

Robotic machining Accuracy test (2017 year)

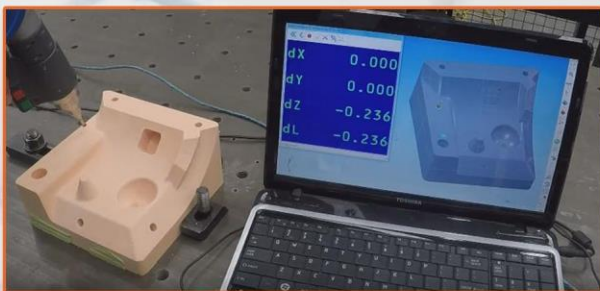
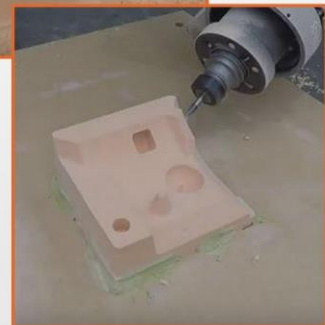
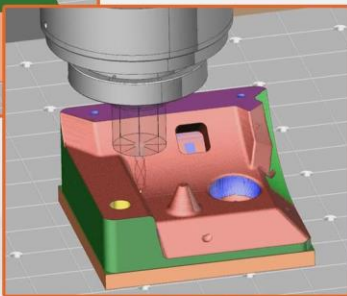
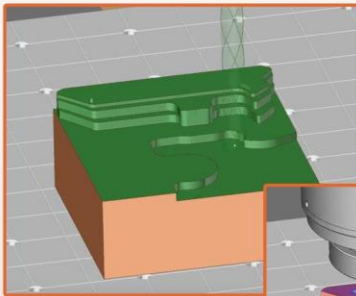
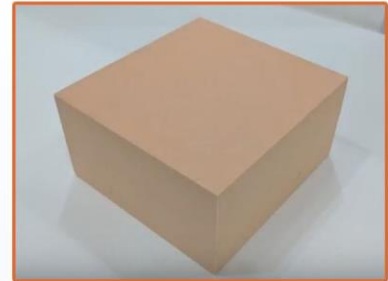
Robot: KUKA KR120 R2900
 Absolute Accuracy KUKA.
 CNC Controller

Material:
 UREOL Medium density resin board

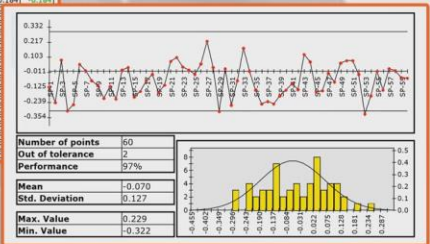
Tools: 20mm End mill
 10mm End
 10 mm Ball Nose
 6 mm Ball Nose
 4 mm Ball Nose

Step Over:
 Roughing:50%
 Semi:2mm
 Finish:0.3mm

Stock:
 1.5mm Roughing
 0.5mm Semi
 0.0mm Finish



SP-35	0.000	-0.300	0.300	-24.001	58.538	95.000	0.000	0.000	-0.246	-0.146
SP-37	0.000	-0.300	0.300	23.403	95.210	95.000	0.000	0.000	-0.227	-0.277
SP-38	0.000	-0.300	0.300	-24.773	142.769	95.000	0.000	0.000	-0.246	-0.146
SP-39	0.000	-0.300	0.300	82.895	29.885	70.000	0.000	0.000	-0.184	-0.184
SP-40	0.000	-0.300	0.300	63.135	9.785	70.000	0.000	0.000		
SP-41	0.000	-0.300	0.300	119.200	11.142	70.000	0.000	0.000		
SP-42	0.000	-0.300	0.300	118.827	32.761	70.000	0.000	0.000		
SP-43	0.000	-0.300	0.300	187.272	125.931	32.728	0.090	0.000		
SP-44	0.000	-0.300	0.300	176.472	123.923	43.528	0.051	0.000		
SP-45	0.000	-0.300	0.300	160.860	141.718	50.900	0.900	0.000		
SP-46	0.000	-0.300	0.300	82.812	144.504	56.668	-0.083	0.000		
SP-47	0.000	-0.300	0.300	95.314	94.642	55.623	-0.094	0.000		
SP-48	0.000	-0.300	0.300	47.854	43.575	79.442	-0.039	0.000		
SP-49	0.000	-0.300	0.300	175.101	55.514	44.899	0.043	0.000		
SP-50	0.000	-0.300	0.300	188.891	112.998	31.109	0.056	0.000		
SP-51	0.000	-0.300	0.300	187.052	63.925	32.948	0.056	0.000		
SP-52	0.000	-0.300	0.300	188.076	171.961	31.924	-0.018	0.000		
SP-53	0.000	-0.300	0.300	129.654	182.071	37.929	0.000	-0.228		
SP-54	0.000	-0.300	0.300	115.090	183.909	36.142	-0.004	-0.131		
SP-55	0.000	-0.300	0.300	79.745	125.671	63.732	-0.001	-0.000		
SP-56	0.000	-0.300	0.300	62.039	86.580	67.475	-0.080	0.000		



Results:

100% of pint were: +/- 0.32
 97% of points were: +/- 0.25

Min value: -0.322
 Max value: 0.229
 Mean: 0.07

