

|  |   |  |
|--|---|--|
| DE=  | EN=                                     |  |
| <b>Metall entspannen mit Vibration 1/3</b> | <b>Stress relief with Vibration 1/3</b> | <b>Wiap AG LTd SA , <a href="http://www.wiap.ch">www.wiap.ch</a></b> |

|            |        |         |
|------------|--------|---------|
|            | Vorher | Nachher |
| <b>Y12</b> | 7.2    | 7.1     |

|            |        |         |
|------------|--------|---------|
|            | Vorher | Nachher |
| <b>Y02</b> | 10.1   | 10.5    |

|            |        |         |
|------------|--------|---------|
|            | Vorher | Nachher |
| <b>Y03</b> | 7.2    | 7.1     |

|            |        |         |
|------------|--------|---------|
|            | Vorher | Nachher |
| <b>Y04</b> | 11.6   | 11.8    |

|            |        |         |
|------------|--------|---------|
|            | Vorher | Nachher |
| <b>Y06</b> | 12     | 11.8    |

|            |        |         |
|------------|--------|---------|
|            | Vorher | Nachher |
| <b>Y08</b> | 12     | 15.2    |

|            |        |         |
|------------|--------|---------|
|            | Vorher | Nachher |
| <b>Y09</b> | 9.6    | 8.9     |

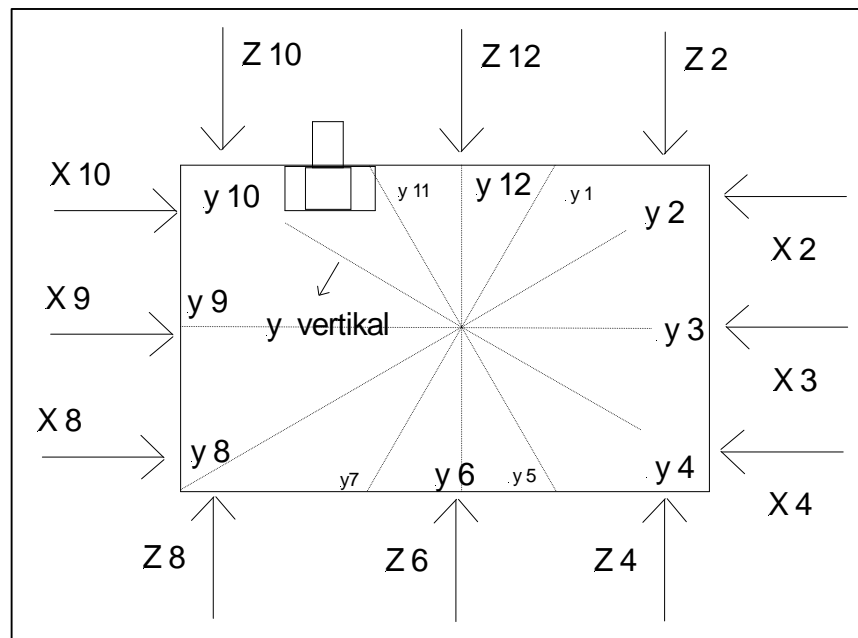
|            |        |         |
|------------|--------|---------|
|            | Vorher | Nachher |
| <b>Y10</b> | 6.3    | 6.3     |

|     |       |        |         |
|-----|-------|--------|---------|
|     |       | Vorher | Nachher |
| Z10 | oben  | 4.00   | 4.10    |
|     | unten | 1.00   | 0.07    |

|     |       |        |         |
|-----|-------|--------|---------|
|     |       | Vorher | Nachher |
| Z12 | oben  | 4.00   | 4.10    |
|     | unten | 1.00   | 0.07    |

|     |       |        |         |
|-----|-------|--------|---------|
|     |       | Vorher | Nachher |
| Z02 | oben  | 4.00   | 4.10    |
|     | unten | 1.00   | 0.07    |

|     |       |        |         |
|-----|-------|--------|---------|
|     |       | Vorher | Nachher |
| X10 | oben  | 18.70  | 19.10   |
|     | unten | 18.70  | 19.10   |



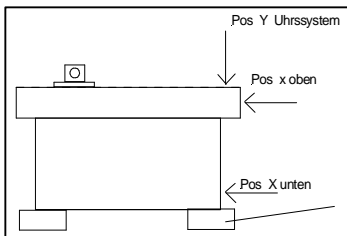
|     |       |        |         |
|-----|-------|--------|---------|
|     |       | Vorher | Nachher |
| X02 | oben  | 9.50   | 9.10    |
|     | unten | 14.00  | 13.60   |

|     |       |        |         |
|-----|-------|--------|---------|
|     |       | Vorher | Nachher |
| X09 | oben  | 17.40  | 18.10   |
|     | unten | 17.40  | 18.10   |

|     |       |        |         |
|-----|-------|--------|---------|
|     |       | Vorher | Nachher |
| X03 | oben  | 12.20  | 12.20   |
|     | unten | 3.90   | 3.20    |

|     |       |        |         |
|-----|-------|--------|---------|
|     |       | Vorher | Nachher |
| X08 | oben  | 17.40  | 18.10   |
|     | unten | 17.40  | 18.10   |

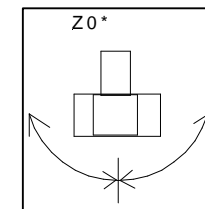
|     |       |        |         |
|-----|-------|--------|---------|
|     |       | Vorher | Nachher |
| X04 | oben  | 9.30   | 9.40    |
|     | unten | 12.30  | 12.50   |



|     |       |        |         |
|-----|-------|--------|---------|
|     |       | Vorher | Nachher |
| Z08 | oben  | 0.00   | 0.00    |
|     | unten | 0.00   | 0.00    |

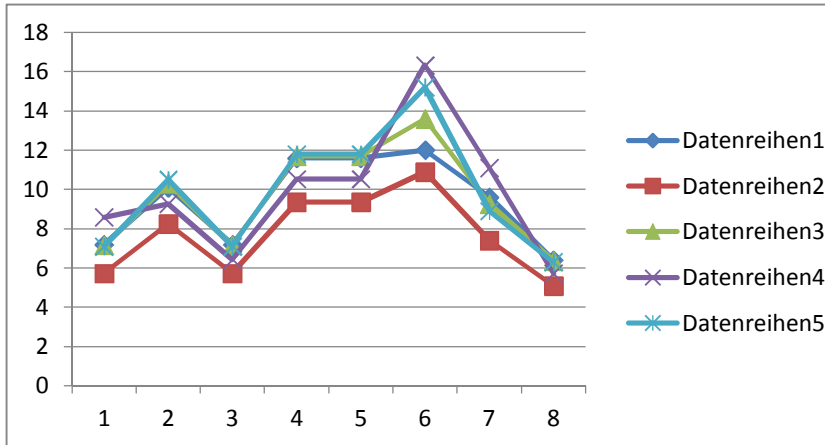
|     |       |        |         |
|-----|-------|--------|---------|
|     |       | Vorher | Nachher |
| Z06 | oben  | 0.00   | 0.00    |
|     | unten | 0.00   | 0.00    |

|     |       |        |         |
|-----|-------|--------|---------|
|     |       | Vorher | Nachher |
| Z04 | oben  | 0.00   | 0.00    |
|     | unten | 0.00   | 0.00    |



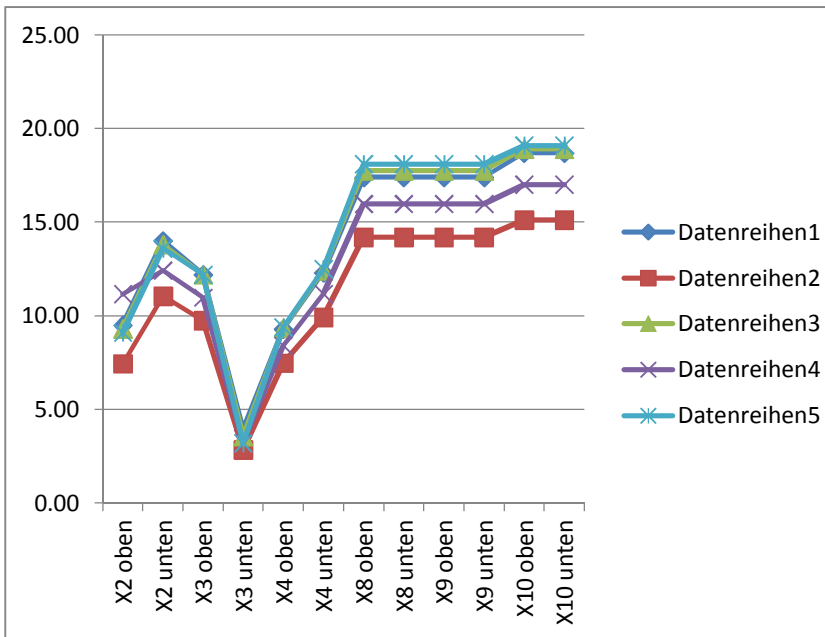
|             |              |           |          |  |                |         |     |
|-------------|--------------|-----------|----------|--|----------------|---------|-----|
| Werkstück   | Best.140698  | Kunde     | Diethelm |  | Excenter Stufe |         | %   |
| Zchn Nr.    | Protokoll x1 | Zuständig | Drehzahl |  | Vorher         | Nachher | Amp |
| Auftrags Nr |              | Operateur | Datum    |  | Motor Strom    |         | Amp |

| Y Achse |      |       |      |       |      |
|---------|------|-------|------|-------|------|
| Y12     | 7.2  | 5.72  | 7.15 | 8.58  | 7.1  |
| Y02     | 10.1 | 8.24  | 10.3 | 9.27  | 10.5 |
| Y03     | 7.2  | 5.72  | 7.15 | 6.435 | 7.1  |
| Y04     | 11.6 | 9.36  | 11.7 | 10.53 | 11.8 |
| Y06     | 11.6 | 9.36  | 11.7 | 10.53 | 11.8 |
| Y08     | 12   | 10.88 | 13.6 | 16.32 | 15.2 |
| Y09     | 9.6  | 7.4   | 9.25 | 11.1  | 8.9  |
| Y10     | 6.4  | 5.08  | 6.35 | 5.715 | 6.3  |



| Y   | MM   | %      |
|-----|------|--------|
| Y12 | -0.1 | -1.748 |
| Y02 | 0.4  | 4.854  |
| Y03 | -0.1 | -1.748 |
| Y04 | 0.2  | 2.137  |
| Y06 | 0.2  | 2.137  |
| Y08 | 3.2  | 29.41  |
| Y09 | -0.7 | -9.459 |
| Y10 | -0.1 | -1.969 |

| X Achse   |       |       |       |       |       |
|-----------|-------|-------|-------|-------|-------|
| X2 oben   | 9.50  | 7.44  | 9.3   | 11.16 | 9.10  |
| X2 unten  | 14.00 | 11.04 | 13.8  | 12.42 | 13.60 |
| X3 oben   | 12.20 | 9.76  | 12.2  | 10.98 | 12.20 |
| X3 unten  | 3.90  | 2.84  | 3.55  | 3.195 | 3.20  |
| X4 oben   | 9.30  | 7.48  | 9.35  | 8.415 | 9.40  |
| X4 unten  | 12.30 | 9.92  | 12.4  | 11.16 | 12.50 |
| X8 oben   | 17.40 | 14.2  | 17.75 | 15.98 | 18.10 |
| X8 unten  | 17.40 | 14.2  | 17.75 | 15.98 | 18.10 |
| X9 oben   | 17.40 | 14.2  | 17.75 | 15.98 | 18.10 |
| X9 unten  | 17.40 | 14.2  | 17.75 | 15.98 | 18.10 |
| X10 oben  | 18.70 | 15.12 | 18.9  | 17.01 | 19.10 |
| X10 unten | 18.70 | 15.12 | 18.9  | 17.01 | 19.10 |



| X         | MM   | %      |
|-----------|------|--------|
| X2 oben   | -0.4 | -5.376 |
| X2 unten  | -0.4 | -3.623 |
| X3 oben   | 0    | 0      |
| X3 unten  | -0.7 | -24.65 |
| X4 oben   | 0.1  | 1.337  |
| X4 unten  | 0.2  | 2.016  |
| X8 oben   | 0.7  | 4.93   |
| X8 unten  | 0.7  | 4.93   |
| X9 oben   | 0.7  | 4.93   |
| X9 unten  | 0.7  | 4.93   |
| X10 oben  | 0.4  | 2.646  |
| X10 unten | 0.4  | 2.646  |

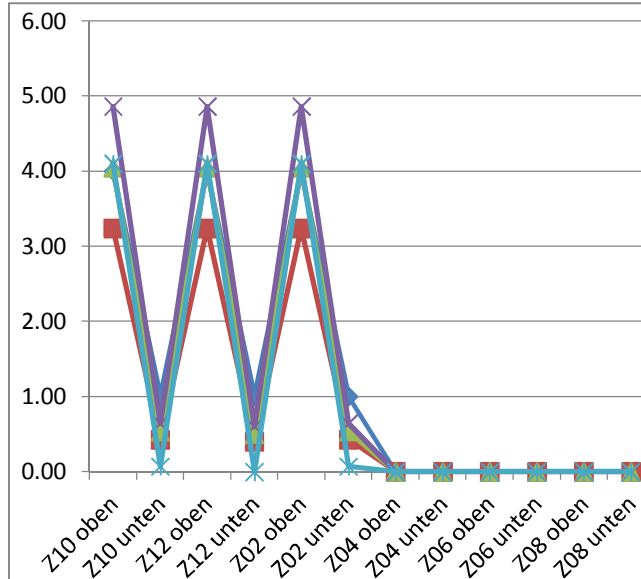
|             |  |           |  |                |  |                    |
|-------------|--|-----------|--|----------------|--|--------------------|
| Werkstück   |  | Kunde     |  | Excenter Stufe |  | %                  |
| Zchn Nr.    |  | Zuständig |  | Drehzahl       |  | Vorher Nachher Amp |
| Auftrags Nr |  | Operateur |  | Datum          |  | Motor Strom Amp    |
| DE=         |  | EN=       |  |                |  |                    |

Metall entspannen mit Vibration 3/3

Stress relief with Vibration 3/3

Wiap AG Ltd SA , [www.wiap.ch](http://www.wiap.ch)

| Z Achse   |      |       |       |       |      |
|-----------|------|-------|-------|-------|------|
| Z10 oben  | 4.00 | 3.24  | 4.05  | 4.86  | 4.10 |
| Z10 unten | 1.00 | 0.428 | 0.535 | 0.642 | 0.07 |
| Z12 oben  | 4.00 | 3.24  | 4.05  | 4.86  | 4.10 |
| Z12 unten | 1.00 | 0.4   | 0.5   | 0.6   | 0.00 |
| Z02 oben  | 4.00 | 3.24  | 4.05  | 4.86  | 4.10 |
| Z02 unten | 1.00 | 0.428 | 0.535 | 0.642 | 0.07 |
| Z04 oben  | 0.00 | 0.00  | 0     | 0     | 0.00 |
| Z04 unten | 0.00 | 0.00  | 0     | 0     | 0.00 |
| Z06 oben  | 0.00 | 0     | 0     | 0     | 0.00 |
| Z06 unten | 0.00 | 0     | 0     | 0     | 0.00 |
| Z08 oben  | 0.00 | 0     | 0     | 0     | 0.00 |
| Z08 unten | 0.00 | 0     | 0     | 0     | 0.00 |



- ◆— Datenreihen1
- Datenreihen2
- ▲— Datenreihen3
- ×— Datenreihen4
- \*— Datenreihen5

| Z         | MM    | %      |
|-----------|-------|--------|
| Z10 oben  | 0.1   | 3.086  |
| Z10 unten | -0.93 | -217.3 |
| Z12 oben  | 0.1   | 3.086  |
| Z12 unten | -1    | -250   |
| Z02 oben  | 0.1   | 3.086  |
| Z02 unten | -0.93 | -217.3 |
| Z04 oben  | 0     | #####  |
| Z04 unten | 0     | #####  |
| Z06 oben  | 0     | #####  |
| Z06 unten | 0     | #####  |
| Z08 oben  | 0     | #####  |
| Z08 unten | 0     | #####  |

|             |  |           |  |                |  |                    |
|-------------|--|-----------|--|----------------|--|--------------------|
| Werkstück   |  | Kunde     |  | Excenter Stufe |  | %                  |
| Zchn Nr.    |  | Zuständig |  | Drehzahl       |  | Vorher Nachher Amp |
| Auftrags Nr |  | Operateur |  | Datum          |  | Motor Strom Amp    |

