



**UNIVERSITI TEKNIKAL MALAYSIA MELAKA**

**Uncertainty Measuring and Evaluating the  
Measurement of Gauge Block by Universal  
Measuring Machine**

Thesis submitted in accordance with the requirements of the Universiti  
Teknikal Malaysia Melaka for the Bachelor Degree of Manufacturing  
Engineering (Manufacturing Process)

by

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Faculty of Manufacturing Engineering

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# UNIVERSITI TEKNIKAL MALAYSIA MELAKA

## BORANG PENGESAHAN STATUS LAPORAN PSM

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BLOCK BY UNIVERSAL MEASURING MACHINE**

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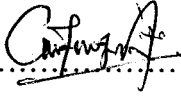
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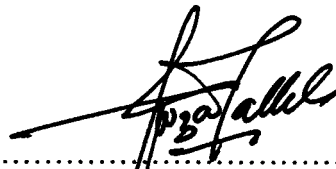
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## APPROVAL

This report is submitted to the Faculty of Manufacturing Engineering of UTeM as a partial fulfilment of the requirements for the degree of Bachelor of Manufacturing Engineering (Process). The members of the supervisory committee are as follow:



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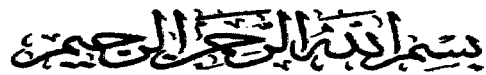
## **ABSTRACT**

This is an approach to the uncertainty analysis that needs to be evaluated so that it will become the guidelines to the other measuring process. Thus, in this project, the utilization of several gauge blocks as samples that must be compulsory in determining the capabilities measuring and evaluating under particular condition. In fact, with the data taken by using the Universal Measuring Machine (UMM) as the apparatus, it must take into account about the possibilities errors that gives the influential results. In this case, some related equations supposed to be applied in conjunction to prove the results obtained. After performing the analysis of those factors, this study produces some better solutions for this kind of errors and it can be a benchmark for the other experimental process. The uncertainty evaluation is conducted according to Guide of Expression on Uncertainty in Measurement (GUM). Therefore, once this research is completed, the final approach is to try to adapt the factors that have been identified in the measurements to reduce the errors. Thus, the evaluating of uncertainty can be minimized synchronizing with the errors reduction from the measurements exposure.

## ABSTRAK

Ini merupakan salah satu pendekatan kepada 'uncertainty analysis' yang mana ia perlu untuk dinilai supaya menjadi panduan kepada sebarang bentuk proses pengukuran. Maka dalam projek ini, beberapa 'gauge block' dijadikan sebagai sampel dalam menentukan kebolehpayaan mengukur and menilai di bawah sesuatu keadaan atau syarat-syarat tertentu. Malah dengan pengambilan data dengan menggunakan 'Universal Measuring Machine', ia mestilah mengambil kira kemungkinan faktor-faktor yang mempengaruhi keputusan. Dalam hal ini, beberapa persamaan yang berkaitan harus diaplikasikan bagi memastikan keputusan yang diterima itu adalah benar dan terbukti. Selepas menganalisis kesemua faktor ini, kajian ini seharusnya dapat menghasilkan penyelesaian yang lebih baik tentang kepelbagaian kesalahan supaya ianya boleh diaplikasikan pada eksperimen-eksperimen lain sebagai tatatanda atau garis panduan. Kemudian kajian ini perlu menghasilkan 'uncertainty evaluation' berdasarkan pada 'Guide of Expression on Uncertainty in Measurement (GUM)' secara lengkap. Pendekatan akhir adalah mengumpulkan segala maklumat dan menterjemahkannya terhadap faktor-faktor yang dikenalpasti bagi mengurangkan kesalahan. Maka 'uncertainty evaluation' dapat dikurangkan selari dengan pengurangan kesalahan hasil daripada kesan ke atas proses pengukuran.

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And last but not least, to all my fellow friends who involves direct or indirectly that always stand strong beside me in giving opinions and supports throughout our relationship, I really thankful and appreciate it. All yours are the most valuable things for the rest of my life.

## **DEDICATION**

*For my beloved parents, my family, my fellow friends and also to those who always give me courage and supports for all these times.*



# TABLE OF CONTENTS

Declaration	i
Approval	ii
Abstract	iii
Abstrak	iv
Acknowledgements	v
Dedication	vi
Table of Contents	vii
List of Figures	xii
List of Tables	xv
List of Abbreviations, Symbols, and Specialized Nomenclature	xvi
List of Appendices	xviii
<b>1. INTRODUCTION</b>	<b>1</b>
1.1 Background of Project	1
1.2 Problems Statements	3
1.3 Objectives of Project	3
1.4 Scope of Project	3
<b>2. LITERATURE REVIEW</b>	<b>5</b>
2.1 Universal Measuring Machine (UMM)	5
2.1.1 Background of Universal Measuring Machine	5
2.1.2 Features	8
2.2 Background of Gauge Blocks	9
2.2.1 Length in Meter	11
2.2.2 Length in Inch	13
2.2.3 ASME Specification	14
2.2.4 Nomenclature and Definitions	14

2.2.5	Tolerance Grades	17
2.2.6	International Standards	19
2.2.7	Physical and Thermal Properties of Gauge Blocks	21
2.2.7.1	Materials	21
2.2.7.2	Flatness Measurements	23
2.2.7.3	Interferometer Technique	25
2.2.7.4	Gauge Block Comparator Technique	27
2.2.7.5	Thermal Expansion	29
2.2.7.6	Thermal Expansion of Gauge Block Materials	30
2.2.7.7	Thermal Expansion Uncertainty	32
2.2.8	Selecting Gauge Blocks	34
2.2.9	Combination of a Required Length	35
2.3	Factors of Measurements	35
2.4	Types of Errors	36
2.4.1	Errors and Uncertainty	36
2.4.2	Experimental Errors	36
2.4.2.1	Indeterminate Errors	37
2.4.2.2	Determinate Errors	37
2.5	Uncertainty Analysis	38
2.5.1	Description of uncertainty in measurement	38
2.5.2	Accuracy specifications of measuring equipment and measurement uncertainty	39
2.5.3	Guide to the Expression of Uncertainty in Measurement (GUM)	42
2.5.3.1	Introduction of GUM	42
2.5.3.2	Basis of GUM	44
2.5.4	Evaluating uncertainty	46
2.5.4.1	Type A evaluation of uncertainty	47
2.5.4.2	Type B evaluation of uncertainty	49

<b>3. METHODOLOGY</b>	<b>50</b>
3.1 Selection of Machine	50
3.1.1 Universal Measuring Machine	50
3.1.2 Basic concept of Universal Measuring Machine	50
3.1.3 Applications	51
3.1.4 Benefits	52
3.1.5 Components of Universal Measuring Machine	52
3.2 Selection of work materials	53
3.3 Uncertainty analysis	54
3.3.1 Reason of estimating uncertainties	55
3.4 Sources of uncertainty	56
3.5 Estimation of uncertainty	57
3.6 Summary of the steps in estimating uncertainty	58
3.7 Measured Difference in Gauge Lengths	59
3.7.1 Reading the Length Difference	59
3.8 Experiment procedure	60
3.8.1 Understanding the uncertainty	62
3.8.2 Literature survey	62
3.8.3 Familiarization (training) of Universal Measuring Machine	63
3.8.4 Measurement and data collection	64
3.8.5 Data analysis	64
3.9 Process Flow	66
3.9.1 The Details of Process Flow	67
3.9.1.1 Machine Calibration	68
3.9.1.2 Setting and Calibrating The Master Gauge Block	73
3.9.1.3 Starting Gauge Block Measurement	81
3.10 Equations Involved in Calculations based on GUM	88

<b>4. RESULTS</b>	91
4.1 Introduction	91
4.2 Measurement on 50 mm of Gauge Block Length	91
4.2.1 Consideration in 50 mm Length of Gauge Block	92
4.2.2 Consideration of Person-In-Charge during Measurements (50 mm length)	98
4.3 Measurement on 75 mm of Gauge Block Length	104
4.3.1 Consideration in 75 mm Length of Gauge Block	105
4.3.2 Consideration of Person-In-Charge during Measurements (75 mm length)	111
4.4 Uncertainty Evaluation of Error in Measurement Results	117
4.4.1 Combined Standard Uncertainty and Expanded Uncertainty	117
4.4.2 Uncertainty on Standard Deviation of Gauge Blocks Length	119
4.4.3 Uncertainty on Temperature with Gauge Block Length	120
4.4.4 Uncertainty on Standard Deviation of Operator	121
4.4.5 Uncertainty on Standard Deviation of Operator and Lengths (Temperature)	122
<b>5. DISCUSSIONS</b>	124
5.1 Introduction	124
5.2 Effects on Measuring Equipment	124
5.2.1 Penetration and Deflection	125
5.2.2 Vibration	127
5.3 Measurement influenced by person performing the task	128
5.3.1 Personal Factors	128
5.4 The Measuring Methods on Equipments and Gauge Blocks	129
5.4.1 Gauge Block Positioning Method	129
5.5 State of the Gauge Blocks to Be Measured	130
5.6 Effects on Environmental Conditions	133
5.6.1 Temperature Effects	133
5.6.2 Thermal Expansion Coefficient Effects	134

<b>6. CONCLUSION AND RECOMMENDATIONS</b>	136
6.1 Conclusion	136
6.2 Recommendations	137
<b>REFERENCES</b>	139
<b>APPENDICES</b>	142
A    Gantt Chart	143
B    Terms used in GUM	145
C    Calibration Certificate (Mahr) for UMM	146
D    Certificate of Calibration for Gauge Block	151

## LIST OF FIGURES

1.1:	Flowchart of measurement process	4
2.1:	Universal Measuring Machine 828 CiM	7
2.2:	A set of gauge blocks	11
2.3:	The length of a gauge block is the distance from the gauging point on the top surface to the plane of the platen adjacent to the wrung gauge block	15
2.4:	Definition of the gauging point on square gauge blocks	17
2.5:	Comparison of ISO grade tolerances (black dashed) and ASME grade tolerances (red)	21
2.6 (a), (b), and (c):	Typical fringe patterns used to measure gauge block flatness. Curvature can be measured as shown in the figures	24
2.7 (a) and (b):	Typical fringe patterns for measuring gauge block parallelism using the interferometer method	26
2.8:	Basic geometry of measurements using a mechanical comparator	27
2.9 (a) and (b):	Location of gauging points on gauge blocks for both length (X) and parallelism (a, b, c, and d) measurements	28
2.10:	Variation of the thermal expansion coefficient of gauge block steel with temperature	30
3.1:	Mitutoyo Gauge Blocks	53
3.2:	Flowchart of project in measurement of uncertainty analysis	61
3.3:	The details of process flow in experimentation	66
3.4:	The main power supply and wearing cotton gloves (in circle)	67
3.5:	The main switch of UMM	68
3.6:	The machine is ready to be used	68
3.7:	The 'CF Mahr' icon	69
3.8:	Function window of zeroing procedure	69

3.9:	Measuring slide	70
3.10:	Reference point run window is selected	70
3.11:	Gauge Management window	71
3.12:	Measuring task window – Free Measurement-Static	71
3.13:	Menu bar of unit selection	72
3.14:	Calibration Free Measurement window needs to be keyed-in	72
3.15:	The master of gauge block from ‘Mahr’	73
3.16:	Measuring slide is locked in its position	74
3.17:	Procedure of locking the support table	74
3.18:	Aligning the gauge block	75
3.19:	Counter spindle, spindle and cap	75
3.20:	Left knob	76
3.21:	Spirit level indicator	76
3.22:	The lever is in unlock position	77
3.23:	Unclamp the spindle position	77
3.24:	Control panel main components	78
3.25:	Calibration free measurement window	78
3.26:	Align window	79
3.27:	Left and right knob	79
3.28:	‘Min’ green box at pop-up window	80
3.29:	‘000’ and align icon	80
3.30:	The accepted value of actual size	81
3.31:	A gauge block of 50 mm length	81
3.32:	A degreaser and cleaner solvent	82
3.33:	Spray on both ends of gauge block	82
3.34:	The gauge block is wiped with the solvent	83
3.35:	The gauge block is put on the support table	83
3.36:	Nominal value is keyed in at the display of free measurement	84
3.37:	The joystick is moved to the left side	84
3.38:	The spindle is getting nearer to the gauge block	85
3.39:	The green light is emitted	85
3.40:	The red indicator at minimum value	86

3.41:	The adjustment of support table with left and right knob	86
3.42:	Centre positioning of the spirit level indicator	87
3.43:	The actual value is appeared at the window display	87
4.1:	Measurement error values ( $\mu\text{m}$ ) versus no. of data taken (50 mm gauge block length)	97
4.2:	Measurement error values ( $\mu\text{m}$ ) versus no. of data taken (50 mm gauge block length) measured by operator	103
4.3:	Measurement error values ( $\mu\text{m}$ ) versus no. of data taken (75 mm gauge block length)	110
4.4:	Measurement error vales ( $\mu\text{m}$ ) versus no. of data taken (75 mm gauge block length) by operator	116
4.5:	The gradient on standard deviations ( $\mu\text{m}$ ) correlate with length of gauge blocks	120
4.6:	Average temperature on workpiece and machine reflect to length of gauge blocks	121
4.7:	Standard deviation values ( $\mu\text{m}$ ) versus gauge block length taken by an operator	122
4.8:	Standard deviation values ( $\mu\text{m}$ ) versus gauge block lengths are influenced by lengths (temperature) and operator	123
5.1:	Probe and spindle deflection	125
5.2:	Penetration on gauge block	126
5.3:	The adjustable support feet	127
5.4:	The setting-up knob for swivelling the support table	130
5.5:	The steel gauge block that can resist collision	131
5.6:	Corrosion on one of the gauge blocks	132
5.7:	Corrosion on both sides of measured length	132
5.8:	Method of holding a gauge block with cotton gloves	135



## LIST OF TABLES

2.1:	British standard inches according years	12
2.2 (a):	Tolerance Grades for Inch Blocks (in $\mu\text{in}$ )	18
2.2 (b):	Tolerance Grades for Metric Blocks ( $\mu\text{m}$ )	19
2.3:	Grade of tolerances in the algorithm of length	20
2.4:	ANSI tolerances for parallelism in microinches	29
2.5:	Thermal expansion Coefficient of selected materials	31
2.6:	Thermal Expansion Coefficients of NIST Master Steel Gauge Blocks ( $10^{-6}/^{\circ}\text{C}$ )	33
2.7:	Values of diameter of a cylinder	47
4.1:	Collected data for $\ell_{ni} = 50$ mm gauge block length	93
4.2:	Collected data for $\ell_{ni} = 50$ mm gauge block length by operator	99
4.3:	Collected data for $\ell_{ni} = 75$ mm gauge block length	106
4.4:	Collected data for $\ell_{ni} = 75$ mm gauge block length by operator	112

## LIST OF ABBREVIATIONS, SYMBOLS, AND SPECIALIZED NOMENCLATURE

ANSI	–	American National Standards Institute
ASME	–	American Society of Mechanical Engineers
ASTM	–	American Society for Testing and Materials
BIPM	-	Bureau International des Poids et Mesures
CIPM	-	International Committee of Weight & Measure
CMM	–	Coordinate Measuring Machine
CNC	-	Computer Numerical Control
CTE	–	Coefficient of Thermal Expansion
EQ	-	Emotional Quotient
GUM	–	Guide of Expression on Uncertainty in Measurement
IQ	-	Intelligence Quotient
ISO	–	International Standards Organisation
N	-	Newton
NIST	–	National Institute of Standards and Technology
SI	-	System International
UMM	–	Universal Measuring Machine
°C	–	Celsius
Pa	–	Pascal
CO <sub>2</sub>	–	Carbon Dioxide
L	–	Length
$\Delta L$	–	Changes in Length of the object
$\Delta T$	–	Temperature Changes
$\alpha_L$	–	Coefficient of Thermal Expansion
$\delta$	–	Uncertainty of Quantity
$S^2$	–	Estimation of Variance of Type A
$\nu_i$	–	Number of Degrees of Freedom
$U^2_j$	–	Variance of Type B

$\bar{d}$	–	Mean Diameter
$s$	–	Standard Deviation or Standard Error of the Mean
$U$	–	Expanded Uncertainty
$u_c$	–	Combined Standard Uncertainty
$k$	–	Coverage Factor
$\mu\text{m}$	–	micrometer (1 millionth of a meter) (metric unit)
$\mu\text{in}$	–	microinch (1 millionth of an inch)
$\text{mm}$	–	millimetre (metric unit)
$\text{in}$	–	inch
$\text{m/s}$	-	meter per second
$^{\circ}\text{F}$	-	Fahrenheit
$\text{nm}$	-	Nanometer
$\lambda$	-	Wavelength
Eq.	-	Equation
met	-	Metabolic rate
$\text{W}\cdot\text{m}^2$	-	Works X Area

## **LIST OF APPENDICES**

Appendix A – Gantt Chart	143
Appendix B – Terms used in GUM	145
Appendix C – Calibration Certificate (Mahr) for UMM	146
Appendix D – Certificate of Calibration for Gauge Block	151

# CHAPTER 1

## INTRODUCTION

### 1.1 Background of Project

Most of us imagine that experimentation almost relates to the data taking in a laboratory. Obviously, it can be defined as making measurements in a laboratory not only data taking that is conducted by any engineers but also investigating the circumstances occurred due to the research. On the other hand, the actual data taking portion of a well-run experimental program generally contributes just a small percentage of the total time and effort expended.

Experiments are an essential and integral tool for engineering and science in general. By definition, experimentation is a procedure for testing (and determination) of a truth, principle, or effect. However, the true values of measured variables are seldom (if ever) known and experiments inherently have errors, e.g., due to instrumentation, data acquisition and reduction limitations, and facility and environmental effects. For these reasons, determination of truth requires estimates for experimental errors, which are referred to as uncertainties. Experimental uncertainty estimates are imperative for risk assessments in design both when using data directly or in calibrating and/or validating simulation methods.

Coleman et. al. (1999) stated that rigorous methodologies for experimental uncertainty assessment have been developed over the past 50 years. Standards and guidelines have been put forth by professional societies (ANSI/ASME, 1985) and international organizations (ISO, 1993). Recent efforts are focused on uniform application and reporting of experimental uncertainty assessment.

The quantitative assessment method was to be compatible with existing methodologies within the technical community. Uncertainties that are difficult to quantify were to be identified and guidelines given on how to report these uncertainties. Additional considerations included: integration of uncertainty analyses into all phases of testing; simplified analysis while focusing on primary error sources; incorporation of recent technical contributions such as correlated bias errors and methods for small sample sizes; and complete professional analysis and documentation of uncertainty for each test. Coleman et. al. (1995, 1999) found that the uncertainty assessment methodology has application to a wide variety of engineering and scientific measurements, which is an update to the earlier standards.

The calculation of uncertainty for a measurement is an effort to set reasonable bounds for the measurement result according to standardized rules. Since every measurement produces only an estimate of the answer, the primary requisite of an uncertainty statement is to inform the reader of how sure the writer is that the answer is in a certain range.

Measurements are accompanied by measurement errors. The uncertainty in the sign and magnitude of a measurement error is called measurement uncertainty. To put this statement in mathematical terms, errors that occur in measurement are random variables that follow statistical distributions. The uncertainty due to a specific error is equal to the standard deviation of the error distribution.

The total error in a measurement is comprised of errors from several possible sources. Among these are parameter error, random error, resolution error, operator bias, sampling error, environmental error, etc. Each error follows a statistical distribution with a standard deviation. According to Castrup (2000), there is an uncertainty associated with each error source. The total uncertainty in a measurement is composed of these uncertainties.

## **1.2 Problems Statements**

- i. Reduction of measurement errors due to the range value possible to have huge differences.
- ii. In obtaining the influential of the measurement in the uncertainty so that it will adapt to the particular factors.
- iii. Get the segregation of each data analysis so that it could interact with uncertainty evaluation.

## **1.3 Objectives of Project**

- i. To identify the possibilities of errors occur during measuring of gauge blocks.
- ii. To investigate the influence of end effects of gauge blocks on the measurement results.
- iii. To perform the uncertainty evaluation according to Guide of Expression on Uncertainty in Measurement (GUM).

## **1.4 Scope of Project**

This project is about to investigate the uncertainty analysis in measurement of gauge block using Universal Measuring Machine (UMM). Thus, the process should be done in the particular condition so that we could identify the discrimination on certain data and results. Thus, the utilization of some gauge blocks with different sizes are applied and the measurement are done repetitively e.g. for 50 data.

In this case, the measurements errors are identified through the collected data based on the appropriate parameters such as length of gauge blocks (temperatures influence), person who performed the task, and also the test of equipments used. At the same time, the factors that influence of errors can be traced out indirectly through

the observation. Once it is investigated, the uncertainty analysis will take over involving particular calculations and equations so that it will be correlated to the Guide of Expression on Uncertainty in Measurement (GUM).

Thus, to get more clear about this project, there is a flow of measurement (refer Figure 1.1) shows the progress and the main method of this measuring activities that will have the correlation with uncertainty analysis. Besides, the Gantt chart as in Appendix A will describe details on the progress of this thesis.

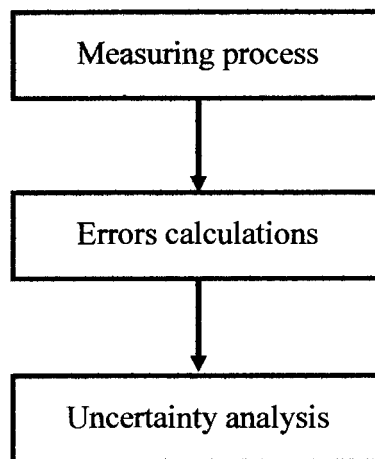


Figure 1.1: Flowchart of measurement process