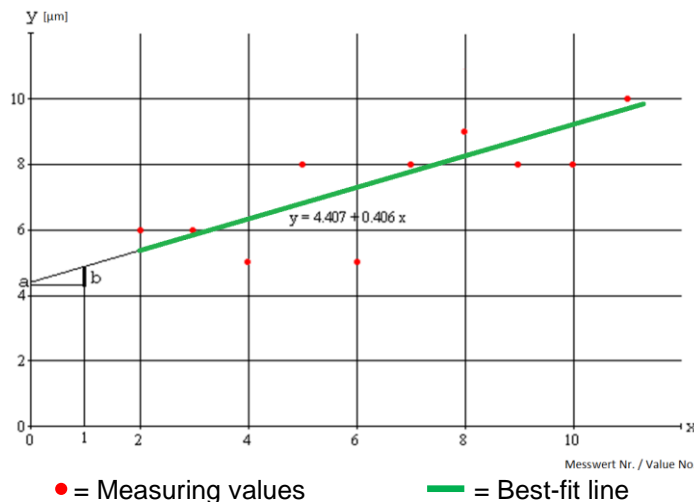


1. Introduction

The ComGage special measurement mode “Dynamic measurement with correction by best-fit line” (wgl014) allows a straightness measurement with the following sequence :

- A probe is moved over the test piece, whereby we assume a uniform speed of movement.
- ComGage uses all measuring values to calculate a best-fit line.
- Next, the difference to the best-fit line is determined for each measuring value.
- Min / Max / Max-Min / (Max+Min)/2 of these differences is output as measuring result.



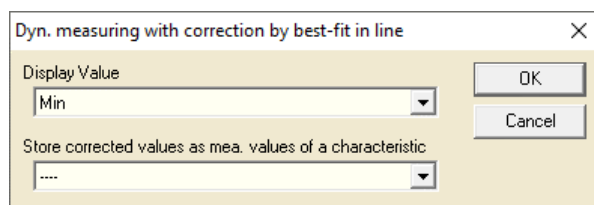
Additionally, it is possible to save the differences to the best-fit line (= corrected values) in another characteristic and then visualise them on the screen in a run chart.

Important notes :

- The software license Module 72 (ComGage Special Modules) is required for this special measurement mode.
- The dynamic measurement can be started / ended by the test step functions “Dynamic measurement on” / “Dynamic measurement off” / “Dynamic measurement on/off”.

2. Configuration

The following configuration dialogue can be opened by clicking the *Setup* button :



The dialog box has a title bar 'Dyn. measuring with correction by best-fit in line' and a close button 'X'. It contains two dropdown menus. The first is labeled 'Display Value' and has 'Min' selected. The second is labeled 'Store corrected values as mea. values of a characteristic' and has '....' selected. There are 'OK' and 'Cancel' buttons.

The following settings can be configured :

Display Value

Here can be selected which value shall be output as measuring result by the special measurement mode.

Available are *Min* / *Max* / *TIR* (*Max-Min*) / *MEAN* (*(Max+Min)/2*).

Store corrected values as mea. values of a characteristic

A characteristic can be selected, in which the differences of the measuring values to the best-fit line (= corrected values) are stored.

The stored values can e.g. be used for a visualisation in a run chart.

The measuring values of this characteristic have to be deleted before each new measurement by the test step function “Delete all measured values”. This is not done automatically.