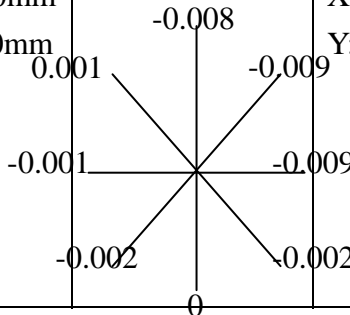
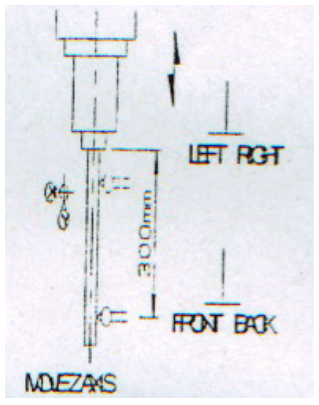
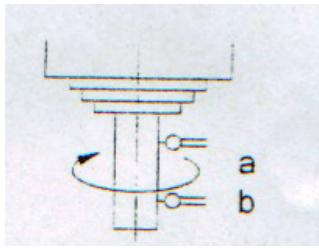
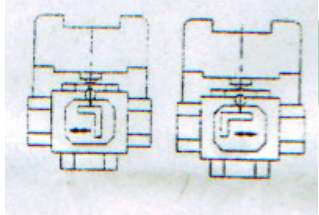
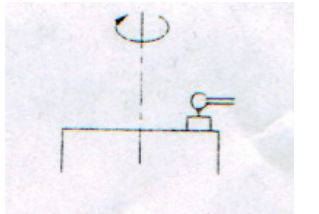
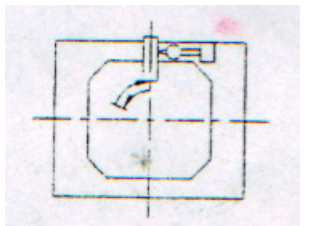
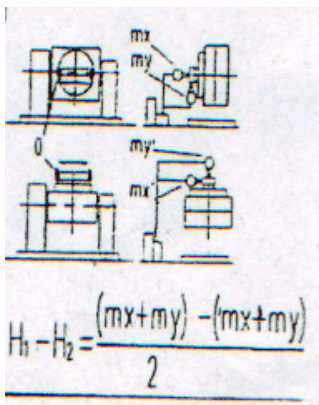




| 跑台前水平及幾何精度檢查  |   |          |                                |  |                    |
|---|---|----------|--------------------------------|--|--------------------|
| Test conditions<br>檢驗項目   | Figure<br>圖示  | Mode     | Allowable<br>容許值標準             | Worker(mm)<br>作業者  | QA(mm)<br>檢驗者      |
| Table movement<br>straightness 工作<br>台移動真直度<br>(直角尺 X/Z 向)      |    | UX300    | 0.01/400 mm                    | 0.005  | 0.008              |
|   |   | MV204CU  |                                |  |                    |
|   |   | UX600    |                                |  |                    |
|   |   | UX500Dyn |                                |  |                    |
|   |   | UX730Dyn |                                |  |                    |
| Z-axis movement<br>straightness Z 軸<br>移動方向真直度<br>(直角尺 Z/X 向)   |    | UX300    | 0.01/400 mm                    | 0.008  | 0.01               |
|   |   | MV204CU  |                                |  |                    |
|   |   | UX600    |                                |  |                    |
|   |   | UX500Dyn |                                |  |                    |
|   |   | UX730Dyn |                                |  |                    |
| Squarness of<br>X-Z X-Z 垂直<br>度                                 |    | UX300    | 0.008/400 mm                   | 0.003  | 0.007              |
|   |   | MV204CU  |                                |  |                    |
|   |   | UX600    |                                |  |                    |
|   |   | UX500Dyn |                                |  |                    |
|   |   | UX730Dyn |                                |  |                    |
| Table movement<br>straightness 工<br>作台移動真直度<br>(直角尺 Y/Z 向)      |  | UX300    | 0.01/400 mm                    | 0.004  | 0.007              |
|   |   | MV204CU  |                                |  |                    |
|   |   | UX600    |                                |  |                    |
|   |   | UX500Dyn |                                |  |                    |
|   |   | UX730Dyn |                                |  |                    |
| Z-axis movement<br>straightness Z 軸<br>移動方向真直度<br>(直角尺 Z/Y 向)   |  | UX300    | 0.01/400 mm                    | 0.004  | 0.006              |
|   |   | MV204CU  |                                |  |                    |
|   |   | UX600    |                                |  |                    |
|   |   | UX500Dyn |                                |  |                    |
|   |   | UX730Dyn |                                |  |                    |
| Squateness of<br>Y-Z Y-Z 垂直<br>度                                |  | UX300    | 0.005/400 mm                   | 0.005  | 0.007              |
|   |   | MV204CU  |                                |  |                    |
|   |   | UX600    |                                |  |                    |
|   |   | UX500Dyn |                                |  |                    |
|   |   | UX730Dyn |                                |  |                    |
| Squareness of<br>spindle sweep to<br>table 主軸迴旋<br>與工作台面垂直<br>度 |  | UX300    | X:0.010/400mm<br>Y:0.010/400mm |  | X:0.009<br>Y:0.009 |
|   |   | MV204CU  |                                |  |                    |
|   |   | UX600    |                                |  |                    |
|   |   | UX500Dyn |                                |  |                    |
|   |   | UX730Dyn |                                |  |                    |

| 跑合前水平及幾何精度檢查   |  |          |                                |                        |                        |
|--|--|----------|--------------------------------|------------------------|------------------------|
| Test conditions<br>檢驗項目  | Figure<br>圖示   | Mode     | Allowable<br>容許值標準             | Worker(mm)<br>作業者      | QA(mm)<br>檢驗者          |
| Parallelism of the extension from spindle taper to Z-axis<br>主軸中心線與 z 軸移動平行度 |   | UX300    | X:0.008/300mm<br>Y:0.008/300mm | X-Z:0.004<br>Y-Z:0.004 | X-Z:0.005<br>Y-Z:0.004 |
|  |  | MV204CU  |                                |                        |                        |
|  |  | UX600    |                                |                        |                        |
|  |  | UX500Dyn |                                |                        |                        |
|  |  | UX730Dyn |                                |                        |                        |
| Run-out of the extension from spindle taper<br>主軸錐孔延伸偏擺                      |   | UX300    | a:0.004/300mm<br>b:0.012/300mm | A:0.002<br>B:0.008     | A:0.002<br>B:0.008     |
|  |  | MV204CU  |                                |                        |                        |
|  |  | UX600    |                                |                        |                        |
|  |  | UX500Dyn |                                |                        |                        |
|  |  | UX730Dyn |                                |                        |                        |
| Squariness 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                | <br>$H_1 - H_2 = \frac{(mx+my) - (mx'+my')}{2}$ | 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<br>檢驗項目                             | Figure<br>圖示 | Mode        | Allowable<br>容許值標準 | Worker(mm)<br>作業者 | QA(mm)<br>檢驗者 |
| 使用平尺量測<br>y 向旋轉變異                                   |              | U 型機全機<br>種 | 0.01/300mm         | 0.008             | 0.008         |
| 使用 300mm 長<br>之試棒 0 度                               |              | U 型機全機<br>種 | 0.01/300mm         | 0.009             | 0.009         |
| C axis deflect during clamp/unclamp<br>C 軸鬆/夾刀時的偏移量 |              | U 型機全機<br>種 | 0.004              |                   | 0.004         |
| C axis backlash BEFORE compensation<br>C 軸補償前背隙檢查   |              | U 型機全機<br>種 |                    |                   |               |
| A axis deflect during clamp/unclamp<br>A 軸鬆/夾刀時的偏移量 |              | U 型機全機<br>種 | 0.002              |                   | 0.002         |
| A axis backlash BEFORE compensation<br>A 軸補償前背隙檢查   |              | U 型機全機<br>種 |                    |                   |               |