

Several contrastive experiments of the on-line measurement are carried out in a grinding machine (MB1332A). The workpieces used in the experiments is measured by TALYROND 262 geometrical error measurement instrument. The results of these experiments successfully verify that the theory and mathematical models are correct. The contrast of the measuring results in these experiments proves that the Single-probe two-step method can realize the complete separation of all kinds of errors basically and this method is applicable to on-line measurement of a workpiece and it can also make the measurement accuracy very high.

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