

ISO 230-2 2006

X Axis Summary Report

-Date of Test **xx/xx/xxxx** -Name of Inspector **John Doe**

-Machine Mfg./Model **12345**

-Machine S/N **67890** -Control Mfg./Model **Fanuc / 16i**

Test Parameters

- Type of Feedback Rotary Encoder
 - NDE Correction (Yes or No) Yes/Laser
 - Coefficient of Thermal Expansion 6.5 PPM /° F
 - Feed Rate 80 In/Minute
 - Dwell time 5 Seconds
 - Control Compensation Active Yes/Reversal & Leadscrew

Test Location

- Position of Axes not under test Y=-7.7402 Z=16.5512 Inches

- Offset to Tool Reference (X/Y/Z) X=2.0000 Y=-4.0000 Z=6.0000 Inches

- Offset to Workpiece Reference (X/Y/Z) X=-16.0000 Y=24.0000 Z=-12.0000 Inches

Test Conditions

- Temperature Sensors	Location	T Start	T End
Material #1	On Table	70.47° F	70.92° F
Air Sensor	On Table	72.26° F	72.85° F
- Air Pressure	29.39 In of Hg		
- Air Humidity	55.18%		

Axis Deviation	Unidirectional ↑	Unidirectional ↓	Bi-directional
Reversal Value	Not Applicable	Not Applicable	B = 0.000046 Inches
Mean Reversal Value	Not Applicable	Not Applicable	B = 0.000022 Inches
Mean Bi-directional Position Deviation	Not Applicable	Not Applicable	M = 0.000156 Inches
Systematic Positional Deviation	E↑ = 0.000143 Inches	E↓ = 0.000168 Inches	E = 0.000173 Inches
Repeatability of Positioning	R↑ = 0.000125 Inches	R↓ = 0.000090 Inches	R = 0.000125 Inches
Accuracy (Coverage Factor = 2)	A↑ = 0.000230 Inches	A↓ = 0.000235 Inches	A = 0.000261 Inches

Prepared By _____

Date _____