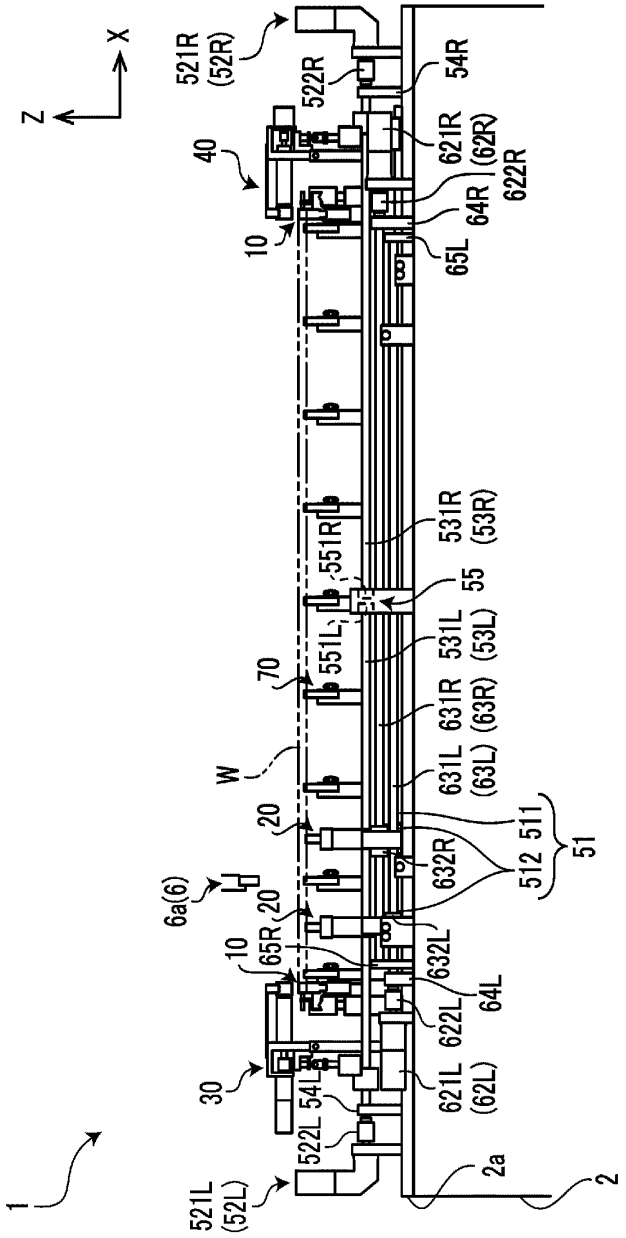
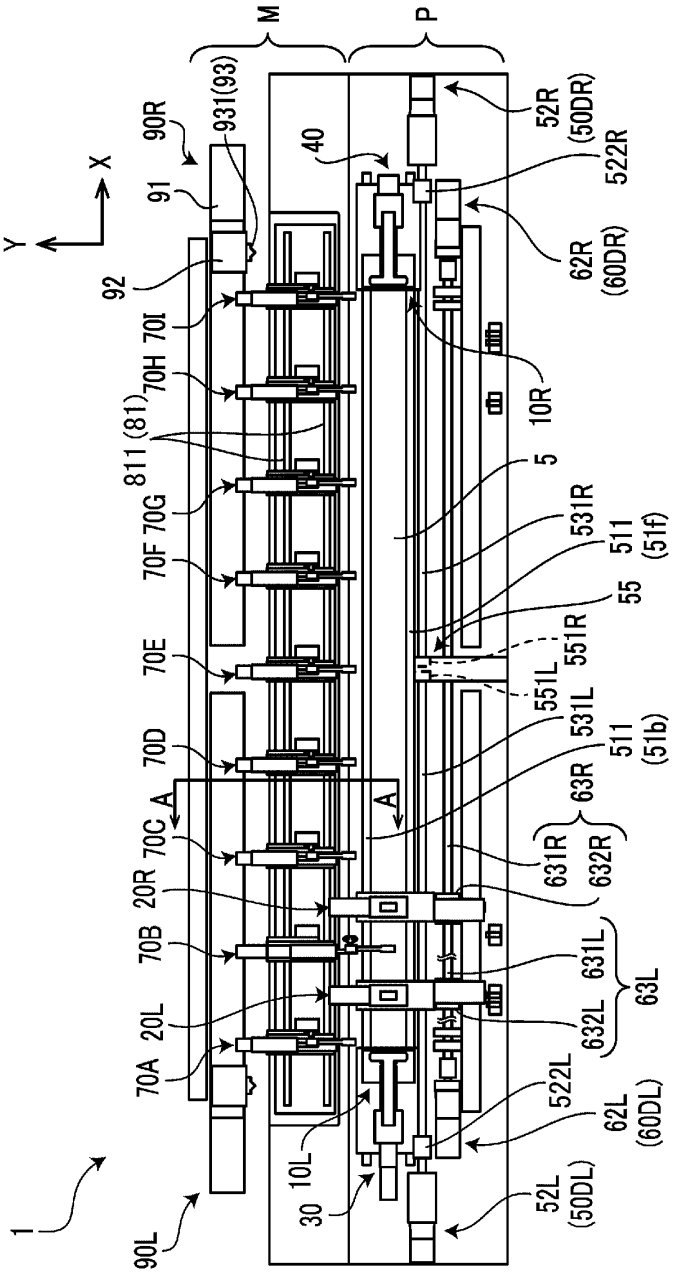
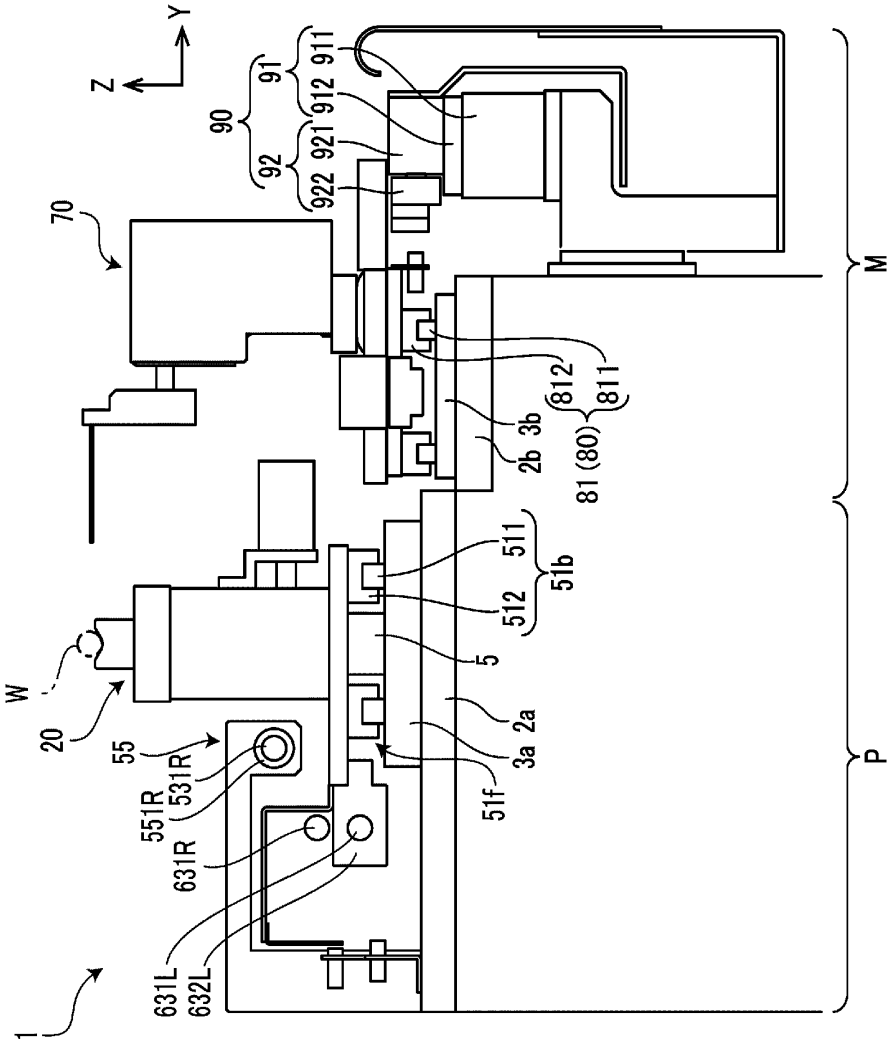
[図1]


X
Z
521R (52R)
522R
54R
621R (62R)
622R
64R
65L
40
10
531R (53R)
551R
55
551L
531L (53L)
631R (63R)
631L (63L)
70
W
20
511
512
51
632R
6a(6)
20
10
65R
632L
622L
64L
621L (62L)
30
54L
522L
521L (52L)
1
2a
2

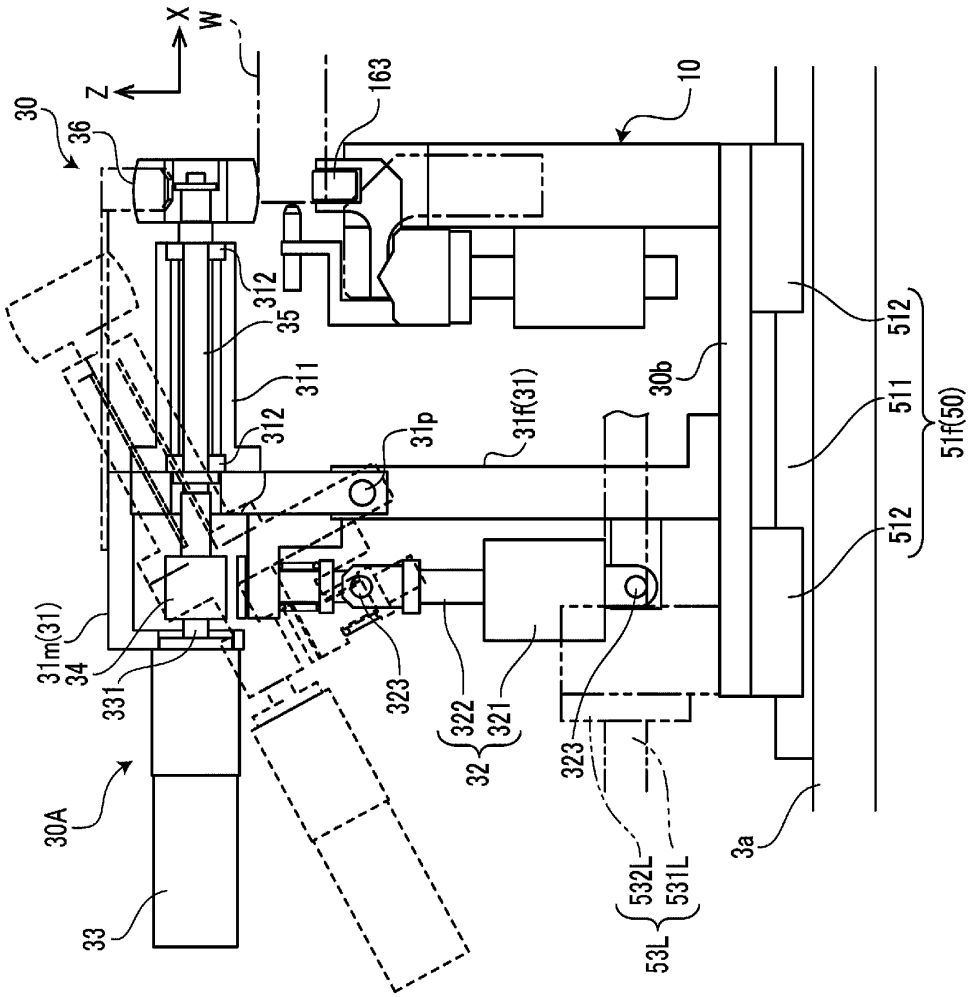
[図2]


M
P
X
Y
90R
931(93)
91
92
40
52R
(50DR)
522R
62R
(60DR)
10R
5
531R
511
(51f)
55
551R
551L
531L
511
(51b)
63R
631R
632R
631L
632L
63L
522L
62L
(60DL)
52L
(50DL)
10L
30
90L
1
70I
70H
811 (81)
70G
70F
70E
70D
70C
70B
20R
20L
70A
A
A

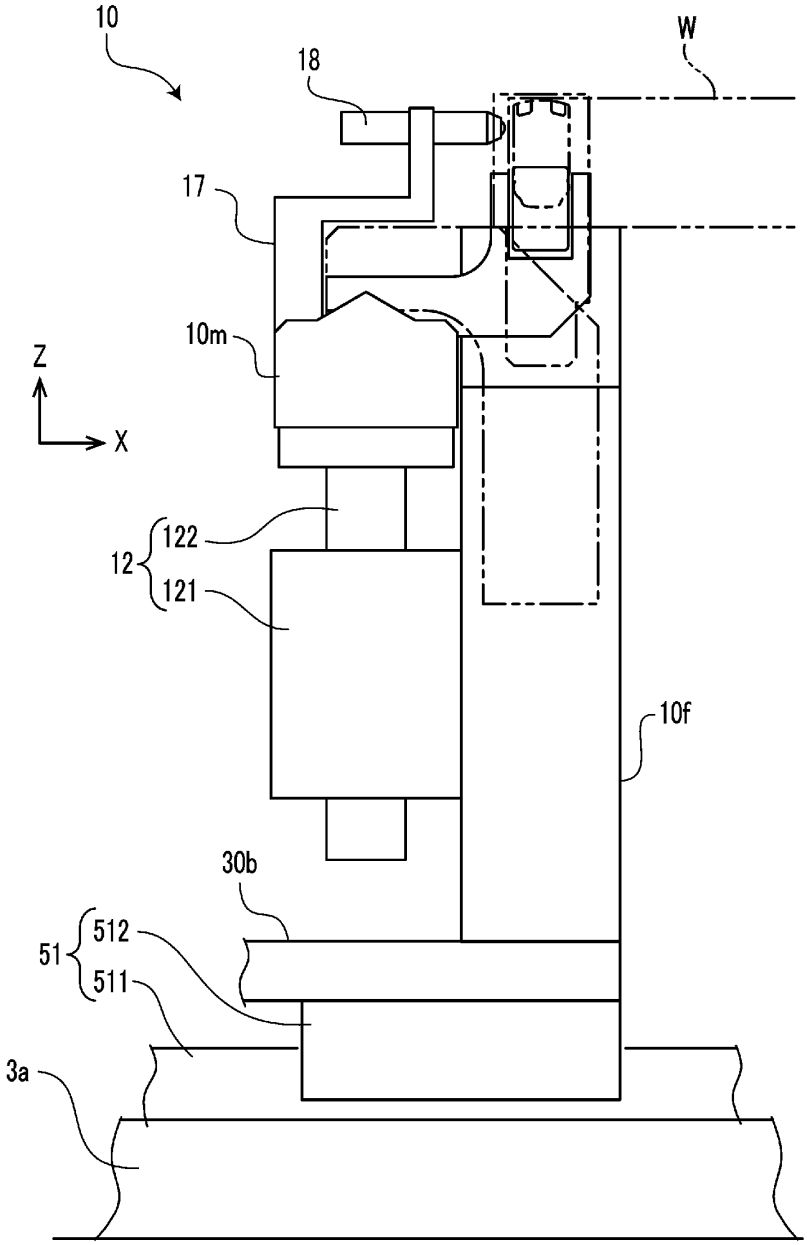
[図3]


Y
Z
90
91
911
912
921
92
922
70
M
812
811
81 (80)
3b
2b
511
51b
512
5
2a
3a
51f
W
20
55
531R
551R
631R
631L
632L
1
P

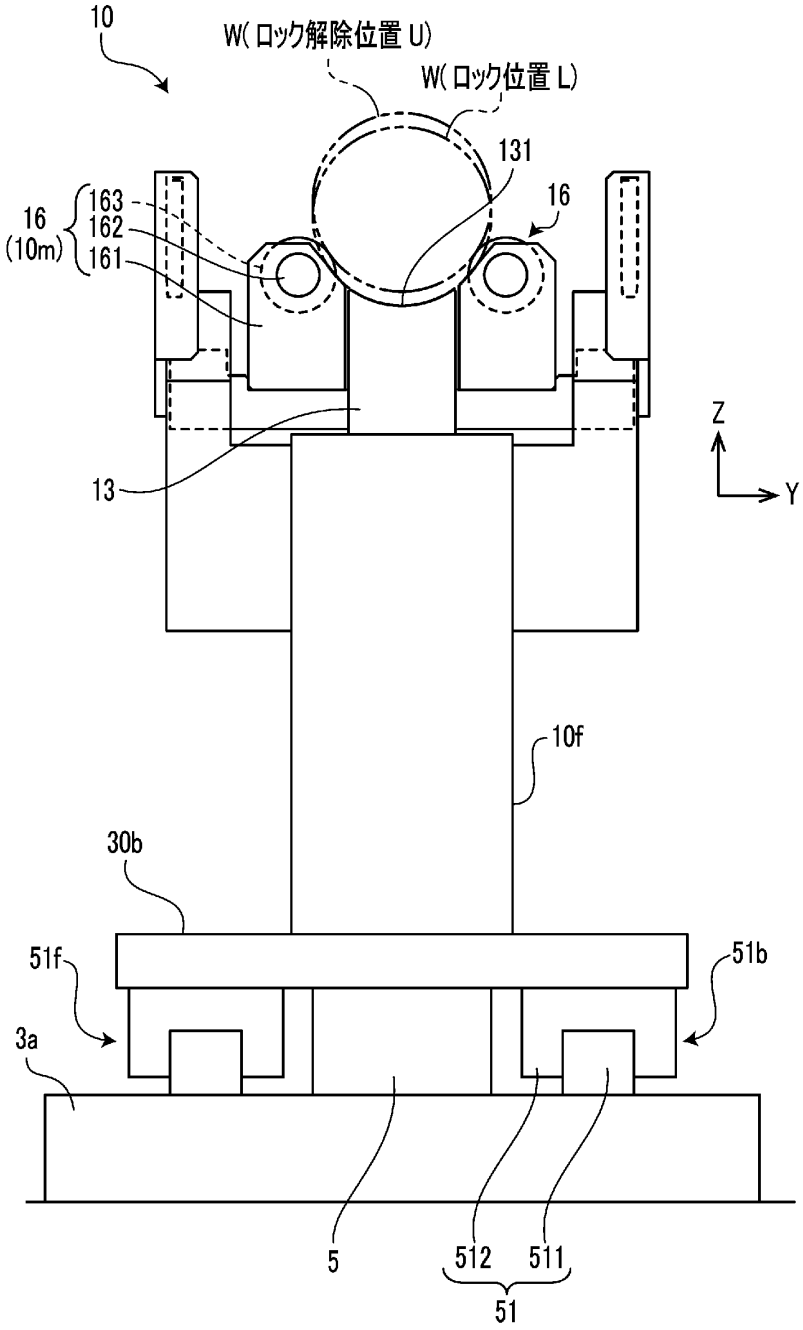
[図4]


X
W
Z
30
36
163
10
312
35
311
312
31p
31f(31)
30b
512
511
512
51f(50)
31m(31)
34
331
323
322
321
32
323
532L
531L
53L
3a
30A
33

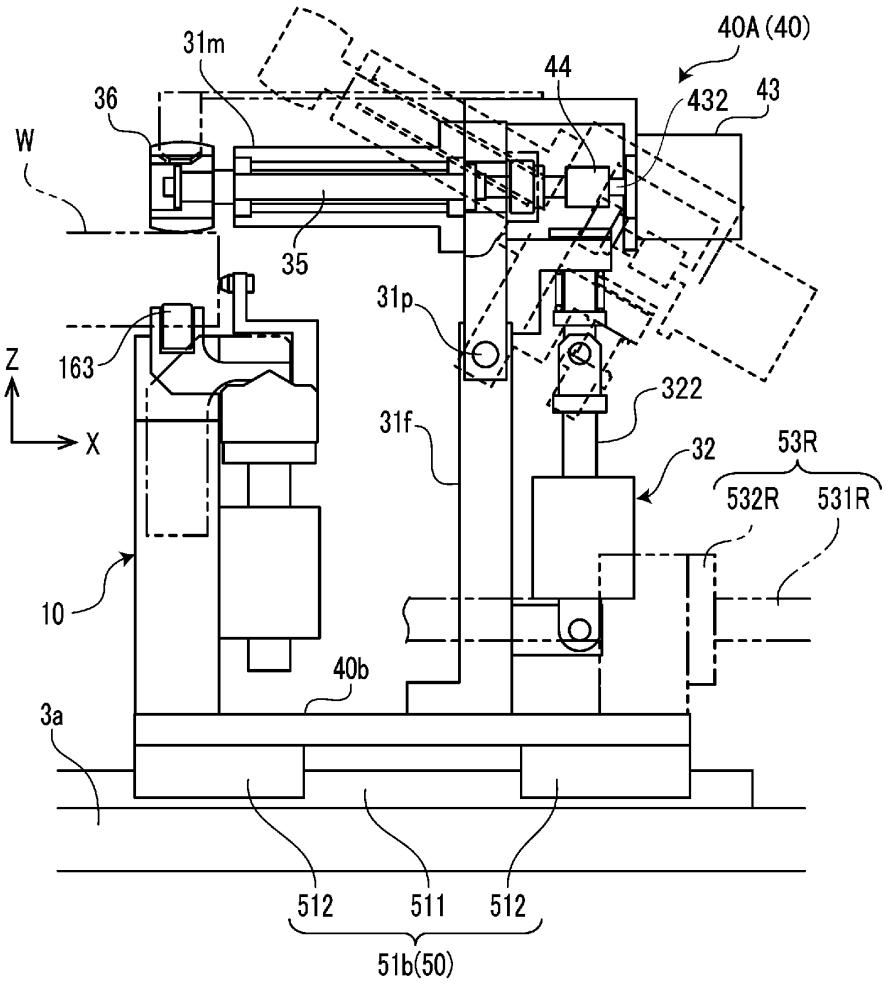
[図5]



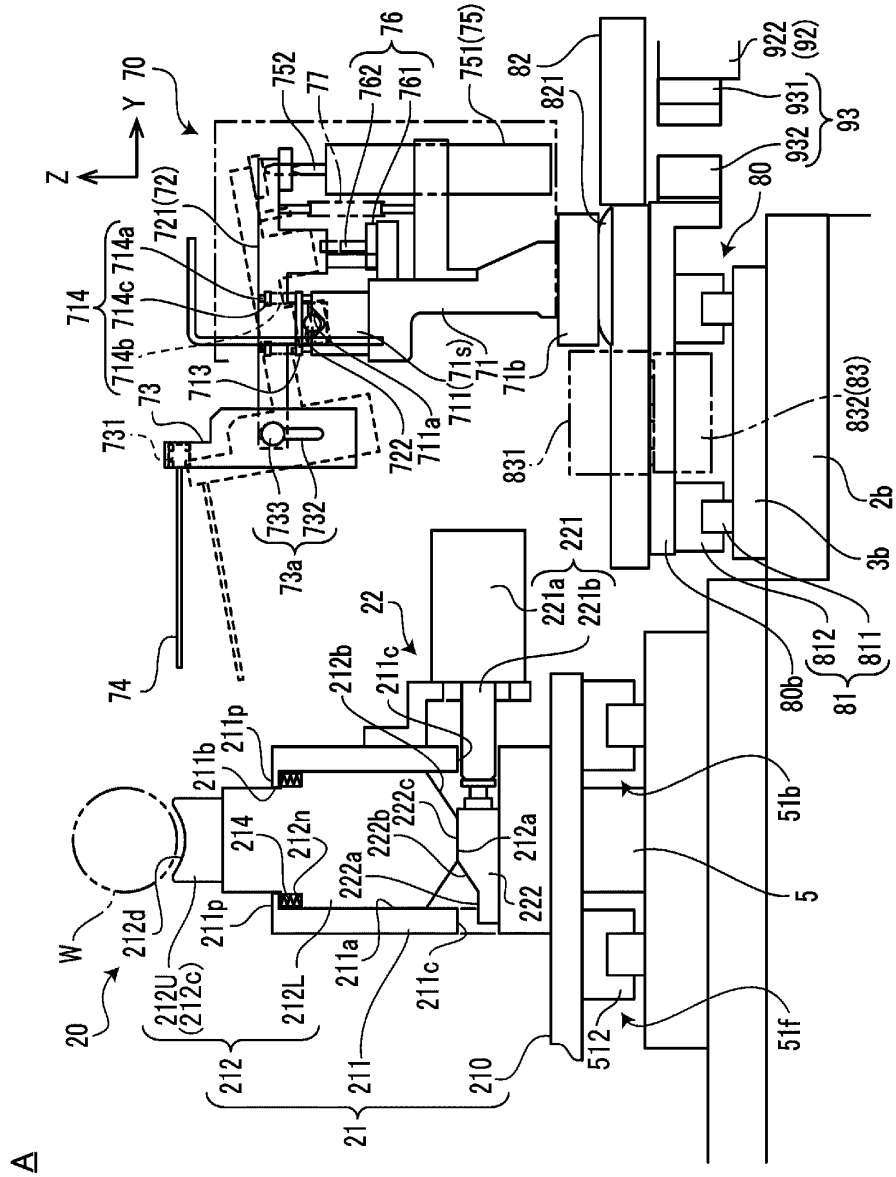
[図6]


10
W(ロック解除位置 U)
W(ロック位置 L)
131
16
163
162
161
16
(10m)
13
Z
Y
10f
30b
51f
51b
3a
5
512
511
51

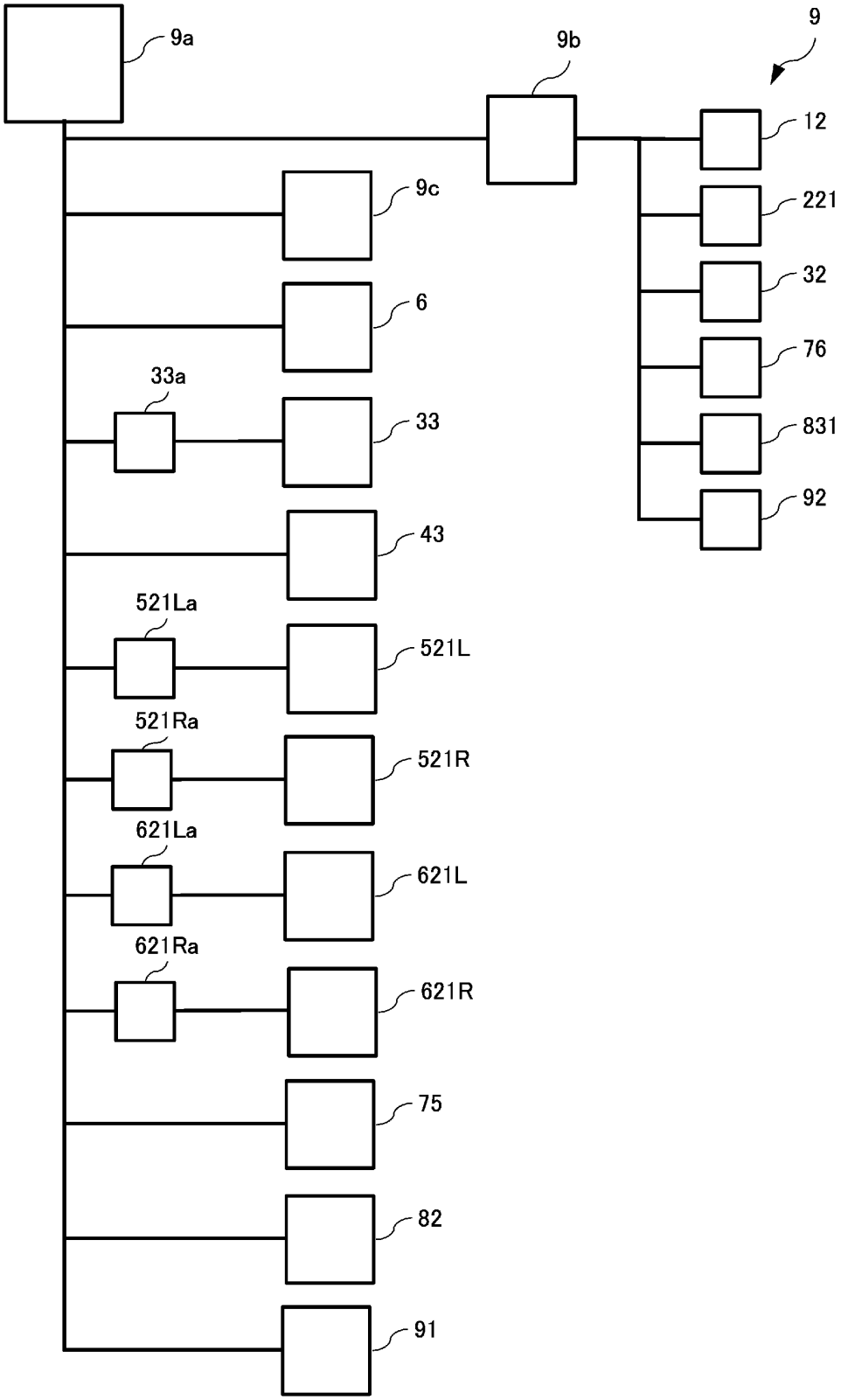
[図7]


40A (40)
31m
44
36
432
43
W
35
31p
Z
163
322
31f
32
53R
X
532R
531R
10
40b
3a
512
511
512
51b(50)

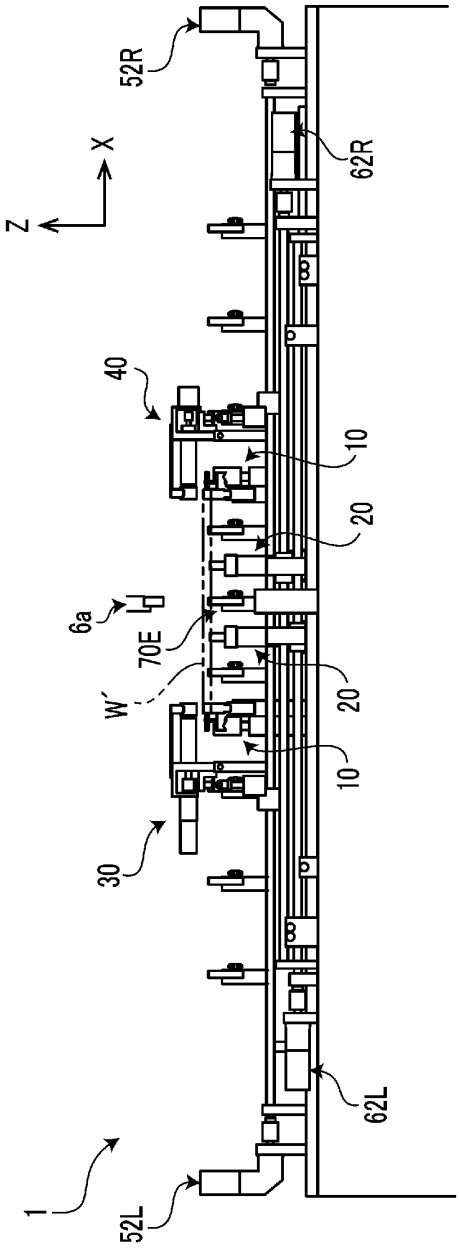
[図8]


A
Y
Z
70
752
77
762
761
76
751(75)
82
821
922
(92)
931
932
93
80
721(72)
714a
714c
714b
714
713
73
731
711(71s)
71
71b
722
711a
831
832(83)
2b
3b
733
732
73a
74
221
221a
221b
22
212b
211c
812
811
81
80b
211p
211b
214
212n
222b
222c
212a
222a
222
51b
5
W
212d
212U
(212c)
212L
211a
211c
512
51f
20
212
211
210
21

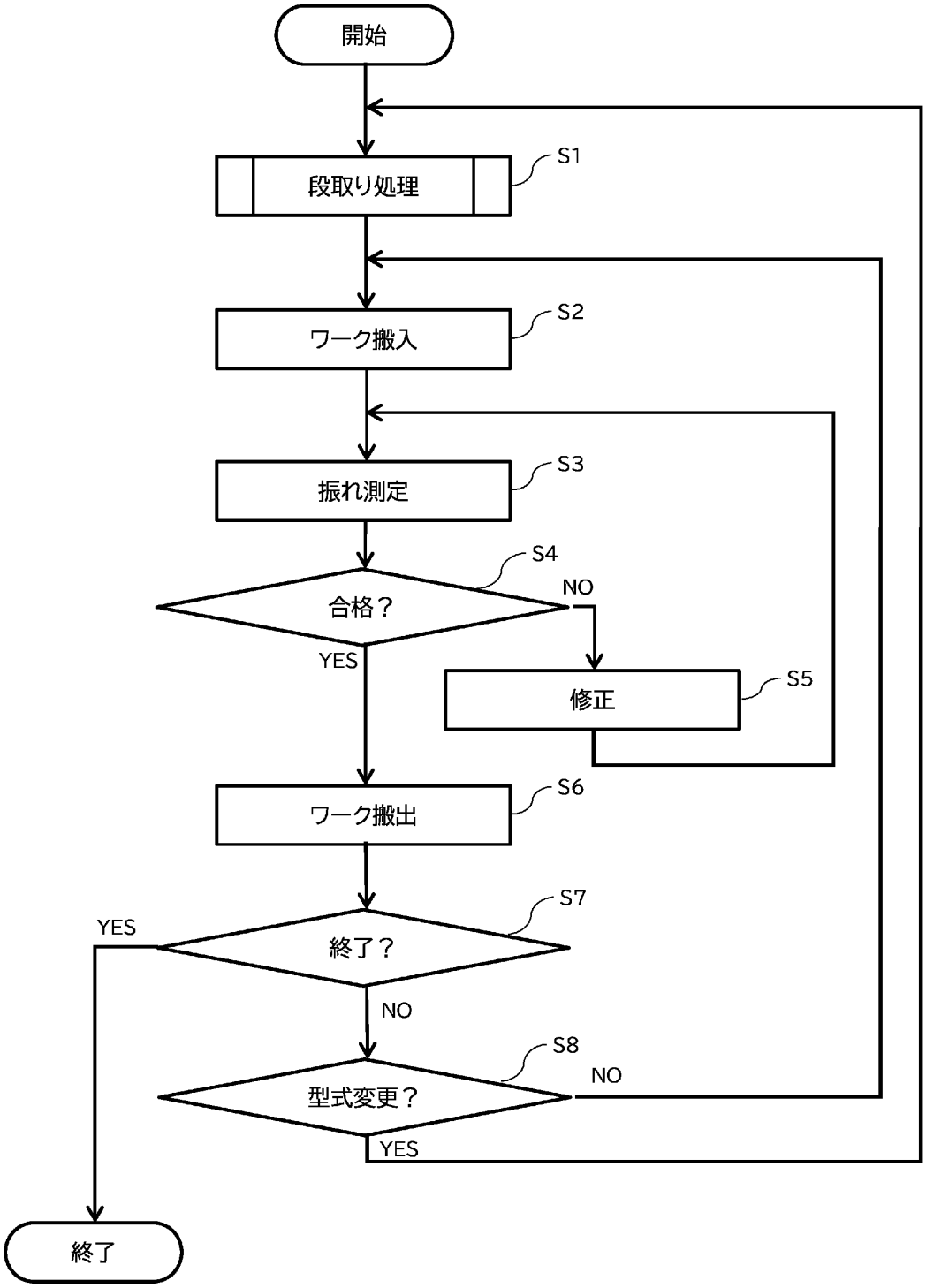
[図9]


9a
9b
9
12
9c
221
6
32
33a
76
33
831
43
92
521La
521L
521Ra
521R
621La
621L
621Ra
621R
75
82
91

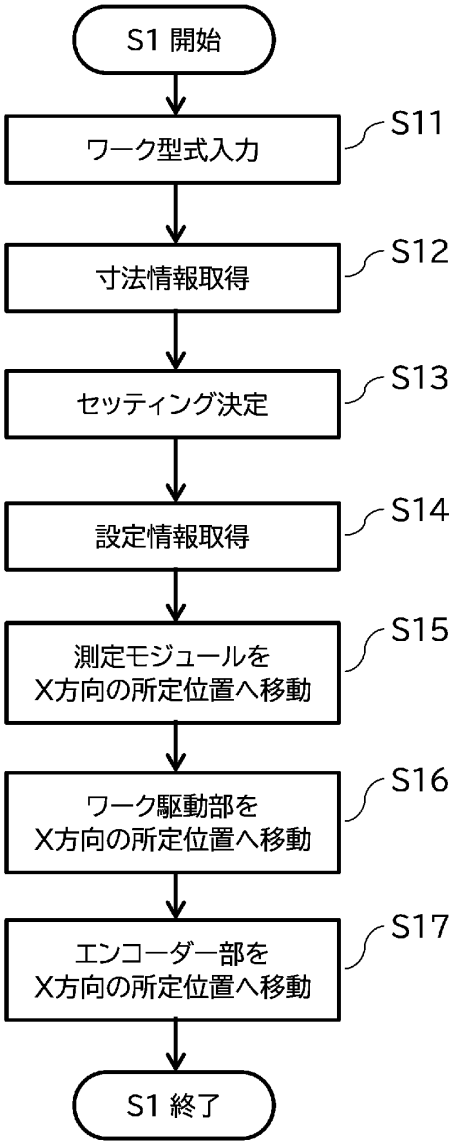
[図10]



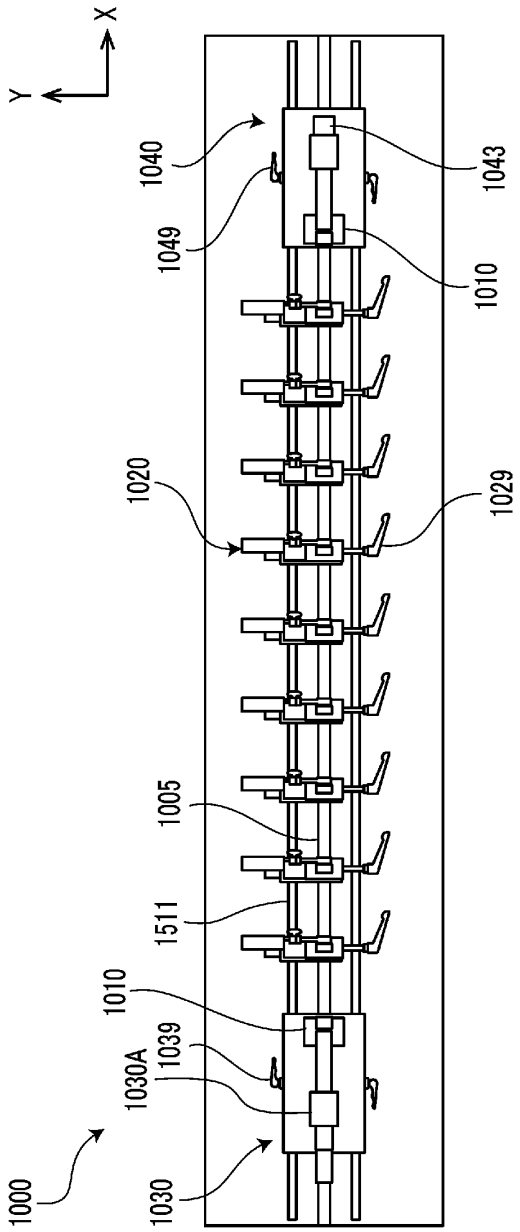
[図11]


開始
段取り処理
S1
ワーク搬入
S2
振れ測定
S3
合格？
S4
NO
YES
修正
S5
ワーク搬出
S6
終了？
S7
YES
NO
型式変更？
S8
NO
YES
終了

[図12]


S1 開始
ワーク型式入力
S11
寸法情報取得
S12
セッティング決定
S13
設定情報取得
S14
測定モジュールを
X方向の所定位置へ移動
S15
ワーク駆動部を
X方向の所定位置へ移動
S16
エンコーダー部を
X方向の所定位置へ移動
S17
S1 終了

[図13]


X
Y
1040
1043
1049
1010
1020
1029
1005
1511
1010
1039
1030A
1000
1030

[図14]

