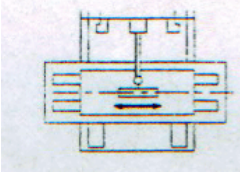
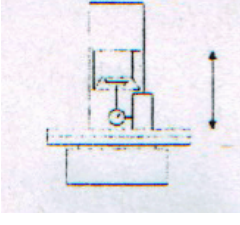
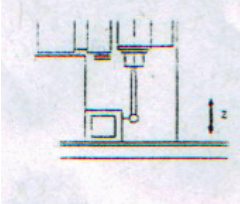
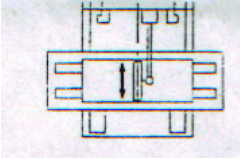
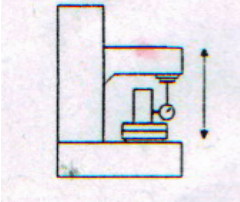
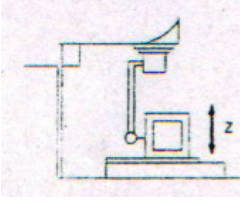
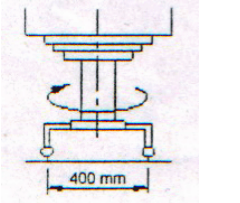
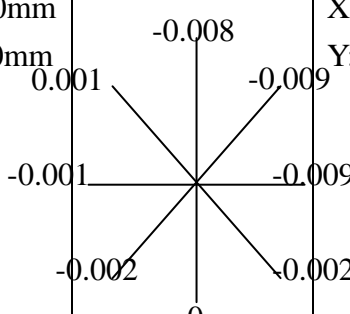
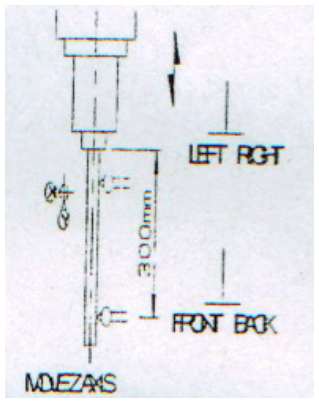
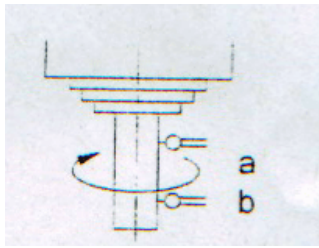
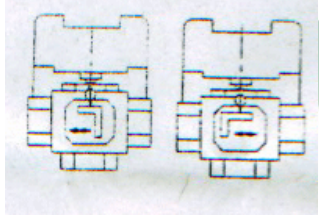
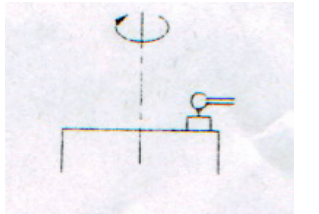
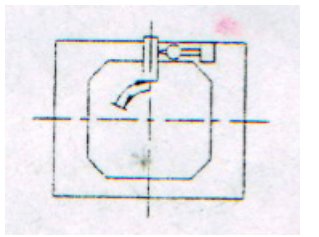
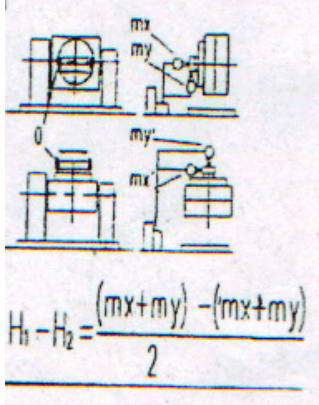
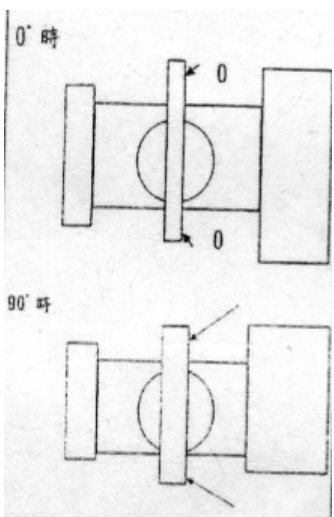
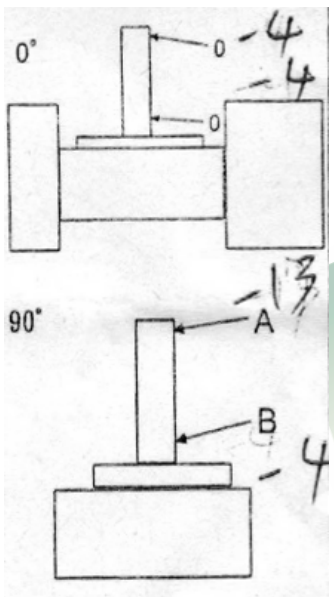


| 跑台前水平及幾何精度檢查 | | | | | |
|---|---|----------|--------------------------------|--|--------------------|
| Test conditions 檢驗項目 | Figure 圖示 | Mode | Allowable 容許值標準 | Worker(mm) 作業者 | QA(mm) 檢驗者 |
| Table movement straightness 工作 台移動真直度 (直角尺 X/Z 向) |  | UX300 | 0.01/400 mm | 0.005 | 0.008 |
| | | MV204CU | | | |
| | | 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 | | | |
| Squariness 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 |  | X:0.009 Y:0.009 |
| | | 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 Y:0.008/300mm | X-Z:0.004 Y-Z:0.004 | X-Z:0.005 Y-Z:0.004 |
| | | MV204CU | | | |
| | | UX600 | | | |
| | | UX500Dyn | | | |
| | | UX730Dyn | | | |
| Run-out of the extension from spindle taper 主軸錐孔延伸偏擺 |  | UX300 | a:0.004/300mm b:0.012/300mm | A:0.002 B:0.008 | A:0.002 B:0.008 |
| | | MV204CU | | | |
| | | UX600 | | | |
| | | UX500Dyn | | | |
| | | UX730Dyn | | | |
| Squareness 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 |
| | | | $H_1 - H_2 = \frac{(mx+my) - (mx'+my')}{2}$ | H1-H2=0.01 | 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 | | | |