CAMSHAFT

GFM Aachen mbH 10.1.2025 10:10:14

Global settings for the measuring program:

Positioning in:
Machine/Work piece coordinates

Unit used: [mm]/[inch]

Meas. program: CAMSHAFT
Work piece file: H5_358

No.	Function	SY	Act.val. mm/DEG.	Nom. val. mm/DEG.	up.tol. mm/DEG.	lo.tol. mm/DEG.	Deviat. mm/DEG.

C A M S H A F T

(1) Start measurement

(2) Choose work piece

(3) Adjustments

(4) Protocol data

(5) Geometry data

(6) Measurement / Evaluation

(7) Alignment

(8) Evaluation of measurements

(9) Calibration

(A) End of programm

F1 Abort | F2 | F3 | F4 | F5 | F6 | F7 | F8 | F9 | F10 Start measurem

CAMSHAFT

GFM Aachen mbH 10.1.2025 10:10:34

No.	Function	SY	Act.val. mm/DEG.	Nom. val. mm/DEG.	up.tol. mm/DEG.	lo.tol. mm/DEG.	Deviat. mm/DEG.

Global settings for the measuring program:

Positioning in:
Machine/Work piece coordinates

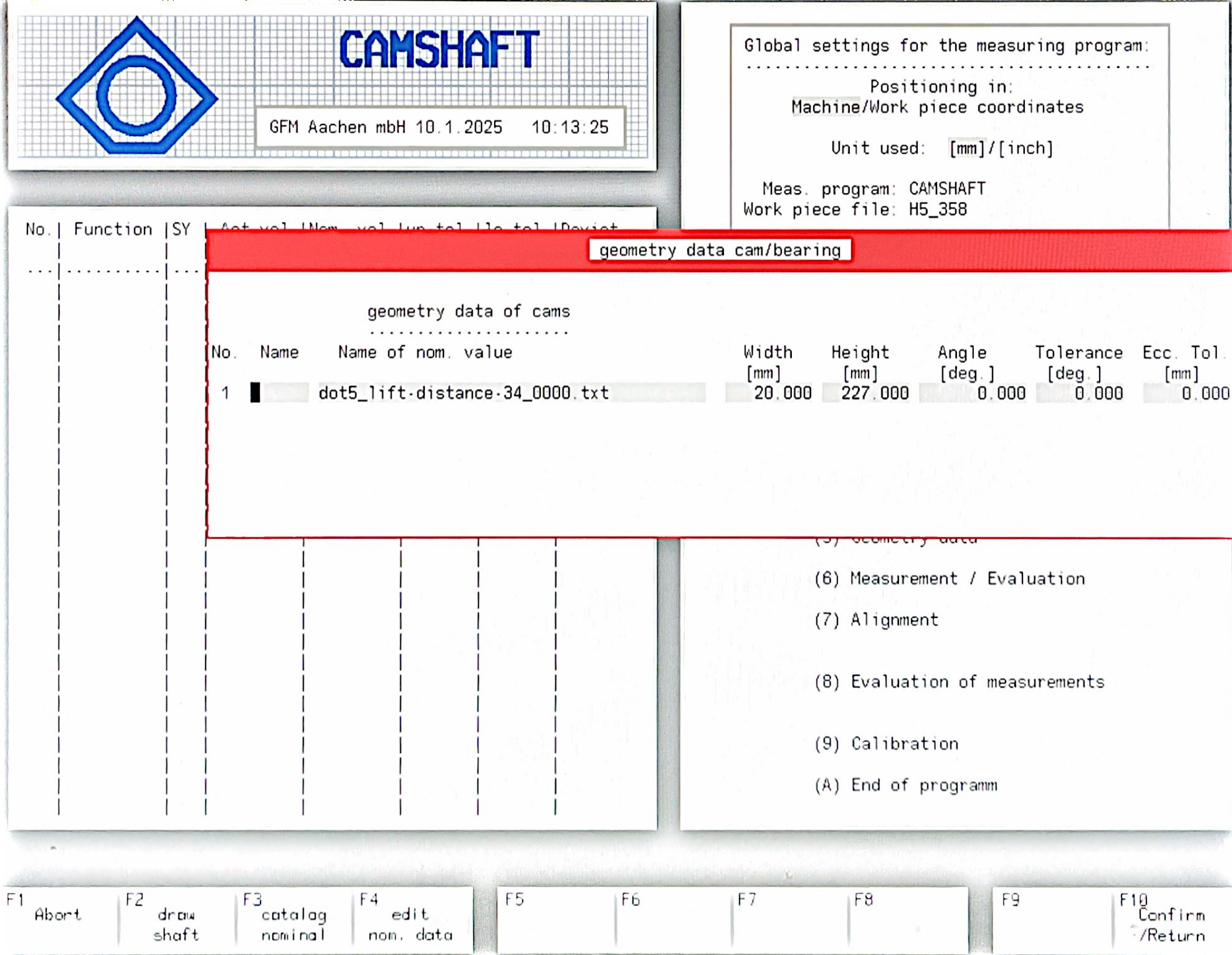
Unit used: [mm]/[inch]

Meas. program: CAMSHAFT
Work piece file: H5_358

Adjustment

```
    Max. diameter:          80.0000
       Scan speed:           80 %
      Output unit:      <-  mm  ->

     Scale factor:      <-  auto ->

Diagram output:         <- offline ->
        · Screen:       <- yes ->
      · Printer:        <- yes ->
      · Plotter:        <-  no ->

Single display (unwinded)
  with lift curve:      <- yes ->
   Tabular output:      <- middle measurement ->

Fitting
   · Polar display:     <- rot.+transv. ->
   ·     Lift curve:    <-   rotatory   ->
   · Tabular output:    <-   rotatory   ->
   ·  Total display:    <- rot.+transv. ->

Store measurements:       yes/no
```

F1 Abort | F2 | F3 | F4 | F5 | F6 | F7 | F8 | F9 | F10 Confirm


CAMSHAFT
GFM Aachen mbH 10.1.2025 10:13:25
Global settings for the measuring program:
Positioning in:
Machine/Work piece coordinates
Unit used: [mm]/[inch]
Meas. program: CAMSHAFT
Work piece file: H5_358
No. | Function | SY
geometry data cam/bearing
geometry data of cams
No. Name Name of nom. value Width [mm] Height [mm] Angle [deg.] Tolerance [deg.] Ecc. Tol. [mm]
1 dot5_lift-distance-34_0000.txt 20.000 227.000 0.000 0.000 0.000
(6) Measurement / Evaluation
(7) Alignment
(8) Evaluation of measurements
(9) Calibration
(A) End of programm
F1 Abort
F2 draw shaft
F3 catalog nominal
F4 edit nom. data
F5
F6
F7
F8
F9
F10 Confirm /Return

CAMSHAFT

GFM Aachen mbH 10.1.2025 10:45:28

Global settings for the measuring program:

Positioning in:
Machine/Work piece coordinates

No.	Function	SY	Act.val. mm/DEG.	Nom. val. mm/DEG.	up.tol. mm/DEG.	lo.tol mm/DEG

Cam data

Designation: dot5_lift-distance-34_0000.txt
Note:

Unit used: [mm]/[inch]

Tabular input

Type: lift values/contour values
Format: one column/two columns
Type of follower: flat follower/roller follower
Radius: 0.0000

Opening side: right/left
Base radius: 34.0000

Adjacent difference

Angular distance: 0.5 °

Range of Lift	Tolerances upper	lower	
Absolute:	0.0100	-0.0100	one/several/none
Adjacent difference:	0.0100		one/several/none

Base Circle

Form:
Radius:

F1 Abort | F2 Print table | F3 Read data from disk | F4 Edit table | F5 | F6 | F7 Display profile | F8 Display lift curve | F9 | F10 Save /Return

CAMSHAFT

GFM Aachen mbH 10.1.2025 10:21:11

C	0.000°
X	1.703mm
Y	141.960mm
Z	294.085mm

TW TA TM M

Temp 17.9 17.5 18.0

MX MY MZ

[µm] -300 -200 0 200 300

Unit used: [mm]/[inch]

Meas. program: CAMSHAFT
Work piece file: H5_358

No.	Function	SY	Act.val. mm/DEG.	Nom. val. mm/DEG.	up.tol. mm/DEG.	lo.tol. mm/DEG.	Deviat. mm/DEG.

Alignment

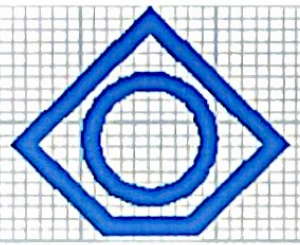
Define axis of workpiece: <· ·>

Define vertical position: <· edit manual ·>

Vertical zero position in machine coordinate system:

Rotatory alignment: <· · ·>

F1 Abort | F2 | F3 | F4 | F5 | F6 | F7 | F8 | F9 | F10 Confirm /Return



CAMSHAFT

GFM Aachen mbH 10.1.2025 10:21:35

C	0.000°	Temp	TW 18.0	TA 17.5	TM 18.0
X	1.703mm	MX			
Y	141.960mm	MY			
Z	294.085mm	MZ			

[µm] -300 -200 0 200 300

Unit used: [mm]/[inch]

Meas. program: CAMSHAFT
Work piece file: H5_358

Catalog of Measurements

No	DP	Date / Time	Client/Mach.No.	Operator	Name	Order/Series No.
1		04.12.24, 15.07				

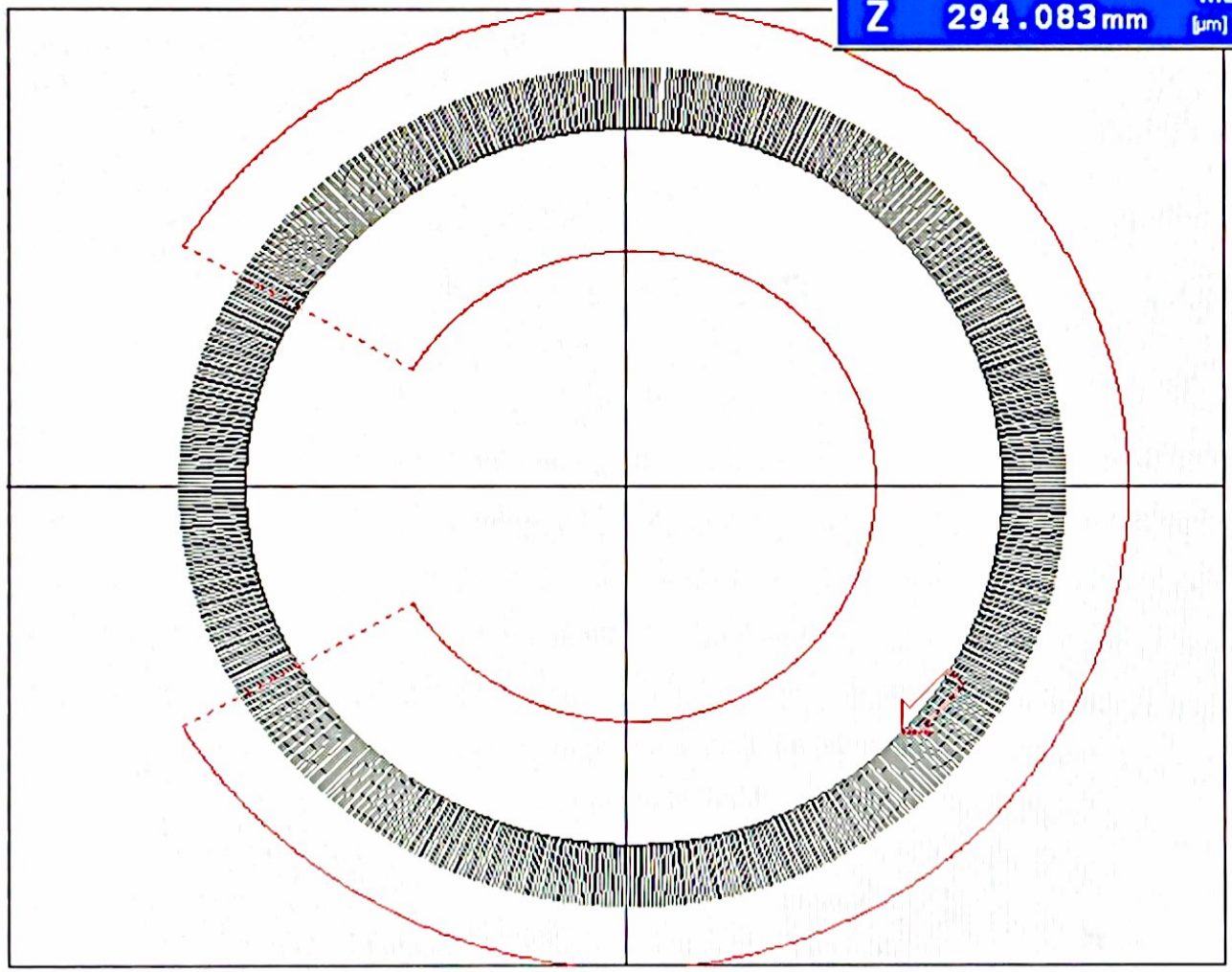
F1 Abort | F2 | F3 Delete | F4 | F5 | F6 | F7 Mark | F8 Sort | F9 | F10 Select /Continue

C	0.000°
X	1.703mm
Y	141.960mm
Z	294.083mm

Temp TW 18.1 TA 17.6 TM 18.0 M

MX MY MZ [µm] -300 -200 0 200 300

Nominal values for curve



2000:1 5 um

Index: 275
R: 34.511
A: 137.000

No.	Function	SY	A m

0000.txt

lues

several/none
several/none

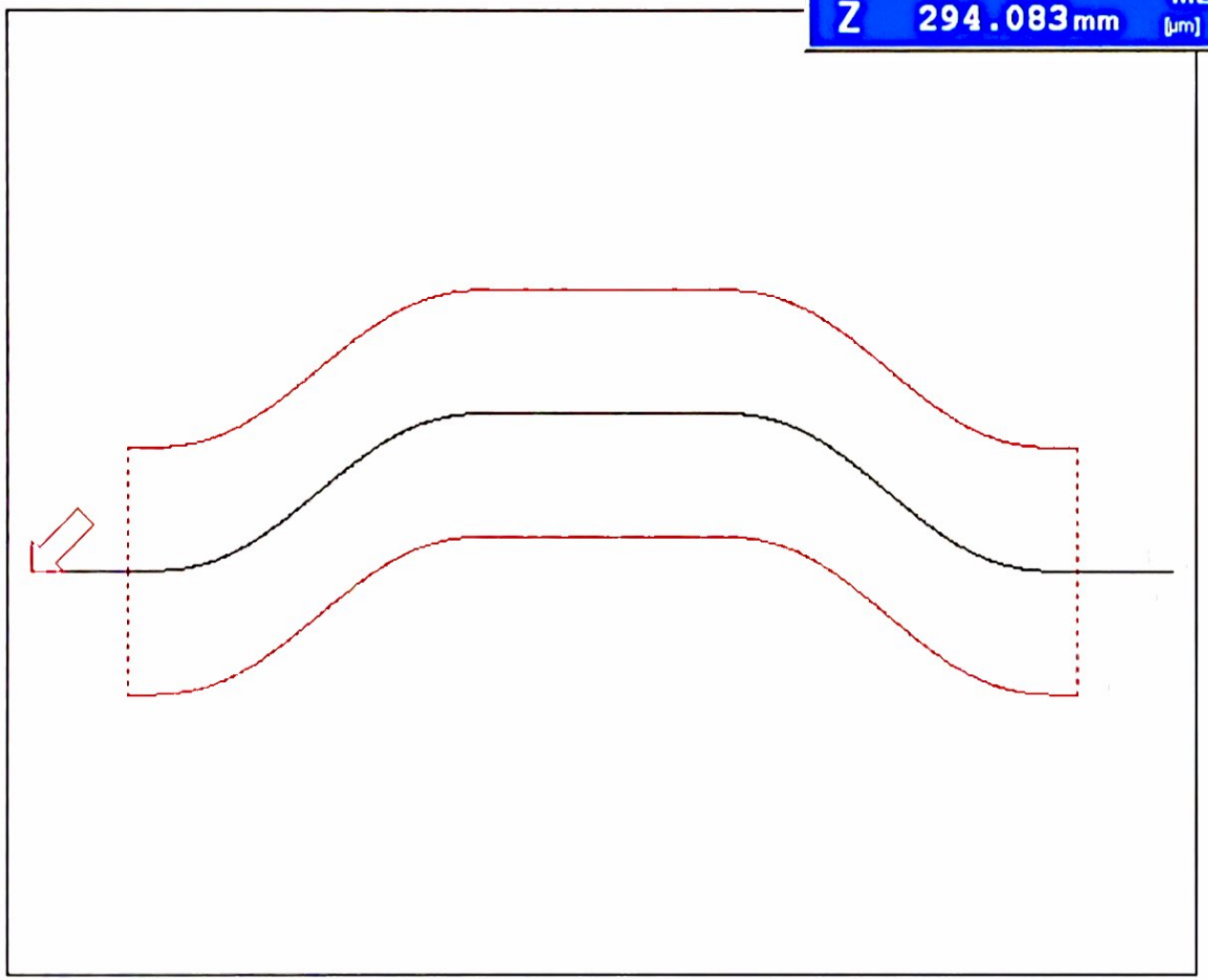
F1 Abort | F2 | F3 <<== | F4 <-- | F5 | F6 | F7 --> | F8 ==>> | F9 | F10 Return

C	0.000°	TW	TA	TM	M	~	C
		Temp	18.0	17.6	18.0		
X	1.703mm	MX					
Y	141.960mm	MY					
Z	294.083mm	MZ					

[µm] -300 -200 0 200 300 | 30 0 -30

Nominal values for curve

No.	Function	SY	A m
...	.....	...	..



2000:1 | 5 um
50:1 | 0.2 mm
20

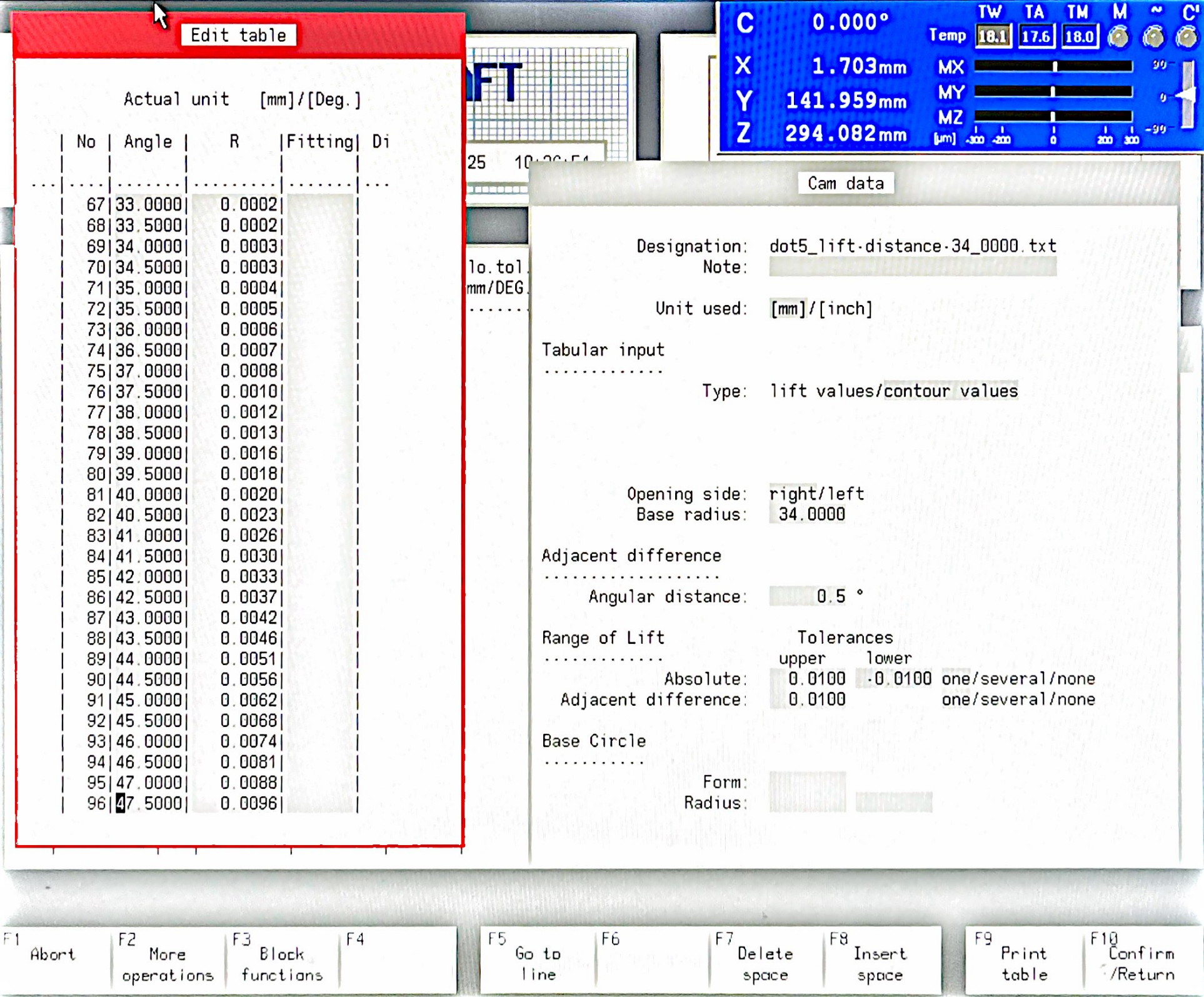
Index: 1
· A: 0.000
· Lift: 0.000

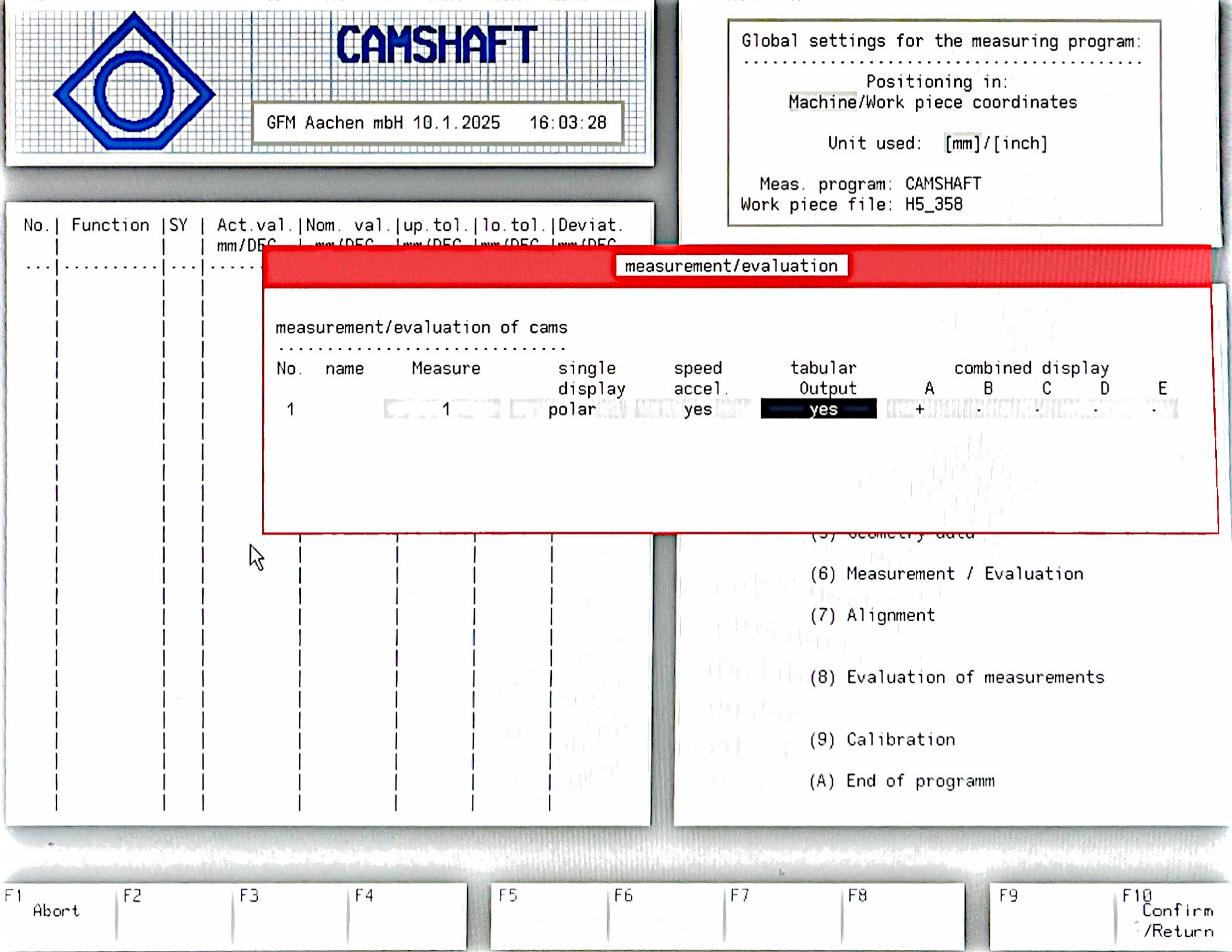
0000.txt

lues

several/none
several/none

F1 Abort | F2 | F3 <<== | F4 <-- | F5 | F6 | F7 --> | F8 ==>> | F9 | F10 Return


Edit table
Actual unit [mm]/[Deg.]
| No | Angle | R | Fitting | Di
67 33.0000 0.0002
68 33.5000 0.0002
69 34.0000 0.0003
70 34.5000 0.0003
71 35.0000 0.0004
72 35.5000 0.0005
73 36.0000 0.0006
74 36.5000 0.0007
75 37.0000 0.0008
76 37.5000 0.0010
77 38.0000 0.0012
78 38.5000 0.0013
79 39.0000 0.0016
80 39.5000 0.0018
81 40.0000 0.0020
82 40.5000 0.0023
83 41.0000 0.0026
84 41.5000 0.0030
85 42.0000 0.0033
86 42.5000 0.0037
87 43.0000 0.0042
88 43.5000 0.0046
89 44.0000 0.0051
90 44.5000 0.0056
91 45.0000 0.0062
92 45.5000 0.0068
93 46.0000 0.0074
94 46.5000 0.0081
95 47.0000 0.0088
96 47.5000 0.0096
C 0.000°
X 1.703mm
Y 141.959mm
Z 294.082mm
TW TA TM M
Temp 18.1 17.6 18.0
MX
MY
MZ
Cam data
Designation: dot5_lift-distance-34_0000.txt
Note:
Unit used: [mm]/[inch]
Tabular input
Type: lift values/contour values
Opening side: right/left
Base radius: 34.0000
Adjacent difference
Angular distance: 0.5 °
Range of Lift
Tolerances
upper lower
Absolute: 0.0100 -0.0100 one/several/none
Adjacent difference: 0.0100 one/several/none
Base Circle
Form:
Radius:
F1 Abort
F2 More operations
F3 Block functions
F4
F5 Go to line
F6
F7 Delete space
F8 Insert space
F9 Print table
F10 Confirm /Return


CAMSHAFT
GFM Aachen mbH 10.1.2025 16:03:28
Global settings for the measuring program:
Positioning in:
Machine/Work piece coordinates
Unit used: [mm]/[inch]
Meas. program: CAMSHAFT
Work piece file: H5_358
No. | Function | SY | Act.val. | Nom. val. | up.tol. | lo.tol. | Deviat.
mm/DEG
measurement/evaluation
measurement/evaluation of cams
No. name Measure single display speed accel. tabular Output combined display A B C D E
1 1 polar yes yes + ...
(6) Measurement / Evaluation
(7) Alignment
(8) Evaluation of measurements
(9) Calibration
(A) End of programm
F1 Abort
F2
F3
F4
F5
F6
F7
F8
F9
F10 Confirm /Return