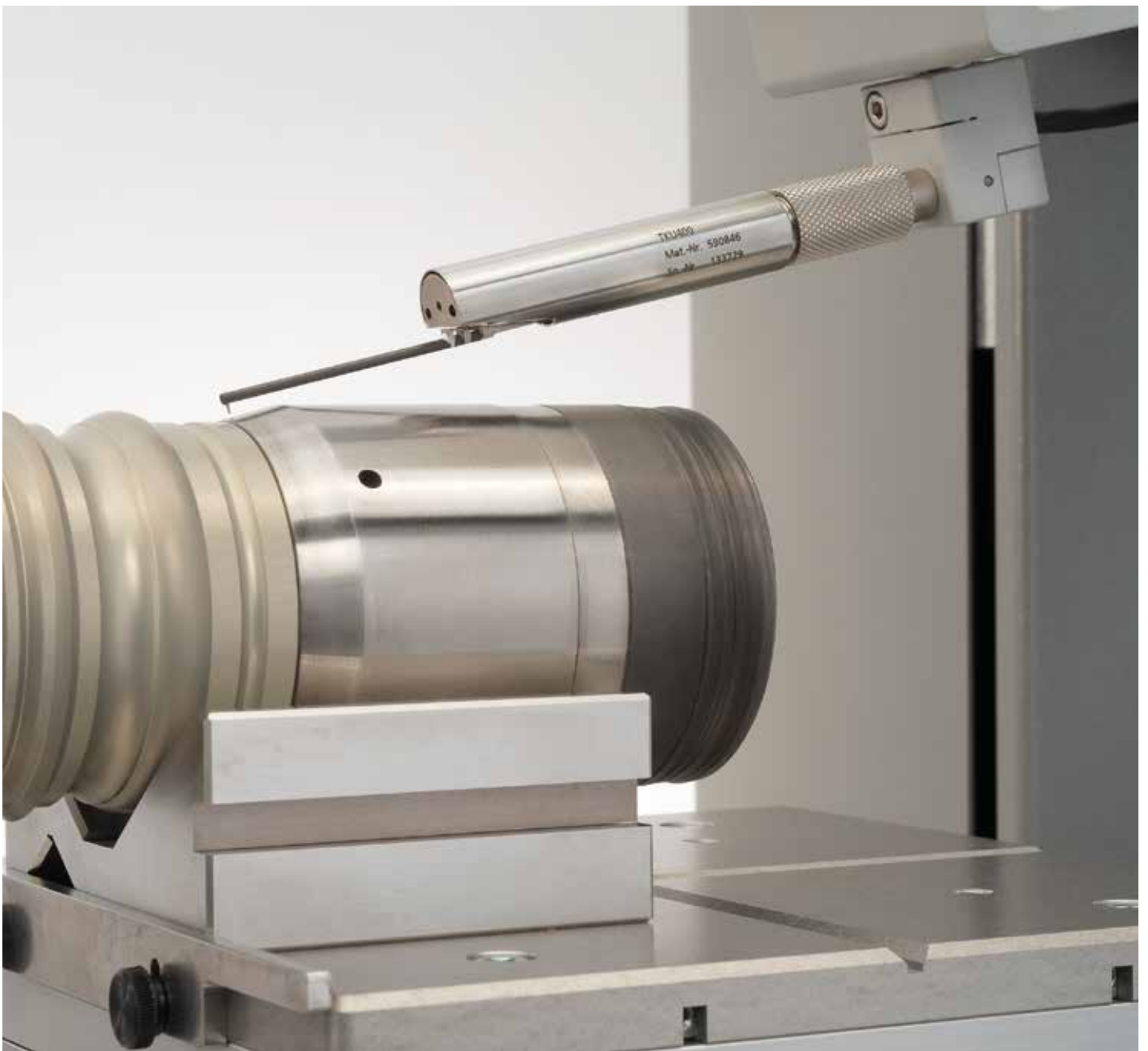


Waveline – Roughness and contour metrology

## Mobile and stationary systems

for efficient, automatable measurements  
in the metrology lab or in production



# Precise metrology for efficient quality control

As a leading manufacturer of metrology systems, HOMMEL-ETAMIC offers a broad portfolio of measurement solutions for industrial manufacturing processes. Our technologies include pneumatic measurement, tactile or optical measurement of roughness, contour, form and dimensional features, as well as optical inspection of machined surfaces.

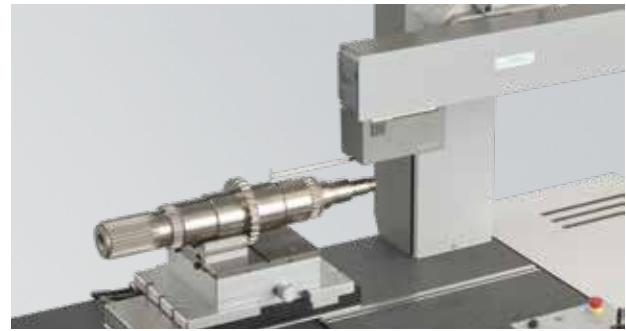
Comprehensive services such as consulting, training, DAKs-DKD calibration and service, including long-term maintenance contracts, round off our worldwide range

of metrology services for quality assurance in industrial manufacturing.

Our measuring systems ensure the quality of the workpiece throughout the entire production process and provide precise measurement data in the shortest possible time. Automatic measuring technologies enhance overall productivity during production through efficiently designed inspection solutions – whether inline or offline, or using spot checks through 100 % inspection of all manufactured workpieces.



Mobile roughness measurement



Stationary roughness & contour measurement

**Waveline measuring systems offer you extensive evaluation possibilities for surface measurement. Our product range consists of mobile surface measuring instruments, stationary measuring systems for manual and automated roughness, contour, topography or twist measurement, as well as combined systems for roughness and contour measurements. We also offer measuring stations tailored to meeting your specific measuring requirements.**

## Roughness measurement

- Roughness parameters
- Core roughness parameters
- Profile parameters
- Waviness parameters
- Motif parameters
- JIS parameters
- Topography evaluation
- Dominant waviness
- Twist parameters

## Contour measurement

- Angle
- Radius
- Distance
- Parallelism
- Crowning
- Gothic arcs
- Edge geometries
- Line profile
- Threads
- Diameter



Please scan for detailed  
Waveline information

# Waveline W5. Portable, reliable roughness measurement



Mobile measurement in production



Precise workpiece support



Exchangeable probes



Tolerance evaluation at a glance



Waveline W5 with optional printer Waveline P5

## System features

- Portable and battery-supplied
- Compact and light in design
- Easy, intuitive handling with click wheel and graphical user interface
- No calibration necessary
- Easily exchangeable probes
- USB port with Windows-compatible data format and battery charging function
- Features *Bluetooth*<sup>®</sup> technology for wireless data transfer and printing
- Battery capacity for up to 800 measurements
- Storage capacity for 5 measuring programs with measuring conditions
- Optional printer P5 with *Bluetooth*<sup>®</sup> technology for documentation of the measurement results on the spot
- Tolerance evaluation at a glance for immediate assessment of the measurement results
- Precise workpiece support, even on small shafts
- Measurement in all possible measuring positions, including on perpendicular surfaces and overhead

Model	Probe	Parameters	Printer	Traverse probing	Profile/material ratio	Tolerance	Statistics	Measuring programs	Roughness standard
W5	with skid	23	optional	no	no	yes	no	5	optional

## Waveline W10. Flexible, precise roughness measurement without boundaries



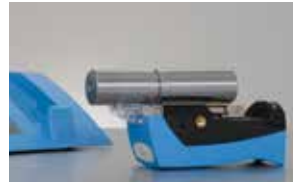
Waveline W10



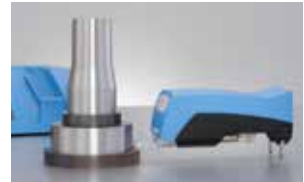
Transverse probing



Integrated roughness standard



Measurement in overhead position



Height adjustment of traverse unit

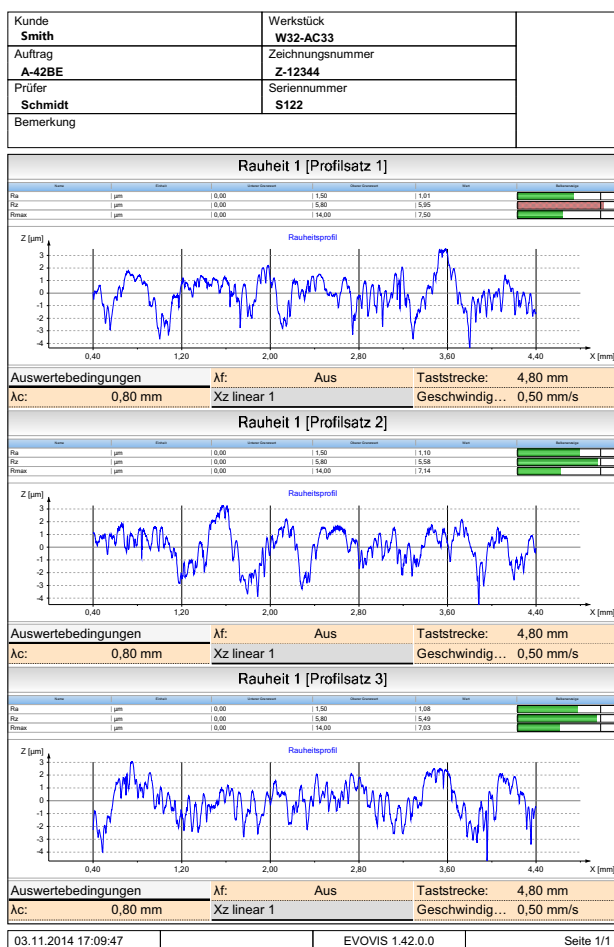
### System features

- Mobile and battery-supplied, with cable-free traverse unit
- Usable as stationary instrument
- Measurement of all common roughness parameters according to international standards
- Modern, intuitive operation via color touchscreen
- Integrated rest and barrel jack for secure storage and continuous operational readiness of the traverse unit
- Immediate verification of the measuring system via the integrated roughness standard
- Easy changing of the skid probes
- Wireless data transfer via *Bluetooth*<sup>®</sup> interface
- Integrated printer for documentation of the measurement results on the spot
- Storage capacity for 7 measuring programs
- Measuring program specifically for verification of the measuring instrument with predefined nominal values
- 90° tilting of the probe for measurements in grooves and incisions or between collars
- Transverse probing without conversion
- Measurement of small workpieces in overhead position
- Contact to the workpiece via precisely polished shafts
- 3-point support on the traverse unit for secure positioning when measuring perpendicular surfaces
- Extendable tripod legs for height adjustment

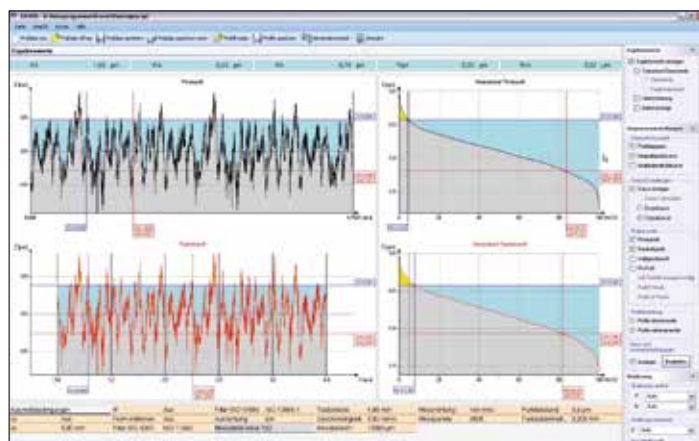
Model	Probe	Parameters	Printer	Traverse probing	Profile/material ratio	Tolerance	Statistics	Measuring programs	Roughness standard
W10	with skid	40	integrated	yes	yes	yes	yes	7	integrated

# Evovis Mobile. Simple evaluation and operation of mobile measuring instruments

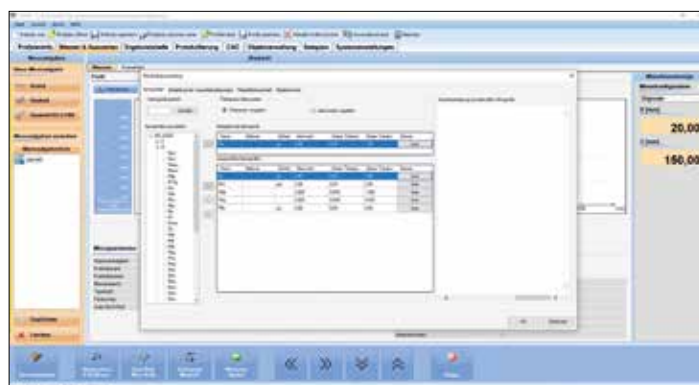
The optional Evovis Mobile software is specifically designed for operation with mobile measuring instruments. In online mode, the mobile measuring instrument is directly controlled by the software and turns into a stationary measuring station. In offline mode, the locally measured parameters and profile data saved in the measuring instrument are transferred and evaluated on the PC.



Multiprint log



Interactive profile analysis



Evaluation according to ISO 21920

## System features

- Clear, user-friendly operating structure
- Remote operation of W5 and W10
- All common roughness and waviness parameters in accordance with ISO 21920, ISO 4287 and other ISO and national standards (ASME, DIN, JIS, Motif, etc.)
- Continuous further development of the software in line with new standards/changes in standards
- Individual test plan creation
- Integrated help with the parameters
- Wizard for selecting the measuring conditions
- Import and subsequent processing of profiles and parameters
- Open design of the print log
- Electronic archiving of reports via PDF printout
- Optional qs-STAT® data export interface
- Optional evaluation of dominant waviness according to VDA 2007

## Waveline W600. Compact measuring systems with simple operation



Waveline W612 measuring station with Digiscan probe system for contour measurement and accessories



Manual height adjustment



Wide range of mounting options (optional)



Roughness probe system with quick-change-adapter

### System features

- Universal, easy-to-use measuring system
- High measurement quality thanks to stable mechanics
- Manual height adjustment with handwheel for precise probe positioning
- Optional base plate for mounting on granite plate with T-slot or threaded bushings provides numerous mounting options
- Interface for probe systems for either roughness or contour measurement with TKU400 or Digiscan probe system
- Subsequent expansion of the measuring system possible due to modular design
- Measurement and evaluation software Evovis with modern interface and extensive functions

Model	W600R	W600C Digiscan	W600RC Digiscan
Traverse unit [mm]	120	120	120
Measuring column [mm]	300	300	300
Granite plate [mm]	700x400x100	700x400x100	700x400x100

## Waveline W800. Modular system concept for maximum flexibility



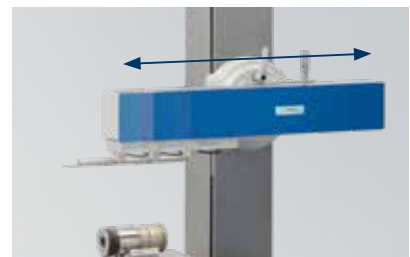
Waveline W812 Digiscan with 500 mm measuring column and 120 mm traverse unit



Quick-change adapter QCA



Probe arms with magnetic coupling



Optimal accessibility of measuring positions

### System features

- Modern, high-resolution probe systems
- Sophisticated probe arm technology
- Unique traverse unit concept for optimum access to measuring positions
- Probe arms with magnetic coupling for fast and easy probe arm change over
- All contour probe arms equipped with an RFID chip for simplified calibration and automatic configuration
- Quick-change adapter QCA enables quick probe system changeover with minimum retooling time and automatic configuration feature
- Horizontal motion of the probe system occurs via the traverse unit enclosure, meaning the probe arm is always in front of the traverse unit
- Control panel for easy, direct operation of the most important measuring and control functions as well as emergency stop function with restart at interrupted axis position

Model	W800R	W800C Digiscan	W800RC Digiscan	W800RC Surfscan	W800RC Nanoscan
Traverse unit [mm]	120 or 200	120 or 200	120 or 200	120 or 200	120 or 200
Measuring column [mm]	500 or 800	500 or 800	500 or 800	500 or 800	500 or 800
Granite plate [mm]	700x520 or 1000x520	700x520 or 1000x520	700x520 or 1000x520	700x520 or 1000x520	700x520 or 1000x520

## Waveline W900. Fast measuring axes for maximum precision and performance



Waveline W920 with 500 mm measuring column and 200 mm traverse unit



Dual operation of two probe systems



Motorized tilt unit



Additional measuring and positioning axes

### System features

- Fast measurement technology
- Highly flexible, dynamic measurement
- Excellent measuring accuracy in combination with Nanoscan probe system
- Dual operation of two probe systems; a roughness probe system can also be installed on the front of the traverse unit; also suitable for optional rotary module
- Optional motorized tilt unit for precise adjustment of the tilt angle and automatic alignment of the probe to the workpiece level
- Extensive options for automated, CNC-controlled measurement runs
- Measuring Z column with linear scale at a resolution of 0.1  $\mu\text{m}$  for measurement of vertical distances outside the Z measuring range of the probe; requires probe arm with double probe tip
- Additional motorized Y axis or X-Y axis combination for automatic zenith search, topography measurement and workpiece positioning
- Optional rotational axis for roughness measurement on cylindrical workpieces in circumferential and axial direction

Model	W900R	W900C Digiscan	W900RC Digiscan	W900RC Surfscan	W900RC Nanoscan
Traverse unit [mm]	120 or 200	120 or 200	120 or 200	120 or 200	120 or 200
Measuring column [mm]	500 or 800	500 or 800	500 or 800	500 or 800	500 or 800
Granite plate [mm]	700x520 or 1000x520	700x520 or 1000x520	700x520 or 1000x520	700x520 or 1000x520	700x520 or 1000x520



# Probe systems with quick-change adapter QCA.

## For optimum configuration of your measuring system

Probe systems with quick-change adapter QCA allow quick and simple system changeovers to accommodate new measurement tasks and thus guarantee reproducible measurement results.

- All probe systems equipped with QCA interfaces
- Automatic setup after probe changeover
- Probe changeover without tools
- Precise, repeatable mechanical position
- Hot-plug-capable
- Future-proof

### TKU400 with TAM probe arms: roughness measurement



- Universal roughness probe system
- Large measuring range
- Suitable for length and transverse measurements
- Easily exchangeable probe arms

### Digiscan with TD probe arms: contour measurement



- Digital measuring system with high resolution
- Optional top/bottom measurement
- Probe arms with magnetic coupling and electronic detection
- Extensive range of probe arm solutions

### Surfscan with WCN probe arms: roughness and contour measurement rolled into one



- Roughness measurement in the measuring range of 8 mm with a resolution of 3 nm
- Probe arms with magnetic coupling and electronic detection
- Optional top/bottom measurement

### Nanoscan with WCN probe arms: roughness and contour measurement rolled into one



- Ultra-precise opto-mechanical probe system
- Wide measuring range with extremely high resolution
- Excellent roughness and contour measuring accuracy in conjunction with W900

Probe arm	Measuring range   Resolution			
Probe system	TKU400	Digiscan	Surfscan	Nanoscan
Standard length	±400 µm   1 nm	60 mm   10 nm	8 mm   3 nm	24 mm   0.3 nm
2-fold length	±800 µm   2 nm	90 mm   15 nm	16 mm   6 nm	48 mm   0.6 nm
Use with measuring system	W600, W800, W900	W600, W800, W900	W800, W900	W800, W900

# Evovis. Evaluation software for roughness and contour measurement with W600/W800/W900



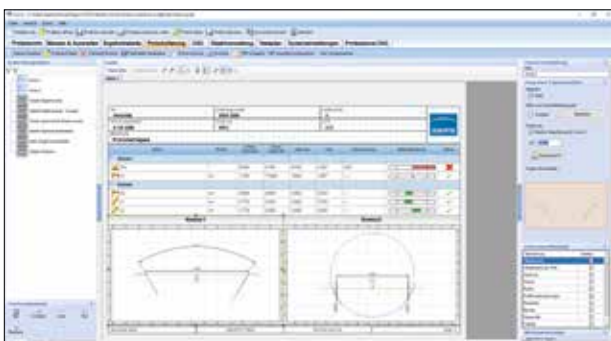
Measuring station control



Evaluation according to ISO 21920



CNC editor for automated measuring runs



Report and template editor

Evovis, the measurement and evaluation software for roughness and contour measurement, offers a standardized user interface with easy-to-understand control logic and extensive support functions for designing individual measurement applications. Its applications range from simple measurements of a single characteristic to fully automated measurement applications within the Industry 4.0 environment.

## User-friendly, intuitive operation

- Modern user interface for safe operation with little training needed
- Central control with all frequently used operating and display functions in one view
- Measuring station control with live display
- Automatic system configuration when changing the probe system or probe arm
- Extensive statistical functions
- Interactive analysis and evaluation functions
- Central administration of all test characteristics
- Evaluation of roughness parameters in the contour profile
- Roughness and contour parameters summarized in a table for further statistical evaluation

## Optimized measurement runs: CNC editor

- Fast and easy programming of automated measurement and evaluation processes with a click of the mouse
- Clear representation in a graphic workflow
- Reduction of operator influences
- Comprehensive function library

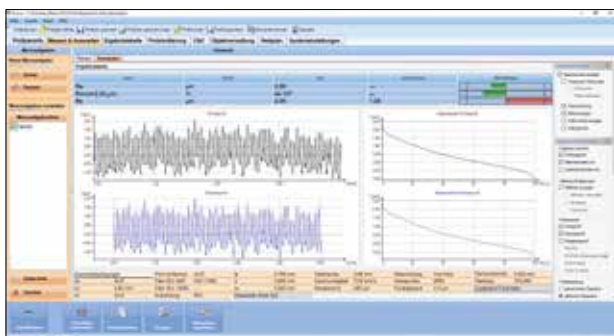
## Option CNC Professional

- Programming of complex, automated measuring processes with axis control, electronic workpiece identification, simplified user interface and automated data export

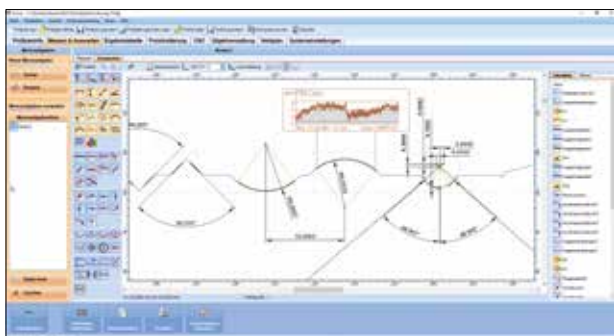
## Documented quality

- Individual, free design of test plans as well as display and print reports
- Easy design and management of templates
- Automatic, electronic archiving of the reports

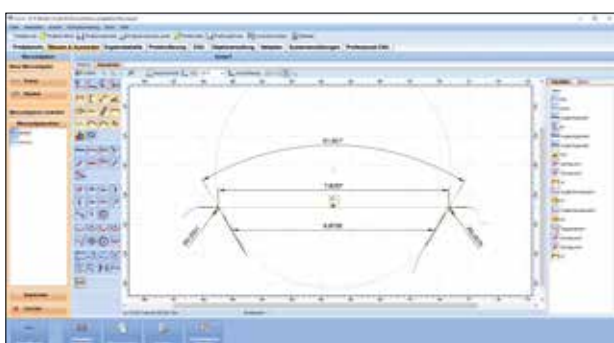
## Evovis. Software functions and options for specific measurement tasks



Roughness measurement with interactive profile evaluation



Contour evaluation



Multiple profile



Calibration assistant

### Roughness measurement and evaluation

- All common parameters in accordance with ISO 21920, ISO 4287 and other ISO and national standards
- Assistant for quick selection of roughness parameters and definition of the measurement conditions for safe processes and simple implementation of complex measurement tasks
- Interactive profile analysis functions for surface parameters
- Evaluation of the measurement results according to tolerance specifications with display in a compact form
- All globally standardized surface parameters for primary, roughness and waviness profiles
- Optionally expandable with function-oriented parameters

### Contour measurement and evaluation

- Contour evaluation with assessment of geometric dimensions, tolerancing of profiles and extensive functions for the assessment of line profile deviations
- Processing of several profiles/characteristics in one test plan
- Evaluation of complex geometric elements such as Gothic arcs or edge geometries
- Icon-based features for quick test plan creation
- Realization of complex applications thanks to precise fitting procedures and various auxiliary elements

### Evaluation of several profiles in one run

- Top/Bottom measurement
- Parallelism, angles and distance between several profiles

### Automated calibration (contour)

- Guided calibration process with recording of the history
- Automatic calibration in CNC mode
- Management of the calibration means

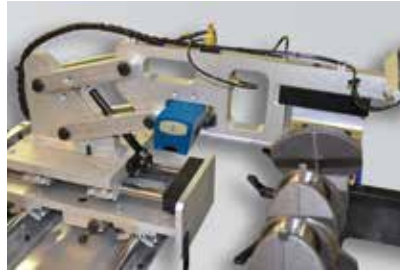
### Options

- qs-STAT® (Q-DAS ASCII transfer format): AQDEF-certified statistics export interface
- Dominant waviness according to VDA 2007
- TwistLive® twist evaluation in accordance with Daimler standard MBN 31 007-07 with additional quick analysis method and live display
- 3D topography evaluation

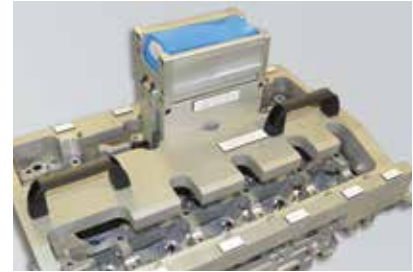
## Individual, manual and semi-automatic measuring fixtures and stations



Measurement in bores



Measurement on shafts



Measurement on plane surfaces

**POU (Point-of-Use) measuring devices** are used for roughness measurement on large workpieces and come with a workpiece-specific design. They are ideal for manual SPC control of roughness features in all stages of the production process and deliver safe and repeatable positioning of the measuring devices.

- Secure and accurate positioning of the traverse unit on the workpiece
- Repeatable measurement results due to template positioning
- Reduction of operator influence
- Transfer of measurement results to process monitoring systems
- Robust measurement in production
- Tailor-made solutions for different workpieces

**Waveslide measuring stations** are individually tailored to suit specific measurement tasks. They are based on proven system components and provide reliable, semi-automatic measurements in the manufacturing environment. These systems are extremely robust and operate with high precision. Workpiece positioning is manual via guided air slides, the measuring process is fully automated.



Guided X-Y positioning via air slide with additional fine adjustment

- Manual, simple positioning of the workpiece (alternatively of the measuring column) via air slide
- Suitable for large and heavy workpieces
- Flexible use for roughness and contour measurement tasks

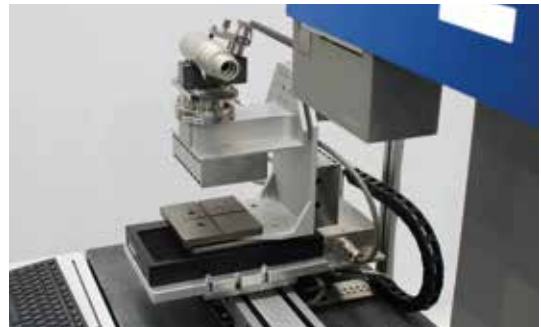


Measuring station Waveslide with 800 mm column, TKU400 probe system for roughness measurement and manually movable measuring table on air slides

## Flexible concepts for individual, fully automatic measurements

Fully automatic measuring systems offer customized, CNC-controlled roughness and contour measurements in the measuring lab or directly in production. They are configured with CNC axes and fixtures specific to the workpiece. Thus, they perform complex measuring tasks on the respective workpieces fully automatically.

- Robust measuring stations suitable for production
- Flexible system concept for numerous applications
- Independent, simultaneously operating CNC axes
- Individual fixtures, optionally with automatic identification of the workpiece
- Extensive safety features
- High reliability due to sophisticated technology
- Simple measuring program creation for fully automated processes via Evovis software
- Transfer of measurement results for further processing to statistics programs such as qs-STAT®



Individual combination of CNC standard travel axes for W800 and W900 measuring systems

**Wavemove measuring stations** are individually designed and feature CNC travel axes for fully automatic measurements on large workpieces. The PAT-CNC probe rotation module rotates the TKU400 roughness probe to the correct position, enabling measurements in different angular positions, such as on end faces.



Rotating measuring column and probe rotation module for optimum access to the measuring point

Fully automatic measuring station Wavemove with safety light barrier for safe, CNC-controlled roughness and contour measurement on the shop floor



## Autonomous processes in the modern manufacturing environment

Fully automated measuring stations offer reliable, operator-independent measuring sequences for both random sample measurement and 100 % inspection of complex components. With the help of handling systems adapted to the measuring station, not only components are moved, but also probe arms are exchanged according to the measuring task and the measuring program.



Probe arm change via robot – magnetic holder



Probe arm and workpiece rest

### Individual solutions for your requirements

- Fully automatic measurement of roughness and contour in one sequence
- Processing of parts magazines without operator intervention
- Fully automatic probe arm change and recognition
- Positioning of the parts for optimal accessibility of the measuring point
- Interfaces to different measuring and handling systems



Fully automated measuring station W920 Nanoscan with cobot for roughness and contour measurement

# Permanent measurement accuracy



Due to the constant use of measuring equipment and the associated wear and tear, the measuring accuracy can change unnoticed. Regular calibration of the device with the help of traceable standards is required, because only calibrated measuring devices ensure that meaningful and correct results are generated.

## DKD calibration laboratory

Our vibration-insulated and air-conditioned calibration laboratory (D-K-15030-01-00) is accredited by the Deutsche Akkreditierungsstelle GmbH (DAkkS) according to DIN EN ISO / IEC 17025.

Here we calibrate your standards. This ensures direct tracing of the measuring equipment to the Physikalisch-Technische Bundesanstalt (PTB) and guarantees measurements and calibrations at the highest metrological level.

If a standard cannot be calibrated, a new one can be obtained from any of our facilities. For non-accredited parameters we deliver a simple factory calibration certificates or test reports. We also carry out capability tests for demanding measurement tasks.

## Our range of calibration services

Our DAkkS accreditation includes the measurement of variables such as roughness, form deviation, contour, contact stylus instruments and shaft measuring systems. Within this scope we issue DAkkS-DKD calibration certificates for e.g.

- roughness standards
- contour standards
- form standards

## Handbook Surface Texture – Theory and Practical Use

This handbook explains roughness parameters, describes the structure of surface measuring devices, supports the user in their use and makes it easier for the designer to specify surface parameters.

## Standards for surface measurement



### Surface inspection standards

To check surface measuring systems with the profile method:

- **Depth setting standard** in polished glass for determining the vertical amplification and the repeatability
- **Geometry standard** in glass or nickel with uniform groove profile for checking the entire measuring system
- **Roughness standard** in steel with irregular surface profile for checking the entire measuring system

### Contour standard KN8

Compliant with VDI/VDE Directive 2629. Characteristics measured: radii, angles, horizontal and vertical distances.

### Twist standards

For verification of twist measuring systems. Calibrated parameters: Dt, DP, DG and Dy.

## Worldwide availability

Our expert teams are available to assist you wherever you are located. We have subsidiaries and distribution partners in key national nations, in order to assist our customers as a reliable production partner.

