



Home Programming Measuring Diagnostics Tools Exit Help						
Measuring		Part Program2				
Part Program2						
Name	Short description	Description	Type	Unit	Value	Diagram
M001		Dynamic Diameter Z71.7	mm	mm	10.1643	
M002		Dynamic Diameter Z93.0	mm	mm	10.1628	
M003		Dynamic Diameter Z37.4	mm	mm	67.5521	
M004		Dynamic Diameter Z105.5	mm	mm	6.7358	

OPTICAL GAUGING

ENSURE
THE COMPLIANCE
OF YOUR MARPOSS
EQUIPMENT WITH
A **CALIBRATION**
PROGRAM!

CALIBRATION



MARPOSS
CARE

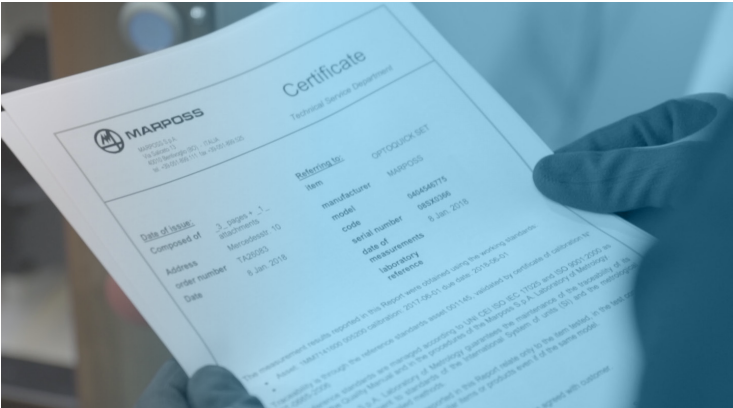
Evaluate the performance of measurement equipment over time is fundamental to verify the reliability of measurements results and the quality of product and process.

Beyond the importance to execute a periodical maintenance of installed products, yearly bench re-calibration is frequently asked to meet the requirements driven by their quality processes and regulation compliance. Measurement results not only depend on the equipment, but can also be affected by environmental conditions, measurement methods and the state of reference masters.

Therefore, it is important to make periodic calibrations of your equipment in order to ensure correct performance and measurement results.



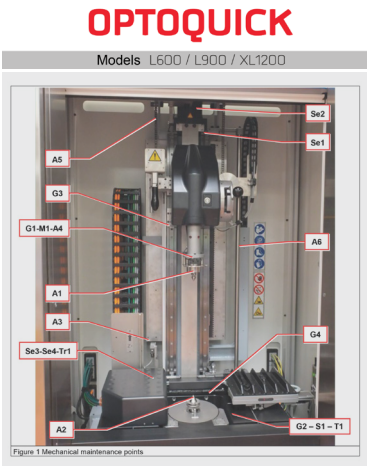
The periodic calibration is executed through a dedicated software tool and specific masters that allow a fine tuning of the product mappings, directly on site.



Marposs can help you to establish a calibration program and through scheduled interventions, an expert Marposs engineer by using the necessary instruments will perform calibration, adjustments and some operations useful to verify what listed here below.

- ✓ Verification of the mechanical and electronic parts to check its efficiency and identification of the critical components that might need to be replaced
- ✓ Execution of ordinary maintenance to be performed (see example below)
- ✓ Execution of some metrology tests by using a sample part, dedicated to determine the achievement of the agreed features

At the end of the planned operations, the qualified Marposs technician will give a calibration report stating the gauge status.



Marposs Calibration Report form with fields for client information, machine details, and technician signature.

1.1 Check List

1.1.1 Maintenance table: symbols

The maintenance intervals (G, S, M, T, SE, A, B, TR, V) and the number of the points (i= 1, 2, 3 etc.) are indicated on the drawings as follows:

Gi = Daily	Si = Weekly	Mi = Monthly
Ti = Every 3 months	Sei = Every 6 months	Ai = Once a year
Bi = Every 2 years	Tri = Every 3 years	Vi = Various

Maintenance intervals are calculated on the basis of two, 8-hour shifts in a 5-day week.

1.1.1.1 Mechanical parts

Refer to Figure 1.

REF.	DEVICE	CHECKING/ACTIVITY	CATEGORY (*)	FREQUENCY	CHECK
Se1	Recirculating ball screw nuts, guide rail and recirculating ball screw	Grease or oil (lubrication test).	2	Every 6 months	
Se2	Drive transmission coupling of the optic sensor slide	Check the tightening torque of the transmission coupling screws.	2	Every 6 months	
Se3	Axial contact unit belt (where present)	Check the condition and tension of the belt.	2	Every 6 months	
Se4	Where present:	Check the wear of the shoe-type contact.	2	Every 6 months	

