

# WIAP MEMV® Diagramm 2016 3 D 2. Position

|                              |  |               |          |                        |  |                       |  |
|------------------------------|--|---------------|----------|------------------------|--|-----------------------|--|
| Werkst. Name ; WS04 Haeusler |  | Schweisskonst |          | Dimension              |  | 800 x 850 x12000 mm   |  |
| Werkstück Gewicht            |  | 22000         | Excenter | Entspannungsanlage Typ |  | Wiap LC20             |  |
| Werkstueckname Schwert       |  | RPM           | Stufe %  | Energie/ N             |  | Erreger Energie % / N |  |
| Drehzahl 0 Grad              |  |               |          |                        |  |                       |  |
| Drehzahl 3. Achse            |  | 4100          | 80       | 6800                   |  | 3717.33               |  |



|       |                |                    |        |        |
|-------|----------------|--------------------|--------|--------|
| Achse | O=Oben U=Unten | V=Vorher N= Nachhe | Anlage | Anlage |
|       |                |                    | 0      | 45/90  |
|       |                |                    | Grad   | Grad   |
|       |                |                    | m/2 s  |        |
| X     | O              | V                  |        | 26.9   |
| X     | O              | N                  |        | 46.1   |
| X     | U              | V                  |        | 2.4    |
| X     | U              | N                  |        | 4.2    |

|   |   |   |  |      |
|---|---|---|--|------|
| X | O | V |  | 14.2 |
| X | O | N |  | 24.1 |
| X | U | V |  | 3.8  |
| X | U | N |  | 6.2  |

|   |   |   |  |      |
|---|---|---|--|------|
| X | O | V |  | 38.3 |
| X | O | N |  | 57.7 |
| X | U | V |  | 0.01 |
| X | U | N |  | 1    |

|   |   |   |  |      |
|---|---|---|--|------|
| X | O | V |  | 34.2 |
| X | O | N |  | 42.5 |
| X | U | V |  | 2.4  |
| X | U | N |  | 2.9  |

|   |    |   |  |   |
|---|----|---|--|---|
| Z | LO | V |  | 4 |
| Z | LO | N |  | 6 |
| Z |    |   |  |   |
| Z |    |   |  |   |

|   |    |   |     |      |
|---|----|---|-----|------|
| Z | LU | V |     | 0.07 |
| Z | LU | N | 1.9 | 0.09 |
| Z |    |   |     |      |
| Z |    |   |     |      |

|       |                    |                    |        |        |
|-------|--------------------|--------------------|--------|--------|
| Achse | L= Links R= Rechts | V=Vorher N= Nachhe | Anlage | Anlage |
|       |                    |                    | 0      | 45/90  |
|       |                    |                    | Grad   | Grad   |
|       |                    |                    | m s/2  |        |
| Y     | L                  | V                  |        | 2.3    |
| Y     | L                  | N                  |        | 3      |
| Y     | R                  | V                  |        |        |
| Y     | R                  | N                  |        |        |

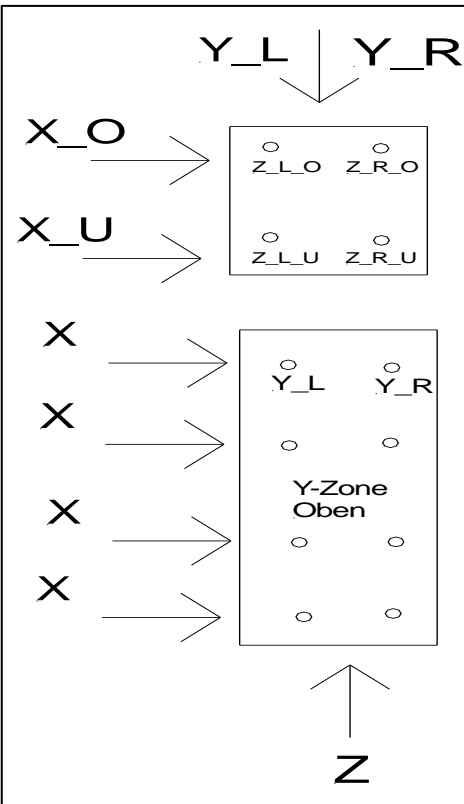
|   |   |   |  |      |
|---|---|---|--|------|
| Y | L | V |  | 0.06 |
| Y | L | N |  | 2.6  |
| Y | R | V |  |      |
| Y | R | N |  |      |

|   |   |   |  |      |
|---|---|---|--|------|
| Y | L | V |  | 0.02 |
| Y | L | N |  | 2.3  |
| Y | R | V |  |      |
| Y | R | N |  |      |

|   |   |   |  |     |
|---|---|---|--|-----|
| Y | L | V |  | 2.3 |
| Y | L | N |  | 3.4 |
| Y | R | V |  |     |
| Y | R | N |  |     |

|   |    |   |  |  |
|---|----|---|--|--|
| Z | RO | V |  |  |
| Z | RO | N |  |  |
| Z |    |   |  |  |
| Z |    |   |  |  |

|   |    |   |  |  |
|---|----|---|--|--|
| Z | RU | V |  |  |
| Z | RU | N |  |  |
| Z |    |   |  |  |
| Z |    |   |  |  |



# WIAP MEMV® Diagramm 2016 3 D

| <u>X Achse</u>               |   |   |   |   |   |
|------------------------------|---|---|---|---|---|
| X Achse oben 0 Grad vorher   | 0 | 0 | 0 | 0 |   |
| X Achse oben 0 Grad nachher  | 0 | 0 | 0 | 0 |   |
| Differenz oben               | 0 | 0 | 0 | 0 | 0 |
| X Achse unten 0 Grad vorher  | 0 | 0 | 0 | 0 |   |
| X Achse unten 0 Grad nachher | 0 | 0 | 0 | 0 |   |
| Differenz unten              | 0 | 0 | 0 | 0 | 0 |

|                                |      |      |      |      |      |
|--------------------------------|------|------|------|------|------|
| X Achse oben 3. Achse vorher   | 26.9 | 14.2 | 38.3 | 34.2 |      |
| X Achse oben 3. Achse nachher  | 46.1 | 24.1 | 57.7 | 42.5 |      |
| Differenz oben                 | 19.2 | 9.9  | 19.4 | 8.3  | 56.8 |
| X Achse unten 3 Achse vorher   | 2.4  | 3.8  | 0.01 | 2.4  |      |
| X Achse unten 3. Achse nachher | 4.2  | 6.2  | 1    | 2.9  |      |
| Differenz unten                | 1.8  | 2.4  | 0.99 | 0.5  | 5.69 |

| <u>Y Achse</u>                  |     |      |      |     |      |
|---------------------------------|-----|------|------|-----|------|
| Y Achse links 0 Grad vorher     | 0   | 0    | 0    | 0   |      |
| Y Achse links 0 Grad nachher    | 0   | 0    | 0    | 0   |      |
| Differenz oben                  | 0   | 0    | 0    | 0   | 0    |
| Y Achse links 3. Achse vorher   | 2.3 | 0.06 | 0.02 | 2.3 |      |
| Y Achse links 3. Achse nachher  | 3   | 2.6  | 2.3  | 3.4 |      |
| Differenz unten                 | 0.7 | 2.54 | 2.28 | 1.1 | 6.62 |
| Y Achse rechts 0 Grad vorher    | 0   | 0    | 0    | 0   |      |
| Y Achse rechts 0 0 Grad nachher | 0   | 0    | 0    | 0   |      |
| Differenz oben                  | 0   | 0    | 0    | 0   | 0    |
| Y Achse rechts 3. Achse vorher  | 0   | 0    | 0    | 0   |      |
| Y Achse rechts 3. Achse nachher | 0   | 0    | 0    | 0   |      |
| Differenz unten                 | 0   | 0    | 0    | 0   | 0    |

| <u>Z Achse</u>                      |   |      |   |   |      |
|-------------------------------------|---|------|---|---|------|
| Z Achse oben links 0 Grad vorher    | 0 | 0    | 0 | 0 |      |
| Z Achse oben links 0 Grad nachher   | 0 | 1.9  | 0 | 0 |      |
| Differenz oben                      | 0 | 1.9  | 0 | 0 | 1.9  |
| Z Achse oben links 3 Achse          | 4 | 0.07 | 0 | 0 |      |
| Z Achse oben links 3. Achse nachher | 6 | 0.09 | 0 | 0 |      |
| Differenz unten                     | 2 | 0.02 | 0 | 0 | 2.02 |
|                                     |   |      |   |   | 0    |
|                                     |   |      |   |   | 0    |

|                               |       |       |
|-------------------------------|-------|-------|
| Veränderung Total 0 Grad      | 1.9   | m s/2 |
| Veränderung Total 3. Achse    | 71.13 | m s/2 |
| Total Veränderung             | 73.03 | m s/2 |
| Total Anzahl Messpunkte       |       |       |
| Vermessen an diesem Werkstück |       |       |

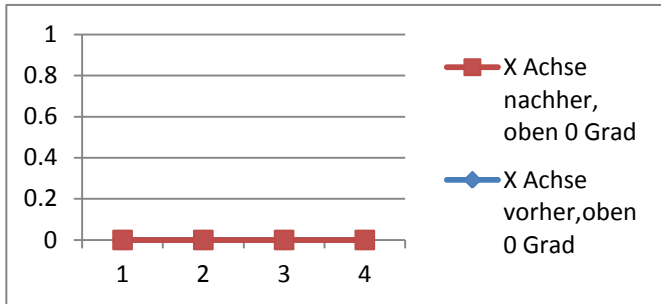
# WIAP MEMV® Diagramm 2016 3 D

## X Achse oben 0 Grad

Differenz Verschiebung

0

m s/2

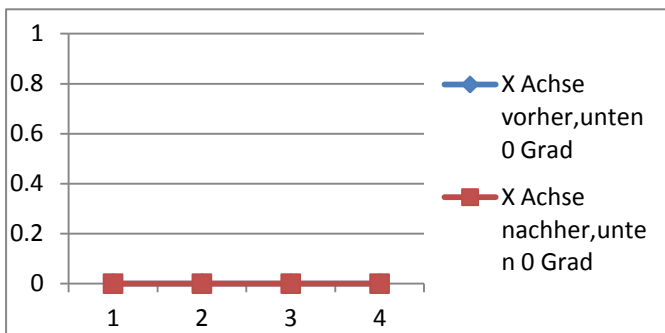


## X Achse unten 0 Grad

Differenz Verschiebung

0

m s/2

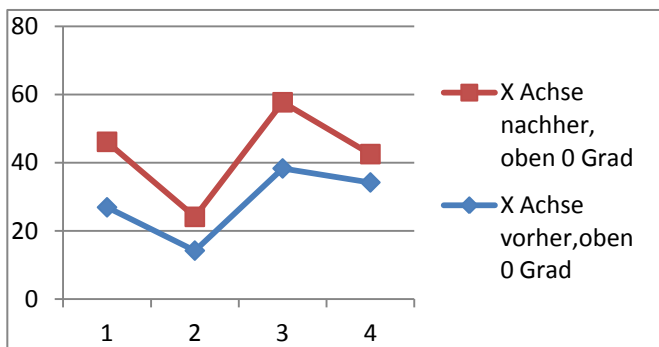


## X Achse Oben 3. Achse

Differenz Verschiebung

56.8

m s/2

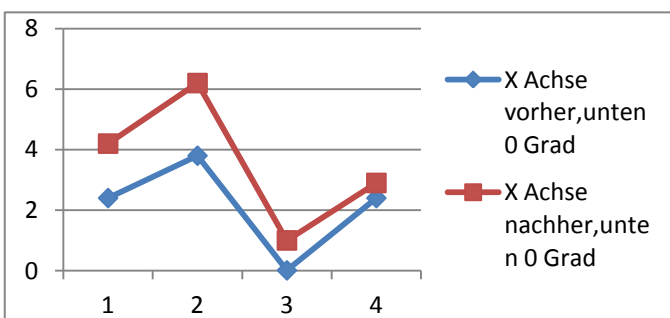


## X Achse unten 3. Achse

Differenz Verschiebung

5.69

m s/2



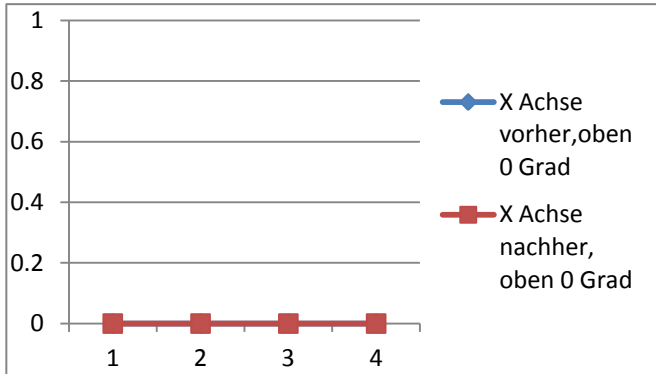
# WIAP MEMV® Diagramm 2016 3 D

**Y Achse 0 links Grad**

Differenz Verschiebung

0

m s/2

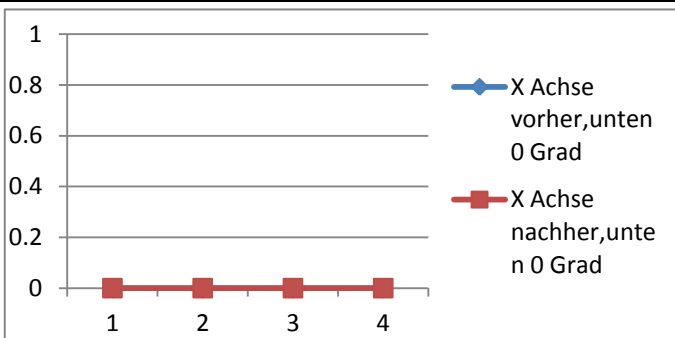


**Y Achse 0 rechts Grad**

Differenz Verschiebung

0

m s/2

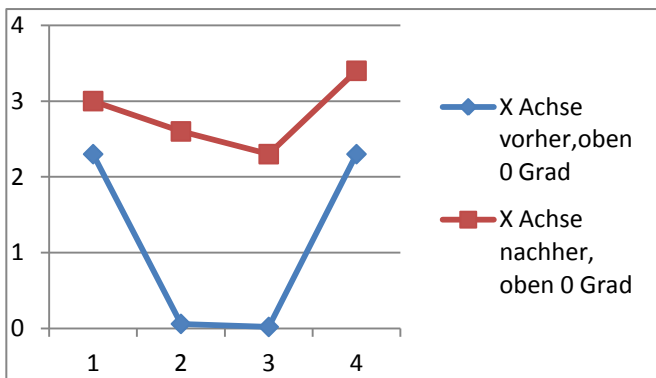


**Y Achse links 3. Achse**

Differenz Verschiebung

6.62

m s/2

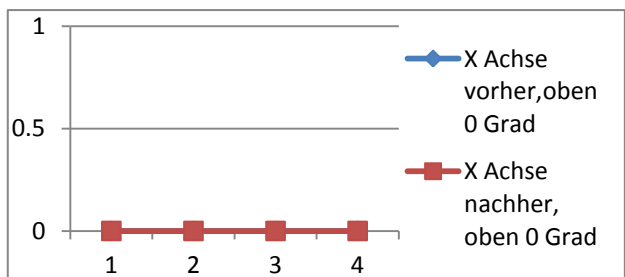


**Y Achse rechts 3. Achse**

Differenz Verschiebung

0

m s/2



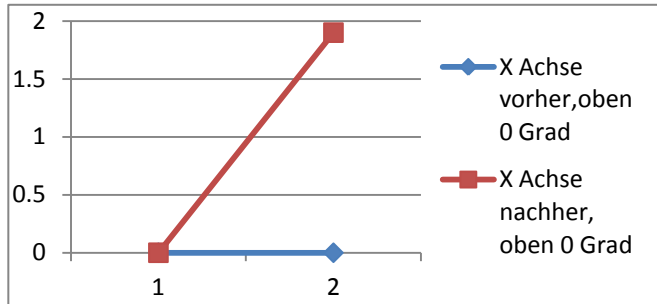
# WIAP MEMV® Diagramm 2016 3 D

**Z Achse 0 Grad**

Differenz Verschiebung

1.9

m s/2

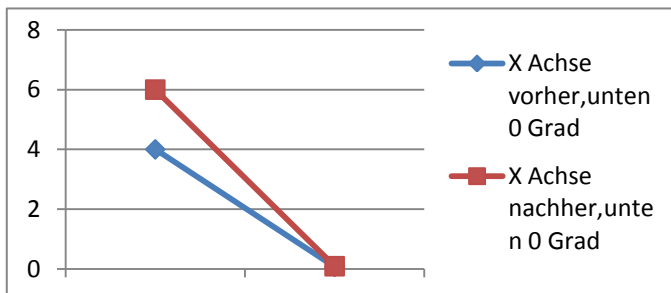


**Z Achse 3. Achse**

Differenz Verschiebung

2.02

m s/2



# WIAP MEMV® Diagramm 2016 3 D

## Exzenter Erreger Tabelle WIAP LC System 100%

| Drehzahl | Einzel           | Doppel  | Einzel             | Doppel  | Einzel             | Doppel  | Einzel               | Doppel  | Einzel               | Doppel  |
|----------|------------------|---------|--------------------|---------|--------------------|---------|----------------------|---------|----------------------|---------|
|          | Scheibe          | Scheibe | Scheibe            | Scheibe | Scheibe            | Scheibe | Scheibe              | Scheibe | Scheibe              | Scheibe |
|          | LC05 bis 5 Tonne |         | LC20 bis 20 Tonnen |         | LC50 bis 50 Tonnen |         | LC100 bis 100 Tonnen |         | LC200 bis 200 Tonnen |         |
| RPM      | N                |         | N                  |         | N                  |         | N                    |         | N                    |         |
| 1000     | 55               | 110     | 209                | 418     | 418                | 836     | 1045                 | 2090    | 2090                 | 4180    |
| 1500     | 124              | 248     | 470                | 940     | 940                | 1880    | 2352                 | 4704    | 4704                 | 9408    |
| 2000     | 220              | 440     | 836                | 1672    | 1672               | 3344    | 4181                 | 8362    | 8362                 | 16724   |
| 2500     | 345              | 690     | 1306               | 2612    | 2612               | 5224    | 6533                 | 13066   | 13066                | 26132   |
| 3000     | 497              | 994     | 1881               | 3762    | 3762               | 7524    | 9407                 | 18814   | 18814                | 37628   |
| 3500     | 676              | 1352    | 2561               | 5122    | 5122               | 10244   | 12805                | 25610   | 25610                | 51220   |
| 4000     | 883              | 1766    | 3344               | 6688    | 6688               | 13376   | 16725                | 33450   | 33450                | 66900   |
| 4500     | 1118             | 2236    | 4233               | 8466    | 8466               | 16932   | 21167                | 42334   | 42334                | 84668   |
| 5000     | 1380             | 2760    | 5226               | 10452   | 10452              | 20904   | 26132                | 52264   | 52264                | 104528  |
| 5500     | 1670             | 3340    | 6324               | 12648   | 12648              | 25296   | 31620                | 63240   | 63240                | 126480  |
| 6000     | 1988             | 3976    | 7526               | 15052   | 15052              | 30104   | 37630                | 75260   | 75260                | 150520  |
| 6500     | 2333             | 4666    | 8832               | 17664   | 17664              | 35328   | 44164                | 88328   | 88328                | 176656  |
| 7000     | 2706             | 5412    | 10244              | 20488   | 20488              | 40976   | 51219                | 102438  | 102438               | 204876  |