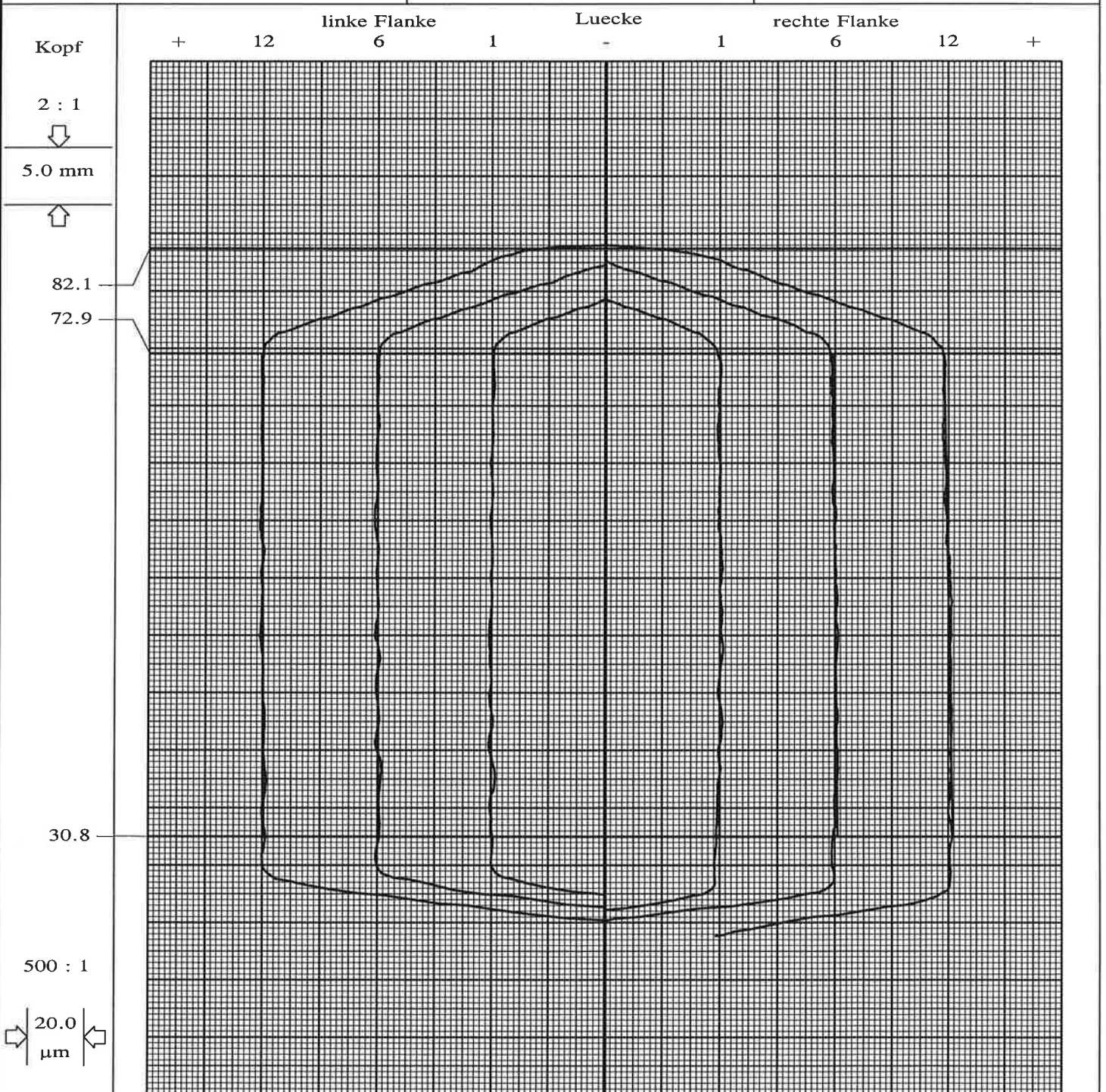


mega

STORK Technical Services B.V.				Flankenlinienprüfung								
A.Mn14-Z17				mn	14.0000	z	17					
SEAWAY PR.10798				alpha_n [Grad]	20.0000	beta [Grad]	0.0000					
Temp. Raum/Öl: 23.5 °C/20.2 °C				b [mm]	230.0000	db [mm]	223.6468					
Q-Soll: LF: 6 RF: 6				dfs [mm]	225.9493	da [mm]	277.4000					
Q-Ist: LF: 1 RF: 1				xm [mm]	6.7200	Taststift Ø [mm]	3.0					
29.03.2015 14:19 #687				Messkreis [mm]	251.440	Lß [%]	80.0/80.0					
oben 1 : 2 ↓ 20.0 mm ↑	linke Flanke Luecke rechte Flanke											
	+ 12 6 1 - 1 6 12 +											
	207.0											
	23.0											
500 : 1 ⇨ 20.0 μm ⇦												
unten	zul. Wert [μm] Q Q [μm] zul. Wert											
F_β	20.0	2.0	2.0	1.5	1 1	3.0	3.5	3.0	20.0			
f_fß	16.6	2.0	2.0	1.0	1 1	3.0	3.0	2.5	16.6			
f_Hß	11.1	-1.0	0.5	-0.5	1 1	0.0	-2.0	-1.0	11.1			
D = 5	Schieflage : 0.000 mm						Schieflage : -0.001 mm					
	Messlänge : 184.000 mm						Messlänge : 184.000 mm					

A.Mn14-Z17	mn	14.0000	z	17
SEAWAY PR.10798	alpha_n [Grad]	20.0000	beta [Grad]	0.0000
Temp. Raum/Öl: 23.5 °C/20.5 °C	b [mm]	230.0000	db [mm]	223.6468
Q-Soll: LF: 6 RF: 6	dfs [mm]	225.9493	da [mm]	277.4000
Q-Ist: LF: 1 RF: 2	xm [mm]	6.7200	Taststift Ø [mm]	3.0
29.03.2015 14:19 #687			Messhöhe [mm]	0.0



Fuss	zul. Wert				Q Q	zul. Wert			
	[μm]					[μm]			
F_a	22.0	2.5	2.5	2.5	1 1	2.5	3.0	3.5	22.0
f_fa	18.0	2.0	2.5	2.5	1 1	2.5	2.5	2.5	18.0
f_Ha	12.0	1.0	1.0	-0.5	1 2	0.0	-2.0	-3.0	12.0
D = 5	Schieflage : 0.001 mm					Schieflage : -0.002 mm			
	Messlänge : 42.076 mm					Messlänge : 42.076 mm			

STORK

Technical Services B.V.

T e i l u n g s p r ü f u n g

A.Mn14-Z17	mn	14.0000	z	17
SEAWAY PR.10798	alpha_n [Grad]	20.0000	beta [Grad]	0.0000
Temp. Raum/Öl: 23.5 °C/21.0 °C	b [mm]	230.0000	db [mm]	223.6468
Q-Soll: fp: 6 Fp: 6	dfs [mm]	225.9493	da [mm]	277.4000
Q-Ist: fp: 5 Fp: 3	xm [mm]	6.7200	Taststift Ø [mm]	3.0
29.03.2015 14:19 #687	Messkreis [mm]	251.4	Messhöhe [mm]	0.0

RF



20.0 µm



LF

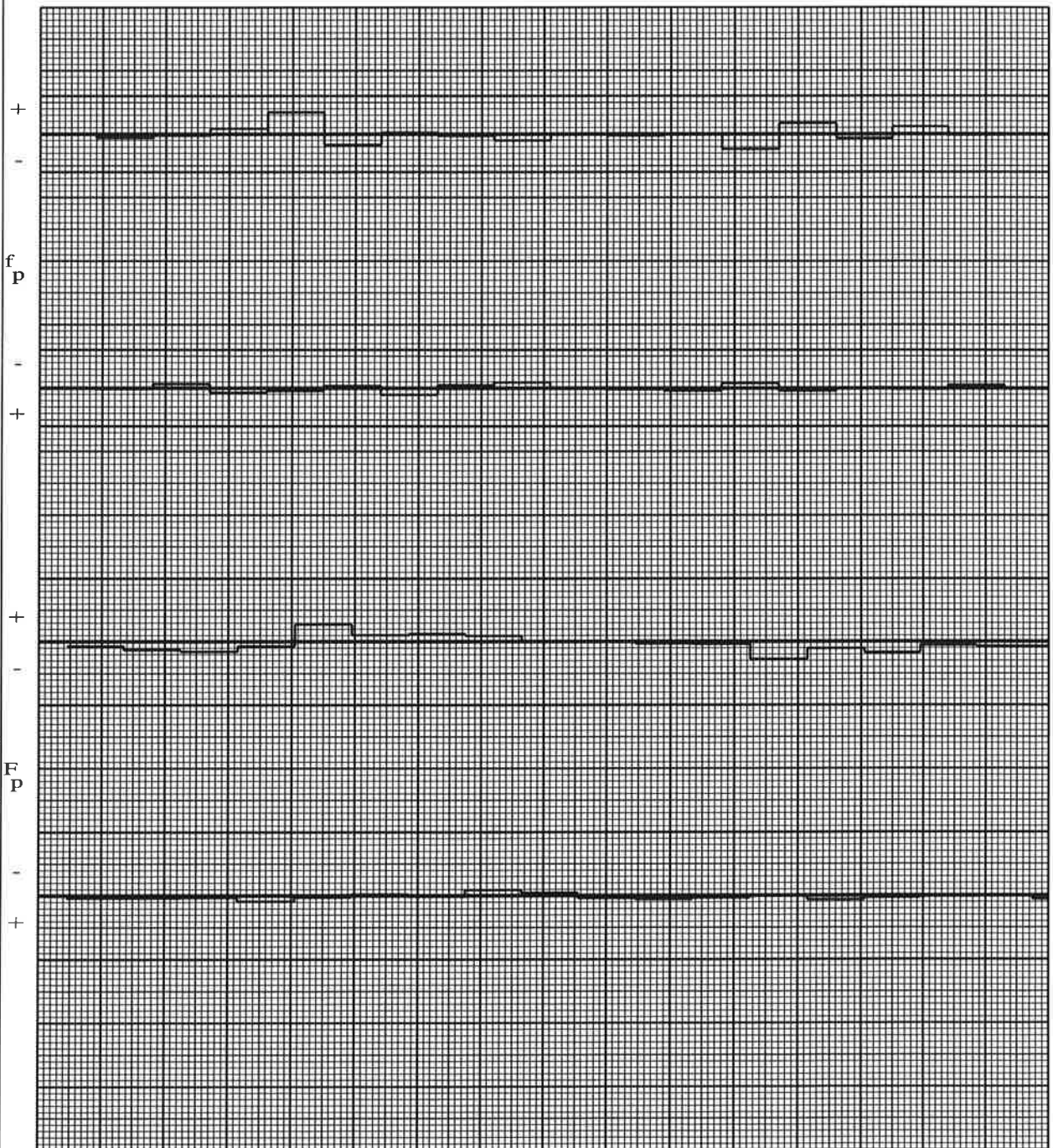
RF



20.0 µm



LF



zul. Wert [µm]

f_p	12.0	LF: 2.0	RF: 7.0
F_p	40.0	LF: 3.5	RF: 11.0