



WIAP®

MEMV®



Metal relax with vibration

Determination Report: MEMV_WM865
Cast iron artificially age with vibration
system MEMV

hpw_2019_06_2019 Update, April 2019

WM 865_10 Introduction

Young cast, eg GG25 warp when treated if he is out for a few months around, much less. Can we with the vibration of the system MEMV aging process accelerate? Please read the test.



WM 865_20

Component weight: 20 kg
 Material: GG-25

Picture: WM_865_20. The small casting 20 Kg could be relaxed with vibration system MEMV.



Picture: WM_865_10. These castings were relaxing on the WIAP MEMV multiple clamping device MEMV and it worked perfectly in only one way.



Picture: WM_865_30. A very good fixing was necessary. 2 axis directions led to the good result.

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Test xy13 to 16 6.3.19 15:00 to 17:00

Component weight: 220kg
Material: GGG40 (nodular cast iron)

Artificially castings aging. The first 2 parts were pre-processed; two parts raw, without preprocessing.



Picture: WM_865_40. Artificially aging of castings.



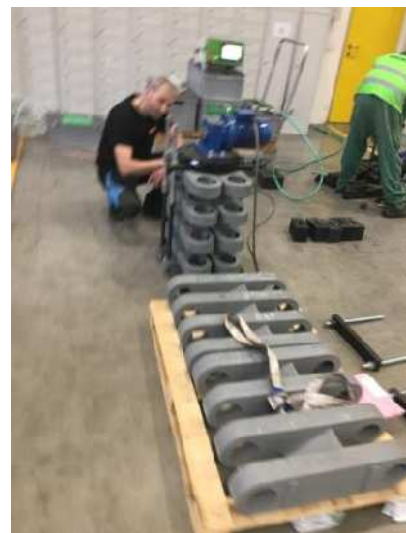
Picture: WM_865_50



Picture: WM_865_60



Picture: WM_865_70



Picture: WM_865_80

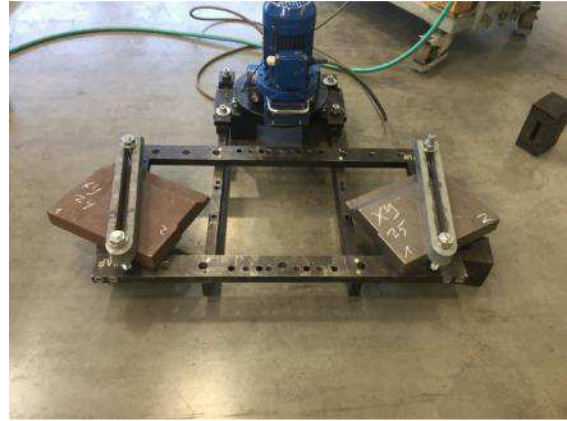
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Test XY24 to XY25 03/06/19 1:15 p.m. to 2:00 p.m.

Component Type: H05284082
 Component weight: 22 Kg
 Material: GGG-40



Picture: WM_865_90



Picture: WM_865_110

Test XY26 to XY27 03/06/19 2:00 p.m. to 3:00 p.m.

Part name: HOUSING 28/30 GG
 Component type: **
 Component weight: 35 Kg
 Material: GG-25



Picture: WM_865_100



Picture: WM_865_120

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Picture: WM_865_130

Artificially aging cast housing



Picture: WM_865_120

Result: XY2 XY7 after processing of 2 pcs. is OK,
editing in tolerance among 0.02mm

Test XY33 and XY34 03/06/19 08:45 to 10:30

Part name: discharge casing 45/45
 Component weight: 160 Kg
 Material: GG-20
 Number / Component 2



Picture: WM_865_130



Picture: WM_865_150

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Saf_Dul 07.04.2019 hp



Conclusion

That artificially aging is that WIAP knew for decades, but it made no meaning-ful investigations. Such was not possible to determine also what kind is best to apply the MEMV process. With a major Swiss company, which also has an operation in Europe, many hours of testing were made. And it was then determined measuring machines earnings reports directly what method when and where the causes. What is certain, there go all kinds identical. It is important that the direction in which order excited when and how that then no delay hinders the workflow process of a manufacturer in the finishing.

The WIAP will create a policy Wi 8f in the matter is that as little as possible mistakes happen.

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