

Step 3

QUALITY ASSESSMENT

The screenshot displays the PQS ARC software interface with several key components:

- Top Panel:** Includes buttons for "Diagramme F1", "Q-Überblick F2", "Protokoll F3", and "Lernmodus F4". It also shows a "Zeit" (Time) section with "4 min" and "Zähl" (Count) values.
- Table:** A table listing data points for different stations and components.

Brenner	Naht-Bez.	Naht-Nr.
Rob3	Station2_N70_re1	270
Rob3	Station2_N71_re2	271
Rob3	Station2_N74_R1	274
Rob3	Station2_N75_R2	275
Rob3	Station2_N70_re2	270
Rob3	Station3_N71_re1	271
Rob3	Station3_N74_R2	274
Rob3	Station3_N75_R1	275
Rob3	Station4_N70_re1	470
Rob3	Station4_N71_re2	471
Rob3	Station4_N74_R1	474
Rob3	Station4_N75_R2	475
- Bottom Panel:** Shows "Nahtinformationen" (Welding Information) with a graph of resistance over time and a table of parameters.

Parameter	Value
Datum	2005-10-07
Uhrzeit	10:43:38
BT-Nr	28013117
Naht-Nr	9
Naht-Bez	Station3_N70_re
Bewertung	0
SZ	2.73 s
Qualität	88.54
Ueff ges	22.95 V
Ieff ges	212.17 A
P rechn	4.87

Documentation of test results

Under "Enter test report" the mask for the documentation of test results opens. Here you find a list of all components marked as a test part.

Entering actual values ascertained

Here quality parameters ascertained (e.g. spot diameter, torque) are entered. In addition, further remarks (e.g. test force, type of breaking etc.) can be entered in the window "component information" and "spot information".

Test part analysis

The corresponding course of resistance in comparison to the total allocation of all weldings of the corresponding spot is displayed.

3. Quality assessment

Thanks to the targeted sampling by application of destructive tests the verifiability of the PQS inline monitoring is prepared. Measurements achieved can be directly stored in the PQS and allocated to each component part and each joint position. For this purpose, all process data monitored by PQS is permanently available.

