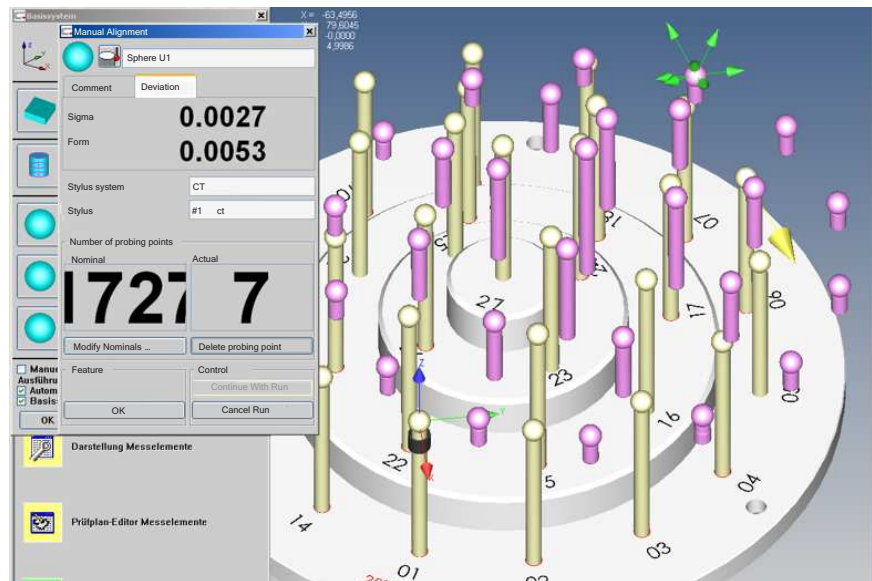
Click as many points as necessary until a plausible form error is indicated for the sphere.



- 10 Click **OK**.

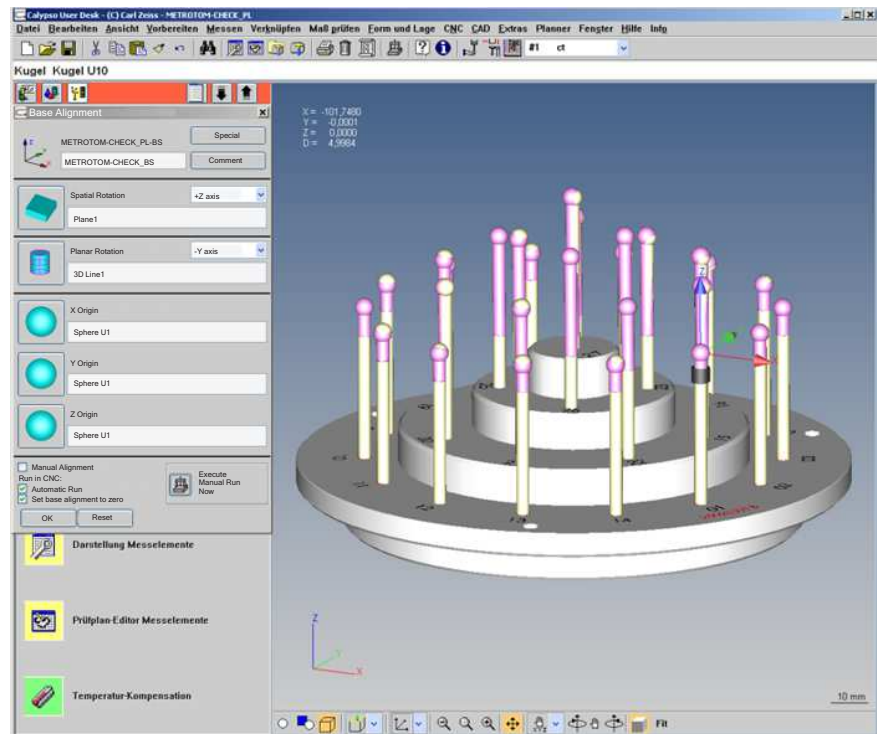
The same window is displayed again. However, this time probeings for «Sphere U6» are requested.

11 Repeat the previous two steps for «Sphere U6» and «Sphere U10».



12 In the »Manual Alignment« window, click **OK** under **Feature**.

The CT volume data is aligned with the CAD model.



13 Click **OK** in the »Base Alignment« window.

NOTE

Even if the manually set probing points are selected very carefully, it is not possible to achieve the maximum possible accuracy. This is why the alignment definitely should be performed again automatically.

Automatic alignment

The loop counter must be set for automatic alignment. Recommendation: 3 loops. Activate also **Clear existing results** and **All Characteristics**; this is done in the »Start Measurement« window. Further information is provided elsewhere in CALYPSO operating instructions and METROTOM operating instructions.

Activating the temperature compensation



- 1 Click the button shown here.

The following window opens:

Temperature	Coefficient	Corr.value <μm>
Workpiece 21.5000	1.30	-1.950000
X Scale 20.0000	7.80	0.000000
Y Scale 20.0000	7.80	0.000000
Z Scale 20.0000	7.80	0.000000

Warning, if the difference
over 25.0000 or under 15.0000

Warning, if the difference
between workpiece temperature and
qualification temperature of the
stylus used is greater than 5.0

OK Reset

Settings for temperature compensation

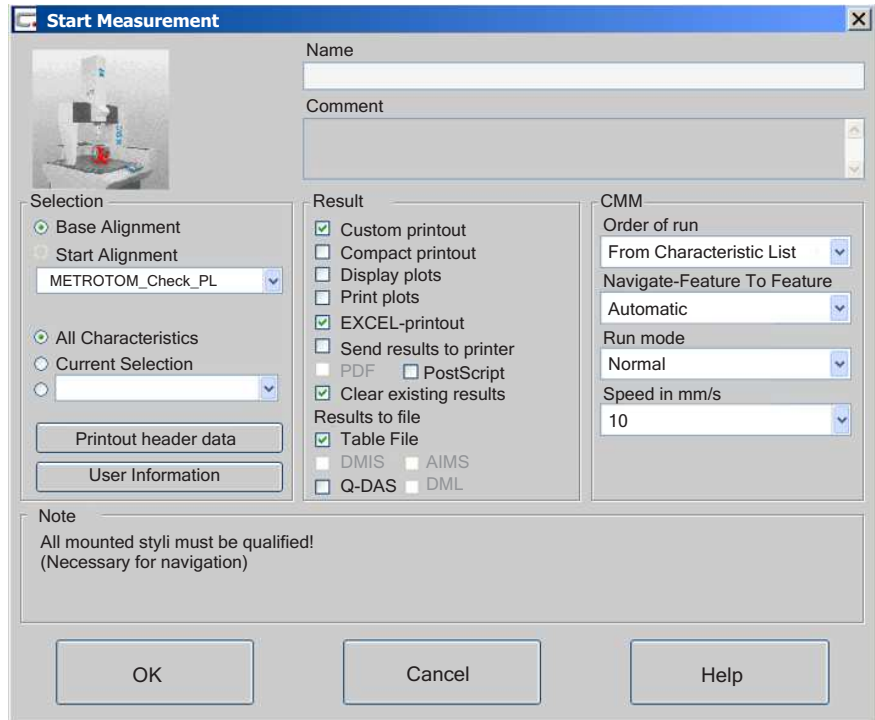
- 2 Activate the **Temperature Compensation on/off** check box.
- 3 Enter the temperature of the test piece under **Workpiece**.
- 4 Enter 20 degrees for the X, Y and Z scale temperatures.
- 5 Click **OK**.

The button is highlighted in green.

Running a measurement plan

1 Select **Plan** → **CNC-Start**.

The following window opens:



The **Start Measurement** dialog box contains the following sections:

- Name**: Text field.
- Comment**: Text area.
- Selection**:
 - ☒ Base Alignment
 - ☐ Start Alignment (dropdown: METROTOM_Check_PL)
 - ☒ All Characteristics
 - ☐ Current Selection (dropdown)
 - ☐ (dropdown)
 - Buttons: Printout header data, User Information
- Result**:
 - ☒ Custom printout
 - ☐ Compact printout
 - ☐ Display plots
 - ☐ Print plots
 - ☒ EXCEL-printout
 - ☐ Send results to printer
 - ☐ PDF ☐ PostScript
 - ☒ Clear existing results
 - Results to file**:
 - ☒ Table File
 - ☐ DMIS ☐ AIMS
 - ☐ Q-DAS ☐ DML
- CMM**:
 - Order of run: From Characteristic List (dropdown)
 - Navigate-Feature To Feature: Automatic (dropdown)
 - Run mode: Normal (dropdown)
 - Speed in mm/s: 10 (dropdown)
- Note**: All mounted styli must be qualified! (Necessary for navigation)
- Buttons: OK, Cancel, Help

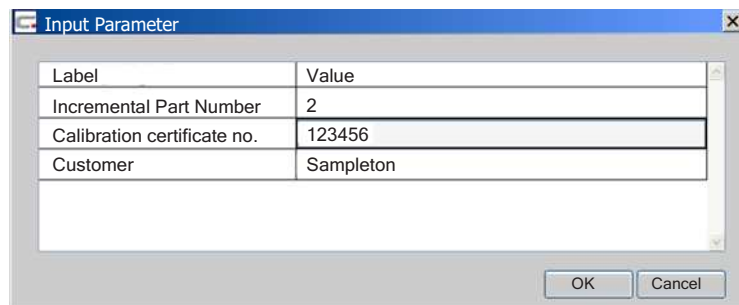
Starting the measurement plan

2 Select **All Characteristics** and **Clear existing results**.

To create a diagram of the sphere distance error, you must also select **EXCEL report** and **Table File**.

3 Click **OK**.

The following window opens:



The **Input Parameter** dialog box contains a table with the following data:

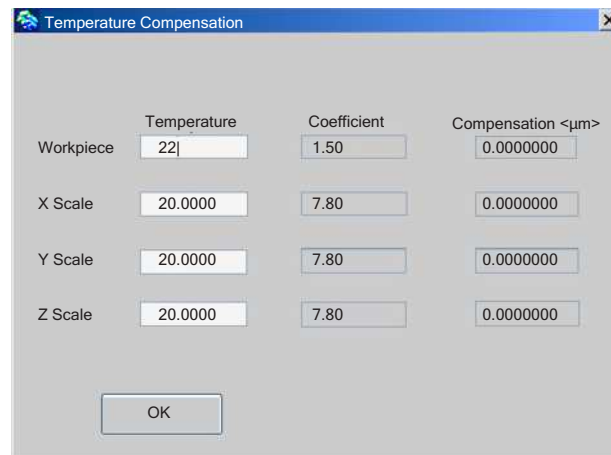
Label	Value
Incremental Part Number	2
Calibration certificate no.	123456
Customer	Sampleton

Buttons: OK, Cancel

4 Enter the number and the name under **Calibration certificate no.** and **Customer**.

5 Click **OK**.

- 6 Check the temperature values in the following window and correct them if necessary.



The 'Temperature Compensation' dialog box contains the following fields:

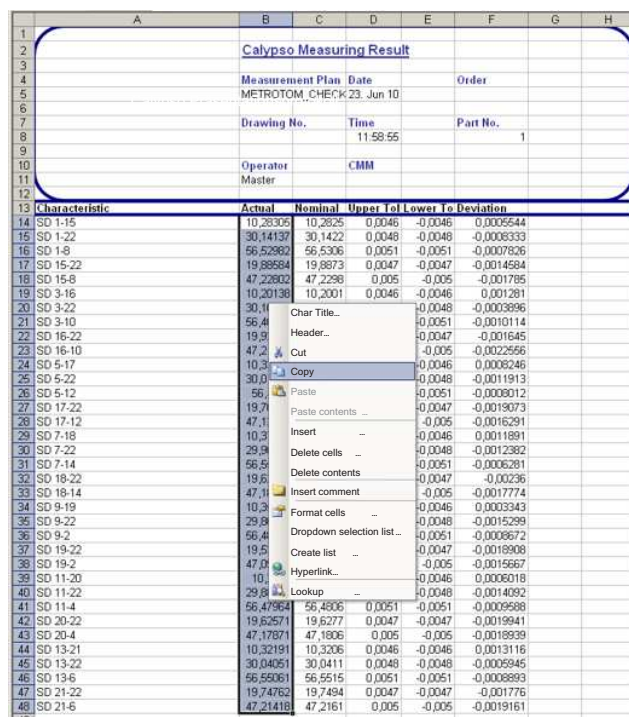
	Temperature	Coefficient	Compensation <μm>
Workpiece	22	1.50	0.000000
X Scale	20.0000	7.80	0.000000
Y Scale	20.0000	7.80	0.000000
Z Scale	20.0000	7.80	0.000000

An 'OK' button is located at the bottom center.

- 7 Click **OK**.

Then the CNC run starts.

At the end of the CNC run, a report is output. In addition, an Excel sheet is created and opened automatically. Values must be copied from the sheet. The Excel sheet requires that **Excel** is installed on the METROTOM user computer. If Excel is not installed, then you must copy the existing table file and open it on a computer on which Excel is installed. By default, the table file is saved to: »... \calypso\home\om\workarea\results« in the following directory. This path can be changed in the system configuration of CALYPSO.




The Excel spreadsheet displays the following data:




Characteristic	Actual	Nominal	Upper Tol	Lower Tol	Deviation
SD 1-15	10,28305	10,2825	0,0046	-0,0046	0,0005544
SD 1-22	30,14137	30,1422	0,0048	-0,0048	-0,0008333
SD 1-8	56,52892	56,5306	0,0051	-0,0051	-0,0007626
SD 15-22	19,88564	19,8873	0,0047	-0,0047	-0,0014584
SD 15-8	47,22802	47,2298	0,005	-0,005	-0,001785
SD 3-16	10,20138	10,2001	0,0046	-0,0046	0,001281
SD 3-22	30,1		-0,0048	-0,003996	
SD 3-10	56,4		0,0051	-0,0010114	
SD 16-22	19,9		0,0047	-0,001645	
SD 16-10	47,2		-0,005	-0,0022566	
SD 5-17	10,3		-0,0046	0,0005246	
SD 5-22	30,0		-0,0048	-0,0011913	
SD 5-12	56,6		0,0051	-0,0008012	
SD 17-22	19,7		0,0047	-0,0019073	
SD 17-12	47,1		-0,005	-0,0016291	
SD 7-18	10,3		-0,0046	0,0011891	
SD 7-22	29,9		-0,0048	-0,0012382	
SD 7-14	56,5		0,0051	-0,0006281	
SD 18-22	19,6		-0,0047	-0,00236	
SD 18-14	47,1		-0,005	-0,0017774	
SD 9-19	10,3		-0,0046	0,0003343	
SD 9-22	29,8		-0,0048	-0,0015299	
SD 9-2	56,4		0,0051	-0,0008672	
SD 19-22	19,5		-0,0047	-0,0019308	
SD 19-2	47,0		-0,005	-0,0015667	
SD 11-20	10,		-0,0046	0,0006018	
SD 11-22	29,8		-0,0048	-0,0014092	
SD 11-4	56,47964	56,4806	0,0051	-0,0051	-0,0009588
SD 20-22	19,62571	19,6277	0,0047	-0,0047	-0,0019941
SD 20-4	47,17871	47,1806	0,005	-0,005	-0,0018839
SD 13-21	10,32191	10,3206	0,0046	-0,0046	0,0013116
SD 13-22	30,04051	30,0411	0,0048	-0,0048	-0,0005945
SD 13-6	56,55061	56,5515	0,0051	-0,0051	-0,0008893
SD 21-22	19,74762	19,7494	0,0047	-0,0047	-0,001776
SD 21-6	47,21418	47,2161	0,005	-0,005	-0,0019161

Excel sheet after execution of the CALYPSO CNC run

Calypso custom printout

Printout Display

ZEISS Calypso				Software Revision	
Test equipment name	Test equipment S/N	Calibration certificate no.			
METROTOM Check	987654	123456			
Measurement Plan				Temperature workpiece	
METROTOM_CHECK_PL				Date	Time
CT dataset					
Customer	Operator	CMM	CMM No.	Incremental Part Number	
...	Master	METROTOM	

	Actual	Nominal	Upper Tol.	Lower Tol.	Deviation
 Overall Result: All Characteristics: Out of tolerance: Above Warning Limit: Not Calculated:					
Temperature					
The temperature of the test equipment when recording the data set was 21.5° C					
Sphere center point distances Position 1					
 SD 1-15	10.2831	10.2825	0.0046	-0.0046	0.0006
 SD 1-22	30.1414	30.1422	0.0048	-0.0048	-0.0008

Custom report

Creating a diagram for the sphere distance error length measuring error

Preparing an Excel spreadsheet

CALYPSO transfers values to an Excel sheet after the CNC run. These values must be copied and the »METROTOM_CHECK_PR« Excel sheet must be added. This file must be copied from the supplied USB stick to the hard disk beforehand ➤ *Preparation* [⇨ 4-7].

In total, three measurements must be performed. For all three measurements, the values must be transferred manually from the Excel sheet. As the result, you obtain a diagram of the sphere distance and length measuring errors.

Conditions

- You must make the required settings prior to the start of the CNC run in order to create the following Excel sheet ➤ *Running a measurement plan* [⇨ 4-22].

	A	B	C	D	E	F	G	H
1								
2								
3								
4								
5								
6								
7								
8								
9								
10								
11								
12								
13								
14								
15								
16								
17								
18								
19								
20								
21								
22								
23								
24								
25								
26								
27								
28								
29								
30								
31								
32								
33								
34								
35								
36								
37								
38								
39								
40								
41								
42								
43								
44								
45								
46								
47								
48								
49								

Excel sheet after execution of the CALYPSO CNC run

- 1 Copy the values in the column named »ACTUAL« (actual values).
- 2 Open the »METROTOM_CHECK_PR« Excel file.
- 3 Switch to the »Input_Measure_results« spreadsheet.

- 4 Insert the copied values in the left of the three »Actual values« columns which are framed in blue.

Measuring result SD							
		Position X-axis = 500 Magnification = 2.94					
Characteristic	Nominal	1. Measurement		2. Measurement		3. Measurement	
		Actual	Measurement error	Actual	Measurement error	Actual	Measurement error
SD1_15	32.4964						
SD1_23	60.5706						
SD1_27	64.4894						
SD1_25	73.5923						
SD1_8	112.9901						
SD3_16	29.0737						
SD3_23	41.6547						
SD3_27	64.5133						
SD3_25	79.0618						
SD3_10	112.9590						
SD5_17	25.6897						
SD5_24	46.9349						
SD5_27	64.3615						
SD5_26	75.9297						
SD5_12	112.9805						
SD7_18	23.4973						
SD7_25	58.9222						
SD7_27	64.4815						
SD7_23	67.3469						
SD7_14	113.0434						
SD9_19	21.9302						
SD9_25	44.1013						
SD9_27	64.4187						
SD9_23	77.7493						
SD9_2	113.0585						
SD11_20	21.3681						
SD11_26	54.6417						
SD11_27	64.3642						
SD11_24	70.5941						
SD11_4	112.9579						
SD13_21	22.4603						
SD13_28	42.1960						
SD13_27	64.4748						
SD13_24	79.7227						
SD13_6	112.9607						

»Measuring_results« spreadsheet

- Open the context menu by right clicking and select **Paste Contents**.

The following window opens:

Paste contents

Paste

☐ All
 ☐ Formulas
 ☒ Values
 ☐ Formats
 ☐ Comments
 ☐ Validity
 ☐ All except borders
 ☐ Column widths
 ☐ Formulas and number formats
 ☐ Values and number formats

Operation

☒ None
 ☐ Add
 ☐ Subtract
 ☐ Multiply
 ☐ Divide

☐ Skip blanks
 ☐ Transpose

Construct

OK

Cancel

»Paste Contents« window, selection options for pasting contents

- Select **Values** and click **OK**.

- 5 Check the nominal values in the table.

These values must correspond to the current calibration values of the test piece. If necessary, you may copy the calibration values from the CALYPSO Excel sheet. The calibration values are located in the »Nominal« column.

- 6 Evaluate two additional CT data sets in the same way.
 - Copy the actual values to the other two columns.
- 7 Switch to the »Input_parameter« spreadsheet in the »METRO-TOM_CHECK_PR« Excel file.
 - Select the desired language in the topmost selection field: German or English.
 - Select the CMM type and the test piece in the following two selection fields.
 - Under *Test uncertainty* (line 6), select add or subtract in order to demonstrate compliance or non-compliance. To prove compliance, subtract the test uncertainty (TU) from the MPE values; to prove non-compliance, add the TU to the MPE values.
 - In lines 27 to 34, enter the test piece information from the calibration certificate.
 - The MPE values to be checked have to be entered in lines 40 and 41. These are usually the values specified by the manufacturer.

2	Sprache / Language	English	▼
3	Please fill in the fields framed in blue!		
4	Device type	METROTOM 1500 G3	▼
5	Calibration phantom	METROTOM-Check	▼
6	Test uncertainty	Subtrahieren / subtract	▼
7			
8	Device		
9	Device type	METROTOM 1500 G3	
10	Serial no.	ENTER_SN	
11			
12	Customer		
13	Name	ENTER_CUSTOMER_NAME	
14	Street	ENTER_CUSTOMER_STREET	
15	City	ENTER_CUSTOMER_CITY	
16	Customer	ENTER_CUSTOMER_OPERATOR	
17	Phone no.	ENTER_CUSTOMER_PHONE	
18	E-mail	ENTER_CUSTOMER_EMAIL	
19			
20	Calibration phantom		
21	Type of calibration phantom	METROTOM-Check	
22	Material of calibration phantom	Ruby	
23	Nominal diameter of spheres [mm]	5	
24	Maximum measurement length [mm]	113	
25	Coefficient of thermal expansion [10 ⁻⁶ /K]	1.5	
26	Expanded uncertainty of the coefficient of thermal expansion [10 ⁻⁶ /K]	0.2	
27	Calibration phantom no.	ENTER_PHANTOM_NO	
28	Date of calibration	ENTER_CERT_DATE	
29	Calibration protocol no.	ENTER_CERT_NO	
30	Calibration department	ENTER_CERT_SERVICE	
31	Expanded (k=2) calibration uncertainty [µm]		
32			
33	Software		
34	CT-Software	ENTER_CT_SW	
35	Version	ENTER_CT_SW_VERSION	
36	Evaluation software	ENTER_EVAL_SW	
37	Version	ENTER_EVAL_SW_VERSION	
38			
39	Maximum Permissible Errors (MPE)		
40	SD _{MPE} [µm]		+ L /
41	EMPE [µm]		+ L /

- For the calculation of length measurement error E, enter the values determined for P_S and P_F on the P-Check test piece via CT measurement in lines 44 and 46. Likewise, enter the corresponding extended test uncertainties (TU) in lines 45 and 47. All four values are included in the Excel evaluation document for the P-Check.
- Then you must fill out all other relevant fields which are framed in blue.

43	Probing error (from separate measurement)	
44	P _S [μm]	
45	Expanded (k=2) uncertainty for P _S [μm]	
46	P _F [μm]	
47	Expanded (k=1.645) uncertainty for P _F [μm]	
48		
49	Calibration phantom temperature [°C]	
50		
51		
52	Measurement position	
53	X [mm]	ENTER MEAS X POS
54	Z [mm]	ENTER MEAS Z POS
55		
56	CT volumetric data	
57	1st measurement	ENTER CT DATA FILE1
58	2nd measurement	ENTER CT DATA FILE2
59	3rd measurement	ENTER CT DATA FILE3
60		
61	Measurement parameters	
62	Voltage [kV]	ENTER TUBE VOLTAGE
63	Current [μA]	ENTER TUBE CURRENT
64	Integration time [ms]	ENTER INT TIME
65	Image Averaging	ENTER IMAGE AVERAGING
66	Gain	ENTER IMAGE GAIN
67	Magnification	ENTER MAGNIFICATION
68	Prefilter	ENTER PREFILTER
69	Number of projections	ENTER NUMBER PROJECTIONS
70	Binning mode	ENTER BINNING MODE
71	Median filter (on/off)	ENTER MEDIAN FILTER
72	Noise suppression filter	ENTER NOISE SUPPRESSION
73	Focal spot control (on/off)	ENTER FSC
74	Y shift (on/off)	ENTER YSHIFT
75		
76	Settings evaluation software	
77	ENTER_EVAL_SW	Measurement strategy spheres: 6 circle paths each 130 points
78		Filtering of circle paths by Gauss filter, low-pass, 15 upr
79		
80	Remarks	
81		
82		
83		
84		
85	Zeiss engineer	ENTER ENGINEER
86		
87	Date	ENTER DATE

»Input_parameters« spreadsheet

The entries made are automatically transferred to the other spreadsheets.

8 Save the Excel file with a new name.

NOTE

The other spreadsheets show a complete list of all parameters, measurement data, and their representation in the diagram of the sphere distance error.

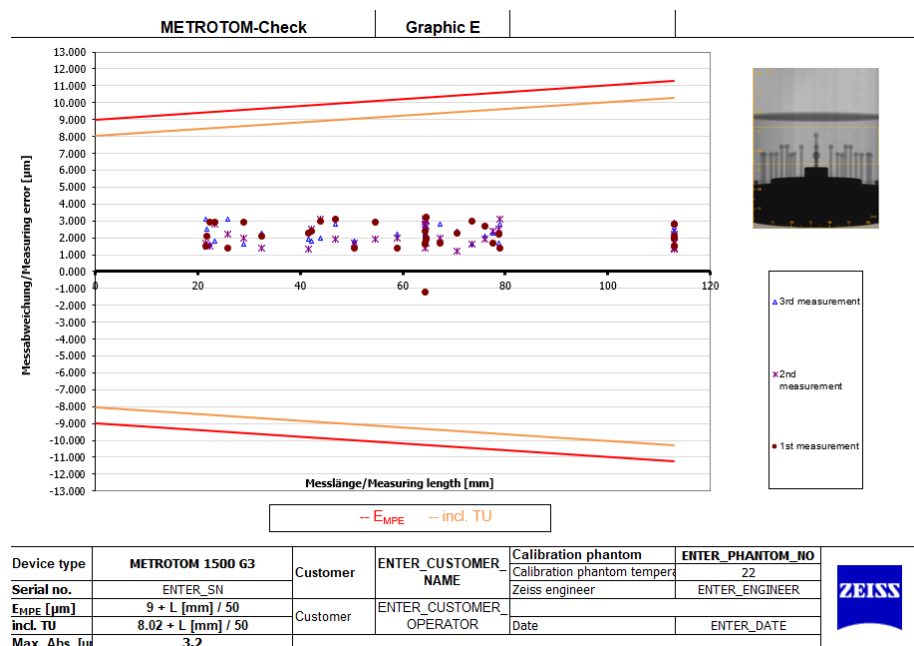
Measurement data

The measurement data is logged on the »Protocol_SD« and »Protocol_E« spreadsheets.

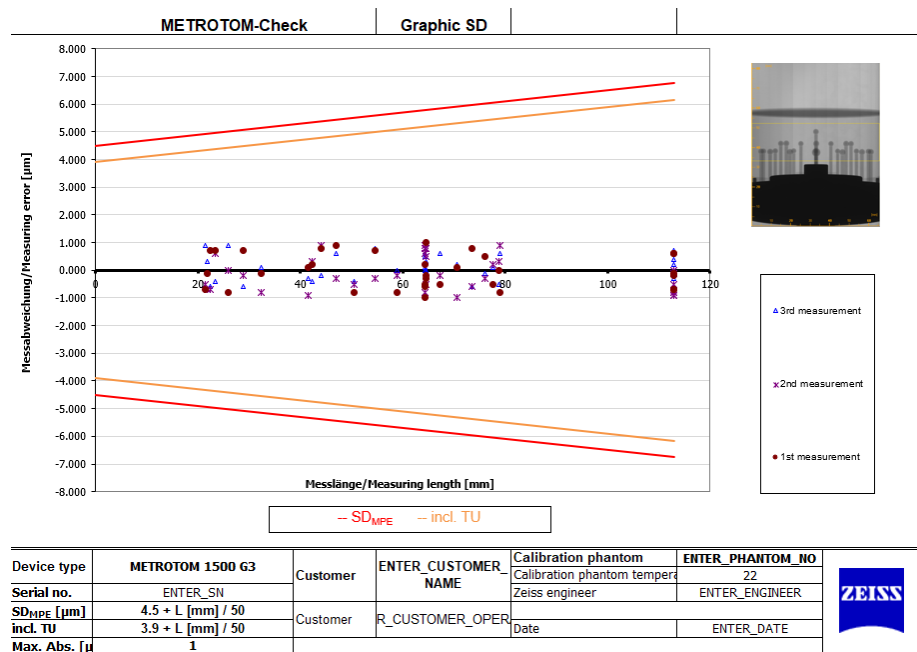
Graphic representation of the measurement data

The measurement creates a diagram of the sphere distance and length measuring error on the »Graphic_SD« and »Graphic_E« spreadsheets. The »Graphic_E« spreadsheet can be displayed only if PS and PF are available as results of the P-Check measurement (see the P-Check operating instructions).

In addition to the output of all parameters, values for the test uncertainty of SD and E are displayed here and these TU values are applied (added or subtracted) to the corresponding MPE values.



»Graphic_E« spreadsheet



»Graphic_SD« spreadsheet

Printing the evaluation table

Finally, you can print the spreadsheets.

- 1 Select the desired spreadsheets including the suitable cover sheet »Cover_M1500«.
- 2 Open the print menu and choose **Selected sheets**.
- 3 Click **Print**.

Causes of measurement errors

If the measurement results are outside the specified tolerances, this may be due to an error in operating the measurement software or to errors in the CT measurement run.

CALYPSO measuring software

Please check the following points:

- The temperature compensation in the measurement plan was active and the correct temperature as well as the correct expansion coefficient were entered.
- The nominal value file suits the test piece used and the current calibration values were used. Check the calibration sticker on the test piece and its date.
- The correct spheres were used during manual alignment.

METROTOM CT scanner

Please check the following points:

- Check the image quality in the volume data. No double edges or distinct image interference may be visible.
- A geometry and axis qualification was performed immediately before the measurement.
- The test piece is fixed in its holder and all screws are tightened.
- The selected reconstruction area is sufficiently large. All spheres of the test piece are visible in the volume data.
- Compare all parameters of the CT measurement with the default values: X-ray voltage, number of projections, etc.

Service

If it is not possible to eliminate the error, inform the ZEISS service department. You will find the phone number in the METROTOM operating instructions.

5

Care

This chapter contains:

Care and storage	5-2
------------------------	-----

Care and storage

Care

The test piece does not require any special measures for care. Nevertheless, you should observe the following:

- Handle the test piece with care.
- Avoid any impact loads.

If the acrylic glass cover is dirty, you can clean it with a damp cloth and a mild domestic cleaning agent.

Storage

The test piece should be stored in a dry, dust-free and protected place. Ideally, you should store the test piece in its original packaging after the measurement.

