

TEST CERTIFICATE: QD12-35-F

Customer:		SO Number:	SO
Order No:		Table Type:	
Customer Ref:		Serial No:	
Date:		Inspector:	

Notation	CONING OF TABLE AXIS		
Method	<p>The Rotary Table on test is placed on a rigid and flat support surface with the rotary axis in the vertical position and a precision sphere / hemi-sphere is placed and centred on the rotary axis. A high-resolution linear indicator is placed on the support surface close to the rotary table so that axial deviation measured at the equator of the sphere can be recorded over a minimum of ten full revolutions of the table (RRa).</p> <p>The process is then repeated with the precision sphere/hemi-sphere placed and centred on the spacer at a known height (h) with the radial deviations measured at the equator of the sphere recorded over a minimum of ten full revolutions of the table (RRb).</p> <p>Measurement data is collected and runout's calculated using AccuScan™ XE200M-RT.</p>		
Illustration of Test			
References	Taylor Hobson Hemi-sphere AccuScan™ XE200M-RT		
Measuring Equipment	One precision glass hemi-sphere PL No: Mobile AccuScan™ XE200M-RT PL No:		
Measured Results	RRa (mm) _____ mm RRb (mm) _____ mm Displacement h (mm) _____ mm Coning of axis C (Arc Second) +/- _____ Arc second	$\text{Coning of axis} = 3600 \times \sin^{-1} \left(\frac{RRb-RRa}{2} / h \right)$	
Notes			

ROTARY PRECISION INSTRUMENTS UK LTD

The Maltings Industrial Estate, Brassmill Lane
Bath BA1 3JL, United Kingdom

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Data Table

RRa 1	RRa 2	RRa 3	RRa 4	RRa 5	RRa 6	RRa 7	RRa 8	RRa 9	RRa 10
<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>

RRb 1	RRb 2	RRb 3	RRb 4	RRb 5	RRb 6	RRb 7	RRb 8	RRb 9	RRb 10
<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>

Axial 1	Axial 2	Axial 3	Axial 4	Axial 5	Axial 6	Axial 7	Axial 8	Axial 9	Axial 10
<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>	<input style="width: 100%; height: 15px;" type="text"/>

RRa Probe Height (mm)

RRb Probe Height (mm)

Results Table

RRa Mean (mm)

RRb Mean (mm)

Axial Mean (mm)

Height Difference (mm)

Coning (arc seconds) +/-

Runout per metre (mm)

Runout at 1m high (mm)

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