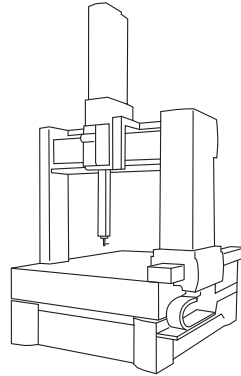


# Influences on measuring results

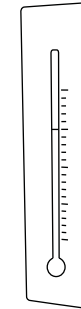
## Measuring Strategy

- Inspection planning
- Sensor
- Measuring method
- Filter setting
- Outlier elimination
- Analysis strategy
- Clamping/fixturing strategy
- Alignment strategy
- Illumination strategy
- Zoom
- Number of measuring points
- Distribution of measuring points
- Probing force
- Scanning speed
- Usage of rotary table
- ...



## Measuring Machine

- Machine geometry
- Sensors
- Measuring standard
- Accuracy (MPE)
- Measuring range
- Measuring software
- Error correction (CAA)
- Qualification normal
- Illumination
- Telecentricity
- Sensor limits
- Hysteresis, dynamics
- ...

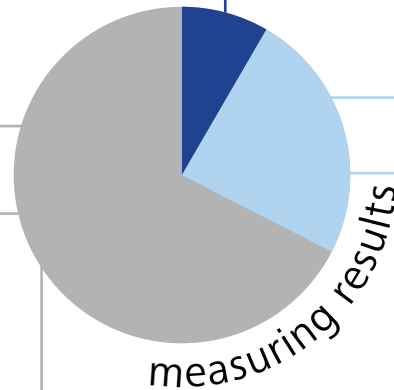


## Environment

- Temperature
- Temperature gradient
- Temperature drift
- Thermal radiation
- Contamination, dust
- Vibrations
- Humidity
- Air draft
- Light reflections
- ...

## Operator

- Education/training
- Use of tools
- Clamping check
- Alignment check
- Stylus qualification
- Measurement planning
- Avoiding of collisions
- Stylus assembly
- Shaft probing
- Machine monitoring
- Care and cleanliness
- Motivation
- ...

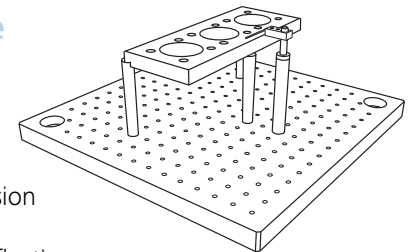


## Inspection Task

- Application orientation
- Tolerance orientation
- Process and cycle time orientation
- Task-oriented reports
- Volume orientation
- ...

## Workpiece

- Form error
- Dimension
- Weight
- Material
- Linear expansion
- Surface
- Brightness/reflection
- Part temperature
- Part contamination
- Elasticity/plasticity
- Drawing/CAD
- ...



We make it visible.