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STARTUP =ALIGNMENT/START,RECALL:,LIST=YES
ALIGNMENT/END
MODE/MANUAL
PREHIT/1.5
RETRACT/1.5
MOVESPEED/ 50
TOUCHSPEED/ 1.2
MANRETRACT/20
FLY/ON,3
FORMAT/TEXT,OPTIONS, ,HEADINGS,SYMBOLS,
;NOM,TOL,MEAS,DEV,OUTTOL, ,
LOADPROBE/1BY20
TIP/T1A0B0, SHANKIJK=0, 0, 1, ANGLE=0
EXTERNALCOMMAND/NO_DISPLAY, NO_WAIT ; C:\PROGRAM
FILES\WANDATAPAGE+ 2011 MR1\DATAPAGESTATS.EXE -listening
TRACEFIELD/DISPLAY,LIMIT=15 ; SUPPLIER : RRP
TRACEFIELD/DISPLAY,LIMIT=15 ; INVOICE# : test
TRACEFIELD/DISPLAY,LIMIT=15 ; SAMPLE# : 1
PLN1 =FEAT/PLANE,CARTESIAN,TRIANGLE
THEO/<7.73,0.39,22.5>,<0,0,1>
ACTL/<143.25,137.99,-630.4>,<-0.002467,-0.004937,0.9999848>
MEAS/PLANE,3
HIT/BASIC,NORMAL,<-9.26,-29.2,22.5>,<0,0,1>,<151.11,174.27,-630.2>,USE
THEO=YES
HIT/BASIC,NORMAL,<32.52,0.4,22.5>,<0,0,1>,<159.61,119.85,-630.45>,USE
THEO=YES
HIT/BASIC,NORMAL,<-0.08,29.97,22.5>,<0,0,1>,<119.02,119.85,-
630.55>,USE THEO=YES
ENDMEAS/
CIR1 =FEAT/CIRCLE,CARTESIAN,IN,LEAST_SQR
THEO/<0,0,18.87>,<0,0,1>,41.9
ACTL/<140.88,145.99,-635.75>,<0,0,1>,41.87
MEAS/CIRCLE,3,WORKPLANE
HIT/BASIC,NORMAL,<-0.65,20.94,19.35>,<0.0311952,-
0.9995133,0>,<140.95,125.06,-633.82>,USE THEO=YES
HIT/BASIC,NORMAL,<20.05,6.08,19>,<-0.9570163,-
0.2900341,0>,<120.23,149.39,-637.36>,USE THEO=YES
HIT/BASIC,NORMAL,<2.31,-20.82,18.25>,<-
0.1100671,0.9939242,0>,<143.08,166.81,-636.07>,USE THEO=YES
ENDMEAS/
LIN1 =FEAT/LINE,CARTESIAN,UNBOUNDED
THEO/<-34.9,-11.64,13.41>,<0,1,0>
ACTL/<105.71,135.98,-638.5>,<0.0259802,0.9996625,0>
MEAS/LINE,2,WORKPLANE
HIT/BASIC,NORMAL,<-34.9,-11.64,13.13>,<-1,0,0>,<105.71,135.98,-
638.5>,USE THEO=YES

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        HIT/BASIC,NORMAL,<-34.9,12.67,13.69>,<-1,0,0>,<106.29,158.32,-
638.5>,USE THEO=YES
        ENDMEAS/
A1      =ALIGNMENT/START,RECALL:STARTUP,LIST=YES
        ALIGNMENT/LEVEL,ZPLUS,PLN1
        ALIGNMENT/TRANS,ZAXIS,PLN1
        ALIGNMENT/TRANS,XAXIS,CIR1
        ALIGNMENT/TRANS,YAXIS,CIR1
        ALIGNMENT/ROTATE,YPLUS,TO,LIN1,ABOUT,ZPLUS
        ALIGNMENT/END
        MODE/DCC
        CLEARP/ZPLUS,10,ZPLUS,0,ON
PLN2    =FEAT/PLANE,CARTESIAN,TRIANGLE
        THEO/<13.2,-2.44,0>,<0,0,1>
        ACTL/<13.2,-2.44,0.15>,<0.0007012,0.0028879,0.9999956>
        MEAS/PLANE,5
        MOVE/CLEARPLANE
        HIT/BASIC,NORMAL,<-9.92,-31.05,0>,<0,0,1>,<-9.92,-31.06,0.25>,USE
THEO=YES
        HIT/BASIC,NORMAL,<18.05,-23.77,0>,<0,0,1>,<18.05,-23.77,0.21>,USE
THEO=YES
        HIT/BASIC,NORMAL,<31.05,-10.14,0>,<0,0,1>,<31.05,-10.14,0.16>,USE
THEO=YES
        HIT/BASIC,NORMAL,<26.09,19.41,0>,<0,0,1>,<26.09,19.41,0.08>,USE
THEO=YES
        HIT/BASIC,NORMAL,<0.71,33.38,0>,<0,0,1>,<0.71,33.38,0.05>,USE
THEO=YES
        ENDMEAS/
        MOVE/CLEARPLANE
CIR2    =FEAT/CONTACT/CIRCLE/DEFAULT,CARTESIAN,IN,LEAST_SQR
        THEO/<0,0,-2>,<0,0,1>,41.9
        ACTL/<0,0.02,-2>,<0,0,1>,41.88
        TARG/<0,0,-2>,<0,0,1>
        START ANG=253.9,END ANG=469.8
        ANGLE VEC=<1,0,0>
        DIRECTION=CCW
        SHOW FEATURE PARAMETERS=NO
        SHOW CONTACT PARAMETERS=YES
        NUMHITS=8,DEPTH=0.5,PITCH=0
        SAMPLE HITS=0,SPACER=0
        AVOIDANCE MOVE=NO,DISTANCE=8
        FIND HOLE=DISABLED,ONERROR=NO,READ POS=NO
        SHOW HITS=NO
        MOVE/CLEARPLANE
LIN2    =FEAT/LINE,CARTESIAN,UNBOUNDED
        THEO/<-34.9,-12.63,-6>,<0,1,0>

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    ACTL/<-34.89,-12.62,-6>,<0.0000213,1,0>
    MEAS/LINE,3,WORKPLANE
    MOVE/CLEARPLANE
    HIT/BASIC,NORMAL,<-34.9,-12.63,-6>,<-1,0,0>,<-34.9,-12.62,-6>,USE
THEO=YES
    HIT/BASIC,NORMAL,<-34.9,-0.01,-6>,<-1,0,0>,<-34.89,0,-6>,USE
THEO=YES
    HIT/BASIC,NORMAL,<-34.9,13.18,-6>,<-1,0,0>,<-34.9,13.19,-6>,USE
THEO=YES
    ENDMEAS/
    MOVE/CLEARPLANE
A2    =ALIGNMENT/START,RECALL:A1,LIST=YES
    ALIGNMENT/LEVEL,ZPLUS,PLN2
    ALIGNMENT/TRANS,ZAXIS,PLN2
    ALIGNMENT/TRANS,XAXIS,CIR2
    ALIGNMENT/TRANS,YAXIS,CIR2
    ALIGNMENT/ROTATE,YPLUS,TO,LIN2,ABOUT,ZPLUS
    ALIGNMENT/END
DIM LOC1= LOCATION OF CIRCLE CIR2 UNITS=MM ,$
GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH HALF ANGLE=NO
AX  NOMINAL    +TOL    -TOL    MEAS    DEV    OUTTOL
D   41.90    0.10    0.10    41.88    -0.02    0.00  #-
END OF DIMENSION LOC1
CIR4    =FEAT/CONTACT/CIRCLE/DEFAULT,CARTESIAN,IN,LEAST_SQR
    THEO/<0,0,-2>,<0,0,1>,45.5
    ACTL/<0,0,-2>,<0,0,1>,45.44
    TARG/<0,0,-2>,<0,0,1>
    START ANG=250.2,END ANG=107.1
    ANGLE VEC=<1,0,0>
    DIRECTION=CCW
    SHOW FEATURE PARAMETERS=NO
    SHOW CONTACT PARAMETERS=YES
        NUMHITS=6,DEPTH=-1,PITCH=0
        SAMPLE HITS=0,SPACER=0
        AVOIDANCE MOVE=NO,DISTANCE=8
        FIND HOLE=DISABLED,ONERROR=NO,READ POS=NO
    SHOW HITS=NO
    MOVE/CLEARPLANE
CIR3    =FEAT/CONTACT/CIRCLE/DEFAULT,CARTESIAN,OUT,LEAST_SQR
    THEO/<0,0,-8.51>,<0,0,1>,78.1,3
    ACTL/<0,0.01,-8.51>,<0,0,1>,78.1,3
    TARG/<0,0,-8.51>,<0,0,1>
    START ANG=218.4,END ANG=137.8
    ANGLE VEC=<1,0,0>
    DIRECTION=CCW
    SHOW FEATURE PARAMETERS=NO

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SHOW CONTACT PARAMETERS=YES
 NUMHITS=8,DEPTH=-0.7,PITCH=0
 SAMPLE HITS=0,SPACER=0
 AVOIDANCE MOVE=NO,DISTANCE=8
 FIND HOLE=DISABLED,ONERROR=NO,READ POS=NO
 SHOW HITS=NO
 MOVE/CLEARPLANE
 DIM LOC2= LOCATION OF CIRCLE CIR4 UNITS=MM ,\$
 GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH HALF ANGLE=NO
 AX NOMINAL +TOL -TOL MEAS DEV OUTTOL
 D 45.50 0.10 0.10 45.44 -0.06 0.00 #---
 END OF DIMENSION LOC2
 DIM LOC3= LOCATION OF CIRCLE CIR3 UNITS=MM ,\$
 GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH HALF ANGLE=NO
 AX NOMINAL +TOL -TOL MEAS DEV OUTTOL
 D 78.10 0.10 0.10 78.10 0.00 0.00 --#-
 END OF DIMENSION LOC3
 MOVE/CLEARPLANE
 PREHIT/3
 RETRACT/3
 CYL1 =FEAT/CYLINDER,CARTESIAN,OUT,NO
 THEO/<0,0,-2>,<0,0,1>,45.5,5
 ACTL/<0,0,-2.15>,<-0.0007012,-0.0028879,0.9999956>,45.5,5
 CONSTR/CYLINDER,CAST,CIR2,INDEPENDENT
 CYL2 =FEAT/CYLINDER,CARTESIAN,OUT,NO
 THEO/<0,0,-2>,<0,0,1>,72.4,5
 ACTL/<0,0,-2.15>,<-0.0007012,-0.0028879,0.9999956>,72.4,5
 CONSTR/CYLINDER,CAST,CIR2,INDEPENDENT
 PLN3 =FEAT/PLANE,CARTESIAN,OUTLINE
 THEO/<6.94,1.89,-1.55>,<0,0,1>
 ACTL/<6.94,1.89,-1.52>,<-0.0000212,0.0002147,1>
 MEAS/PLANE,5
 MOVE/CLEARPLANE
 HIT/BASIC,NORMAL,<-14.31,-28.49,-1.55>,<0,0,1>,<-14.31,-28.49,-
 1.52>,USE THEO=YES
 HIT/BASIC,NORMAL,<15.24,-27.9,-1.55>,<0,0,1>,<15.24,-27.91,-1.51>,USE
 THEO=YES
 HIT/BASIC,NORMAL,<32.86,5.6,-1.55>,<0,0,1>,<32.85,5.6,-1.52>,USE
 THEO=YES
 HIT/BASIC,NORMAL,<15.53,30.93,-1.55>,<0,0,1>,<15.53,30.93,-1.53>,USE
 THEO=YES
 HIT/BASIC,NORMAL,<-14.62,29.32,-1.55>,<0,0,1>,<-14.62,29.32,-1.52>,USE
 THEO=YES
 ENDMEAS/
 PREHIT/1.5
 RETRACT/1.5

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F1    =GENERIC/PLANE,DEPENDENT,CARTESIAN,$
      NOM/XYZ,<0,0,-0.77>,$
      MEAS/XYZ,<0,0,-0.77>,$
      NOM/IJK,<0,0,-1>,$
      MEAS/IJK,<0,0,-1>
      MOVE/CLEARPLANE
V1    =LOOP/START,ID=NO,NUMBER=15,START=1,SKIP=2,4,6,7,8,9,11,13,15,,
      OFFSET:XAXIS=0,YAXIS=0,ZAXIS=0,ANGLE=18
PLN4  =FEAT/CONTACT/PLANE/DEFAULT,CARTESIAN,OUTLINE
      THEO/<-19.46,-22.92,-0.88>,<-0.7051349,0.5969407,0.3826834>
      ACTL/<-19.47,-22.91,-0.88>,<-0.7035938,0.5956328,0.3875272>
      TARG/<-19.46,-22.92,-0.88>,<-0.7051349,0.5969407,0.3826834>
      ANGLE VEC=<0.4769917,0,0.8789078>,SQUARE
      SHOW FEATURE PARAMETERS=NO
      SHOW CONTACT PARAMETERS=YES
      NUMHITS=2,NUMROWS=2
      SPACER=1.5
      AVOIDANCE MOVE=NO,DISTANCE=8
      SHOW HITS=NO
      MOVE/CLEARPLANE
PLN5  =FEAT/CONTACT/PLANE/DEFAULT,CARTESIAN,OUTLINE
      THEO/<-16.76,-27.01,-1>,<0.785623,-0.4861583,0.3826834>
      ACTL/<-16.66,-27.07,-0.95>,<0.7830251,-0.4846954,0.3897975>
      TARG/<-16.76,-27.01,-1>,<0.785623,-0.4861583,0.3826834>
      ANGLE VEC=<0.4379176,0,-0.8990151>,SQUARE
      SHOW FEATURE PARAMETERS=NO
      SHOW CONTACT PARAMETERS=YES
      NUMHITS=2,NUMROWS=2
      SPACER=1.5
      AVOIDANCE MOVE=NO,DISTANCE=8
      SHOW HITS=NO
      MOVE/CLEARPLANE
DIM ANGL1= 3D ANGLE FROM PLANE PLN4 TO  ZAXIS ,$
GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH
AX NOMINAL  +TOL  -TOL  MEAS  DEV  OUTTOL
A  -22.50   1.00   1.00  -22.80  -0.30   0.00  #--
DIM ANGL3= 3D ANGLE FROM PLANE PLN5 TO  ZAXIS ,$
GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH
AX NOMINAL  +TOL  -TOL  MEAS  DEV  OUTTOL
A   22.50   1.00   1.00   22.94   0.44   0.00  --#
LIN3  =FEAT/LINE,CARTESIAN,UNBOUNDED,NO
      THEO/<-9.71,-11.47,-0.78>,<0.6461239,0.7632325,0>
      ACTL/<-9.72,-11.47,-0.77>,<0.6461219,0.7632342,0>
      CONSTR/LINE,INTOF,F1,PLN4
LIN4  =FEAT/LINE,CARTESIAN,UNBOUNDED,NO
      THEO/<-8.47,-13.45,-0.78>,<0.526214,0.8503522,0>

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        ACTL/<-8.36,-13.52,-0.77>,<0.5263276,0.8502819,0>
        CONSTR/LINE,INTOF,PLN5,F1
PNT1   =FEAT/POINT,CARTESIAN,NO
        THEO/<-23.39,-27.63,-0.78>,<0.6461239,0.7632325,0>
        ACTL/<-23.39,-27.62,-0.77>,<0.6461219,0.7632342,0>
        CONSTR/POINT,PIERCE,LIN3,CYL2
PNT2   =FEAT/POINT,CARTESIAN,NO
        THEO/<-14.7,-17.36,-0.78>,<0.6461239,0.7632325,0>
        ACTL/<-14.7,-17.36,-0.77>,<0.6461219,0.7632342,0>
        CONSTR/POINT,PIERCE,LIN3,CYL1
PNT3   =FEAT/POINT,CARTESIAN,NO
        THEO/<-12.08,-19.28,-0.78>,<0.526214,0.8503522,0>
        ACTL/<-11.96,-19.35,-0.77>,<0.5263276,0.8502819,0>
        CONSTR/POINT,PIERCE,LIN4,CYL1
PNT4   =FEAT/POINT,CARTESIAN,NO
        THEO/<-19.16,-30.72,-0.78>,<0.526214,0.8503522,0>
        ACTL/<-19.04,-30.78,-0.77>,<0.5263276,0.8502819,0>
        CONSTR/POINT,PIERCE,LIN4,CYL2
DIM DIST1= 2D DISTANCE FROM POINT PNT4 TO POINT PNT1 (CENTER TO
CENTER),NO_RADIUS UNITS=MM,$
GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH
AX NOMINAL  +TOL  -TOL  MEAS  DEV  OUTTOL
M   5.24   0.12   0.00   5.38   0.14   0.02 --->
DIM DIST2= 2D DISTANCE FROM POINT PNT2 TO POINT PNT3 (CENTER TO
CENTER),NO_RADIUS UNITS=MM,$
GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH
AX NOMINAL  +TOL  -TOL  MEAS  DEV  OUTTOL
M   3.25   0.12   0.00   3.39   0.14   0.02 --->
        LOOP/END
        WORKPLANE/ZPLUS
PLN6   =FEAT/PLANE,CARTESIAN,TRIANGLE
        THEO/<5.71,1.25,-2>,<0,0,1>
        ACTL/<5.71,1.25,-1.92>,<-0.0005425,0.0001393,0.9999998>
        MEAS/PLANE,4
        MOVE/CLEARPLANE
        HIT/BASIC,NORMAL,<-3.98,-21.09,-2>,<0,0,1>,<-3.97,-21.09,-1.92>,USE
THEO=YES
        HIT/BASIC,NORMAL,<18.84,-10.3,-2>,<0,0,1>,<18.85,-10.3,-1.91>,USE
THEO=YES
        HIT/BASIC,NORMAL,<14.85,15.86,-2>,<0,0,1>,<14.84,15.86,-1.92>,USE
THEO=YES
        HIT/BASIC,NORMAL,<-6.87,20.54,-2>,<0,0,1>,<-6.88,20.54,-1.93>,USE
THEO=YES
        ENDMEAS/
        MOVE/CLEARPLANE
        MOVE/POINT,NORMAL,PART,<0.00,100.00,20.00>

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WORKPLANE/YPLUS

DIM DIST3= 2D DISTANCE FROM PLANE PLN2 TO PLANE PLN3 PAR TO
ZAXIS,NO_RADIUS UNITS=MM,\$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
|----|---------|------|------|------|-----|--------|
|----|---------|------|------|------|-----|--------|

| | | | | | | |
|---|------|------|------|------|-------|----------|
| M | 1.55 | 0.00 | 0.05 | 1.52 | -0.03 | 0.00 #-- |
|---|------|------|------|------|-------|----------|

DIM DIST4= 2D DISTANCE FROM PLANE PLN6 TO PLANE PLN2 PAR TO
ZAXIS,NO_RADIUS UNITS=MM,\$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

| AX | NOMINAL | +TOL | -TOL | MEAS | DEV | OUTTOL |
|----|---------|------|------|------|-----|--------|
|----|---------|------|------|------|-----|--------|

| | | | | | | |
|---|------|------|------|------|-------|------------|
| M | 2.00 | 0.55 | 0.00 | 1.92 | -0.08 | -0.08 <--- |
|---|------|------|------|------|-------|------------|

DATDEF/FEATURE=PLN2,A

FCFPARL1 =PARALLELISM OF PLN3

FEATCTRLFRAME/SHOWPARAMS=YES,SHOWEXPANDED=YES

CADGRAPH=OFF,REPORTGRAPH=OFF,TEXT=OFF,MULT=10.00,ARROWDENSITI
TY=100,OUTPUT=BOTH,UNITS=MM

DIMENSION/PARALLELISM,0.05,<PZ>,<type>,<len>,A,<dat>,<dat>

NOTE/FCFPARL1

FEATURES/PLN3,,