

# HEIDENHAIN ACCOM

Customer:

Type of machine: Pyramid Nano  
SNr. / Year of mnf.: 778 / 2011  
Reference meas. system / IDNo. / SrNo.: KGM 102 / 365 251-01 / 21 131 892

Position of axis:

X: 147.0000 mm Y: 407.0000 mm Z: -32.0000 mm  
IV: 0.0000 mm V: 0.0000 mm

Measuring method: KGK

File name: KreisXY1.KGK

Measuring plane: XY

Nominal radius: 30 mm

Starting angle: 30 Degree

Measuring points: 998

Feed rate: 500 mm/min

Measuring angle: 360 Degree

Direction of rot.: CW

## Characteristic data of the measurement according to ISO 230-4

Circular deviation G <sub>yx</sub> :	0.0019 mm
Circular deviation G <sub>xy</sub> :	0.0018 mm (KreisXY.KGK)
Bi-directional circular deviation G(b)xy:	0.0021 mm KreisXY1.KGK / KreisXY.KGK
radial deviation F <sub>yx</sub> min:	-0.0008 mm
radial deviation F <sub>yx</sub> max:	0.0016 mm
Mean bi-directional radial deviation D <sub>xy</sub> :	0.0000 mm KreisXY1.KGK / KreisXY.KGK

Mean feed rate: 487.5385 mm/min

Mean Radius: 30.0001 mm

Backlash: X+: 0.0002 mm X-: -0.0004 mm  
Y+: -0.0002 mm Y-: 0.0001 mm

Reversal spikes: X+: 0.0004 mm X-: 0.0007 mm  
Y+: 0.0012 mm Y-: 0.0012 mm

Centre point comp. value: X: -0.0004 mm Y: -0.0003 mm

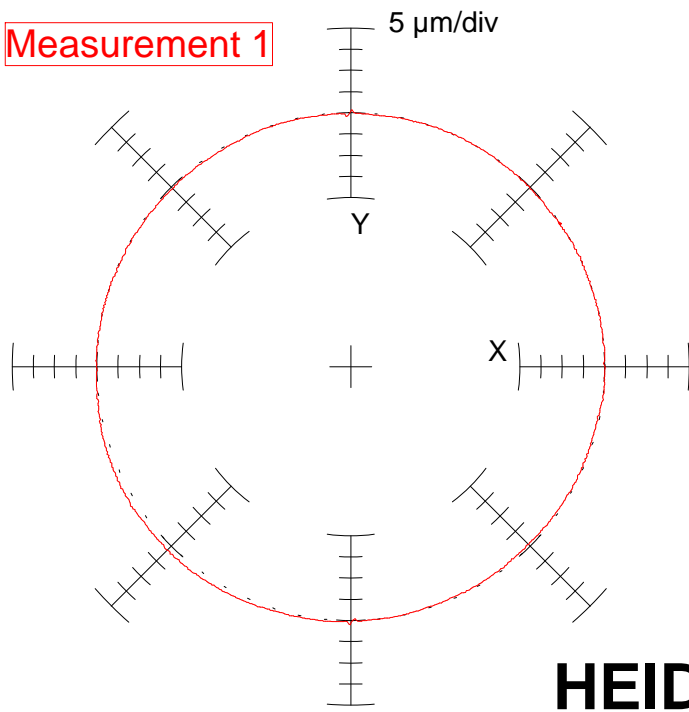
Squareness: 37.7531 µm/m

Axis length difference: X is 0.000 % longer as Y

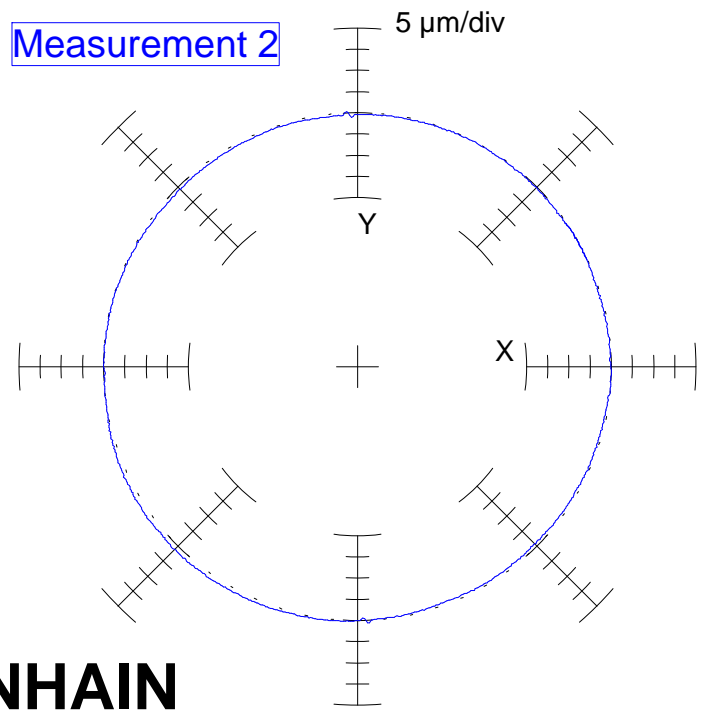
Date/Time: 10:34:13

Inspector:

Measurement 1

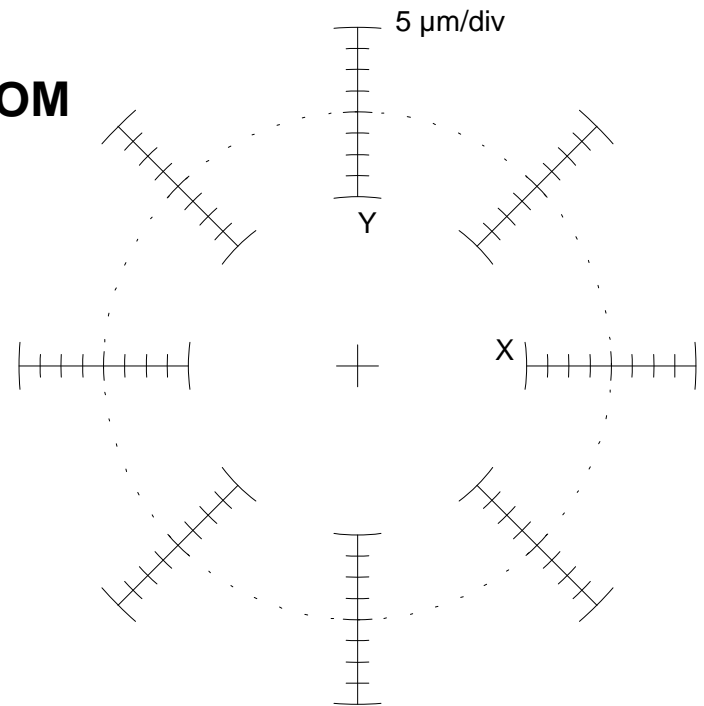
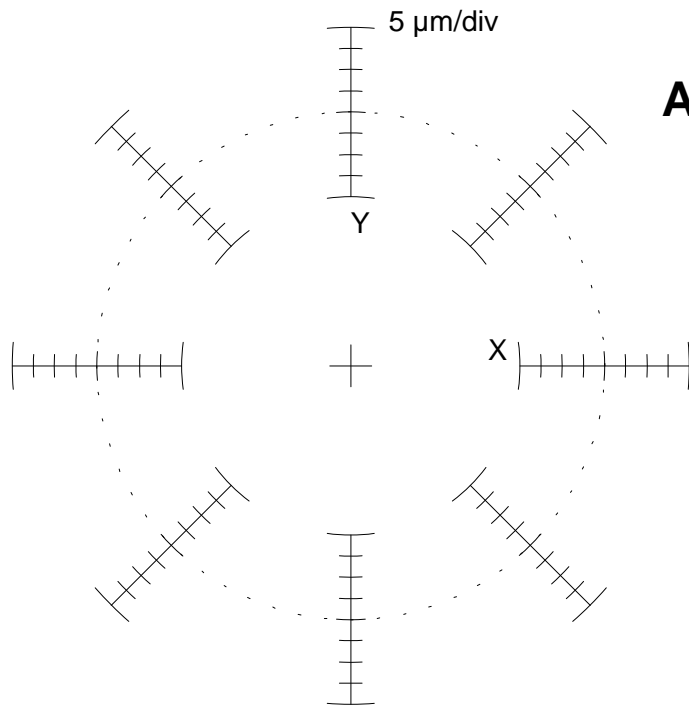


Measurement 2



HEIDENHAIN

ACCOM



Measurement 1: KreisXY1.KGK  
 Type of machine: Pyramid Nano  
 SrNo. / Year of mnf.: 778 / 2011  
 Remark:

Date/Time: 10:34:13

Excentricity:  
 Radius: 30 mm  
 Feed rate: 500 mm/min  
 Start / Meas. angle: 30 / 360 Degree  
 Direction of rot.: CW  
 Measuring plane: XY  
 Inspector:

Measurement 2: KreisXY.KGK  
 Type of machine: Pyramid Nano  
 SrNo. / Year of mnf.: 778 / 2011  
 Remark:

Date/Time: 10:33:33

Excentricity:  
 Radius: 30 mm  
 Feed rate: 500 mm/min  
 Start / Meas. angle: 30 / 360 Degree  
 Direction of rot.: CCW  
 Measuring plane: XY  
 Inspector: