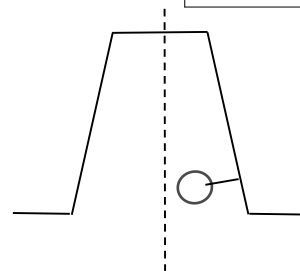


Diagnostic	X
Remise en état	
Machine de niveaux	X

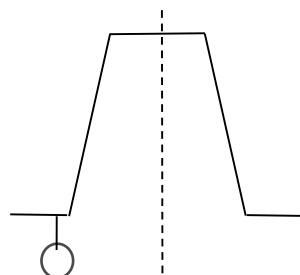
Concentricité broche
Spindle concentricity

Tolérance RD	Broche
0.010	0.004

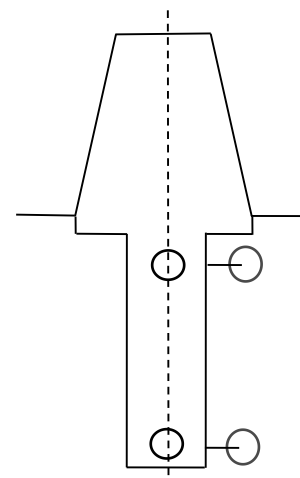


Planéité face broche
Spindle face flatness

Tolérance RD	Broche
0.008	NA



Parallélisme broche
par rapport axe Z selon axes X et Y
Spindle parallelism in relation to axis Z according to axes X and Y

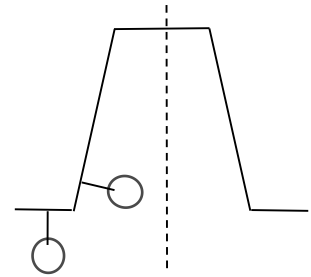


Tolérance RD	Broche
0.040/200 selon X	0.008/250
0.040/200 selon Y	0.020/250
Concentricité à 0.010/25mm nez de broche	0.008/25
Concentricité à 0.020/100mm nez de broche	0.030/250

Jeux mécanique broche
Spindle mechanical plays

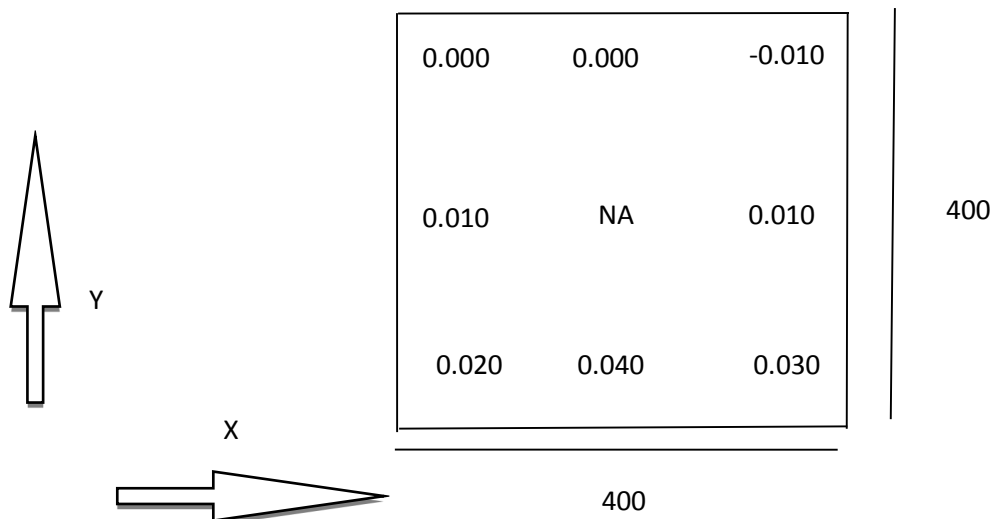
Jeux axial

Jeux radial

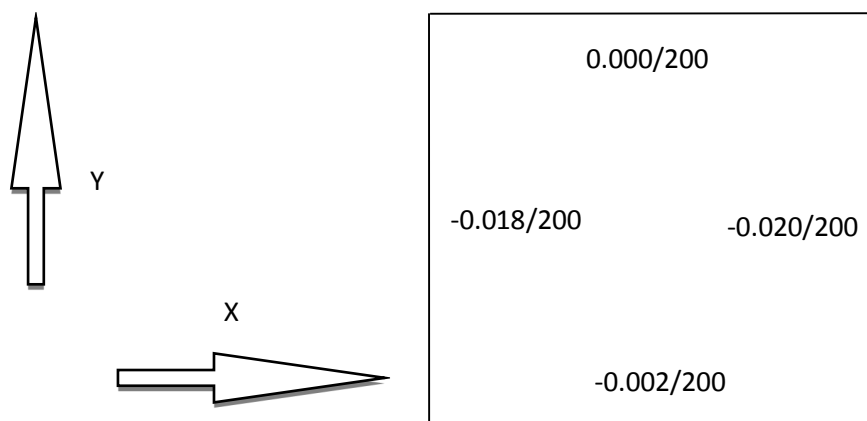


Tolérance RD	Broche
Axial 0.090	0.070
Radial 0.008	0.008

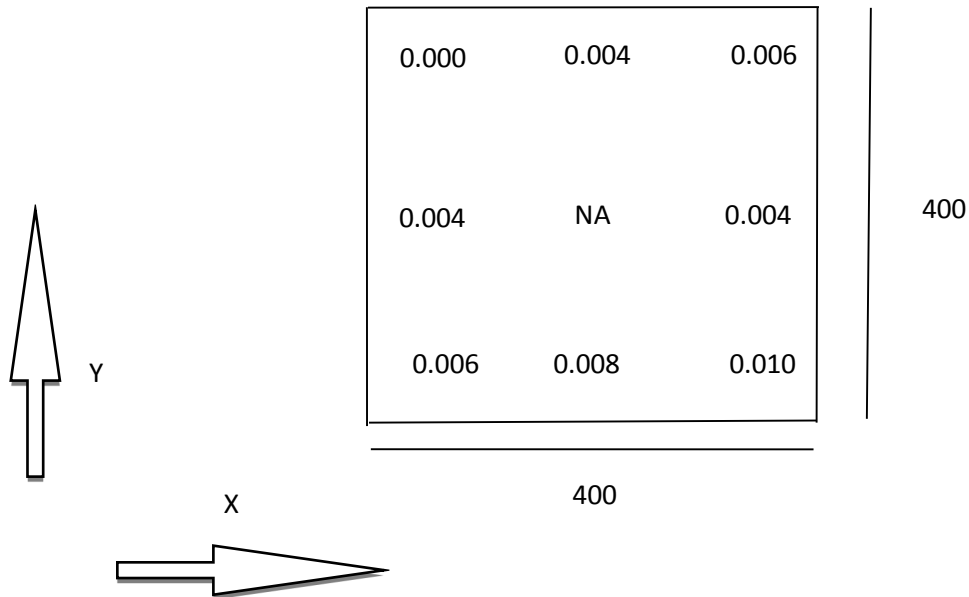
Planéité de la palette 1
Pallet 1 flatness



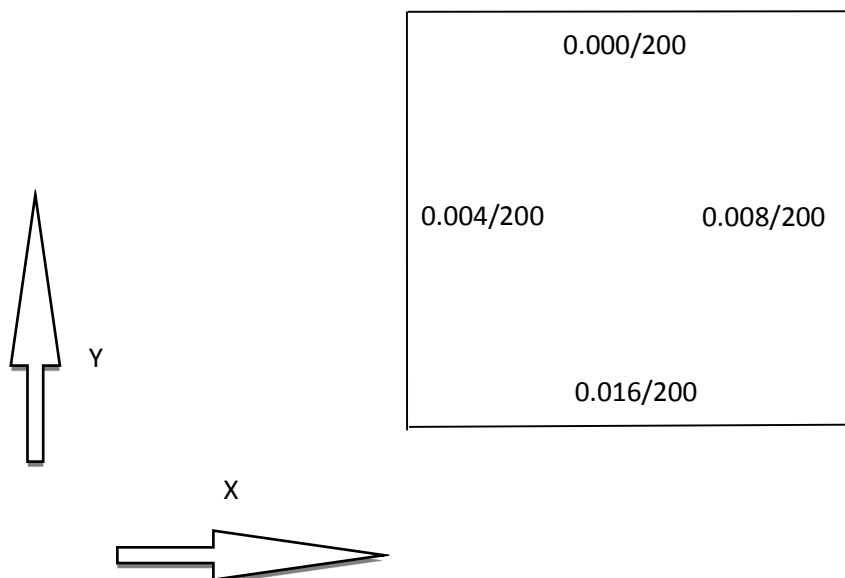
Planéité de la palette 1 en rotation
Pallet 1 flatness in rotation



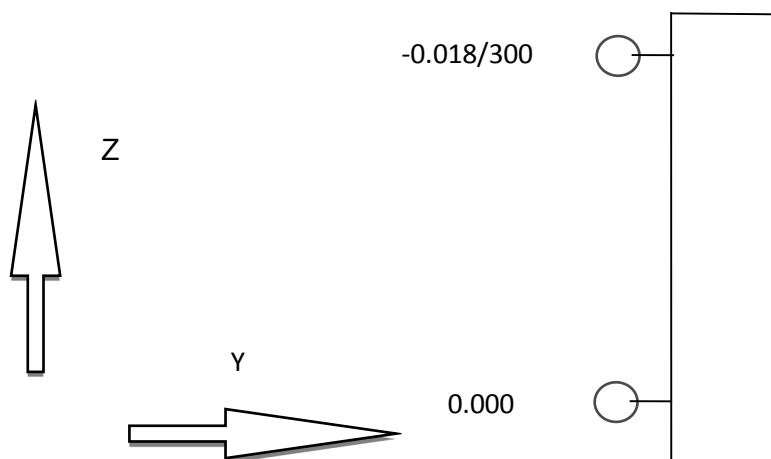
Planéité de la palette 2
Pallet 2 flatness



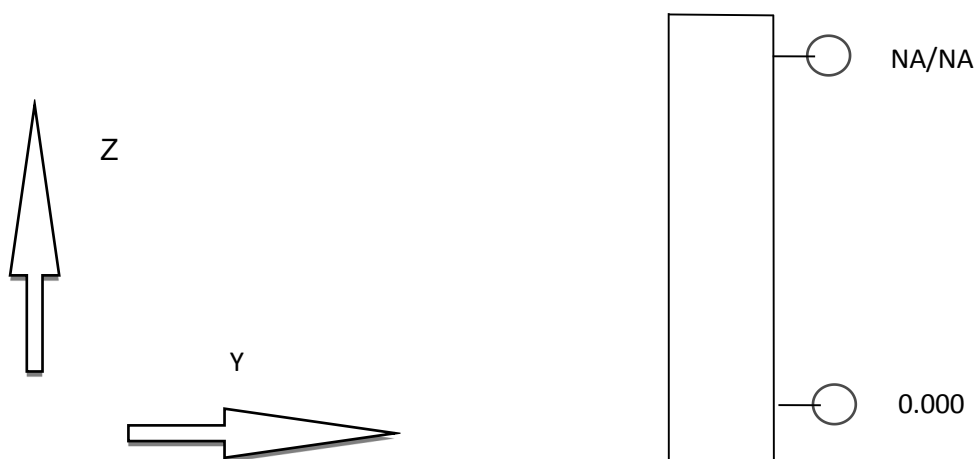
Planéité de la palette 2 en rotation
Pallet 2 flatness in rotation



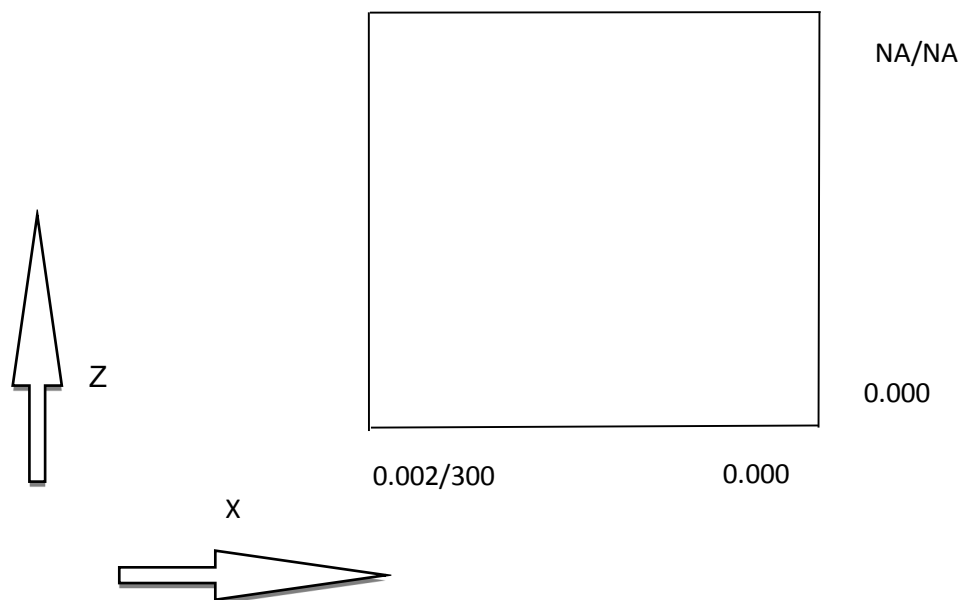
Parallélisme de la palette par rapport à l'axe Z en A -90
Parallelism of the pallet By report to Z axis With A -90



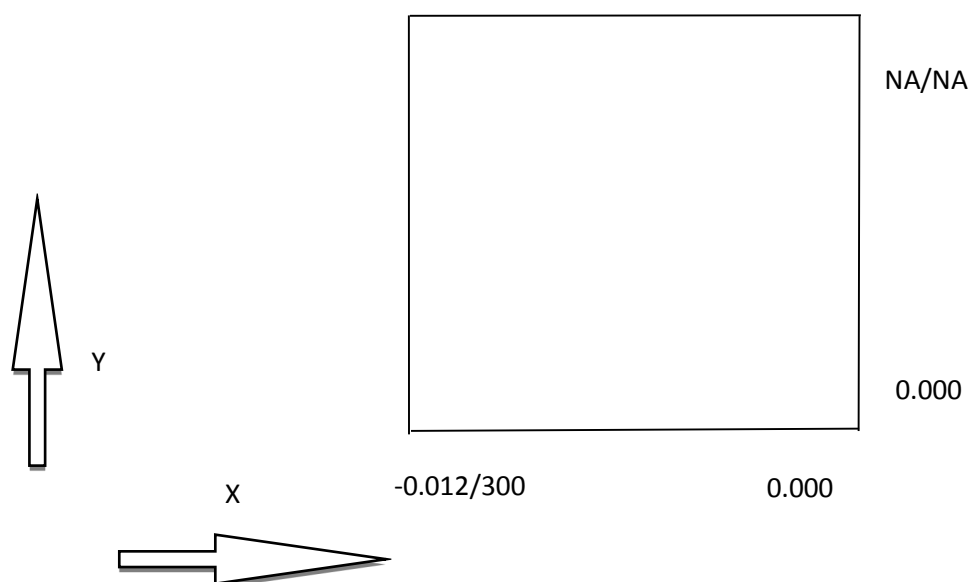
Parallélisme de la palette par rapport à l'axe Z en B 90
Parallelism of the pallet By report to Z axis With B 90



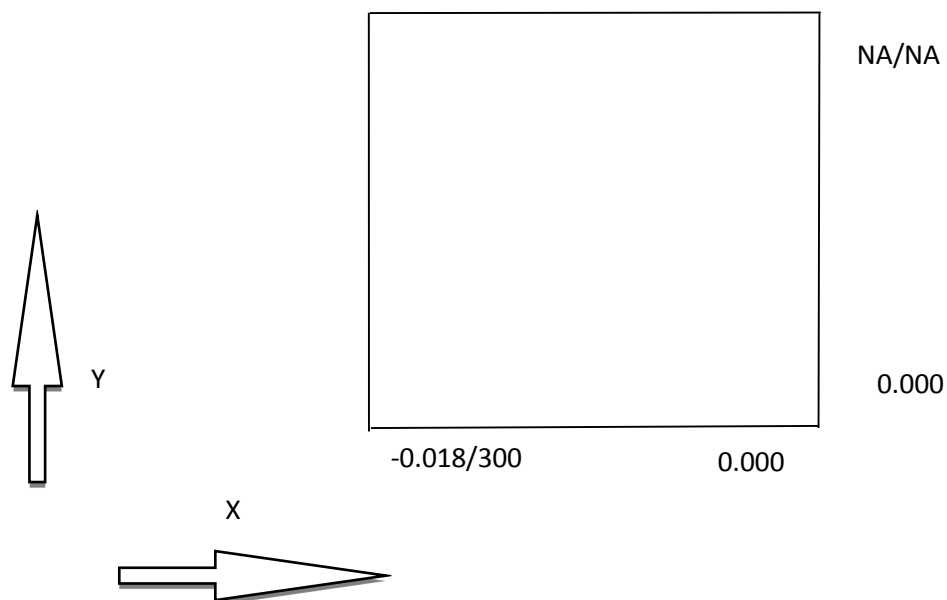
Parallélisme palette selon axes X et Z axe A0
Parallelism Pallet according to axes X and Z axe A0



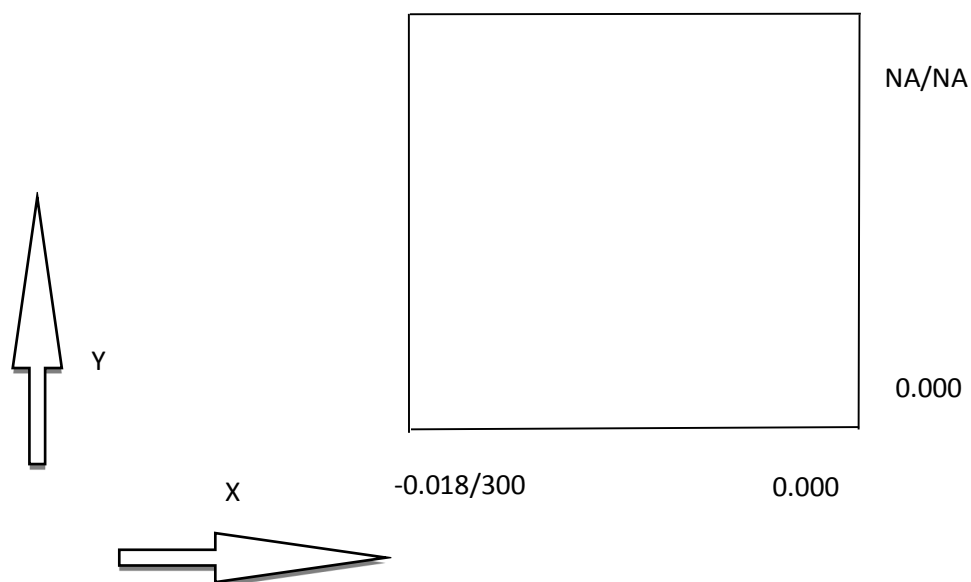
Parallélisme palette selon axes X et Z axe C 90
Parallelism Pallet according to axes X and Z axe C90



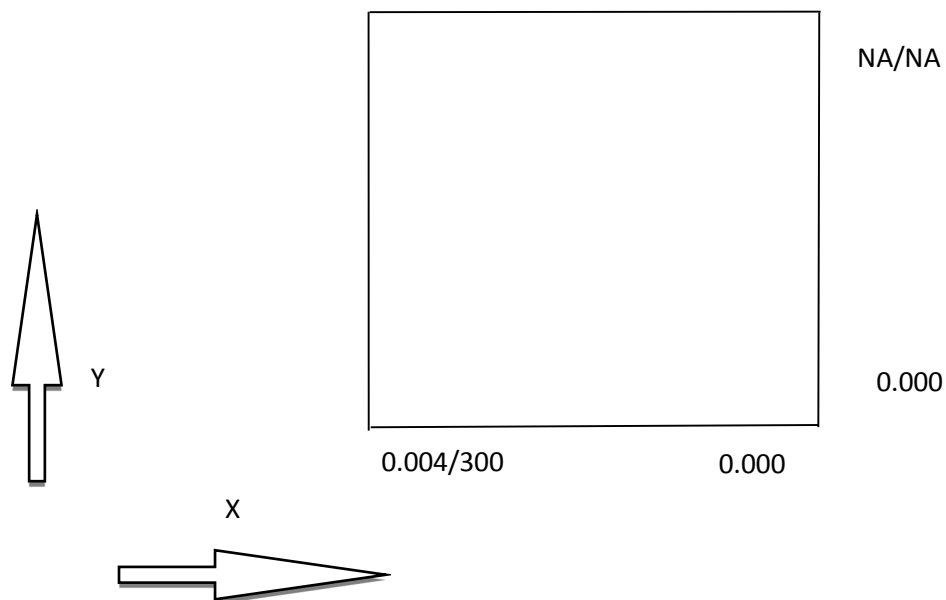
Parallélisme palette selon axes X et Z axe C 180
Parallelism Pallet according to axes X and Z axe C180



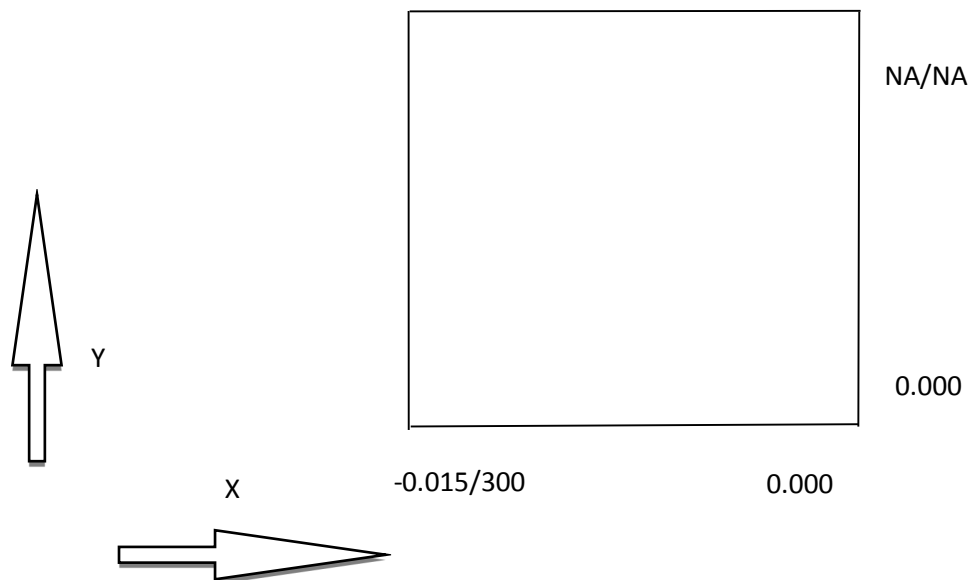
Parallélisme palette selon axes X et Z axe C 270
Parallelism Pallet according to axes X and Z axe C270



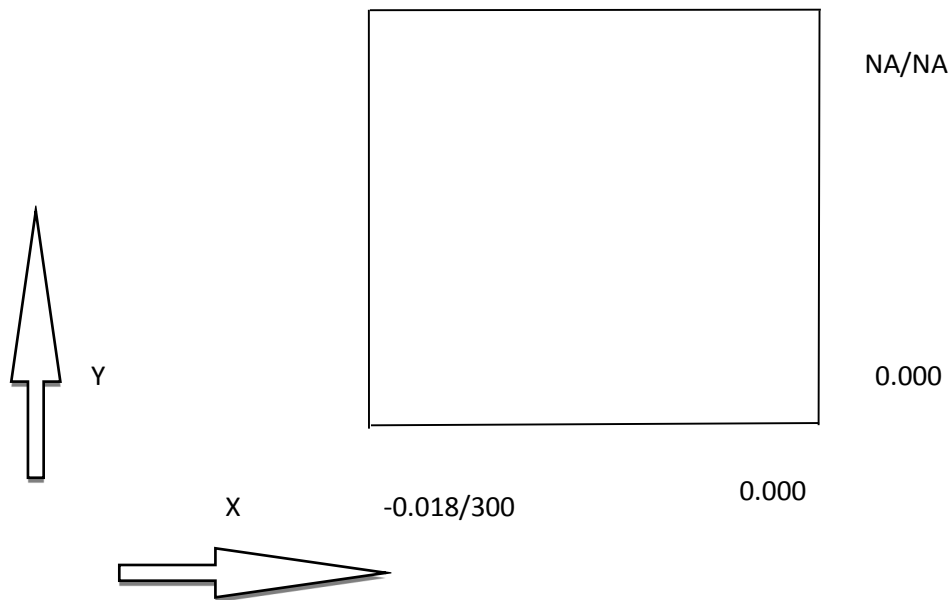
Parallélisme palette selon axes X et Z axe C-0
Parallelism Pallet according X and Z axe C-0



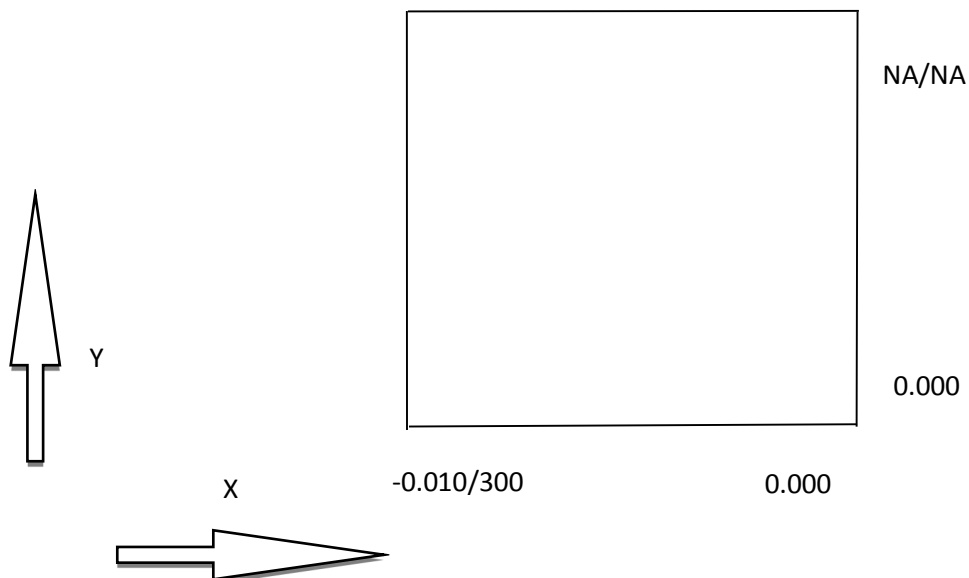
Parallélisme palette selon axes X et Z axe C-90
Parallelism Pallet according to axes X and Z axe C-90



Parallélisme palette selon axes X et Z axe C -180
Parallelism Pallet according to axes X and Z axe C -180

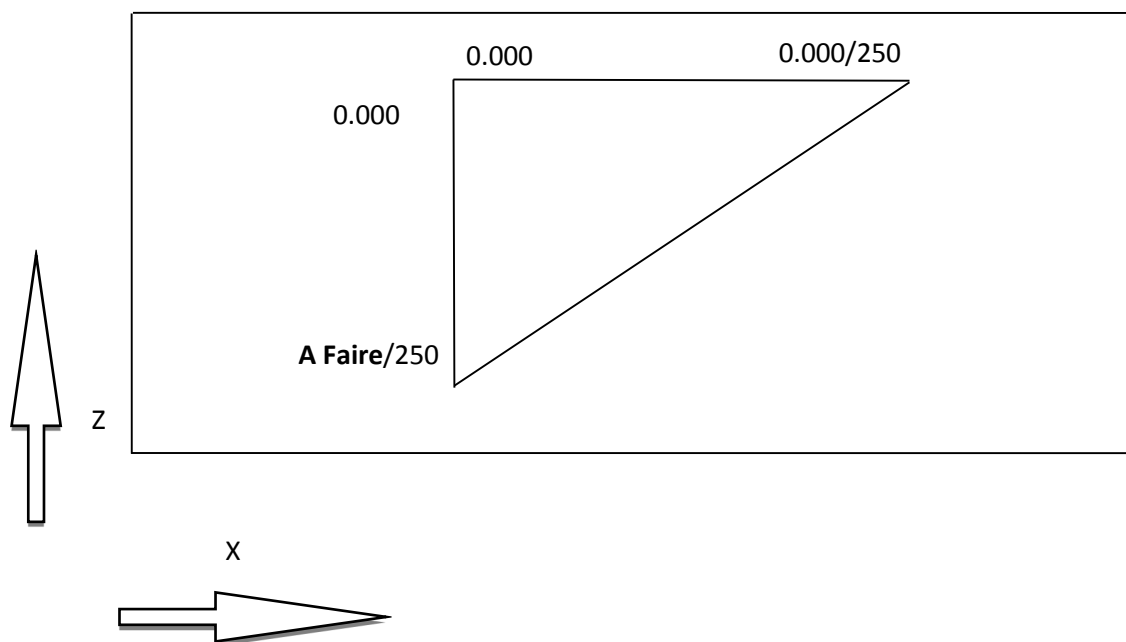


Parallélisme palette selon axes X et Z axe C -270
Parallelism Pallet according to axes X and Z axe C -270

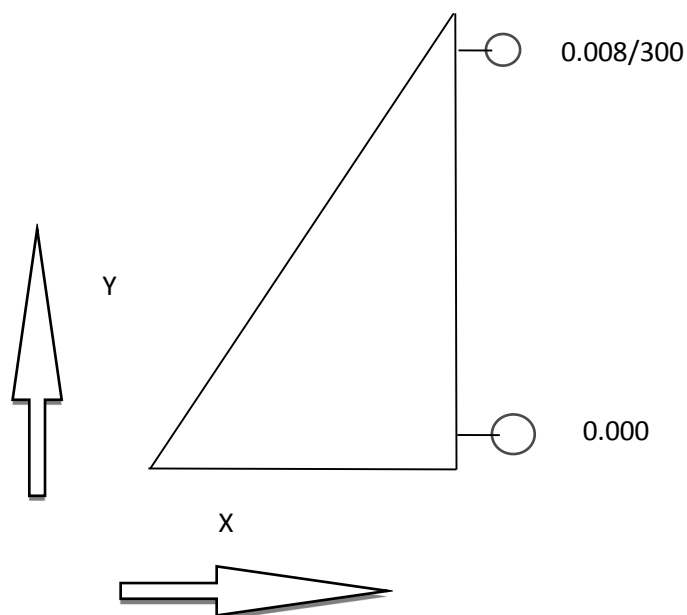


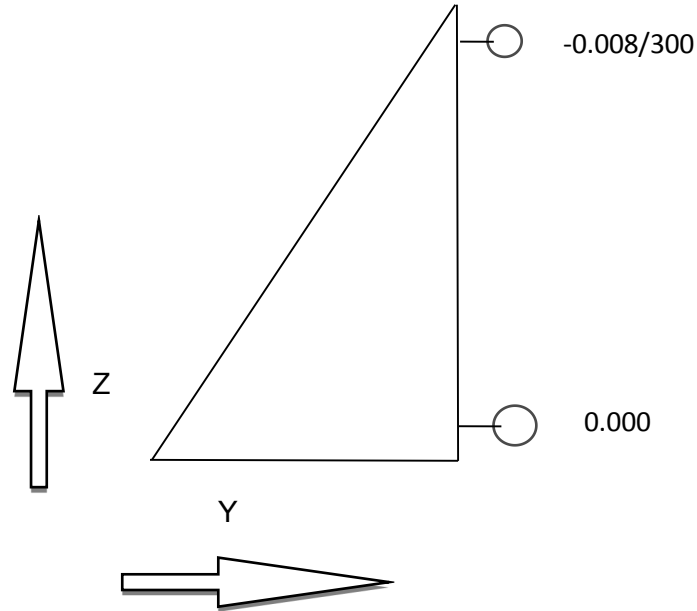
Perpendicularité table axe Y / axe Z
Table perpendicularity axis Y / axis Z

Perpendicularité X / Z
Perpendicularity X / Z

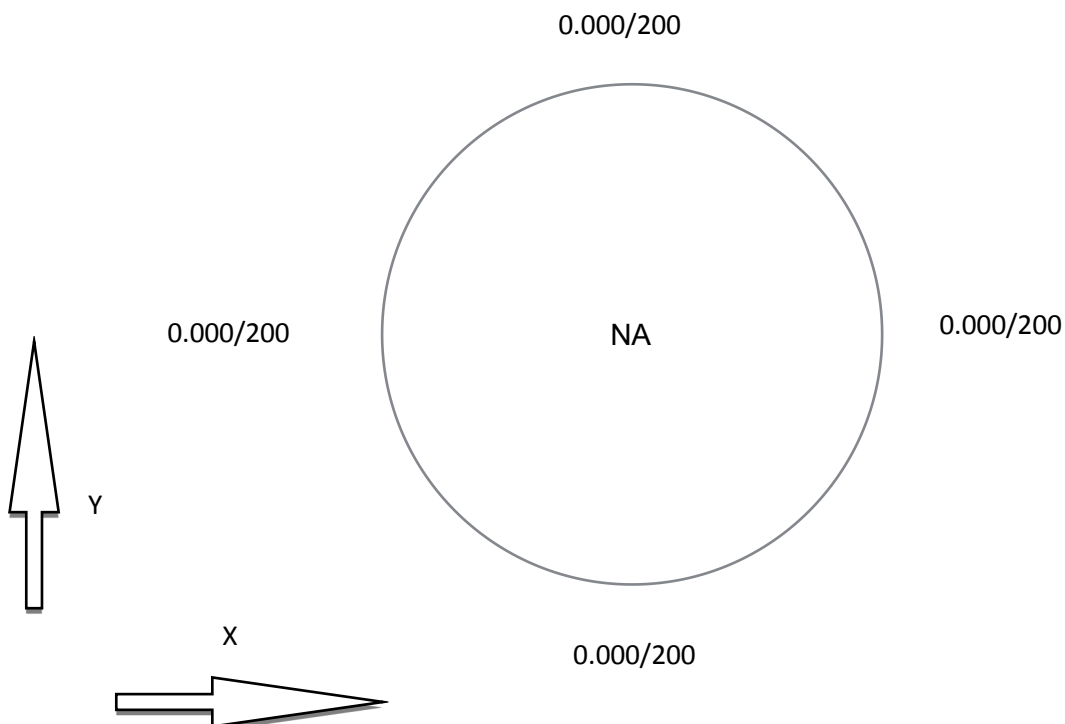


Perpendicularité table axe Y / axe X
Table perpendicularity axis Y / axis X

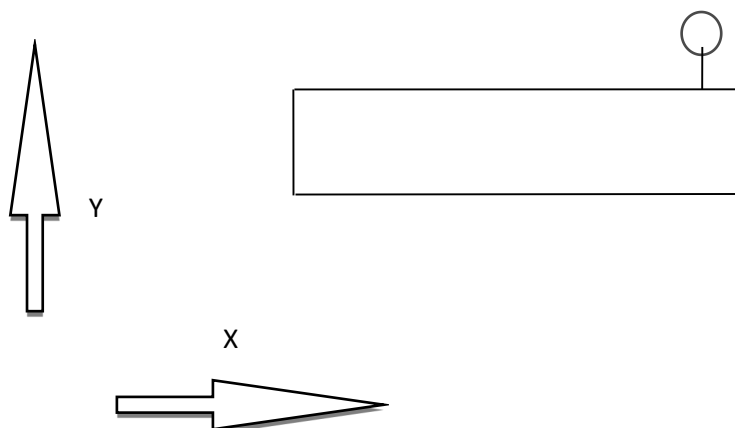




Perpendicularité de la table par rapport a la Broche
Fixer le comparateur dans la broche
et le faire tourner
Table perpendicularity in relation to the spindle
Fix the comparator in the spindle and make it turn



Jeux bridage débridage table selon axe Y
Sets clamping unclamping table according to Y axis



Tolérance RD	Jeux serrage desserage palette
0.020	0.004

Jeux inversion
Relever paramètre N° N12 & N13 Micron
Mettre paramètre inversion à zéro
Régler jeux inversion
Contrôle jeux mécanique
Inversion plays
Take the measurement of parameter N° N12 & N13 Micron
Put inversion parameter back to 0
Adjust inversion plays
Control mechanical plays

Tolérance RD	Valeur para	Jeux	Jeux méca
X 0,065	-2/9	0.018	0.012
Y 0,065	2/9	0.006	0.004
Z 0,065	6/8	0.016	0.010
A 0.045	8/8	0.012	0.008
C 0.045	25/25	0.035	0.020

VALIDÉ