

# Raport pomiarowy / Inspection Report / Vermessungsprotokoll

**1655/20**

Klient / Customer / Kunde

Nazwa narzędzia / Name of tools / Werkzeuge OBERSTEMPEL EURO D

Nr rysunku / Drawing No / Zeichnung Nr SGNDAXBV03 TA21X10 XDOV-21x100-01-O-N-ADAM

Typ / Type / Typ Korsch XL 400

Materiał / Material / Material 1.2358

Wytap / Welt / Stahl SN dv 78038

HRC 59/55

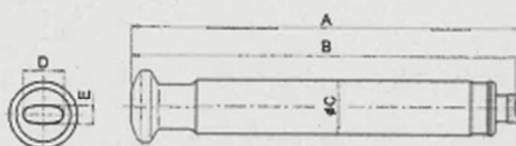
Nie zgodność z rysunkami / According drawings / Übereinstimmung mit Zeichnungen

Powłoka / Coating / Beschichtung Nie/No/Nein

Kreska / Line / Bruchlinie Nie/No/Nein

Grawer / Engraving / Gravur Nie/No/Nein

Gebucht 532



|           |           |          |          |          |         |
|-----------|-----------|----------|----------|----------|---------|
| A 133.600 | B 131.600 | C 25.350 | D 21.000 | E 10.000 | F 0.000 |
|-----------|-----------|----------|----------|----------|---------|

|    | A       | B       | C      | D      | E     | F |    | A       | B       | C      | D      | E     | F |
|----|---------|---------|--------|--------|-------|---|----|---------|---------|--------|--------|-------|---|
| 1  | 133.595 | 131.600 | 25.344 | 20.977 | 9.979 |   | 26 | 133.599 | 131.593 | 25.345 | 20.974 | 9.977 |   |
| 2  | 133.596 | 131.592 | 25.345 | 20.974 | 9.978 |   | 27 | 133.598 | 131.594 | 25.344 | 20.977 | 9.978 |   |
| 3  | 133.598 | 131.597 | 25.342 | 20.975 | 9.977 |   | 28 | 133.598 | 131.592 | 25.345 | 20.974 | 9.979 |   |
| 4  | 133.596 | 131.595 | 25.343 | 20.976 | 9.978 |   | 29 | 133.599 | 131.598 | 25.346 | 20.975 | 9.978 |   |
| 5  | 133.596 | 131.595 | 25.342 | 20.975 | 9.979 |   | 30 | 133.597 | 131.599 | 25.345 | 20.976 | 9.979 |   |
| 6  | 133.596 | 131.599 | 25.343 | 20.973 | 9.978 |   | 31 | 133.597 | 131.596 | 25.346 | 20.975 | 9.978 |   |
| 7  | 133.599 | 131.594 | 25.346 | 20.975 | 9.979 |   | 32 | 133.597 | 131.593 | 25.343 | 20.973 | 9.979 |   |
| 8  | 133.596 | 131.594 | 25.345 | 20.976 | 9.978 |   | 33 | 133.596 | 131.592 | 25.345 | 20.975 | 9.978 |   |
| 9  | 133.596 | 131.599 | 25.344 | 20.975 | 9.979 |   | 34 | 133.599 | 131.595 | 25.346 | 20.976 | 9.977 |   |
| 10 | 133.598 | 131.591 | 25.345 | 20.977 | 9.978 |   | 35 | 133.596 | 131.598 | 25.345 | 20.976 | 9.978 |   |
| 11 | 133.597 | 131.596 | 25.345 | 20.974 | 9.979 |   | 36 |         |         |        |        |       |   |
| 12 | 133.596 | 131.597 | 25.343 | 20.975 | 9.978 |   | 37 |         |         |        |        |       |   |
| 13 | 133.596 | 131.593 | 25.342 | 20.976 | 9.977 |   | 38 |         |         |        |        |       |   |
| 14 | 133.596 | 131.588 | 25.343 | 20.975 | 9.978 |   | 39 |         |         |        |        |       |   |
| 15 | 133.595 | 131.599 | 25.346 | 20.973 | 9.979 |   | 40 |         |         |        |        |       |   |
| 16 | 133.596 | 131.597 | 25.345 | 20.975 | 9.977 |   | 41 |         |         |        |        |       |   |
| 17 | 133.596 | 131.589 | 25.344 | 20.976 | 9.979 |   | 42 |         |         |        |        |       |   |
| 18 | 133.595 | 131.597 | 25.345 | 20.974 | 9.978 |   | 43 |         |         |        |        |       |   |
| 19 | 133.596 | 131.595 | 25.342 | 20.974 | 9.978 |   | 44 |         |         |        |        |       |   |
| 20 | 133.599 | 131.599 | 25.343 | 20.977 | 9.977 |   | 45 |         |         |        |        |       |   |
| 21 | 133.598 | 131.598 | 25.342 | 20.974 | 9.978 |   | 46 |         |         |        |        |       |   |
| 22 | 133.599 | 131.595 | 25.343 | 20.975 | 9.979 |   | 47 |         |         |        |        |       |   |
| 23 | 133.599 | 131.598 | 25.346 | 20.976 | 9.978 |   | 48 |         |         |        |        |       |   |
| 24 | 133.598 | 131.592 | 25.345 | 20.973 | 9.979 |   | 49 |         |         |        |        |       |   |
| 25 | 133.597 | 131.598 | 25.346 | 20.975 | 9.978 |   | 50 |         |         |        |        |       |   |

Inspektor jakości / Quality inspector / Kontroller

Jakubiak Paweł

Data / Date / Datum 2020-09-22

*Jakubiak*



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# Raport pomiarowy / Inspection Report / Vermessungsprotokoll **1655/20**

Klient / Customer / Kunde

Nazwa narzędzia / Name of tools / Werkzeuge UNTERSTEMPEL EURO D

Nr rysunku / Drawing No / Zeichnung Nr SDNDAXB03 TA21X10 XDOV-21x100-01-U-ADAM

Typ / Type / Typ Korsch XL 400

Materiał / Material / Material 1.2358

Wytap / Melt / Stahl SM dv 78038  
HRC 59/55

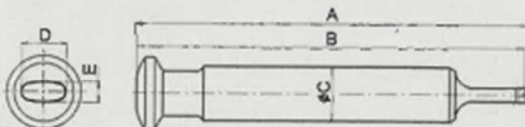
Na zgodność z rysunkami / According drawings / Übereinstimmung mit Zeichnungen

Powłoka / Coating / Beschichtung Nie/No/Nein

Kreska / Line / Bruchkerbe Nie/No/Nein

Grawer / Engraving / Gravier Nie/No/Nein

**Gebucht** 538



|                      |                      |                      |                     |                     |                   |
|----------------------|----------------------|----------------------|---------------------|---------------------|-------------------|
| A 133.600 $\pm 0.02$ | B 131.600 $\pm 0.02$ | C 25.350 $\pm 0.013$ | D 21.000 $\pm 0.02$ | E 10.000 $\pm 0.02$ | F 0.000 $\pm 0.0$ |
|----------------------|----------------------|----------------------|---------------------|---------------------|-------------------|

|    | A       | B       | C      | D      | E     | F |    | A       | B       | C      | D      | E     | F |
|----|---------|---------|--------|--------|-------|---|----|---------|---------|--------|--------|-------|---|
| 1  | 133.592 | 131.598 | 25.344 | 20.977 | 9.978 |   | 26 | 133.595 | 131.595 | 25.342 | 20.975 | 9.976 |   |
| 2  | 133.593 | 131.593 | 25.341 | 20.974 | 9.977 |   | 27 | 133.599 | 131.598 | 25.343 | 20.976 | 9.975 |   |
| 3  | 133.593 | 131.589 | 25.343 | 20.975 | 9.978 |   | 28 | 133.600 | 131.596 | 25.342 | 20.975 | 9.976 |   |
| 4  | 133.591 | 131.597 | 25.342 | 20.976 | 9.975 |   | 29 | 133.599 | 131.596 | 25.343 | 20.977 | 9.975 |   |
| 5  | 133.593 | 131.589 | 25.343 | 20.975 | 9.976 |   | 30 | 133.598 | 131.597 | 25.342 | 20.974 | 9.977 |   |
| 6  | 133.593 | 131.585 | 25.342 | 20.973 | 9.975 |   | 31 | 133.599 | 131.594 | 25.344 | 20.975 | 9.978 |   |
| 7  | 133.591 | 131.586 | 25.344 | 20.975 | 9.976 |   | 32 | 133.599 | 131.598 | 25.341 | 20.976 | 9.975 |   |
| 8  | 133.593 | 131.588 | 25.341 | 20.976 | 9.978 |   | 33 | 133.597 | 131.595 | 25.342 | 20.975 | 9.976 |   |
| 9  | 133.590 | 131.583 | 25.342 | 20.975 | 9.977 |   | 34 | 133.600 | 131.596 | 25.343 | 20.973 | 9.975 |   |
| 10 | 133.593 | 131.593 | 25.343 | 20.974 | 9.978 |   | 35 | 133.599 | 131.598 | 25.342 | 20.975 | 9.976 |   |
| 11 | 133.591 | 131.594 | 25.342 | 20.977 | 9.978 |   | 36 |         |         |        |        |       |   |
| 12 | 133.594 | 131.586 | 25.343 | 20.974 | 9.977 |   | 37 |         |         |        |        |       |   |
| 13 | 133.594 | 131.590 | 25.342 | 20.975 | 9.978 |   | 38 |         |         |        |        |       |   |
| 14 | 133.594 | 131.585 | 25.343 | 20.976 | 9.975 |   | 39 |         |         |        |        |       |   |
| 15 | 133.593 | 131.594 | 25.342 | 20.975 | 9.976 |   | 40 |         |         |        |        |       |   |
| 16 | 133.593 | 131.587 | 25.343 | 20.973 | 9.975 |   | 41 |         |         |        |        |       |   |
| 17 | 133.592 | 131.591 | 25.344 | 20.975 | 9.976 |   | 42 |         |         |        |        |       |   |
| 18 | 133.591 | 131.585 | 25.341 | 20.976 | 9.978 |   | 43 |         |         |        |        |       |   |
| 19 | 133.593 | 131.591 | 25.342 | 20.975 | 9.977 |   | 44 |         |         |        |        |       |   |
| 20 | 133.594 | 131.595 | 25.343 | 20.977 | 9.978 |   | 45 |         |         |        |        |       |   |
| 21 | 133.594 | 131.590 | 25.342 | 20.974 | 9.975 |   | 46 |         |         |        |        |       |   |
| 22 | 133.593 | 131.586 | 25.343 | 20.975 | 9.976 |   | 47 |         |         |        |        |       |   |
| 23 | 133.593 | 131.582 | 25.342 | 20.976 | 9.975 |   | 48 |         |         |        |        |       |   |
| 24 | 133.593 | 131.587 | 25.344 | 20.975 | 9.976 |   | 49 |         |         |        |        |       |   |
| 25 | 133.594 | 131.591 | 25.341 | 20.973 | 9.978 |   | 50 |         |         |        |        |       |   |

Inspektor jakości / Quality Inspector / Kontroller

Jakubiak Paweł

Data / Date / Datum 2020-09-22



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# Raport pomiarowy / Inspection Report / Vermessungsprotokoll **1655/20**

Klient / Customer / Kunde

Nazwa narzędzia / Name of tools / Werkzeuge MATRIZE EURO D

Nr rysunku / Drawing No / Zeichnung Nr MNDXBXW2V02 TA21X10 XDOV-21x100-01-VW-0.03-M-ADAMUS / Type / Typ Korsch XL 400

Materiał / Material / Material 1.2080

 Wytap / Melt / Stahl SN  
 HRC 61

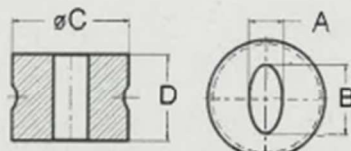
Na zgodność z rysunkami / According drawings / Übereinstimmung mit Zeichnungen

Powłoka / Coating / Beschichtung Nie/No/Nein

Kreska / Line / Bruchkante Nie/No/Nein

Grawer / Engraving / Gravier Nie/No/Nein

Gebucht 533



|          |          |          |          |         |         |
|----------|----------|----------|----------|---------|---------|
| A 10.000 | B 21.000 | C 38.100 | D 23.800 | E 0.000 | F 0.000 |
|----------|----------|----------|----------|---------|---------|

|    | A      | B      | C      | D      | E | F |    | A      | B      | C      | D      | E | F |
|----|--------|--------|--------|--------|---|---|----|--------|--------|--------|--------|---|---|
| 1  | 10.010 | 21.005 | 38.098 | 23.794 |   |   | 26 | 10.010 | 21.006 | 38.098 | 23.794 |   |   |
| 2  | 10.011 | 21.007 | 38.096 | 23.797 |   |   | 27 | 10.012 | 21.007 | 38.096 | 23.800 |   |   |
| 3  | 10.010 | 21.005 | 38.099 | 23.800 |   |   | 28 | 10.009 | 21.006 | 38.099 | 23.796 |   |   |
| 4  | 10.013 | 21.006 | 38.097 | 23.798 |   |   | 29 | 10.010 | 21.004 | 38.096 | 23.800 |   |   |
| 5  | 10.010 | 21.005 | 38.098 | 23.799 |   |   | 30 | 10.014 | 21.011 | 38.097 | 23.800 |   |   |
| 6  | 10.010 | 21.004 | 38.096 | 23.798 |   |   | 31 | 10.011 | 21.008 | 38.099 | 23.797 |   |   |
| 7  | 10.009 | 21.003 | 38.099 | 23.795 |   |   | 32 | 10.012 | 21.009 | 38.097 | 23.799 |   |   |
| 8  | 10.015 | 21.011 | 38.096 | 23.798 |   |   | 33 | 10.012 | 21.004 | 38.098 | 23.800 |   |   |
| 9  | 10.011 | 21.010 | 38.097 | 23.796 |   |   | 34 | 10.009 | 21.006 | 38.096 | 23.797 |   |   |
| 10 | 10.015 | 21.009 | 38.098 | 23.793 |   |   | 35 | 10.008 | 21.005 | 38.099 | 23.798 |   |   |
| 11 | 10.012 | 21.006 | 38.096 | 23.794 |   |   | 36 |        |        |        |        |   |   |
| 12 | 10.013 | 21.007 | 38.098 | 23.799 |   |   | 37 |        |        |        |        |   |   |
| 13 | 10.011 | 21.007 | 38.096 | 23.799 |   |   | 38 |        |        |        |        |   |   |
| 14 | 10.014 | 21.014 | 38.099 | 23.793 |   |   | 39 |        |        |        |        |   |   |
| 15 | 10.012 | 21.005 | 38.097 | 23.800 |   |   | 40 |        |        |        |        |   |   |
| 16 | 10.013 | 21.007 | 38.098 | 23.799 |   |   | 41 |        |        |        |        |   |   |
| 17 | 10.012 | 21.005 | 38.096 | 23.798 |   |   | 42 |        |        |        |        |   |   |
| 18 | 10.010 | 21.008 | 38.098 | 23.793 |   |   | 43 |        |        |        |        |   |   |
| 19 | 10.009 | 21.008 | 38.096 | 23.800 |   |   | 44 |        |        |        |        |   |   |
| 20 | 10.012 | 21.005 | 38.097 | 23.794 |   |   | 45 |        |        |        |        |   |   |
| 21 | 10.014 | 21.007 | 38.099 | 23.799 |   |   | 46 |        |        |        |        |   |   |
| 22 | 10.012 | 21.008 | 38.097 | 23.800 |   |   | 47 |        |        |        |        |   |   |
| 23 | 10.012 | 21.005 | 38.099 | 23.798 |   |   | 48 |        |        |        |        |   |   |
| 24 | 10.012 | 21.009 | 38.098 | 23.799 |   |   | 49 |        |        |        |        |   |   |
| 25 | 10.010 | 21.003 | 38.096 | 23.800 |   |   | 50 |        |        |        |        |   |   |

Inspektor jakości / Quality Inspector / Kontrollier

Wójtowicz Wojciech

Data / Date / Datum 2020-09-24



ISO 13485

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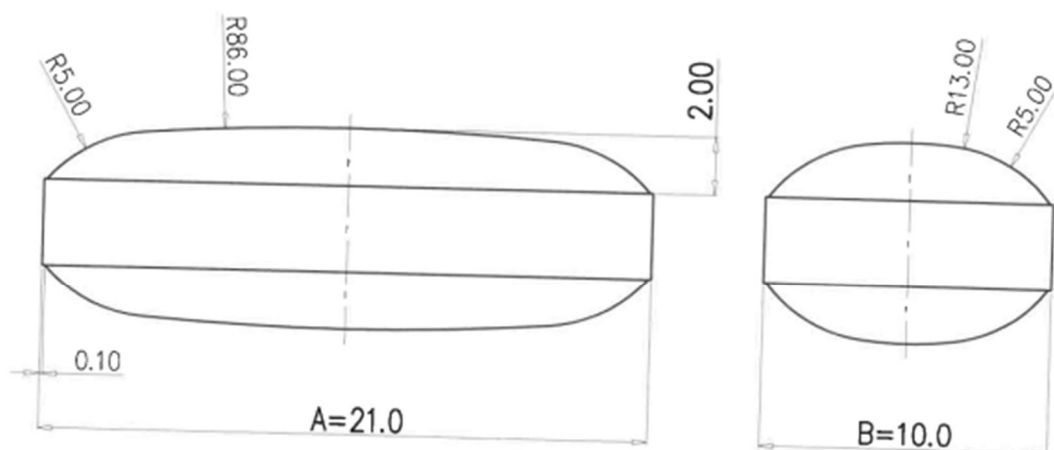
Tabletten-/Drageekernmaße: Oval 21x10

Volumen:  $180.1 \text{ mm}^2 \times H + 445.6 \text{ mm}^3$

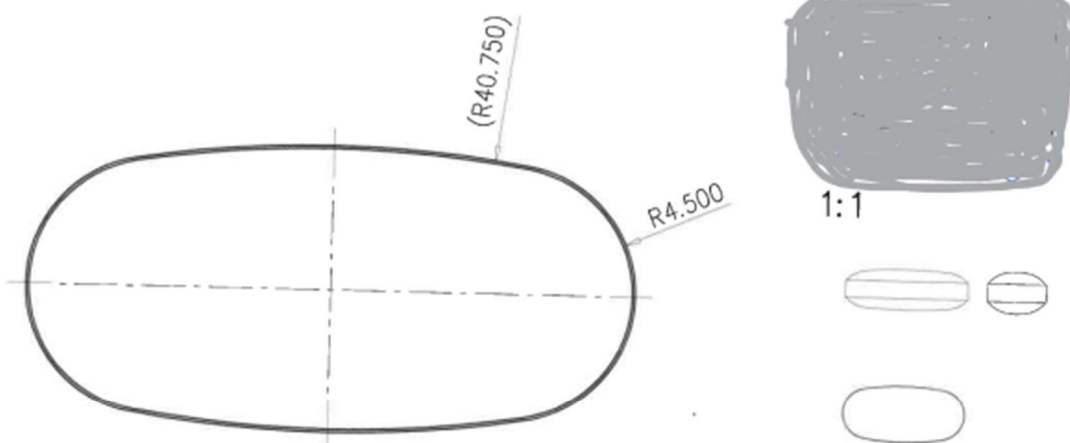
2000 mg mit  $H = 6.07 \text{ mm}$  und  $\rho = 1.3 \text{ mg/mm}$

Stempelbelastbarkeit: 81kN für Werkstoff: 1.2358 H: Steghöhe in [mm]

Bei hartverchromten Stempeln bitte 80% der angegebenen Presskräften anwenden.



Ansicht der Prägefläche vom Oberstempel und Unterstempel



1.2358+  
zlec.1518/17



|                       |                                                                                        |                            |
|-----------------------|----------------------------------------------------------------------------------------|----------------------------|
| Höhe H:               | Produkt:                                                                               | Kunde:                     |
| Gezeichnet A.Teresiak |                                                                                        |                            |
| Geprüft S.Skrzypek    |                                                                                        | Maßstab                    |
| Freigabe S.Skrzypek   |                                                                                        | 5:1/A4                     |
| Benennung:            | Tabletten/Drageekern Oval 21x10<br>ohne Bruchkerbe,<br>Wölbungsradius Stirnseite R 5,0 | Zeichnung Nr.<br>W000180TK |