**Introduction**

Machine tool (MT) capability & availability are of paramount importance in modern manufacturing industry. The first is determined by measurement, the second depends on maintenance & calibration which includes measurement procedures.

Increasing measurement efficiency leads to:
1. More accurate & repeatable results
2. Machine downtime decrease
3. Uncertainty estimation

**Novelty**

More investigated

Less investigated

**Methodology**

Input  Sort  Analyse  Compare  Report

MS Office Access DBMS

**Data management**

Measurement

- Measurement Equipment
- Environment & Machine Type
- Manual Input
- Report Generator

Novel Database

- Graphical User Interface
- Machine Tool Controller Data
- Statistical Process Control

Capability Assessment

- Application
- Purchase

Comparison

- Analysis
- Compare

**New test development**

The alternative to a traditional laser measurement is proposed for a straightness. Simple, precise and more effective on long ranges, the method utilizes taut wire and an optical sensor, mounted on a moving table (saddle).

Sensor displacement is measured in a number of points which form a graph showing a combined error of the guide and the wire like shown on the graph:

\[ x_i = x_{i-1} + \epsilon_i - c_{i-1} \]

where:
- \( x \) - guide error on a step \( i \)
- \( \epsilon \) - combined error (measured), and
- \( c \) - combined error on the shifted wire

The accuracy of measurement does not depend on wire surface defects and its straightness, the only factor which affects the result is repeatability of the wire which proved to be very high. This brings final measurement error to a sub-micron level.