
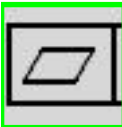
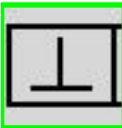
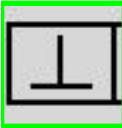
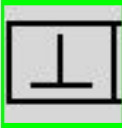
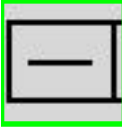
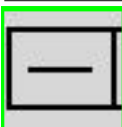

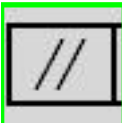







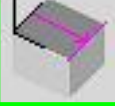






Plan pomiarowy	Data 31 stycznia 2014	CMM MMZ_G
Nr rysunku	Godzina 8:43:49	Zlecenie
Kontroler Master	CMM C32Bit	Nr sztuki H16 01.2014.

Rzecz.	Nominal	Górna tol.	Dolna tol.	Odchylka
 Wynik ogólny Wszystkie charakterystyki: 45 Poza tolerancja: 0 Poza granica ostrzeżenia: 0 Nie wykonano: 0				
 1 DIN Ebenheit A 0.0045	0.0000	0.0100		-- 0.0045
 2 DIN Rechtwinkligkeit bei D1 zu B1-B2 0.0027	0.0000	0.0100		-- 0.0027
 2 DIN Rechtwinkligkeit bei D2 zu B1-B3 0.0015	0.0000	0.0100		- 0.0015
 2 DIN Rechtwinkligkeit zu C 0.0031	0.0000	0.0100		-- 0.0031
 3 DIN Geradheit Bahn B1 0.0035 Soll konvex 0,003 +0,01 Auswertung über Grafik Messelement	0.0000	0.0130		-- 0.0035
 3 DIN Geradheit Bahn B2 0.0048 Soll konvex 0,003 +0,01 Auswertung über Grafik Messelement	0.0000	0.0130		-- 0.0048
 4 Distanz D1 - D2_X 299.9891	299.9850	0.0050	-0.0050	---- 0.0041
 5 DIN Parallelität D1 zu C 0.0006	0.0000	0.0100		- 0.0006



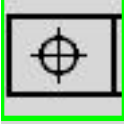



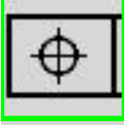

	Rzecz.	Nominal	Górna tol.	Dolna tol.	Odchyłka
	5 DIN Parallelität D2 zu C2 0.0001	0.0000	0.0100		 0.0001
	6 DIN Parallelität D1 zu B 0.0066	0.0000	0.0100		--- 0.0066
	6 DIN Parallelität D2 zu B 0.0037	0.0000	0.0100		-- 0.0037
	7 DIN Position zu BC 0.0801	0.0000	0.1000		---- 0.0801
	Z -124.9629	-125.0000			0.0371
	X -68.0150	-68.0000			-0.0150
	8 DIN Ebenheit B1 - B2 0.0068	0.0000	0.0100		--- 0.0068
	9 DIN Geradheit C 0.0047	0.0000	0.0100		-- 0.0047
	10 DIN Rechtwinkligkeit zu B 0.0021	0.0000	0.0100		- 0.0021
	11 Mass 50,5 50.5179	50.5000	0.0500	-0.0500	-- 0.0179
	12 DIN Parallelität zu C 0.0007	0.0000	0.0400		- 0.0007
	13 Mass 55,25 -55.2360	-55.2500	0.0500	-0.0500	-- 0.0140
	14 DIN Parallelität zu B 0.0011	0.0000	0.0400		- 0.0011
	15 Z D1 199 -124.9629	-125.0000			0.0371



	Rzecz.	Nominal	Górna tol.	Dolna tol.	Odchyłka
	16 X D1 199 -68.0150	-68.0000			-0.0150
	25 Z D2 199 -124.9606	-125.0000			0.0394
	26 X D2 199 -368.0041	-367.9850			-0.0191
	27 Mass 436 -436.0017	-436.0000	0.2000	-0.2000	-0.0017
	28 DIN Parallelität zu C 0.0054	0.0000	0.0100		0.0054
	29 Mass 559.5 559.4959	559.5000	0.2000	-0.2000	-0.0041
	30 DIN Parallelität zu A 0.0061	0.0000	0.0200		0.0061
	31 Durchmesser D1 199 199.0290	199.0000	0.0440	0.0150	0.0290
	31 Durchmesser D2 199 199.0265	199.0000	0.0440	0.0150	0.0265
	32 Durchmesser D1 200 200.0619	200.0000	0.1000	0.0500	0.0619
	32 Durchmesser D2 200 200.0599	200.0000	0.1000	0.0500	0.0599






8 H7 zur Spindelbohrung

	Rzecz.	Nominal	Górna tol.	Dolna tol.	Odchyłka
	17 Distanz D1 Z_Z 79.2543	79.2573			-0.0031
	18 Distanz D1 X_X 72.6171	72.6260			-0.0089
	19 DIN Position zu D1				----
	Z 0.0160	0.0000	0.0200		0.0160
	X 79.2511	79.2570			-0.0059
	X -72.6206	-72.6260			0.0054
	20 Durchmesser 8 D1 8.0075	8.0000	0.0150	0.0000	0.0074
	21 Distanz D2 Z_Z 79.2578	79.2570			0.0008
	22 Distanz D2 X_X 72.6210	72.6260			-0.0050
	23 DIN Position zu D2				--
	Z 0.0056	0.0000	0.0200		0.0056
	X 79.2549	79.2570			-0.0021
	X -72.6241	-72.6260			0.0019
	24 Durchmesser 8 D2 8.0081	8.0000	0.0150	0.0000	0.0080



Weitere Abmessungen für die NA

	D6H7_1 6.0088	6.0000	0.0120	0.0000	-- 0.0088
	D6H7_2 6.0087	6.0000	0.0120	0.0000	-- 0.0087
	Dystans L30_Z 30.0035	30.0000			0.0035




Nazwa CM
440 424

Kontroler
Master

Godzina
8:43:49

Data
31 stycznia 2014



	Rzecz.	Nominal	Górna tol.	Dolna tol.	Odchyłka
	Dystans L35,5_X 35.4982	35.5000			-0.0018
	Dystans L55_Z 55.0053	55.0000			0.0053
	Dystans L25±0,02_Z 25.0018	25.0000	0.0200	-0.0200	- 0.0018