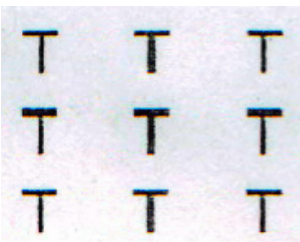
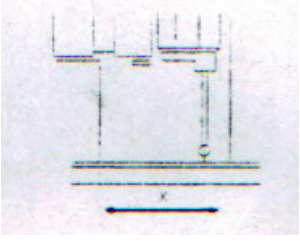
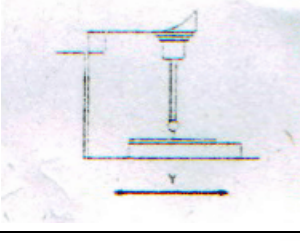
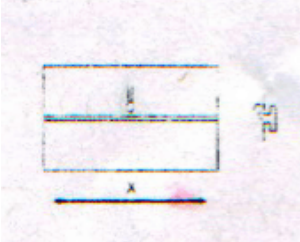
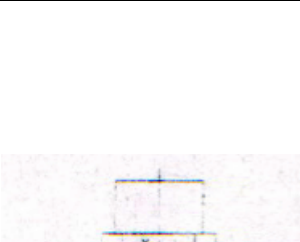
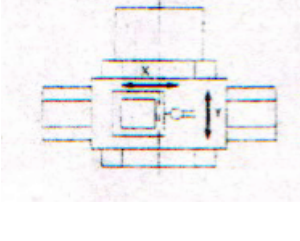
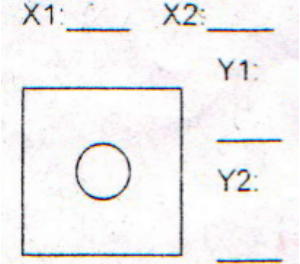
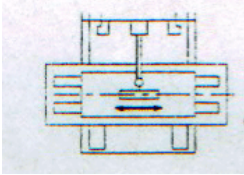
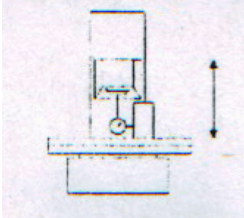
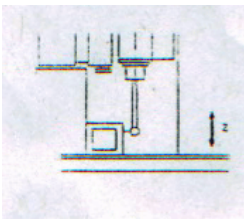
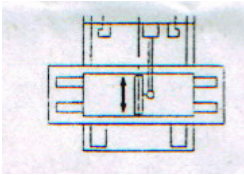
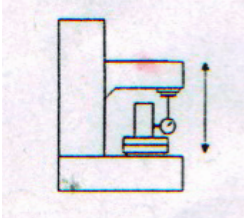
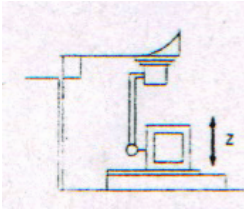
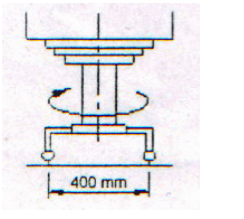
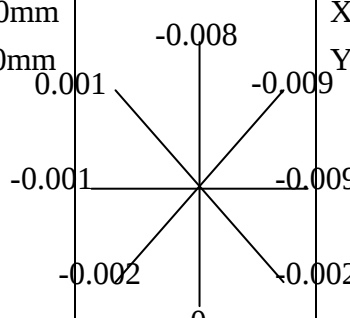
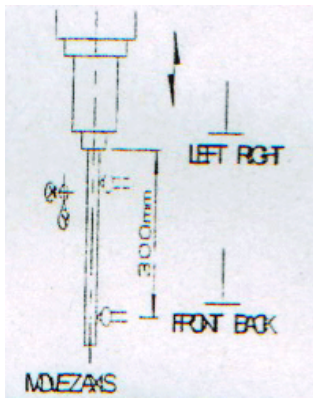
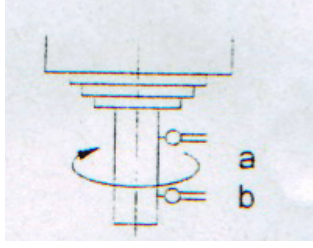
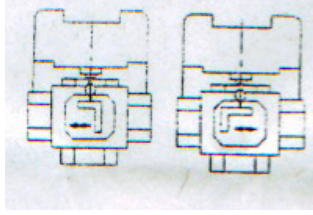
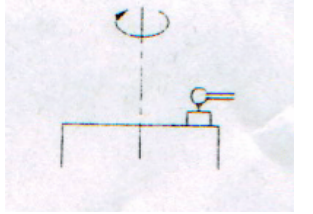
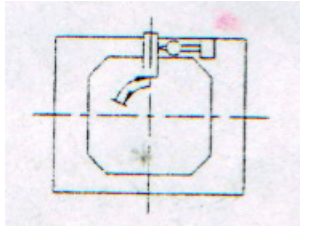
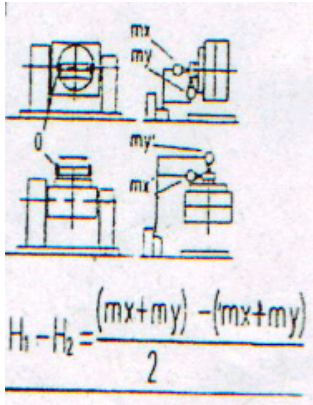
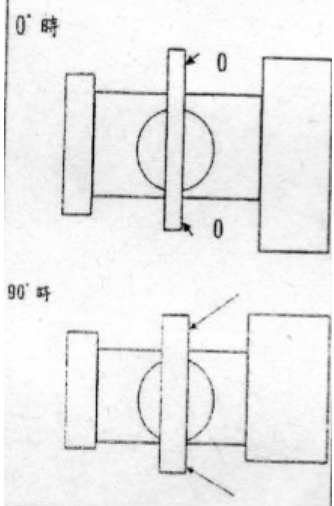
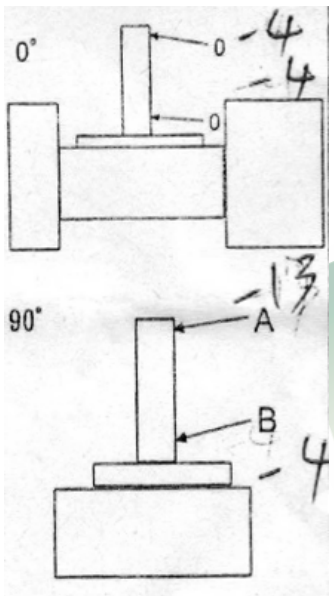


跑合前水平及幾何精度檢查					
Test conditions 檢驗項目	Figure 圖示	Mode	Allowable 容許值標準	Worker(mm) 作業者	QA(mm) 檢驗者
Level on table(static) 工作台靜(動)態 水平		UX300	X : 0.03mm/m Y : 0.03mm/m	0.02 0.015	
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			
Parallelism of table movement to X-axis 工作台 面移動平行度 x 軸		UX300	0.01/full mm	0.004	
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			
Parallelism of table movement to Y-axis 工作台 面移動平行度 y 軸		UX300	0.01/full mm	0.001	
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			
Straightness of the side surface of the center T-slot 參考 T 溝 側面移動真直度		UX300	0.01/full mm	0.006	
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			
Parallelism of the side surface between T-slot T 溝間的平行度		UX300	0.01/full mm	0.004	
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			
Table movement straightness 工作 台 X&Y 移動真 直度(直角尺 X/Y 向)		UX300	0.008/400 mm	x-x:0.003 y-y:0.003	
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			
Squareness of X-Y X-Y 垂直 度		UX300	0.008/400 mm	0.006	
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			

跑合前水平及幾何精度檢查					
Test conditions 檢驗項目	Figure 圖示	Mode	Allowable 容許值標準	Worker(mm) 作業者	QA(mm) 檢驗者
Table movement straightness 工作 台移動真直度 (直角尺 X/Z 向)		UX300	0.01/400 mm	0.005	0.008
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			
Z-axis movement straightness Z 軸 移動方向真直度 (直角尺 Z/X 向)		UX300	0.01/400 mm	0.008	0.01
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			
Squarness of X-Z X-Z 垂直 度		UX300	0.008/400 mm	0.003	0.007
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			
Table movement straightness 工 作台移動真直度 (直角尺 Y/Z 向)		UX300	0.01/400 mm	0.004	0.007
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			
Z-axis movement straightness Z 軸 移動方向真直度 (直角尺 Z/Y 向)		UX300	0.01/400 mm	0.004	0.006
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			
Squateness of Y-Z Y-Z 垂直 度		UX300	0.005/400 mm	0.005	0.007
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			
Squareness of spindle sweep to table 主軸迴旋 與工作台面垂直 度		UX300	X:0.010/400mm Y:0.010/400mm		
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			

跑合前水平及幾何精度檢查					
Test conditions 檢驗項目	Figure 圖示	Mode	Allowable 容許值標準	Worker(mm) 作業者	QA(mm) 檢驗者
Parallelism of the extension from spindle taper to Z-axis 主軸中心線與 z 軸移動平行度		UX300	X:0.008/300mm	X-Z:0.004	X-Z:0.005
		MV204CU	Y:0.008/300mm	Y-Z:0.004	Y-Z:0.004
		UX600			
		UX500Dyn			
		UX730Dyn			
Run-out of the extension from spindle taper 主軸錐孔延伸偏擺		UX300	a:0.004/300mm	A:0.002	A:0.002
		MV204CU	b:0.012/300mm	B:0.008	B:0.008
		UX600			
		UX500Dyn			
		UX730Dyn			
Squarness of c-axis movement c 軸 90 度		UX300	0.005/400 mm	0.003	0.003
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			
Run-out of table face 工作 台偏擺		UX300	0.010/400 mm	0.006	0.006
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			
Repeatability of c-axis C 軸 重覆精度		UX300	0.006/full	0.002	0.002
		MV204CU			
		UX600			
		UX500Dyn			
		UX730Dyn			
Parallelism between center line of tilt A axis and base plate		U 型機全機種	my	1	1
			mx	-4	-4
			my'	0	0
			mx'	4	4
			H1-H2=0.01	0.0035	0.0035

跑合前水平及幾何精度檢查					
Test conditions 檢驗項目	Figure 圖示	Mode	Allowable 容許值標準	Worker(mm) 作業者	QA(mm) 檢驗者
使用平尺量測 y 向旋轉變異		U 型機全機種	0.01/300mm	0.008	0.008
使用 300mm 長 之試棒 0 度		U 型機全機種	0.01/300mm	0.009	0.009
C axis deflect during clamp/unclamp C 軸 鬆/夾刀時的偏移量		U 型機全機種	0.004		0.004
C axis backlash BEFORE compensation C 軸 補償前背隙檢查		U 型機全機種			
A axis deflect during clamp/unclamp A 軸 鬆/夾刀時的偏移量		U 型機全機種	0.002		0.002
A axis backlash BEFORE compensation A 軸 補償前背隙檢查		U 型機全機種			