



ตารางที่ 4.5 ตารางแสดงข้อมูลจากการวัดจุดที่สำคัญต่างๆ ของเรือนปืม P772 หลังการแก้ไขแล้ว

| No. | Lot No. | Data Housing Machine | | | | | | | | |
|-----|---------|----------------------|------------------|---------------|---------------|------------------|--------------------|-----------|-----------|-----------|
| | | 5.25 ±0.05 | 5° ±20' | R45 ± 0.05 | R47 ± 0.05 | ∅ 69.5 | 41 | 0.01 ⊥ | 0.01 ○ | 0.02 ▭ |
| | | 5.20 - 5.25 | 4°40' - 5°10' | | | 69.52 - 69.53 | 41.075 - 41.080 | | | |
| 1 | 5K15B | 5.234 | 5°08'54" | 45.028 | 47.006 | 69.526 | 41.075 | 0.010 | 0.006 | 0.005 |
| 2 | 5K15B | 5.245 | 4°51'24" | 44.966 | 47.042 | 69.523 | 41.076 | 0.009 | 0.008 | 0.003 |
| 3 | 5K15B | 5.220 | 4°56'2" | 44.971 | 47.042 | 69.528 | 41.080 | 0.009 | 0.008 | 0.011 |
| 4 | 5K15B | 5.227 | 4°47'50" | 45.006 | 47.038 | 69.522 | 41.079 | 0.003 | 0.008 | 0.005 |
| 5 | 5K16B | 5.228 | 4°55'0" | 45.032 | 46.998 | 69.521 | 41.079 | 0.007 | 0.006 | 0.004 |
| 6 | 5K16B | 5.242 | 5°5'10" | 45.034 | 47.016 | 69.524 | 41.080 | 0.010 | 0.012 | 0.006 |
| 7 | 5K16B | 5.248 | 4°41'52" | 45.024 | 47.024 | 69.529 | 41.078 | 0.005 | 0.010 | 0.004 |
| 8 | 5K16B | 5.233 | 4°46'38" | 45.000 | 47.025 | 69.523 | 41.076 | 0.006 | 0.003 | 0.003 |
| 9 | 5K16B | 5.240 | 4°45'35" | 45.000 | 47.039 | 69.528 | 41.079 | 0.006 | 0.012 | 0.004 |
| 10 | 5K17B | 5.239 | 5°9'55" | 45.038 | 46.988 | 69.520 | 41.079 | 0.010 | 0.006 | 0.003 |
| 11 | 5K17B | 5.221 | 4°41'40" | 45.010 | 47.027 | 69.528 | 41.080 | 0.006 | 0.009 | 0.006 |
| 12 | 5K17B | 5.240 | 5°9'16" | 45.013 | 46.984 | 69.528 | 41.080 | 0.009 | 0.002 | 0.002 |
| 13 | 5K17B | 5.249 | 5°01'7" | 45.0130 | 47.008 | 69.520 | 41.080 | 0.010 | 0.013 | 0.009 |
| 14 | 5K17B | 5.243 | 5°07'2" | 45.029 | 46.994 | 69.522 | 41.079 | 0.006 | 0.014 | 0.005 |
| 15 | 5K18B | 5.231 | 5°09'23" | 45.047 | 46.985 | 69.527 | 41.080 | 0.003 | 0.009 | 0.003 |
| 16 | 5K18B | 5.236 | 5°07'38" | 45.039 | 46.995 | 69.523 | 41.080 | 0.005 | 0.008 | 0.004 |
| 17 | 5K18B | 5.248 | 5°5'34" | 45.038 | 46.999 | 69.523 | 41.080 | 0.007 | 0.006 | 0.002 |
| 18 | 5K18B | 5.249 | 5°9'9" | 45.035 | 46.994 | 69.526 | 41.080 | 0.008 | 0.015 | 0.004 |
| 19 | 5K18B | 5.240 | 5°2'7" | 45.020 | 46.956 | 69.526 | 41.079 | 0.007 | 0.006 | 0.005 |
| 20 | 5K19B | 5.233 | 5°9'42" | 45.039 | 47.004 | 69.521 | 41.078 | 0.006 | 0.005 | 0.001 |
| 21 | 5K19B | 5.244 | 5°01'23" | 45.030 | 46.998 | 69.527 | 41.078 | 0.010 | 0.005 | 0.004 |
| 22 | 5K19B | 5.236 | 4°44'28" | 45.029 | 47.008 | 69.523 | 41.080 | 0.009 | 0.013 | 0.004 |
| 23 | 5K19B | 5.221 | 4°51'35" | 45.032 | 47.006 | 69.527 | 41.079 | 0.010 | 0.013 | 0.004 |
| 24 | 5K19B | 5.226 | 4°53'44" | 45.032 | 46.997 | 69.529 | 41.080 | 0.007 | 0.015 | 0.018 |
| 25 | 5k19B | 5.231 | 5°03'6" | 44.988 | 47.032 | 69.522 | 41.076 | 0.009 | 0.007 | 0.006 |
| 26 | 5K23A | 5.212 | 4°44'32" | 45.008 | 47.019 | 69.526 | 41.0770 | 0.009 | 0.008 | 0.007 |
| 27 | 5K23A | 5.245 | 4°40' | 44.992 | 47.033 | 69.522 | 41.075 | 0.002 | 0.011 | 0.011 |



ตารางที่ 4.5 ตารางแสดงข้อมูลจากการวัดจุดที่สำคัญต่างๆ ของเรือนป้อม P 772 หลังการแก้ไขแล้ว (ต่อ)

| No. | Lot No. | Data Housing Machine | | | | | | | | |
|-----|---------|----------------------|--------------------|---------------|---------------|------------------|--------------------|-----------|-----------|-----------|
| | | 5.25 ± 0.05 | 5° ± 20' | R45 ± 0.05 | R47 ± 0.05 | ∅ 69.5 | 41 | 0.01 ⊥ | 0.01 ○ | 0.02 ▭ |
| | | 5.20 - 5.25 | 4° 40' - 5° 10' | | | 69.52 - 69.53 | 41.075 - 41.080 | | | |
| 28 | 5K23A | 5.221 | 5° 08' 58" | 45.029 | 46.990 | 69.524 | 41.079 | 0.006 | 0.004 | 0.003 |
| 29 | 5K23B | 5.235 | 5° 08' 1" | 44.999 | 47.015 | 69.522 | 41.080 | 0.010 | 0.009 | 0.011 |
| 30 | 5K23B | 5.247 | 5° 09' 42" | 45.016 | 47.007 | 69.522 | 41.079 | 0.009 | 0.012 | 0.002 |

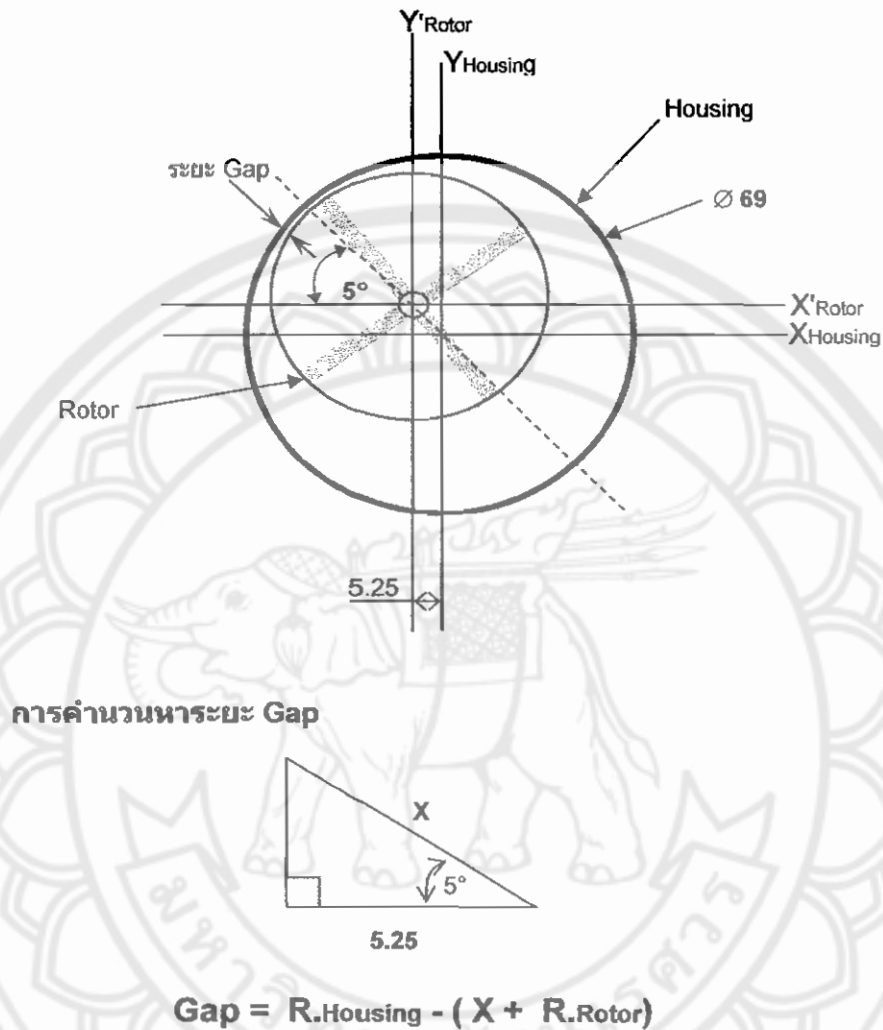
ตารางที่ 4.6 ตารางแสดงข้อมูลจากการวัดจุดที่สำคัญต่างๆ ของเพลท P 772 หลังการแก้ไขแล้ว

| No. | Lot No. | Data Plate Machine | | | | | |
|-----|---------|--------------------|------------|------------|------------|-----------|-----------|
| | | 5.25 ± 0.05 | 5° ± 20' | R45 ± 0.05 | R47 ± 0.05 | 0.01 ▭ | 0.04 ⊥ |
| 1 | 5K15B | 5.248 | 5° 30' 40" | 44.968 | 47.033 | 0.006 | 0.005 |
| 2 | 5K15B | 5.194 | 5° 20' 50" | 45.028 | 46.972 | 0.016 | 0.003 |
| 3 | 5K16B | 5.247 | 5° 27' 24" | 45.029 | 46.963 | 0.009 | 0.004 |
| 4 | 5K16B | 5.242 | 5° 34' 30" | 44.958 | 47.038 | 0.010 | 0.003 |
| 5 | 5K16B | 5.232 | 5° 32' 05" | 44.961 | 47.022 | 0.001 | 0.002 |
| 6 | 5K16B | 5.247 | 5° 32' 21" | 44.968 | 47.028 | 0.016 | 0.002 |
| 7 | 5K16B | 5.250 | 5° 27' 41" | 44.991 | 47.001 | 0.011 | 0.006 |
| 8 | 5K16B | 5.241 | 5° 20' 04" | 45.004 | 46.989 | 0.018 | 0.003 |
| 9 | 5K16B | 5.221 | 5° 09' 13" | 44.992 | 47.004 | 0.009 | 0.002 |
| 10 | 5K17B | 5.251 | 5° 18' 56" | 45.043 | 46.950 | 0.011 | 0.003 |
| 11 | 5K17B | 5.226 | 3° 55' 51" | 45.024 | 46.965 | 0.010 | 0.004 |
| 12 | 5K17B | 5.240 | 5° 32' 35" | 44.983 | 47.008 | 0.022 | 0.002 |
| 13 | 5K17B | 5.209 | 5° 25' 16" | 45.013 | 46.973 | 0.020 | 0.003 |
| 14 | 5K17B | 5.243 | 5° 36' 06" | 44.977 | 47.021 | 0.010 | 0.003 |
| 15 | 5K18B | 5.215 | 5° 34' 55" | 44.981 | 47.008 | 0.027 | 0.008 |
| 15 | 5K18B | 5.215 | 5° 34' 55" | 44.981 | 47.008 | 0.027 | 0.008 |
| 16 | 5K18B | 5.239 | 5° 33' 31" | 45.009 | 46.988 | 0.013 | 0.004 |
| 17 | 5K18B | 5.234 | 5° 28' 02" | 44.987 | 47.007 | 0.014 | 0.005 |

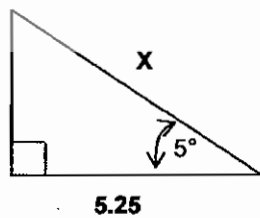
ตารางที่ 4.6 ตารางแสดงข้อมูลจากการวัดจุดที่สำคัญต่างๆ ของเพลท P 772 หลังการแก้ไขแล้ว (ต่อ)

| No. | Lot No. | Data Plate Machine | | | | | |
|-----|---------|--------------------|--------------------|----------------|----------------|--|--|
| | | 5.25 ± 0.05 | $5^\circ \pm 20''$ | $R45 \pm 0.05$ | $R47 \pm 0.05$ | 0.01  | 0.04  |
| 18 | 5K18B | 5.245 | 5°35'31" | 45.002 | 46.981 | 0.011 | 0.002 |
| 19 | 5K19B | 5.214 | 5°28'12" | 45.008 | 46.974 | 0.015 | 0.003 |
| 20 | 5K19B | 5.264 | 5°35'43" | 44.990 | 47.002 | 0.015 | 0.004 |
| 21 | 5K19B | 5.199 | 5°34'52" | 45.041 | 46.930 | 0.016 | 0.003 |
| 22 | 5K19B | 5.250 | 5°25'53" | 45.016 | 46.981 | 0.011 | 0.002 |
| 23 | 5K19B | 5.251 | 5°21'55" | 45.010 | 46.986 | 0.009 | 0.002 |
| 24 | 5K23A | 5.234 | 5°46'54" | 44.973 | 47.029 | 0.004 | - |
| 25 | 5K23A | 5.232 | 5°50'22" | 45.004 | 47.012 | 0.004 | - |
| 26 | 5K23A | 5.222 | 5°56'05" | 45.000 | 46.999 | 0.002 | - |
| 27 | 5K23A | 5.237 | 5°51'36" | 45.006 | 46.980 | 0.010 | - |
| 28 | 5K23B | 5.221 | 5°41'39" | 44.991 | 47.012 | 0.016 | 0.002 |
| 29 | 5K23B | 5.233 | 5°35'01" | 44.994 | 47.037 | 0.011 | 0.001 |
| 30 | 5K23B | 5.228 | 5°37'54" | 44.997 | 47.025 | 0.015 | 0.001 |

Housing & Rotor VIP P772



- EX. ทราบระยะห่างระหว่างจุดศูนย์กลางทั้งสองเท่ากับ 5.25 mm
 ทราบรัศมีของ Housing เท่ากับ 34.7565 mm
 ทราบรัศมีของ Rotor เท่ากับ 29.4 mm



$$X = \frac{5.25}{\cos 5^\circ} = 5.27 \text{ mm}$$

ดังนั้น $\text{Gap} = 34.7565 - (5.27 + 29.4) = 0.086 \text{ mm}$

การ Stamp Lot Number ๒๒ Housing

| วันที่ | สัญลักษณ์ |
|--------|-----------|
| 1 | 1 |
| 2 | 2 |
| 3 | 3 |
| 4 | 4 |
| 5 | 5 |
| 6 | 6 |
| 7 | 7 |
| 8 | 8 |
| 9 | 9 |
| 10 | A |
| 11 | B |
| 12 | C |
| 13 | D |
| 14 | E |
| 15 | F |
| 16 | G |
| 17 | H |
| 18 | J |
| 19 | K |
| 20 | L |
| 21 | M |
| 22 | N |
| 23 | O |
| 24 | P |
| 25 | Q |
| 26 | R |
| 27 | S |
| 28 | T |
| 29 | U |
| 30 | V |
| 31 | W |

| เดือน | สัญลักษณ์ |
|-----------|-----------|
| January | 1 |
| February | 2 |
| March | 3 |
| April | 4 |
| May | 5 |
| June | 6 |
| July | 7 |
| August | 8 |
| September | 9 |
| October | X |
| November | Y |
| December | Z |

| ปี | สัญลักษณ์ |
|------|-----------|
| 2005 | 5 |
| 2006 | 6 |
| 2007 | 7 |
| 2008 | 8 |
| 2009 | 9 |
| 2010 | 10 |
| 2011 | 11 |