

Fig. 7.3.3a: Measured surface topographies and residuals: sample P30050A,G00 tilt.

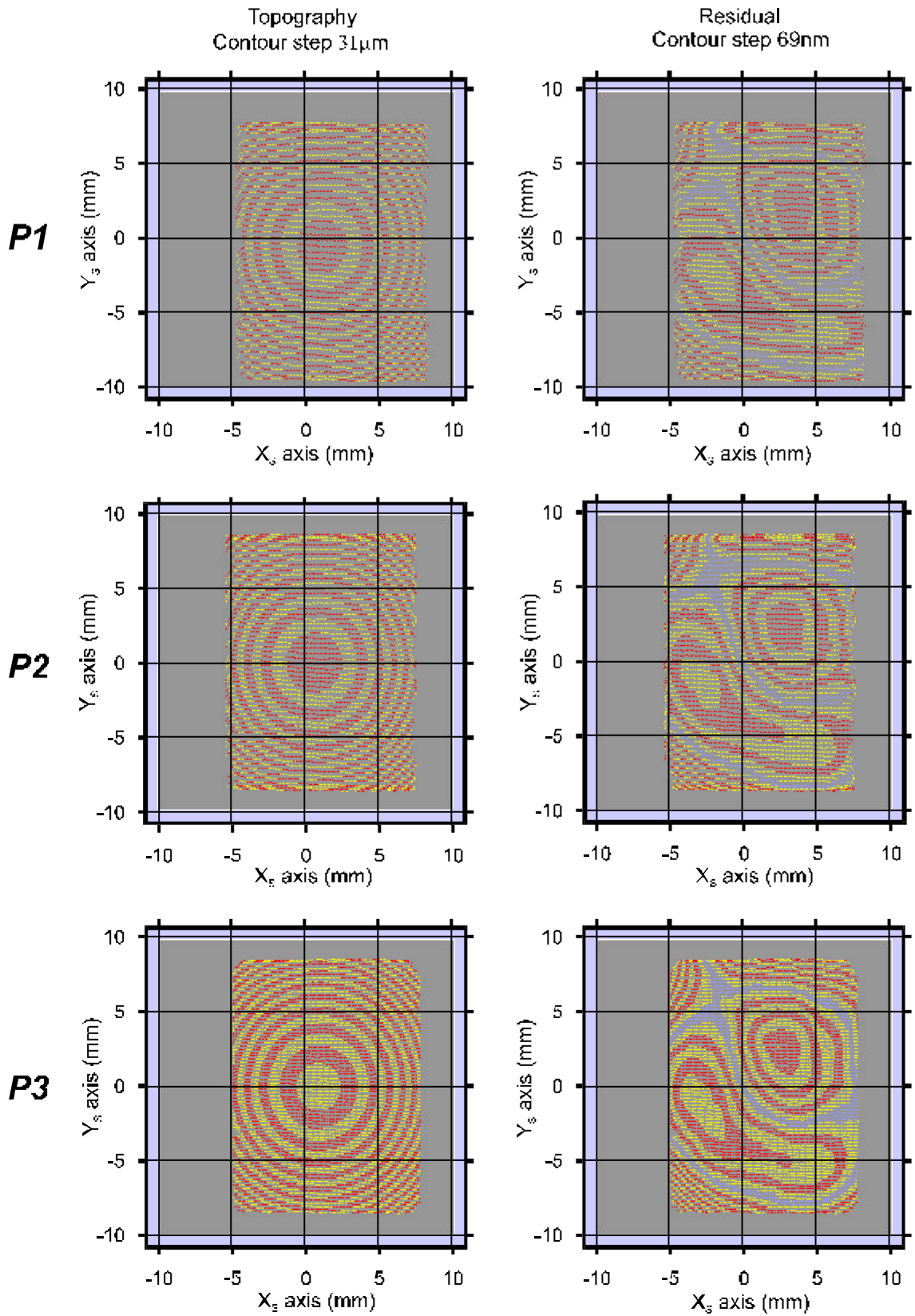


Table 7.3.3b: Measured results for sample P30050A, G30 tilt.

Sample P30050A G30 tilt	Parameter	P1 $d_R=180.1\text{mm}$	P2 $d_R=182.6\text{mm}$	P3 $d_R=188.4\text{mm}$
Experiment	N(points)	6273	7845	11711
	Dz(mm)	0.478	0.421	0.389
	A(mm <sup>2</sup> )	280.8	278.3	263.9
2D fitting	$K_B(\text{rad})$	$4.922 \cdot 10^{-3}$	$-3.527 \cdot 10^{-3}$	$4.420 \cdot 10^{-4}$
	$r_B^2$	0.9999902	0.9999897	0.9999899
	$K_C(\text{rad})$	$-5.231 \cdot 10^{-3}$	$-3.484 \cdot 10^{-3}$	$-3.958 \cdot 10^{-3}$
	$r_C^2$	0.9999867	0.9999856	0.9999832
	$R_B(\text{mm})$	170.3	170.4	170.5
	$R_C(\text{mm})$	149.0	149.1	149.1
	$R_B(\text{mm})$	170.0	170.2	170.2
	$R_C(\text{mm})$	149.0	149.2	149.3
3D fitting	$s_B(\text{mm})$	$4.4 \cdot 10^{-3}$	$3.9 \cdot 10^{-3}$	$3.1 \cdot 10^{-3}$
	$s_C(\text{mm})$	$6.2 \cdot 10^{-3}$	$5.1 \cdot 10^{-3}$	$4.5 \cdot 10^{-3}$
	$x_0(\text{mm})$	0.822	0.072	0.062
	$y_0(\text{mm})$	0.795	-0.517	-0.589
	$s_{x_0}(\text{mm})$	$1.5 \cdot 10^{-4}$	$8.0 \cdot 10^{-5}$	$9.2 \cdot 10^{-5}$
	$s_{y_0}(\text{mm})$	$1.8 \cdot 10^{-4}$	$6.6 \cdot 10^{-5}$	$5.5 \cdot 10^{-5}$
	$q(^{\circ})$	28.93	28.89	28.85
	$s_q(^{\circ})$	$1.0 \cdot 10^{-2}$	$8.4 \cdot 10^{-3}$	$6.9 \cdot 10^{-3}$
	$r^2$	0.9999966	0.9999966	0.9999964
	DZ <sub>RESIDUAL</sub> (mm)	$1.039 \cdot 10^{-3}$	$4.291 \cdot 10^{-4}$	$9.728 \cdot 10^{-4}$

Möller-Wedel radioscope measurement:  $R_B=170.9\pm 1.0\text{mm}$   
 $R_C=148.8\pm 1.0\text{mm}$

Fig. 7.3.3b: Measured surface topographies and residuals: sample P30050A, G30 tilt.

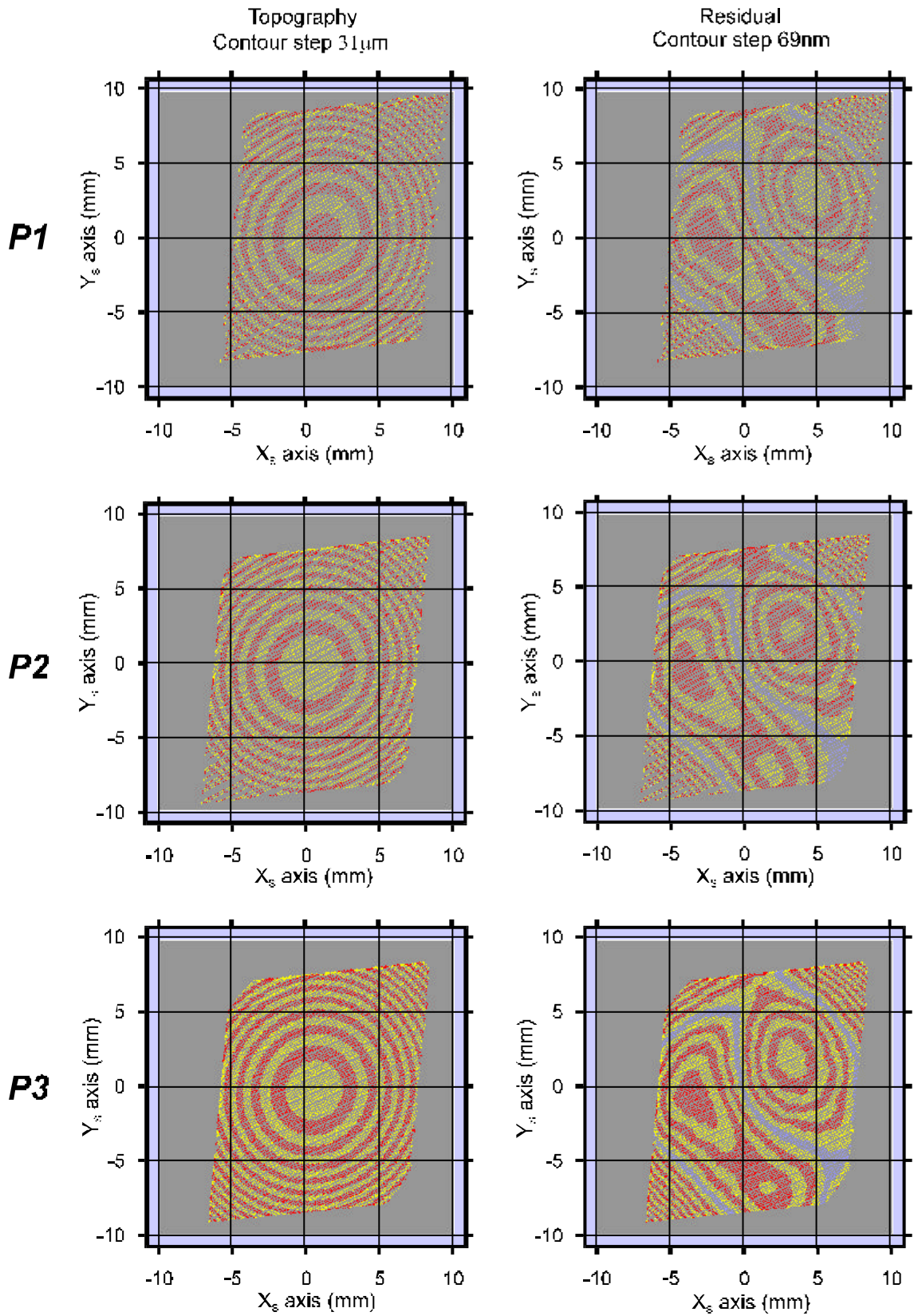


Table 7.3.3c: Measured results for sample P30050A, G60 tilt.

Sample P30050A G60 tilt	Parameter	P1 $d_R=180.1\text{mm}$	P2 $d_R=182.6\text{mm}$	P3 $d_R=188.4\text{mm}$
Experiment	N(points)	6455	7950	11045
	Dz(mm)	0.462	0.439	0.399
	A(mm <sup>2</sup> )	268.8	273.4	265.1
2D fitting	$K_B(\text{rad})$	$4.647 \cdot 10^{-3}$	$2.652 \cdot 10^{-3}$	$3.548 \cdot 10^{-3}$
	$r_B^2$	0.9999856	0.9999875	0.9999880
	$K_C(\text{rad})$	$6.995 \cdot 10^{-4}$	$-7.272 \cdot 10^{-3}$	$-1.078 \cdot 10^{-3}$
	$r_C^2$	0.9999847	0.9999847	0.9999798
	$R_B(\text{mm})$	170.2	170.2	170.4
	$R_C(\text{mm})$	149.2	149.3	149.6
	$R_B(\text{mm})$	170.1	170.0	170.1
	$R_C(\text{mm})$	149.3	149.4	149.6
3D fitting	$s_B(\text{mm})$	$4.4 \cdot 10^{-3}$	$3.4 \cdot 10^{-3}$	$2.8 \cdot 10^{-3}$
	$s_C(\text{mm})$	$5.4 \cdot 10^{-3}$	$4.1 \cdot 10^{-3}$	$4.1 \cdot 10^{-3}$
	$x_0(\text{mm})$	0.795	0.445	0.598
	$y_0(\text{mm})$	0.882	0.118	0.177
	$s_{x_0}(\text{mm})$	$7.0 \cdot 10^{-5}$	$5.2 \cdot 10^{-5}$	$4.3 \cdot 10^{-5}$
	$s_{y_0}(\text{mm})$	$1.7 \cdot 10^{-4}$	$8.5 \cdot 10^{-5}$	$9.4 \cdot 10^{-5}$
	$q(^{\circ})$	58.92	58.75	58.54
	$s_q(^{\circ})$	$9.6 \cdot 10^{-3}$	$7.5 \cdot 10^{-3}$	$6.5 \cdot 10^{-3}$
	$r^2$	0.9999969	0.9999975	0.9999975
	DZ <sub>RESIDUAL</sub> (mm)	$5.598 \cdot 10^{-4}$	$6.552 \cdot 10^{-4}$	$7.034 \cdot 10^{-4}$

Möller-Wedel radioscope measurement:  $R_B=170.9\pm 1.0\text{mm}$   
 $R_C=148.8\pm 1.0\text{mm}$

Fig. 7.3.3c: Measured surface topographies and residuals: sample P30050A, G60 tilt.

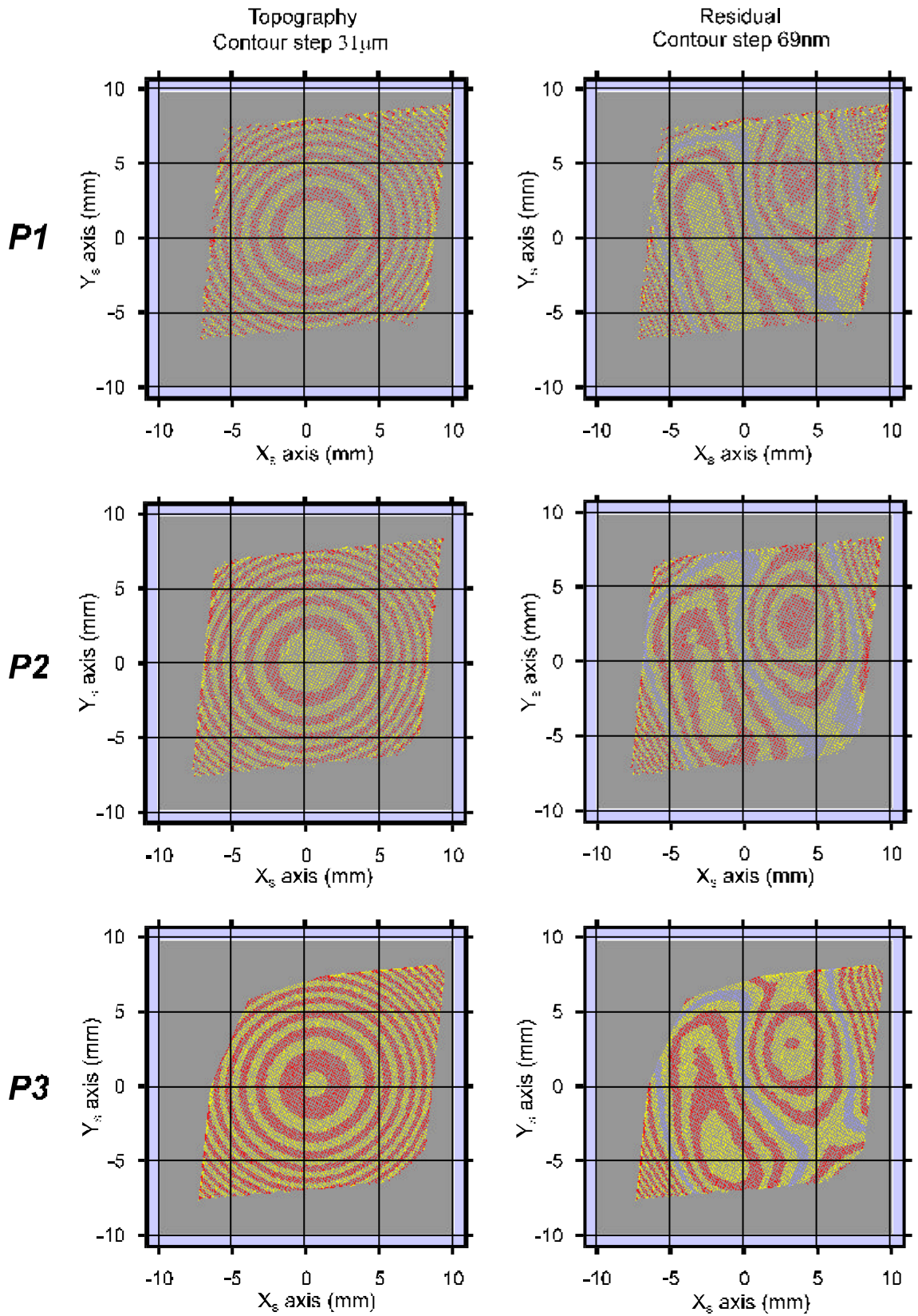


Table 7.3.3d: Measured results for sample P30050A, G90 tilt.

Sample P30050A G90 tilt	Parameter	P1 $d_R=180.1\text{mm}$	P2 $d_R=182.6\text{mm}$	P3 $d_R=188.4\text{mm}$
Experiment	N(points)	5444	6828	10739
	Dz(mm)	0.366	0.357	0.333
	A(mm <sup>2</sup> )	234.7	225.6	221.1
2D fitting	$K_B(\text{rad})$	$-2.166 \cdot 10^{-3}$	$-2.377 \cdot 10^{-3}$	$-1.303 \cdot 10^{-3}$
	$r_B^2$	0.9999886	0.9999913	0.9999933
	$K_C(\text{rad})$	$2.520 \cdot 10^{-3}$	$3.284 \cdot 10^{-3}$	$1.400 \cdot 10^{-3}$
	$r_C^2$	0.9999946	0.9999952	0.9999926
	$R_B(\text{mm})$	170.0	170.1	170.2
	$R_C(\text{mm})$	149.5	149.6	149.7
3D fitting	$R_B(\text{mm})$	170.2	170.3	170.4
	$R_C(\text{mm})$	149.3	149.4	149.5
	$s_B(\text{mm})$	$4.9 \cdot 10^{-3}$	$3.6 \cdot 10^{-3}$	$3.1 \cdot 10^{-3}$
	$s_C(\text{mm})$	$4.1 \cdot 10^{-3}$	$4.4 \cdot 10^{-3}$	$2.7 \cdot 10^{-3}$
	$x_0(\text{mm})$	0.374	0.487	0.207
	$y_0(\text{mm})$	0.368	0.406	0.220
	$s_{x_0}(\text{mm})$	$7.1 \cdot 10^{-5}$	$6.4 \cdot 10^{-5}$	$3.8 \cdot 10^{-5}$
	$s_{y_0}(\text{mm})$	$6.2 \cdot 10^{-5}$	$5.9 \cdot 10^{-5}$	$3.6 \cdot 10^{-5}$
	$q(^{\circ})$	89.37	89.33	89.35
	$s_q(^{\circ})$	$5.5 \cdot 10^{-3}$	$4.9 \cdot 10^{-3}$	$3.7 \cdot 10^{-3}$
	$r^2$	0.9999979	0.9999980	0.9999982
	Dz <sub>RESIDUAL</sub> (mm)	$3.712 \cdot 10^{-4}$	$5.162 \cdot 10^{-4}$	$5.972 \cdot 10^{-4}$

Möller-Wedel radioscope measurement:

$R_B=170.9\pm 1.0\text{mm}$

$R_C=148.8\pm 1.0\text{mm}$

Fig. 7.3.3d: Measured surface topographies and residuals: sample P30050A,G90 tilt.

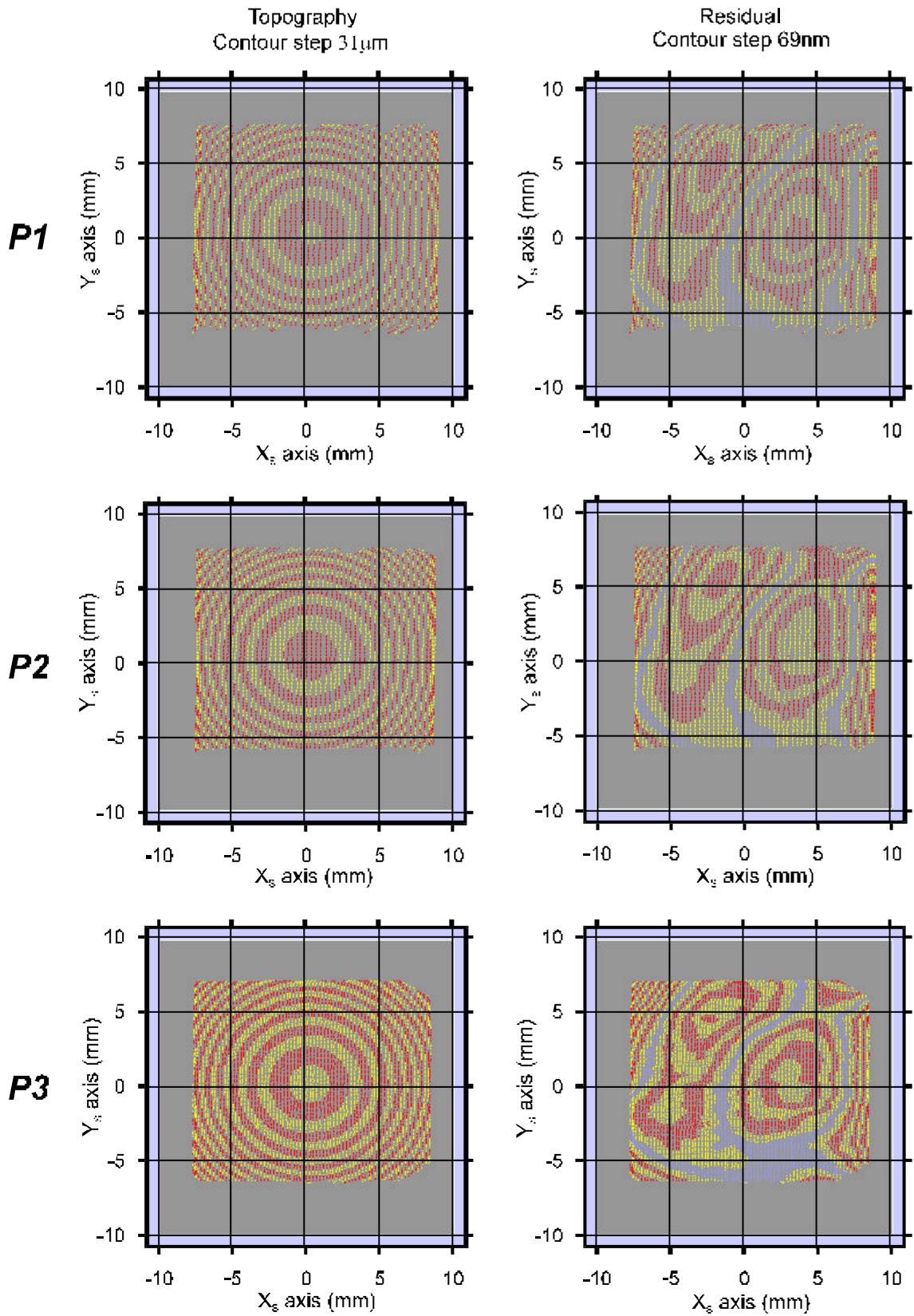


Table 7.3.4a: Measured results for sample P30050B, G00 tilt.

Sample P30050B G00 tilt	Parameter	P1 $d_R=180.0\text{mm}$	P2 $d_R=182.6\text{mm}$	P3 $d_R=188.4\text{mm}$
Experiment	N(points)	5306	6817	10768
	Dz(mm)	0.433	0.359	0.357
	A(mm <sup>2</sup> )	229.1	225.9	219.5
2D fitting	$K_B(\text{rad})$	$4.676 \cdot 10^{-4}$	$-1.619 \cdot 10^{-3}$	$-1.643 \cdot 10^{-3}$
	$r_B^2$	0.9999974	0.9999974	0.9999980
	$K_C(\text{rad})$	$1.324 \cdot 10^{-2}$	$3.953 \cdot 10^{-3}$	$4.063 \cdot 10^{-3}$
	$r_C^2$	0.9999954	0.9999960	0.9999941
	$R_B(\text{mm})$	170.0	170.1	170.3
	$R_C(\text{mm})$	149.2	149.3	149.3
3D fitting	$R_B(\text{mm})$	170.2	170.3	170.4
	$R_C(\text{mm})$	149.0	149.1	149.1
	$s_B(\text{mm})$	$2.8 \cdot 10^{-3}$	$2.9 \cdot 10^{-3}$	$2.4 \cdot 10^{-3}$
	$s_C(\text{mm})$	$3.6 \cdot 10^{-3}$	$2.5 \cdot 10^{-3}$	$2.7 \cdot 10^{-3}$
	$x_0(\text{mm})$	1.971	0.589	0.605
	$y_0(\text{mm})$	0.087	-0.274	-0.278
	$s_{x_0}(\text{mm})$	$5.4 \cdot 10^{-5}$	$3.9 \cdot 10^{-5}$	$3.5 \cdot 10^{-5}$
	$s_{y_0}(\text{mm})$	$1.3 \cdot 10^{-4}$	$4.3 \cdot 10^{-5}$	$4.1 \cdot 10^{-5}$
	$q(^{\circ})$	0.31	0.26	0.26
	$s_q(^{\circ})$	$3.9 \cdot 10^{-3}$	$3.3 \cdot 10^{-3}$	$3.1 \cdot 10^{-3}$
	$r^2$	0.9999992	0.9999991	0.9999987
	Dz <sub>RESIDUAL</sub> (mm)	$2.288 \cdot 10^{-4}$	$4.811 \cdot 10^{-4}$	$2.799 \cdot 10^{-4}$

Möller-Wedel radioscope measurement:  $R_B = 169.7 \pm 1\text{mm}$   
 $R_C = 147.7 \pm 1\text{mm}$



Fig. 7.3.4a: Measured surface topographies and residuals: sample P30050B,G00 tilt.

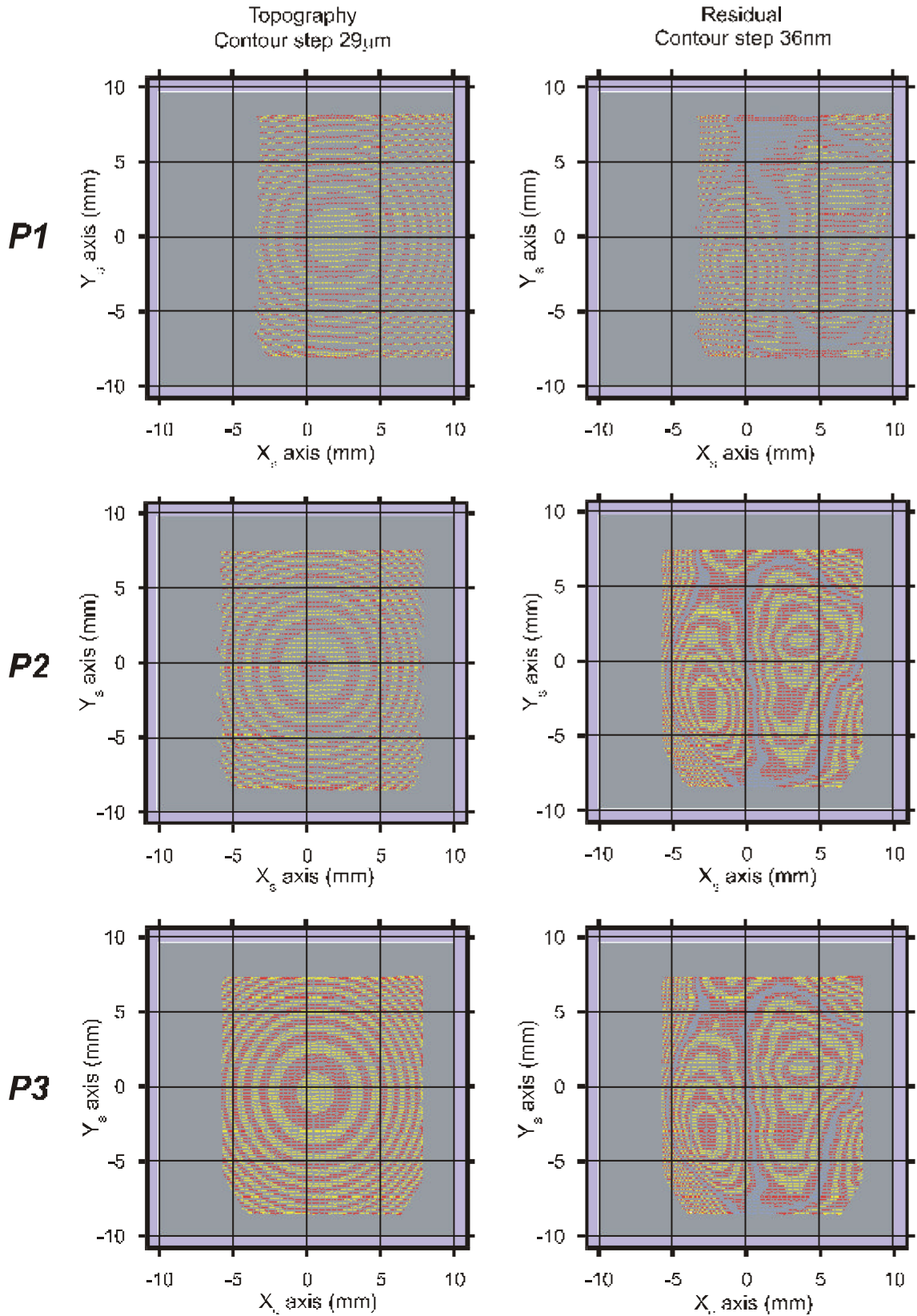


Table 7.3.4b: Measured results for sample P30050B, G30 tilt.

Sample P30050B G30 tilt	Parameter	P1 $d_R=180.0\text{mm}$	P2 $d_R=182.6\text{mm}$	P3 $d_R=188.4\text{mm}$
Experiment	N(points)	6125	7692	11617
	Dz(mm)	0.438	0.427	0.413
	A(mm <sup>2</sup> )	277.9	277.0	263.8
2D fitting	$K_B(\text{rad})$	$1.131 \cdot 10^{-3}$	$9.928 \cdot 10^{-4}$	$9.247 \cdot 10^{-4}$
	$r_B^2$	0.9999968	0.9999969	0.9999509
	$K_C(\text{rad})$	$1.607 \cdot 10^{-3}$	$1.453 \cdot 10^{-3}$	$1.696 \cdot 10^{-3}$
	$r_C^2$	0.9999924	0.9999915	0.9998808
	$R_B(\text{mm})$	170.1	170.2	170.2
	$R_C(\text{mm})$	149.1	149.2	149.3
3D fitting	$R_B(\text{mm})$	169.9	169.9	170.0
	$R_C(\text{mm})$	149.2	149.2	149.3
	$s_B(\text{mm})$	$2.5 \cdot 10^{-3}$	$2.4 \cdot 10^{-3}$	$1.9 \cdot 10^{-3}$
	$s_C(\text{mm})$	$3.0 \cdot 10^{-3}$	$2.9 \cdot 10^{-3}$	$2.5 \cdot 10^{-3}$
	$x_0(\text{mm})$	0.194	0.170	0.172
	$y_0(\text{mm})$	0.235	0.212	0.238
	$s_{x_0}(\text{mm})$	$4.2 \cdot 10^{-4}$	$3.9 \cdot 10^{-5}$	$3.3 \cdot 10^{-5}$
	$s_{y_0}(\text{mm})$	$4.4 \cdot 10^{-4}$	$4.3 \cdot 10^{-5}$	$3.5 \cdot 10^{-5}$
	$q(^{\circ})$	30.74	30.75	33.83
	$s_q(^{\circ})$	$5.5 \cdot 10^{-3}$	$5.4 \cdot 10^{-3}$	$4.4 \cdot 10^{-3}$
	$r^2$	0.9999989	0.9999987	0.9999987
	Dz <sub>RESIDUAL</sub> (mm)	$1.999 \cdot 10^{-4}$	$3.009 \cdot 10^{-4}$	$5.628 \cdot 10^{-4}$

Möller-Wedel radioscope measurement:  $R_B = 169.7 \pm 1\text{mm}$   
 $R_C = 147.7 \pm 1\text{mm}$

Fig. 7.3.4b: Measured surface topographies and residuals: sample P30050B, G30 tilt.

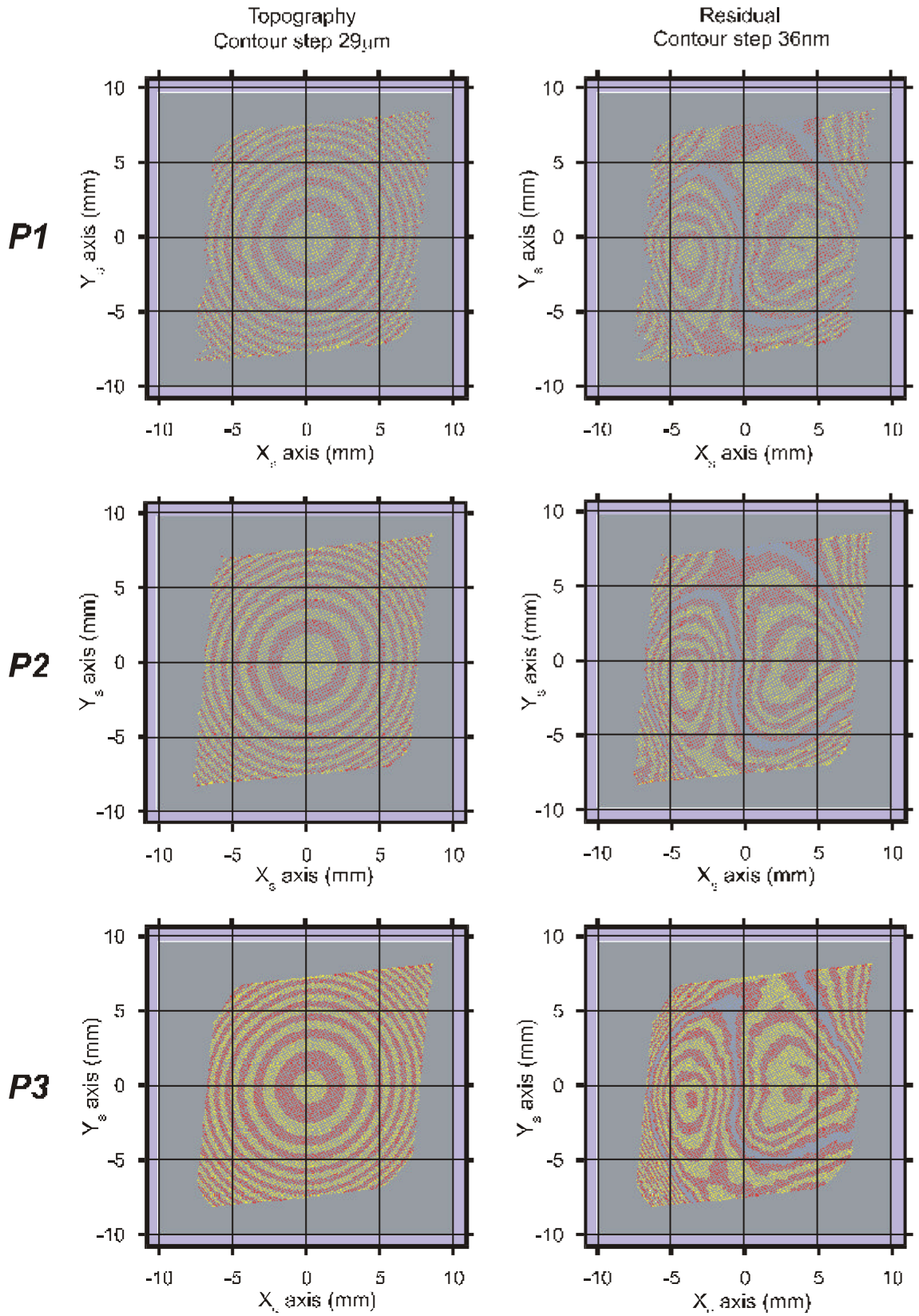




Fig. 7.3.4c: Measured surface topographies and residuals: sample P30050B, G60 tilt.

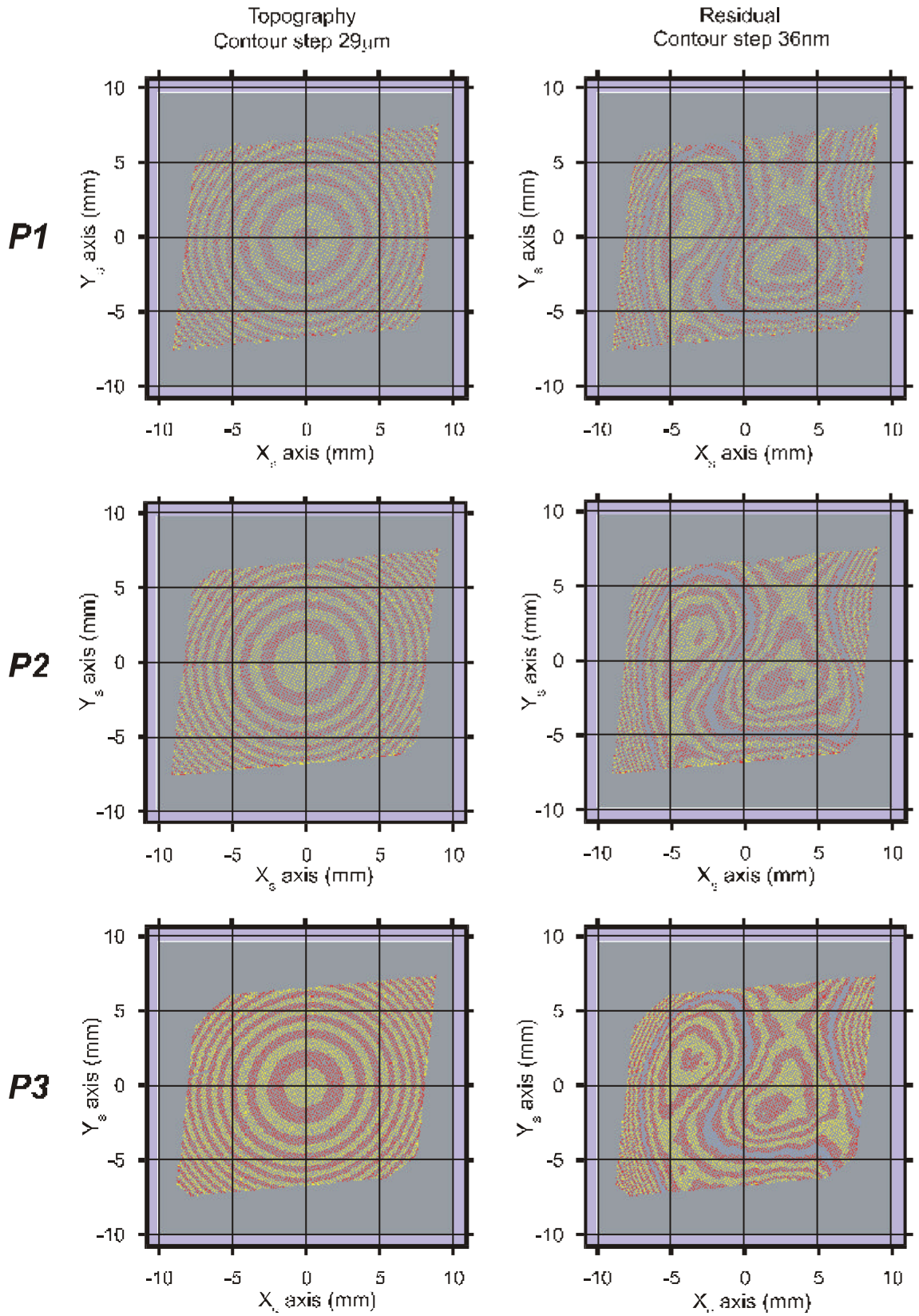


Table 7.3.4d: Measured results for P30050B, G90 tilt.

Sample P30050B G90 tilt	Parameter	P1 $d_R=180.0\text{mm}$	P2 $d_R=182.6\text{mm}$	P3 $d_R=188.4\text{mm}$
Experiment	N(points)	5549	6923	10917
	Dz(mm)	0.394	0.383	0.331
	A(mm <sup>2</sup> )	231.6	222.9	219.7
2D fitting	$K_B(\text{rad})$	$3.667 \cdot 10^{-4}$	$-2.722 \cdot 10^{-3}$	$-8.962 \cdot 10^{-4}$
	$r_B^2$	0.9999955	0.9999939	0.9999959
	$K_C(\text{rad})$	$-3.329 \cdot 10^{-3}$	$5.927 \cdot 10^{-4}$	$-1.261 \cdot 10^{-3}$
	$r_C^2$	0.9999971	0.9999968	0.9999961
	$R_B(\text{mm})$	170.1	170.1	170.3
	$R_C(\text{mm})$	148.7	148.8	148.8
	$R_B(\text{mm})$	169.9	169.9	170.1
	$R_C(\text{mm})$	148.8	148.9	148.9
3D fitting	$s_B(\text{mm})$	$3.4 \cdot 10^{-3}$	$2.8 \cdot 10^{-3}$	$2.4 \cdot 10^{-3}$
	$s_C(\text{mm})$	$5.2 \cdot 10^{-3}$	$4.3 \cdot 10^{-3}$	$3.4 \cdot 10^{-3}$
	$x_0(\text{mm})$	0.062	-0.465	0.154
	$y_0(\text{mm})$	-0.494	0.088	-0.187
	$s_{x_0}(\text{mm})$	$5.9 \cdot 10^{-5}$	$3.8 \cdot 10^{-5}$	$3.3 \cdot 10^{-5}$
	$s_{y_0}(\text{mm})$	$6.0 \cdot 10^{-5}$	$6.1 \cdot 10^{-5}$	$3.9 \cdot 10^{-5}$
	$q(^{\circ})$	0.20	0.18	0.29
	$s_q(^{\circ})$	$4.9 \cdot 10^{-3}$	$4.1 \cdot 10^{-3}$	$3.5 \cdot 10^{-3}$
	$r^2$	0.9999984	0.9999986	0.9999983
	Dz <sub>RESIDUAL</sub> (mm)	$3.002 \cdot 10^{-4}$	$3.126 \cdot 10^{-4}$	$5.812 \cdot 10^{-4}$

Möller-Wedel radioscope measurement:  $R_B = 169.7 \pm 1\text{mm}$

$R_C = 147.7 \pm 1\text{mm}$

Fig. 7.3.4d: Measured surface topographies and residuals: sample P30050B,G90 tilt.

