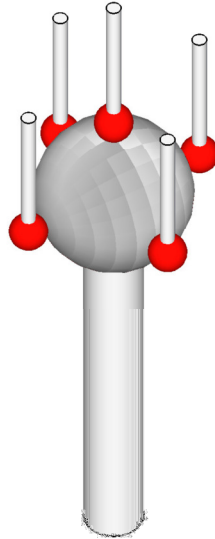


HELMEL REPEATABILITY TEST

Locate Calibration Sphere near center of machine. Carefully measure the Calibration Sphere with (5) touches – 4 around equator and 1 at top, as shown.



Record values of X, Y and Z. Repeat a total of (10) times. Find the Range of the Maximum and Minimum values for each of X, Y, and Z from the (10) measurements. The Greatest Differential Value is the REPEATABILITY of the CMM.