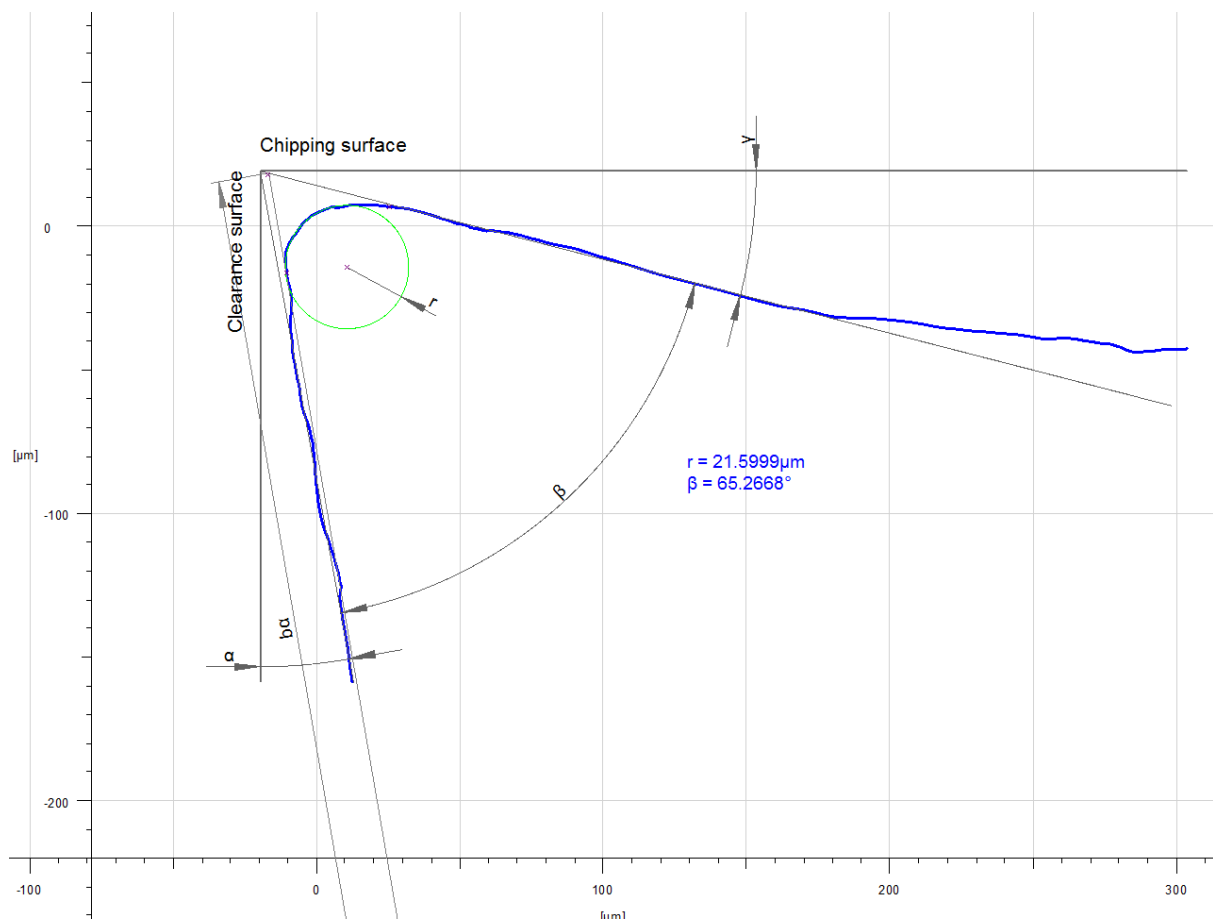
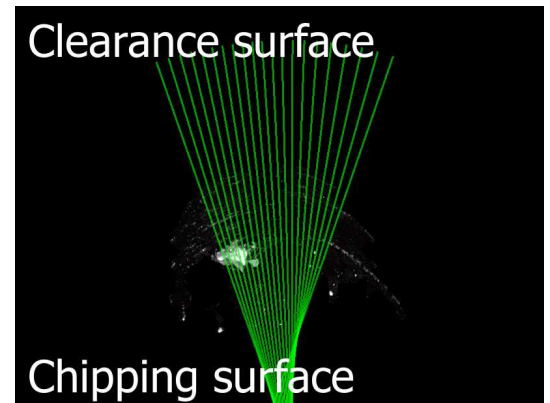


# IF-EdgeMasterModule Measurement Report

## Cutting Edge Measurement

ReferenceType: 1  
Number of extracted profiles: 50  
Edge profile type: Supporting Bevel  
Date of measurement: 11.9.2015 17:42:59  
Operator: Administrator

Name	Value	[u]	Description
r	21.5999	$\mu\text{m}$	Mean radius of mean edge
bp1 $\alpha$	311.2930	$\mu\text{m}$	Proj. supporting bevel length 1 (former: Sp1)
bp2 $\alpha$	300.0095	$\mu\text{m}$	Proj. supporting bevel length 2 (former: Sp2)
b $\alpha$	315.9314	$\mu\text{m}$	True supporting bevel length (former: St)
$\alpha$ b	-260.1700	$^\circ$	Angle of supporting bevel (former: $\alpha$ supporting)
$\alpha$	10.3055	$^\circ$	Clearance angle
$\beta$	65.2668	$^\circ$	Wedge angle
$\gamma$	14.4276	$^\circ$	Chip angle
S $\alpha$	34.8634	$\mu\text{m}$	Dist. apex to end of clearance roundness (former: a)
S $\gamma$	43.9436	$\mu\text{m}$	Dist. apex to end of chipping roundness (former: b)
K	1.2605		Symmetry of cutting edge
$\Delta$ r	20.8882	$\mu\text{m}$	Min. dist. of edge to apex (former: S)
Ecq	231.8102	nm	Form deviation of circle (RMS)
Form	Trumpet		Estimated Curvature

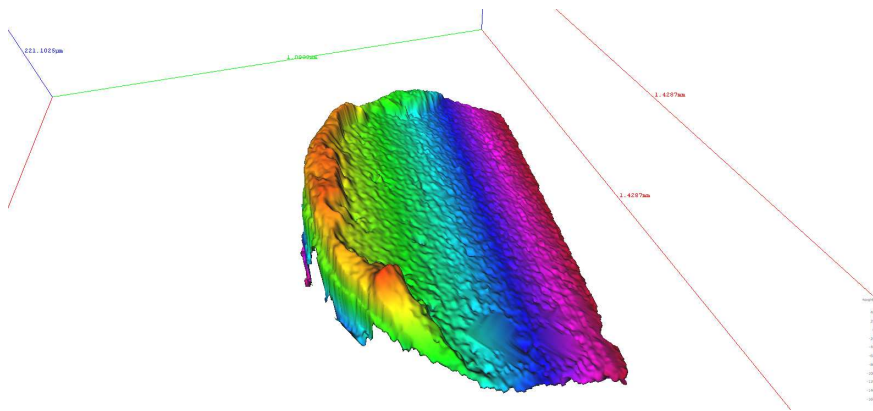


# IF-EdgeMasterModule Measurement Report

## Cutting Edge Measurement

ReferenceType:	1
Number of extracted profiles:	50
Edge profile type:	Supporting Bevel
Date of measurement:	30.9.2015 18:11:30
Operator:	Administrator

### 3D View

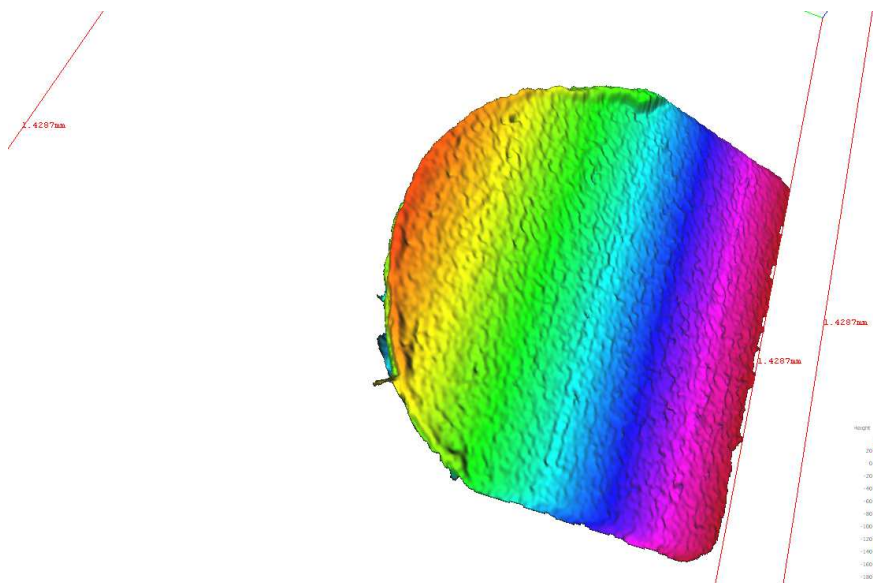


# IF-EdgeMasterModule Measurement Report

## Cutting Edge Measurement

ReferenceType:	1
Number of extracted profiles:	50
Edge profile type:	Supporting Bevel
Date of measurement:	30.9.2015 18:06:13
Operator:	Administrator

### 3D View

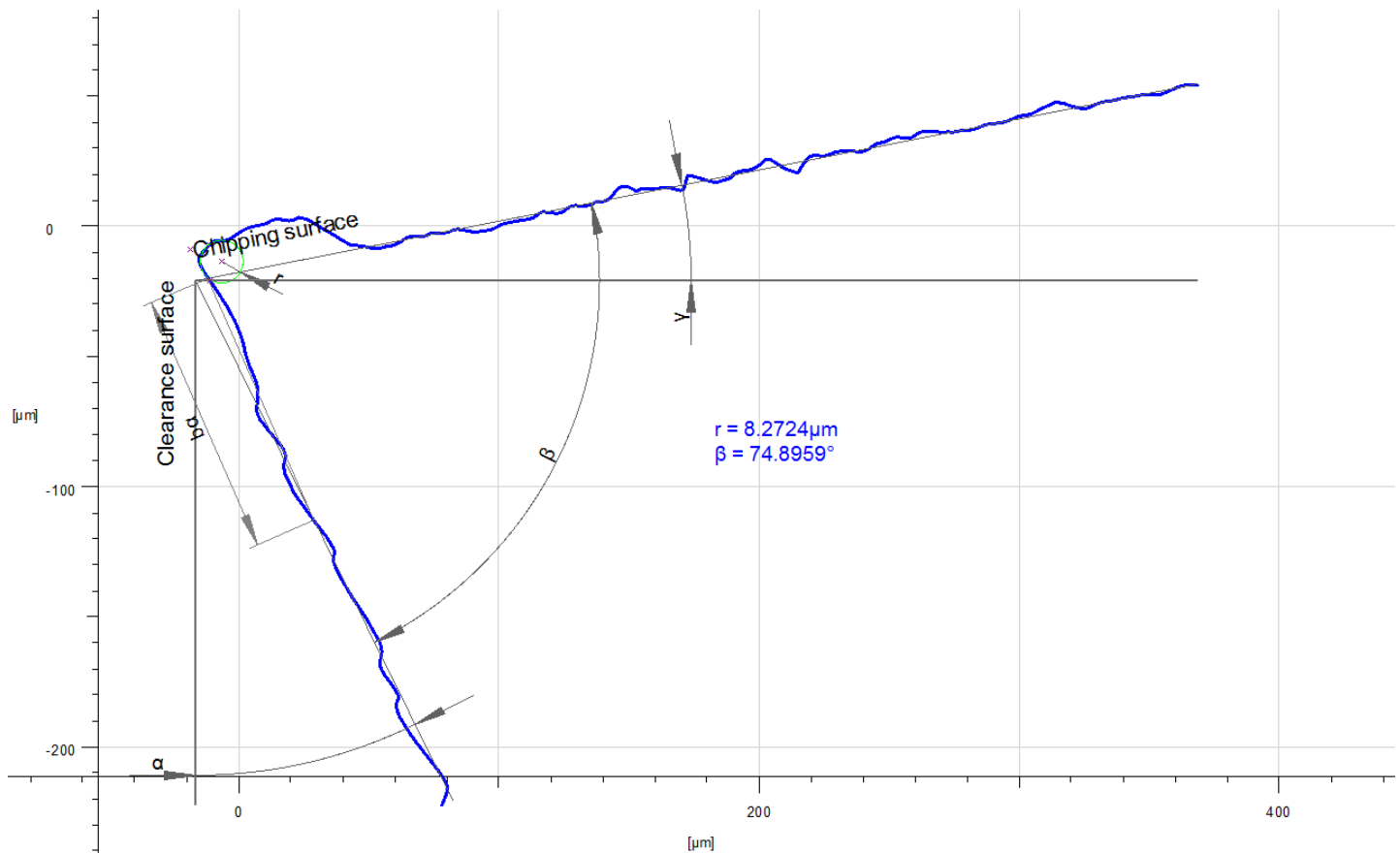


# IF-EdgeMasterModule Measurement Report

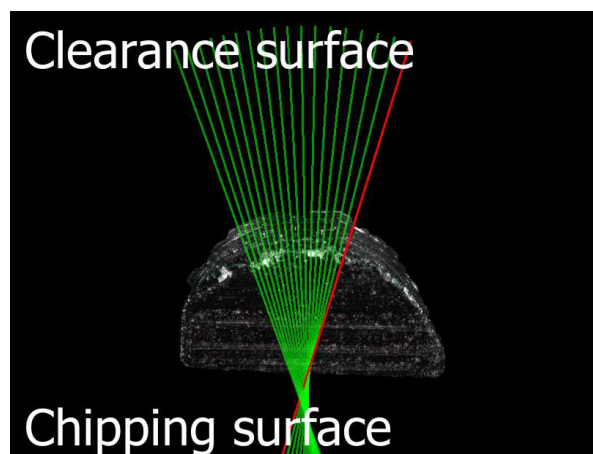
## Cutting Edge Measurement

ReferenceType:	1
Number of extracted profiles:	50
Edge profile type:	Supporting Bevel
Date of measurement:	30.9.2015 17:58:15
Operator:	Administrator

Profile #18



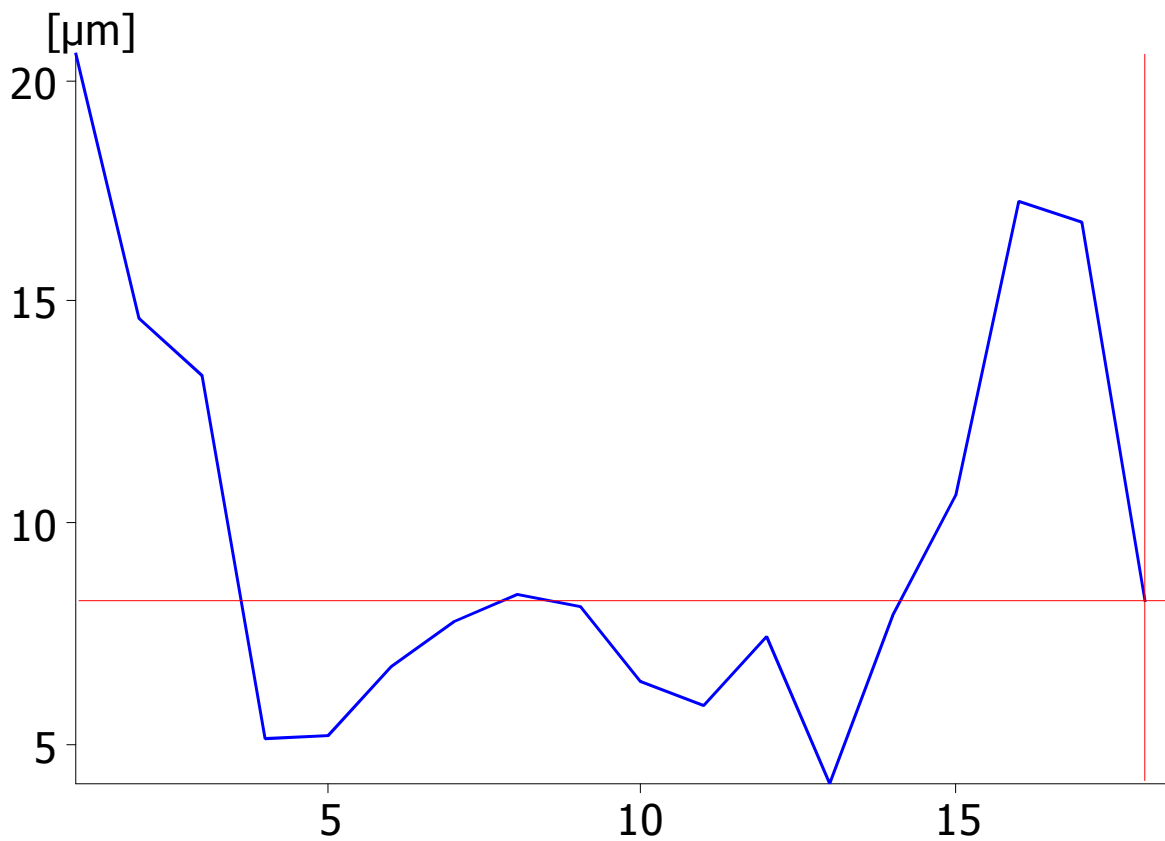
Surface



## Profile Parameter Statistics

	visible	r [ $\mu\text{m}$ ]	Ecq [nm]	bp1 $\alpha$ [ $\mu\text{m}$ ]	bp2 $\alpha$ [ $\mu\text{m}$ ]	ba [ $\mu\text{m}$ ]	ab [°]	$\alpha$ [°]	$\beta$ [°]	$\gamma$ [°]	Sa [ $\mu\text{m}$ ]	Sy [ $\mu\text{m}$ ]	K	$\Delta r$ [ $\mu\text{m}$ ]
Mean:		9.6967	403.7081	250.2925	271.3335	273.7975	-127.6530	25.0066	76.3289	-11.3355	14.7505	6.1020	0.4225	4.6751
Std. Dev.:		4.7807	190.4708	315.6853	314.8012	347.1262	87.3579	0.9806	1.0953	0.4021	1.1157	2.0353	0.1683	2.2141
Minimum:		4.1176	182.4976	20.1034	42.3009	20.7363	-249.0707	23.0072	74.4457	-12.5160	12.3779	2.7503	0.1775	1.3839
Maximum:		20.5909	866.9362	1173.7530	1189.1224	1286.1027	-64.7185	26.7147	78.5362	-10.8001	16.6747	10.0978	0.8158	10.8982
Median:		8.0331	341.5727	101.0204	124.2091	109.5483	-68.2416	24.9176	76.5175	-11.2393	14.9673	6.3991	0.4336	4.6549
Robust:		8.3582	369.2660	75.0692	107.9052	80.7411	-67.6483	24.3690	76.8003	-11.3069	15.1999	7.0885	0.3910	4.6699

## Edge Parameter r



## Profile Parameters

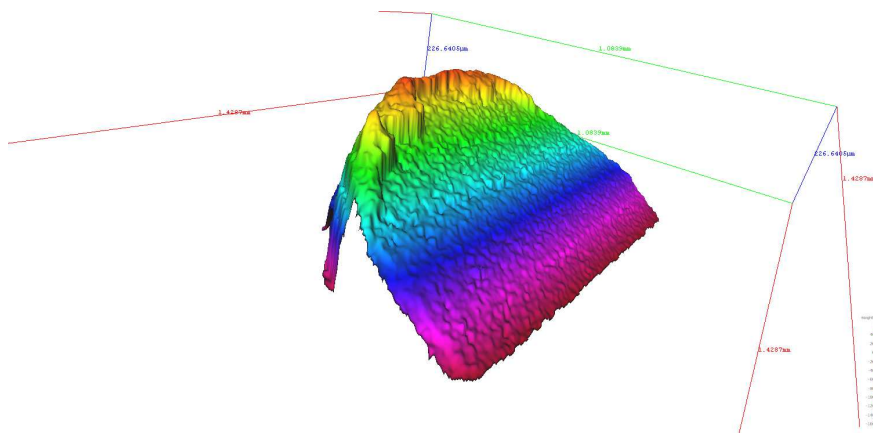
	visible	r [μm]	Ecq [nm]	bp1α [μm]	bp2α [μm]	ba [μm]	ab [°]	α [°]	β [°]	γ [°]	Sα [μm]	Sγ [μm]	K	Δr [μm]
1:	yes	20.5909	620.6542	42.8669	73.7711	46.2101	-248.0719	24.4607	78.0553	-12.5160	12.6912	9.3628	0.7377	5.7823
2:	yes	14.6120	326.5017	94.2848	123.4051	100.9803	-249.0184	25.1812	76.6608	-11.8420	14.1096	6.7690	0.4797	4.7522
3:	yes	13.3271	496.8339	595.2770	628.0642	653.0163	-65.7247	24.7058	76.6502	-11.3560	14.7103	6.5424	0.4447	4.6381
4:	yes	5.1310	200.0492	51.2879	75.8344	55.4675	-67.6153	24.2062	76.7523	-10.9585	15.5057	4.5054	0.2906	2.6278
5:	yes	5.1740	356.6437	89.7108	110.9436	95.3874	-70.1339	24.8021	76.5231	-11.3251	15.7093	3.2494	0.2068	2.2142
6:	yes	6.7691	307.5355	238.4709	260.1236	263.1628	-64.9816	26.4796	74.7267	-11.2064	13.1392	4.5573	0.3468	10.8982
7:	yes	7.7453	392.0621	109.6132	125.0132	117.3561	-249.0707	25.4431	75.6283	-11.0714	15.0717	5.1504	0.3417	3.8601
8:	yes	8.4077	298.3221	66.6885	85.1305	72.0987	-67.6623	25.2754	75.9969	-11.2722	15.4921	7.9881	0.5156	7.0648
9:	yes	8.1303	267.6519	107.7560	127.3604	117.0188	-67.0498	25.7773	75.5364	-11.3137	15.2067	7.6923	0.5058	5.4501
10:	yes	6.4071	564.0815	86.4403	107.2803	92.7191	-248.7932	23.9814	77.5522	-11.5335	15.2014	4.8276	0.3176	3.0034
11:	yes	5.8853	276.5292	20.1034	42.3009	20.7363	-75.8084	23.0072	78.5362	-11.5434	15.4981	2.7503	0.1775	1.3839
12:	yes	7.4103	421.1918	214.5565	232.4471	233.0243	-67.0356	24.0887	77.1147	-11.2034	14.5774	6.5201	0.4473	3.9363
13:	yes	4.1176	182.4976	63.5007	83.1817	68.1006	-68.8209	25.9965	75.7755	-11.7720	15.7620	3.2853	0.2084	2.0558
14:	yes	7.9359	211.7935	388.1832	405.5330	425.1108	-245.9421	24.4189	76.6375	-11.0564	14.8629	6.2781	0.4224	4.3872
15:	yes	10.6055	408.1784	1173.7530	1189.1224	1286.1027	-65.8732	24.2881	76.5119	-10.8001	16.6747	6.1512	0.3689	5.0051
16:	yes	17.2521	866.9362	846.3792	864.2464	933.2919	-245.0770	25.0331	75.9198	-10.9530	12.3779	10.0978	0.8158	6.5380
17:	yes	16.7668	753.1585	222.8844	242.0515	246.4934	-64.7185	26.7147	74.4457	-11.1604	14.8006	6.6611	0.4501	5.8820
18:	yes	8.2724	316.1252	93.5088	108.1935	102.0778	-66.3559	26.2588	74.8959	-11.1547	14.1187	7.4467	0.5274	4.6716

# IF-EdgeMasterModule Measurement Report

## Cutting Edge Measurement

ReferenceType:	1
Number of extracted profiles:	50
Edge profile type:	Supporting Bevel
Date of measurement:	30.9.2015 17:57:34
Operator:	Administrator

### 3D View



ReferenceType:	1
Number of extracted profiles:	50
Edge profile type:	Supporting Bevel
Date of measurement:	30.9.2015 17:50:54
Operator:	Administrator

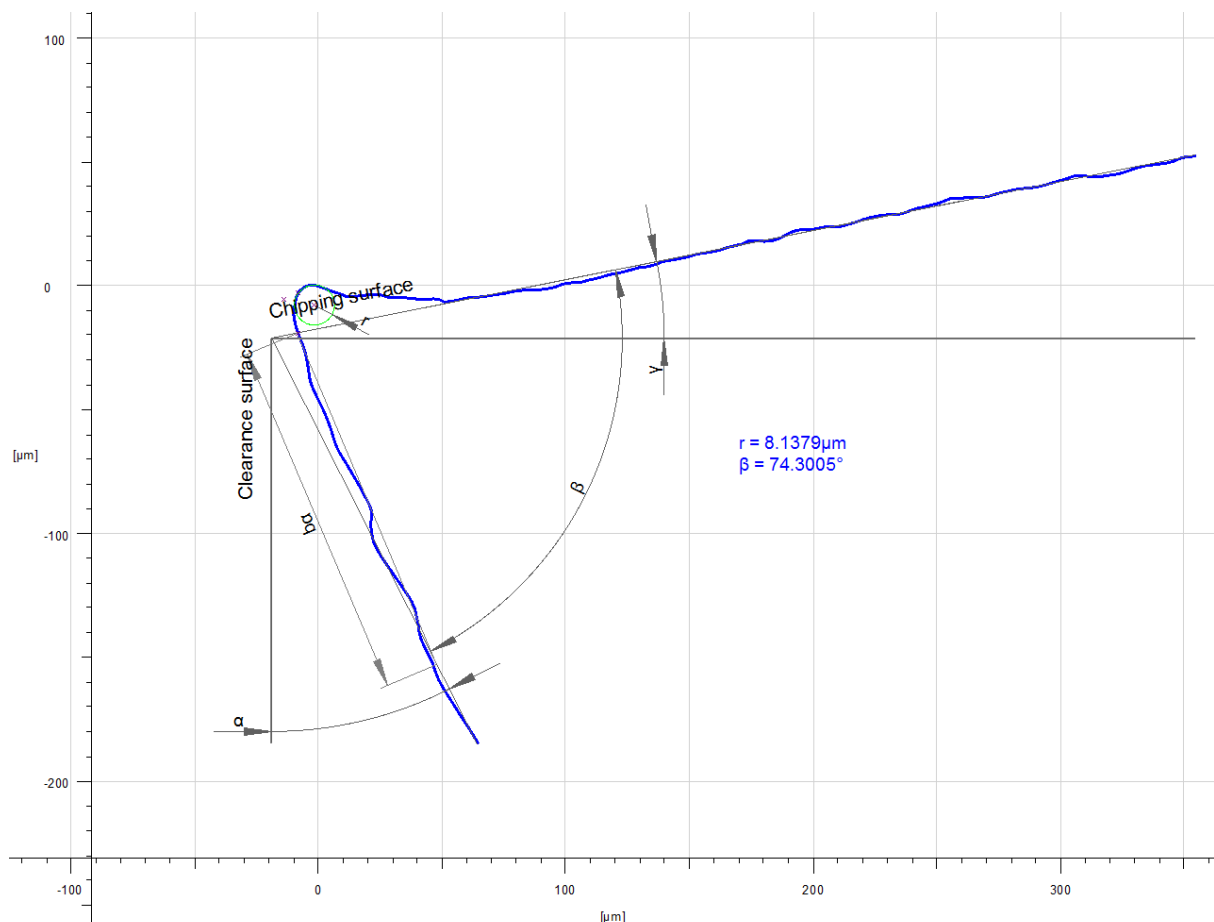
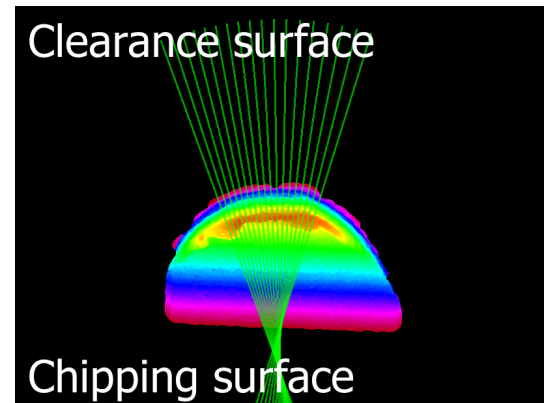


# IF-EdgeMasterModule Measurement Report

## Cutting Edge Measurement

ReferenceType: 1  
Number of extracted profiles: 50  
Edge profile type: Supporting Bevel  
Date of measurement: 30.9.2015 17:56:37  
Operator: Administrator

Name	Value	[u]	Description
r	8.1379	$\mu\text{m}$	Mean radius of mean edge
bp1 $\alpha$	134.3288	$\mu\text{m}$	Proj. supporting bevel length 1 (former: Sp1)
bp2 $\alpha$	153.8972	$\mu\text{m}$	Proj. supporting bevel length 2 (former: Sp2)
b $\alpha$	145.8695	$\mu\text{m}$	True supporting bevel length (former: St)
$\alpha$ b	-67.0556	$^\circ$	Angle of supporting bevel (former: $\alpha$ supporting)
$\alpha$	26.9179	$^\circ$	Clearance angle
$\beta$	74.3005	$^\circ$	Wedge angle
$\gamma$	-11.2184	$^\circ$	Chip angle
S $\alpha$	14.5924	$\mu\text{m}$	Dist. apex to end of clearance roundness (former: a)
S $\gamma$	6.4857	$\mu\text{m}$	Dist. apex to end of chipping roundness (former: b)
K	0.4445		Symmetry of cutting edge
$\Delta$ r	4.3615	$\mu\text{m}$	Min. dist. of edge to apex (former: S)
Ecq	164.3638	nm	Form deviation of circle (RMS)
Form	Waterfall		Estimated Curvature

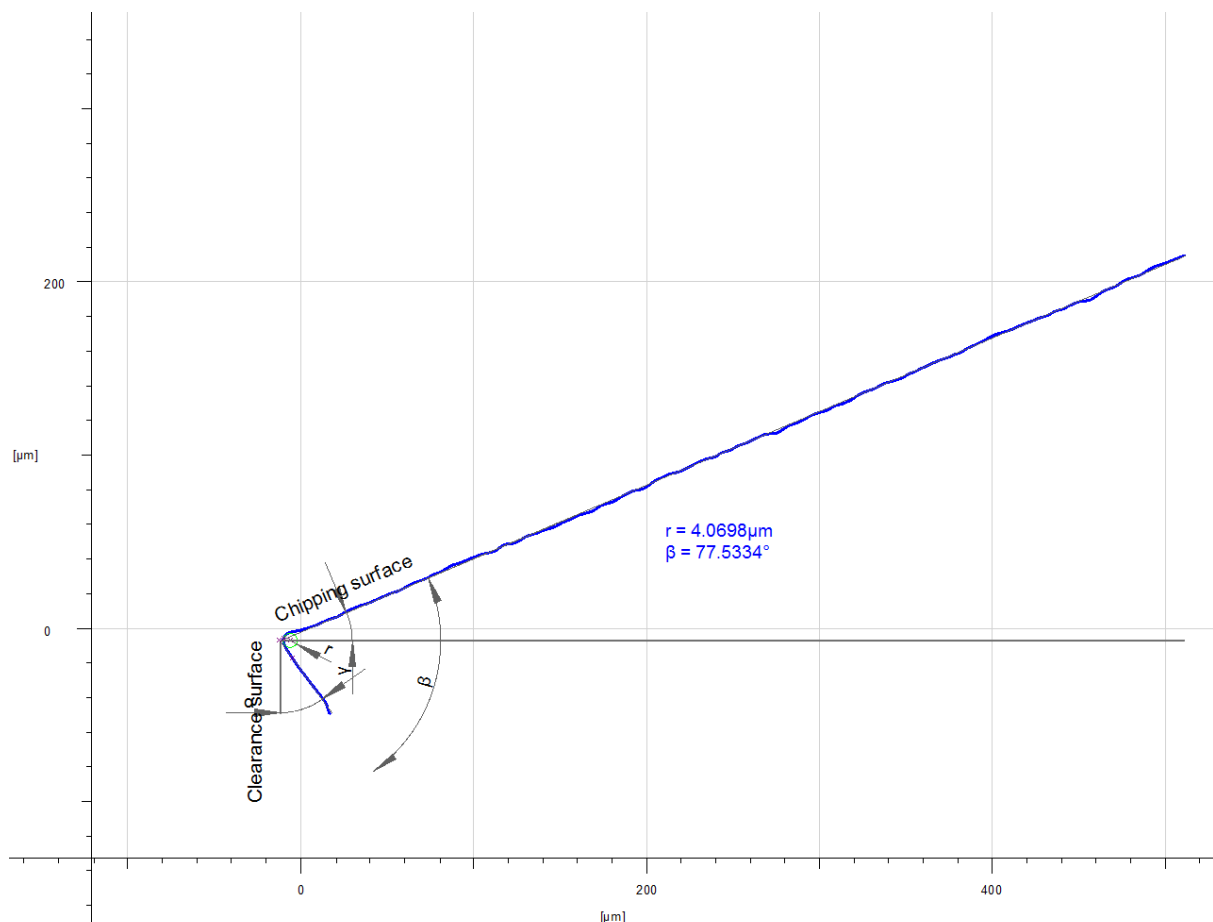
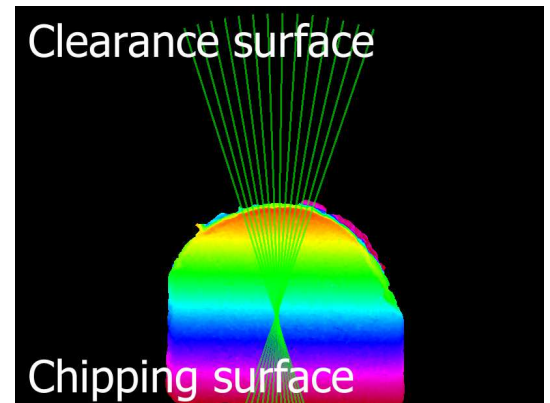


# IF-EdgeMasterModule Measurement Report

## Cutting Edge Measurement

ReferenceType: 1  
Number of extracted profiles: 50  
Edge profile type: Supporting Bevel  
Date of measurement: 30.9.2015 18:05:03  
Operator: Administrator

Name	Value	[u]	Description
r	4.0698	µm	Mean radius of mean edge
bp1α	-		Proj. supporting bevel length 1 (former: Sp1)
bp2α	-		Proj. supporting bevel length 2 (former: Sp2)
bα	-		True supporting bevel length (former: St)
αb	-		Angle of supporting bevel (former: α supporting)
α	35.4624	°	Clearance angle
β	77.5334	°	Wedge angle
γ	-22.9958	°	Chip angle
Sα	12.4942	µm	Dist. apex to end of clearance roundness (former: a)
Sγ	2.6535	µm	Dist. apex to end of chipping roundness (former: b)
K	0.2124		Symmetry of cutting edge
Δr	2.2985	µm	Min. dist. of edge to apex (former: S)
Ecq	59.1211	nm	Form deviation of circle (RMS)
Form	Waterfall		Estimated Curvature

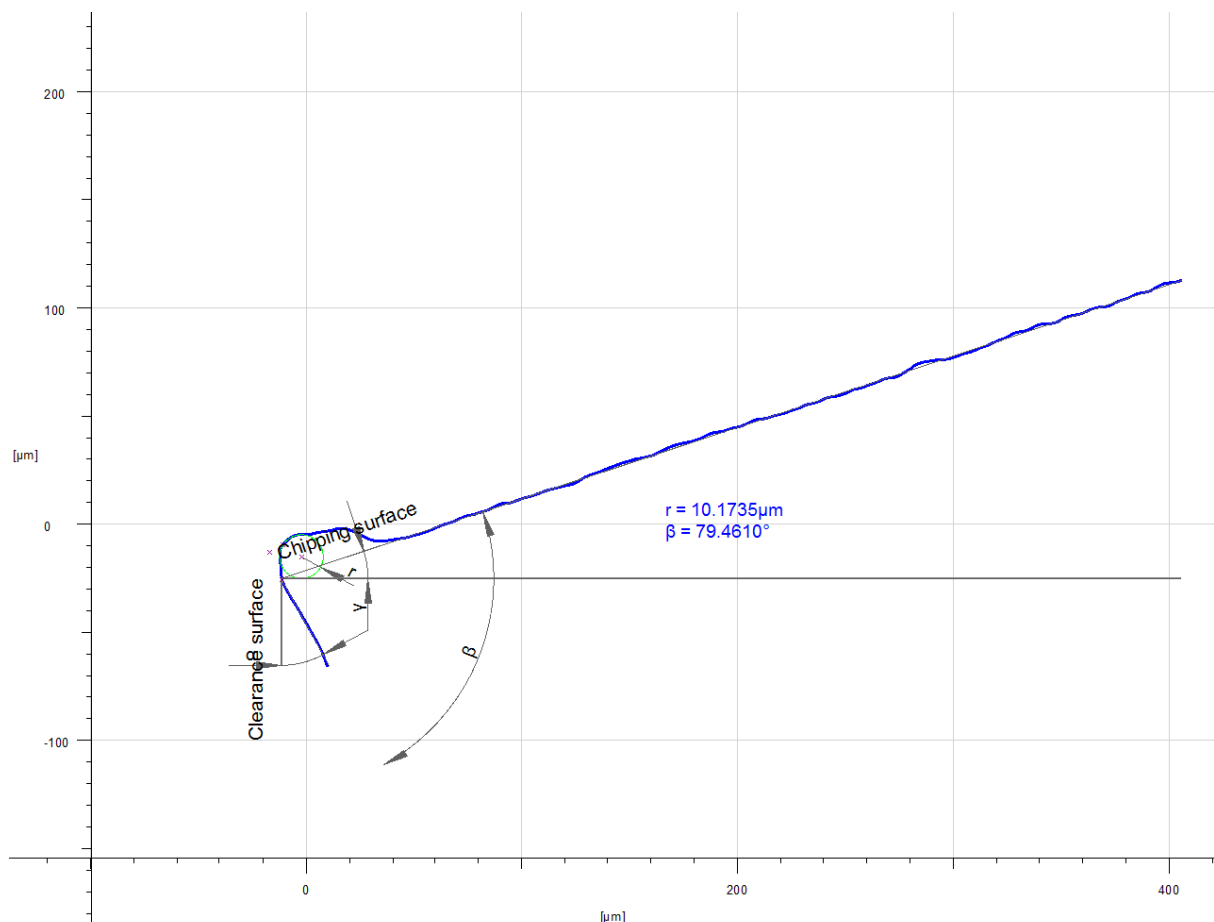
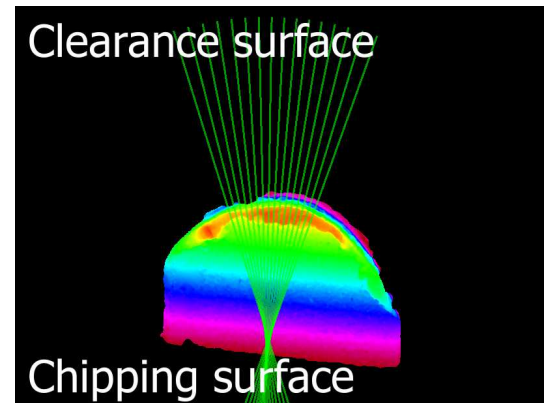


# IF-EdgeMasterModule Measurement Report

## Cutting Edge Measurement

ReferenceType: 1  
Number of extracted profiles: 50  
Edge profile type: Supporting Bevel  
Date of measurement: 30.9.2015 18:09:53  
Operator: Administrator

Name	Value	[u]	Description
r	10.1735	$\mu\text{m}$	Mean radius of mean edge
bp1 $\alpha$	-		Proj. supporting bevel length 1 (former: Sp1)
bp2 $\alpha$	-		Proj. supporting bevel length 2 (former: Sp2)
b $\alpha$	-		True supporting bevel length (former: St)
$\alpha$ b	-		Angle of supporting bevel (former: $\alpha$ supporting)
$\alpha$	28.8393	$^{\circ}$	Clearance angle
$\beta$	79.4610	$^{\circ}$	Wedge angle
$\gamma$	-18.3004	$^{\circ}$	Chip angle
S $\alpha$	13.9778	$\mu\text{m}$	Dist. apex to end of clearance roundness (former: a)
S $\gamma$	7.2587	$\mu\text{m}$	Dist. apex to end of chipping roundness (former: b)
K	0.5193		Symmetry of cutting edge
$\Delta$ r	4.7166	$\mu\text{m}$	Min. dist. of edge to apex (former: S)
Ecq	108.7300	nm	Form deviation of circle (RMS)
Form	Waterfall		Estimated Curvature

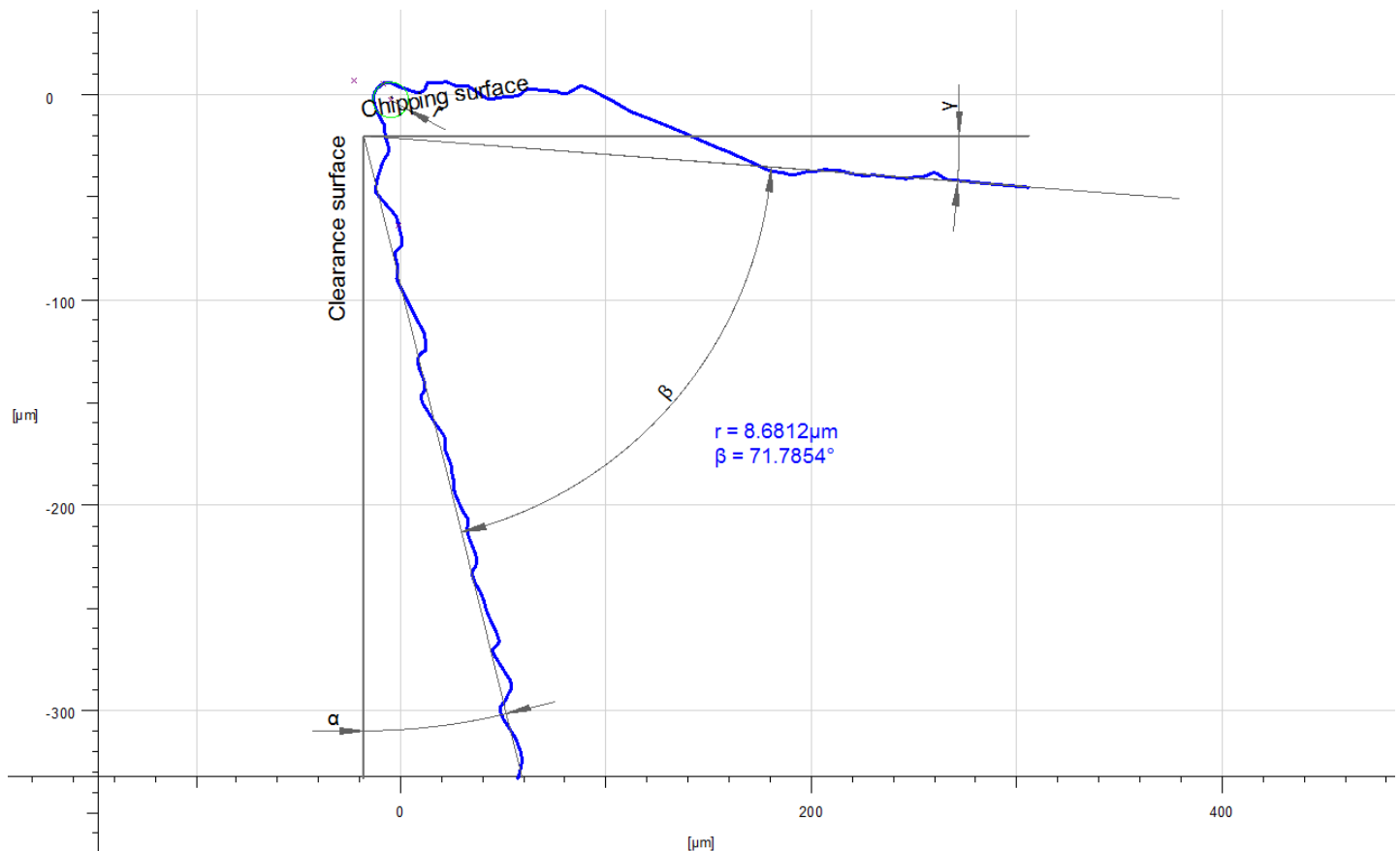


# IF-EdgeMasterModule Measurement Report

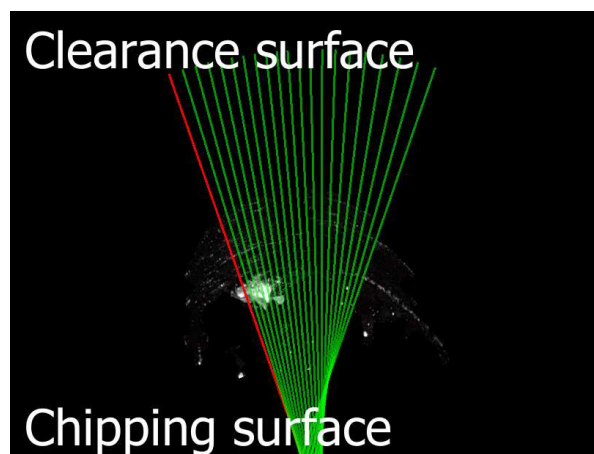
## Cutting Edge Measurement

ReferenceType:	1
Number of extracted profiles:	50
Edge profile type:	Supporting Bevel
Date of measurement:	11.9.2015 17:41:58
Operator:	Administrator

Profile #1



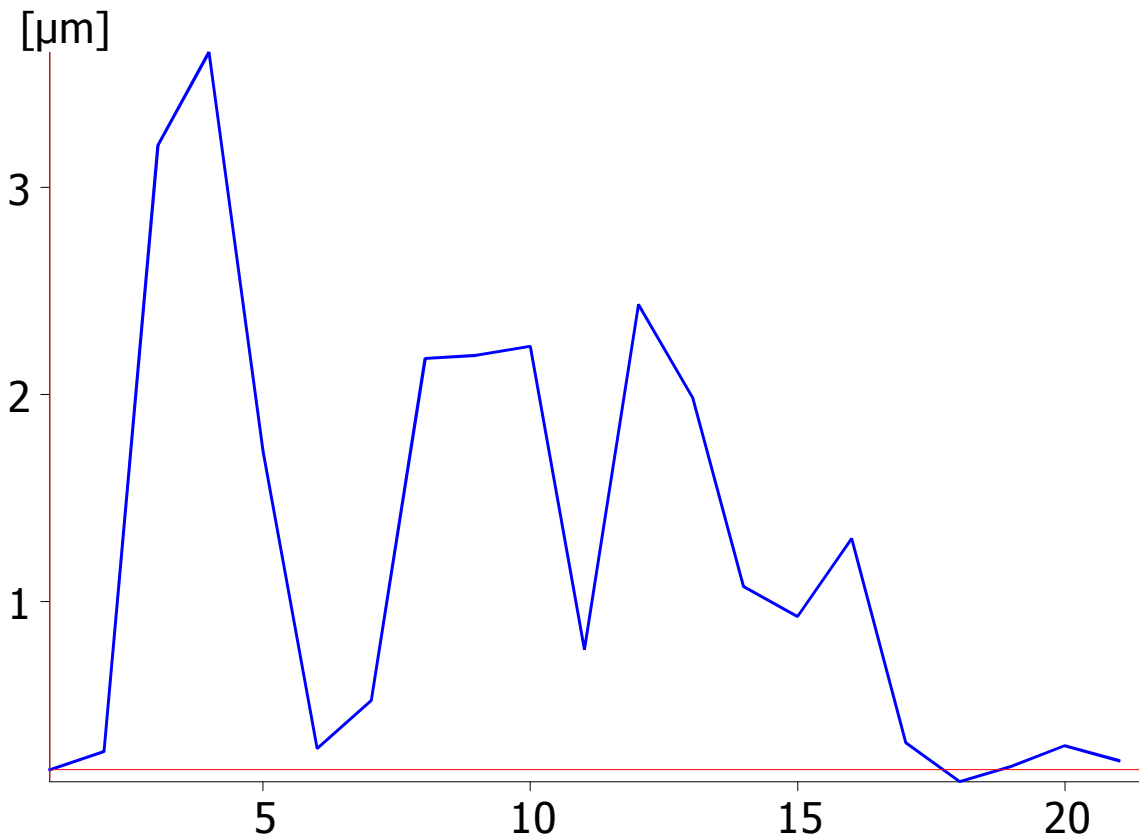
Surface



## Profile Parameter Statistics

	visible	r [μm]	Ecq [nm]	bp1α [μm]	bp2α [μm]	ba [μm]	ab [°]	α [°]	β [°]	γ [°]	Sα [μm]	Sγ [μm]	K	Δr [μm]
Mean:		23.8269	1239.0470	833.4043	864.5279	848.9260	-115.4776	11.5944	73.8530	4.5526	45.7137	50.9085	1.2093	20.1007
Std. Dev.:		14.8224	1085.8676	1640.6467	1634.8453	1662.4654	73.6486	4.6145	1.9369	3.5765	25.8518	56.5655	1.0876	16.7557
Minimum:		6.1627	124.7195	3.9833	42.5725	4.0430	-259.4899	3.3768	68.4905	-1.1220	7.5940	3.5622	0.1394	4.1486
Maximum:		50.5117	3650.5746	6467.4478	6494.1519	6546.1889	-75.5966	17.8539	77.1363	10.4129	114.1779	173.2707	3.3383	71.9226
Median:		23.3890	918.2159	363.6268	399.0186	373.5666	-81.1043	13.7149	73.8837	3.2389	45.0854	24.4263	0.6633	13.6125
Robust:		8.8465	266.5304	308.7760	344.8482	315.5874	-79.9419	13.9036	74.1178	3.0175	42.3005	15.5873	0.3370	8.8407

## Edge Parameter Ecq



## Profile Parameters

	visible	r [μm]	Ecq [nm]	bp1α [μm]	bp2α [μm]	ba [μm]	ab [°]	α [°]	β [°]	γ [°]	Sα [μm]	Sγ [μm]	K	Δr [μm]
1:	yes	8.6812	176.9826	-	-	-	-	13.8467	71.7854	4.3678	74.4622	14.0669	0.1889	11.4782
2:	yes	6.1627	271.3144	178.8744	200.8079	182.5704	-78.4515	14.5044	72.2567	3.2389	19.3960	64.7503	3.3383	13.6125
3:	yes	41.2663	3193.9656	-	-	-	-	13.7149	73.8837	2.4014	45.0854	63.8289	1.4157	27.1363
4:	yes	50.5117	3650.5746	195.8726	253.9200	202.1332	-75.7028	16.3482	73.8038	-0.1520	60.1035	25.5453	0.4250	23.0390
5:	yes	27.2990	1720.8387	73.1159	134.0856	74.8092	-77.7860	16.5045	74.6175	-1.1220	63.8328	8.8969	0.1394	11.3873
6:	yes	7.1409	283.4329	2019.5283	1990.7405	2085.0648	-75.5966	14.4860	74.8130	0.7010	7.5940	24.4263	3.2165	5.8633
7:	yes	14.2367	519.1864	518.3827	556.4523	534.9236	-75.7145	14.5908	73.3565	2.0527	17.2917	22.7267	1.3143	9.9014
8:	yes	36.1325	2170.4180	889.1953	932.5804	918.3096	-255.5339	14.7713	73.5345	1.6942	29.4132	44.1768	1.5019	19.8524
9:	yes	34.2881	2188.1686	363.6268	404.1233	373.5666	-76.7532	14.3862	72.8322	2.7816	77.5683	25.9025	0.3339	21.0386
10:	yes	36.3788	2233.5031	3.9833	42.5725	4.0430	-80.1416	12.4488	74.8214	2.7299	37.4995	60.6630	1.6177	22.6822
11:	yes	32.0721	762.4644	692.5953	729.1674	708.5003	-257.8368	12.3837	74.6206	2.9957	62.0419	142.5336	2.2974	42.6813
12:	yes	41.3622	2430.0121	39.1065	76.1269	39.3271	-83.9273	15.6333	71.1704	3.1962	64.7003	158.0811	2.4433	43.1553
13:	yes	48.9521	1986.8049	90.9164	133.4802	92.4677	-259.4899	17.8539	68.4905	3.6556	114.1779	173.2707	1.5176	71.9226
14:	yes	25.2947	1064.5003	41.2866	67.7076	41.5330	-83.7570	10.3014	75.6205	4.0781	52.5967	159.1399	3.0257	37.8688
15:	yes	23.3890	918.2159	-	-	-	-	9.9732	73.6114	6.4153	55.1554	20.3395	0.3688	15.4898
16:	yes	18.4099	1301.7467	6467.4478	6494.1519	6546.1889	-81.1043	8.9122	74.1702	6.9176	34.0389	16.0381	0.4712	11.0799
17:	yes	9.6553	308.6692	400.9011	399.0186	403.3120	-83.7321	7.2131	72.8594	9.9275	32.2209	5.6029	0.1739	5.6908
18:	yes	8.8536	124.7195	-	-	-	-	5.0189	75.1048	9.8764	50.2272	9.8726	0.1966	8.6145
19:	yes	12.1206	198.3801	526.2317	552.9837	527.1401	-86.6358	3.5696	76.0175	10.4129	26.6647	15.1782	0.5692	9.3462
20:	yes	9.2199	294.8833	-	-	-	-	3.6444	76.4075	9.9481	15.7933	10.4764	0.6633	6.1254
21:	yes	8.9379	221.2056	-	-	-	-	3.3768	77.1363	9.4869	20.1245	3.5622	0.1770	4.1486