

Check Sheet Trial Ventilator Plate

Process : RALC & Robot KUKA

Art. : AY189.5108S

Setup Speed : 100

Released:

Program : D914_H140_SP2_1

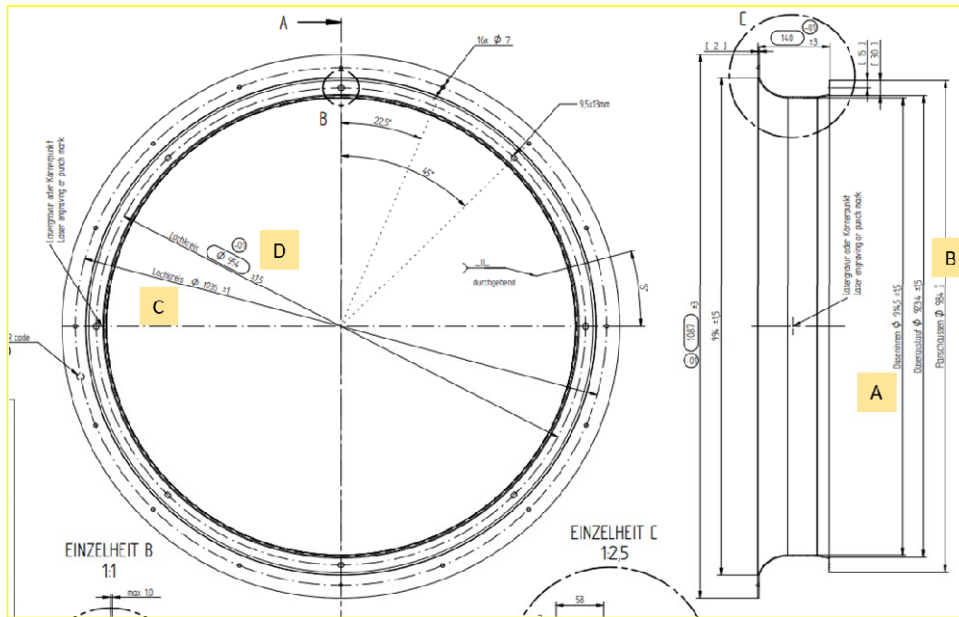
Material : BLS200

Setup Feed : 100

25-Aug-23

Observation Inside Diameter Fan Nozzle (yellow marking)

Dimensional check	Point	Sample 1	Sample 2	Sample 3	Sample 4	Sample 5	Sample 6	Sample 7	Judgement
A	A1	911.48	914.93	915.12	915.61	914.04	917.28	915.88	OK
	A2	914.84	916.93	915.18	916.63	915.07	914.91	913.94	
	A3	915.55	913.71	914.02	915.96	916.12	916.17	916.04	
	A4	914.09	915.43	915.43	913.72	915.94	912.88	916.09	
Std : 914.5 ±1.5	913.00 916.00	913.99	915.25	914.9	915.5	915.3	915.3	915.5	



Other dimensional check (blue marking)

Dimensional check	Point	Sample 1	Sample 2	Sample 3	Sample 4	Sample 5	Sample 6	Sample 7	Judgement	NOTE :
B	B1	989	984	980	986	986	983	984	OK Sample 2 - 7 (reprogram)	Sample 1 : NG caused program still using old setup (same Height 210 galvanize)
	B2	990	987	983	983	985	983	985		
	B3	990	983	983	984	985	987	984		
	B4	987	982	985	983	987	983	986		
Std : 984 ⁺³ ₋₂	982 987	989.00	984.00	982.8	984.0	985.8	984.0	984.8		
Dimensional check	Point	Sample 1	Sample 2	Sample 3	Sample 4	Sample 5	Sample 6	Sample 7	Judgement	Prepared :
C	C1	1035	1035	1035	1035	1035	1034	1035	OK	
	C2	1035	1035	1034	1034	1035	1034	1034		
	C3	1036	1035	1034	1034	1034	1035	1035		
	C4	1034	1035	1035	1035	1036	1035	1035		
Std : 1035 ±1	1034 1036	1035.0	1035.0	1034.5	1034.5	1035.0	1034.5	1034.8		Checked :
Dimensional check	Point	Sample 1	Sample 2	Sample 3	Sample 4	Sample 5	Sample 6	Sample 7	Judgement	Approved :
D	D1	955	953	954	955	954	954	954	OK Sample 2 - 7 (reprogram)	
	D2	957	954	953	954	953	954	955		
	D3	957	955	955	955	955	957	955		
	D4	956	954	954	954	955	954	954		
Std : 954 ±1.5	952.5 955.5	956.25	954.00	954.0	954.5	954.3	954.8	954.5		