

HIGH SPEED PRECISION LATHE

ACCURACY CHART




MODEL: SB1054

SERIAL NO: SB1054-0003

MANUFACTURE
DATE: 03.2011

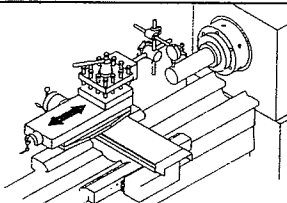
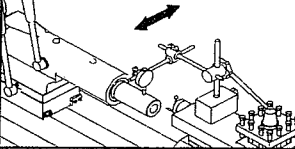
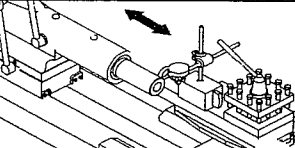
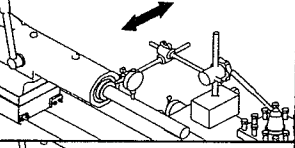
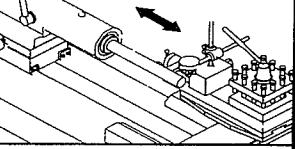
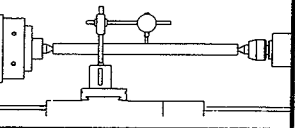
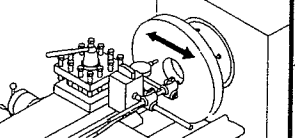
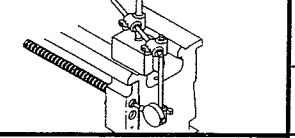
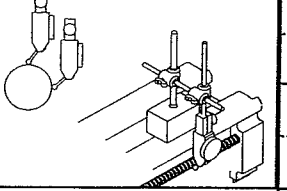
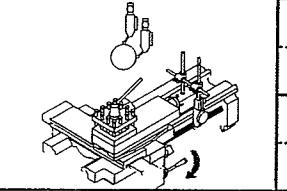
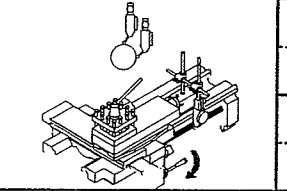
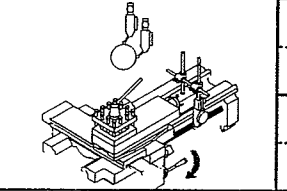
INVERTER: _____

ELECTRIC
POWER: Ø360 HZ 440V

| AUTHORIZED SIGNATURE | | |
|---|---|--|
| PLANT MANAGER | CHIEF INSPECTOR | PLANT INSPECTOR |
|  |  |  |

I.STATIC PRECISION INSPECTION

| TEST | | | RECOMMENDED STANDARDS | | ACTUAL | | |
|--|--------------------------------|---|---|------------------------------|-----------------------------|----------------------------|--------------------|
| No. | Item | | Illustration | ~500mm | 500~1000mm | ~500mm | 500~1000mm |
| | | | | Metric Imperial | Metric Imperial | Metric Imperial | Metric Imperial |
| 1 | Straightness of bed slide ways | Longitudinal direction (in vertical plane) | | 0.04 /1000mm 0.0016 /40" | 0.05 /1000mm 0.002 /40" | 0.0005 | |
| | | Transverse direction (in vertical plane) | | 0.04 /1000mm 0.0016 /40" | 0.05 /1000mm 0.002 /40" | | 0.0013 |
| 3 | Parallelism of bed slide ways | | | 0.015 /1000mm 0.0006 /40" | 0.02 /1000mm 0.0008 /40" | 0.0004 | |
| | 4 Spindle center runout | | | 0.01mm 0.0004" | ED 0.0006" | | 0.0007 |
| 5 | Spindle nose runout | | | 0.008mm 0.00032" | 0.01mm 0.0004" | 0.0007 | |
| | 6 | Runout of flange end face of spindle | | | 0.01mm 0.0004" | | 0.015mm 0.0006" |
| 7 | | Spindle taper hole runout(at end of test bar) | | | 0.015 /300mm 0.0006 /12" | 0.02 /300mm 0.0008 /12" | 0.0005 |
| | 8 | Parallelism of center line of main spindle to longitudinal motion of carriage | in vertical plane(high at free end of test bar) | | 0.01 /300mm 0.0004 /12" | 0.02 /300mm 0.0008 /12" | |
| in horizontal plane(forward at free end of test bar) | | | | 0.01 /300mm 0.0004 /12" | 0.02 /300mm 0.0008 /12" | 0.00039 | |

| TEST | | | RECOMMENDED STANDARDS | | ACTUAL | |
|------|--|---|-----------------------|--------------------|--------------------|--------------------|
| No. | Item | Illustration | ~500mm | 500 ~ 1000mm | ~500mm | 500 ~ 1000mm |
| | | | Metric Imperial | Metric Imperial | Metric Imperial | Metric Imperial |
| 9 | Parallelism between center lines of spindle and longitudinal motion of tool slide(in vertical plane) | | 0.015 /150mm | 0.02 /150mm | | |
| | |  | 0.0006 /6" | 0.0008 /6" | 0.0004 | |
| 10 | Parallelism between longitudinal motion of carriage and center line of tailstock spindle hole | in vertical plane(hight at free end) | 0.015 /150mm | 0.02 /150mm | | |
| | |  | 0.0006 /6" | 0.0008 /6" | 0.0005 | |
| | | in horizontal plane(forward at free end) | 0.008 /150mm | 0.01 /150mm | | |
| | |  | 0.00032 /6" | 0.0004 /6" | 0.0003 | |
| 11 | Parallelism between longitudinal motion of carriage and center line of tailstock spindle bore | in vertical plane(hight at free end) | 0.015 /300mm | 0.02 /300mm | | |
| | |  | 0.0006 /12" | 0.0008 /12" | 0.0004 | |
| | | in horizontal plane(forward at free end) | 0.01 /300mm | 0.02 /300mm | | |
| | |  | 0.0004 /12" | 0.0008 /12" | 0.0003 | |
| 12 | Difference in center height between head stock & tailstock(hight at tailstock) | | 0.015 /300mm | 0.02 /300mm | | |
| | |  | 0.0006 /12" | 0.0008 /12" | 0.0004 | |
| 13 | Squareness of cross slide motion with center line of main spindle | | 0.02 /300mm | 0.03 /300mm | | |
| | |  | 0.0008 /12" | 0.0012 /12" | 0.0007 | |
| 14 | Axial slip of leadscrew | | 0.05mm | 0.01mm | | |
| | |  | 0.0002" | 0.0004" | 0.00019 | |
| 15 | Parallelism of center line of leadscrew bearing to carriage slideways | in vertical plane | 0.1mm | 0.1mm | | |
| | |  | 0.004" | 0.004" | 0.0007 | |
| | | in horizontal plane | 0.1mm | 0.1mm | | |
| | |  | 0.004" | 0.004" | 0.00039 | |
| 16 | Alignment of leadscrew with half nut | in vertical plane | 0.15mm | 0.15mm | | |
| | |  | 0.006" | 0.006" | 0.00047 | |
| | | in horizontal plane | 0.15mm | 0.15mm | | |
| | |  | 0.006" | 0.006" | 0.00058 | |