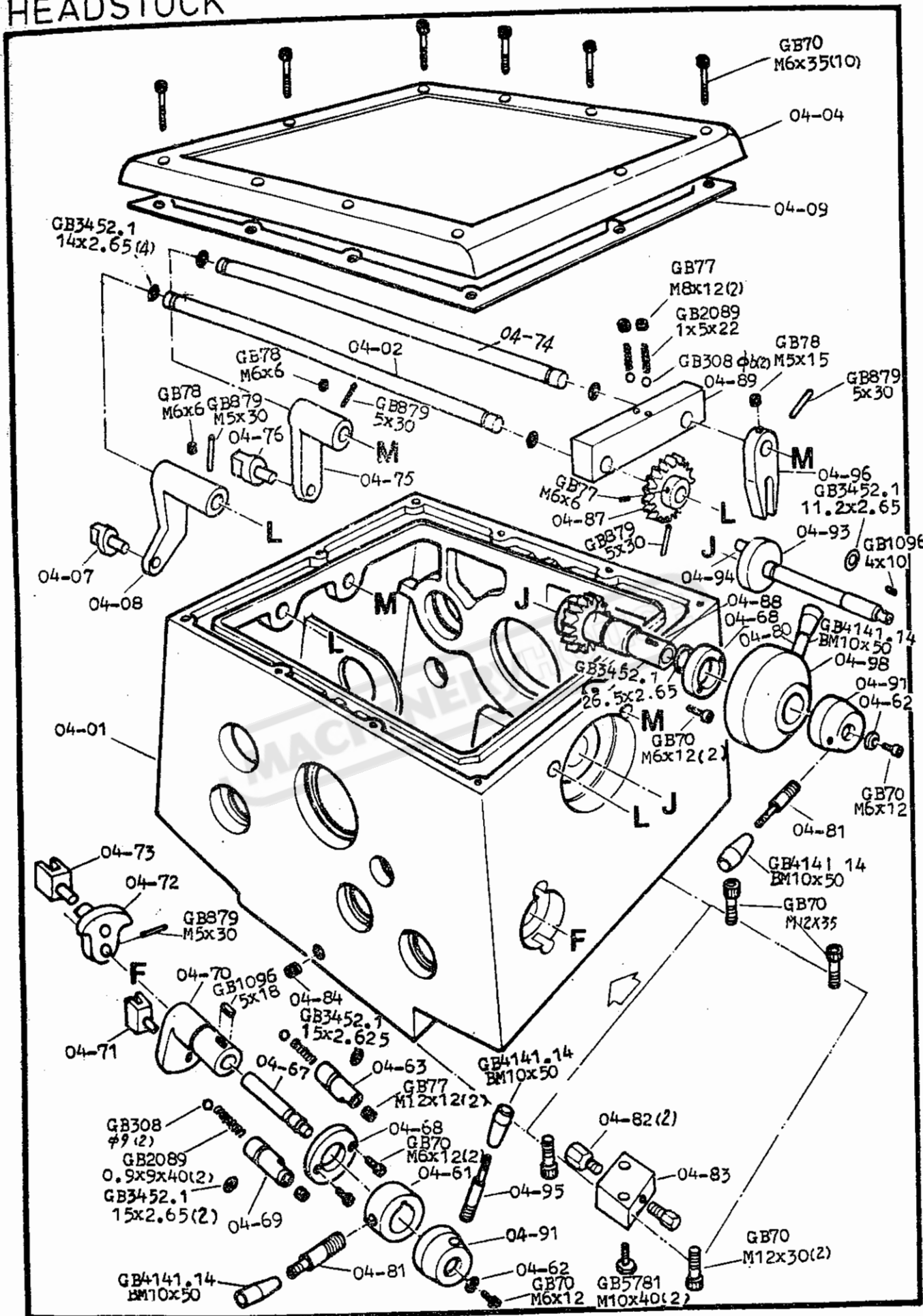
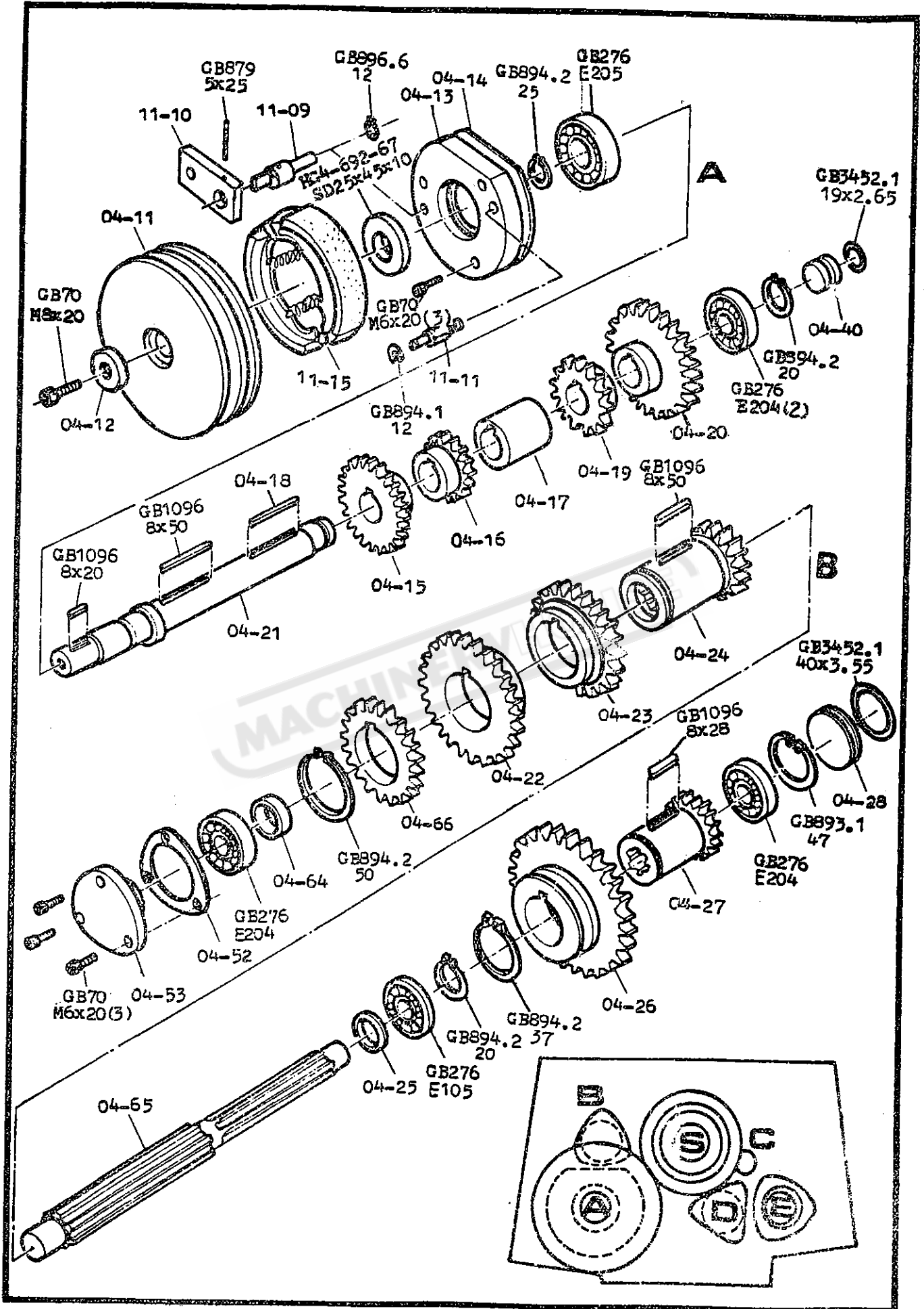


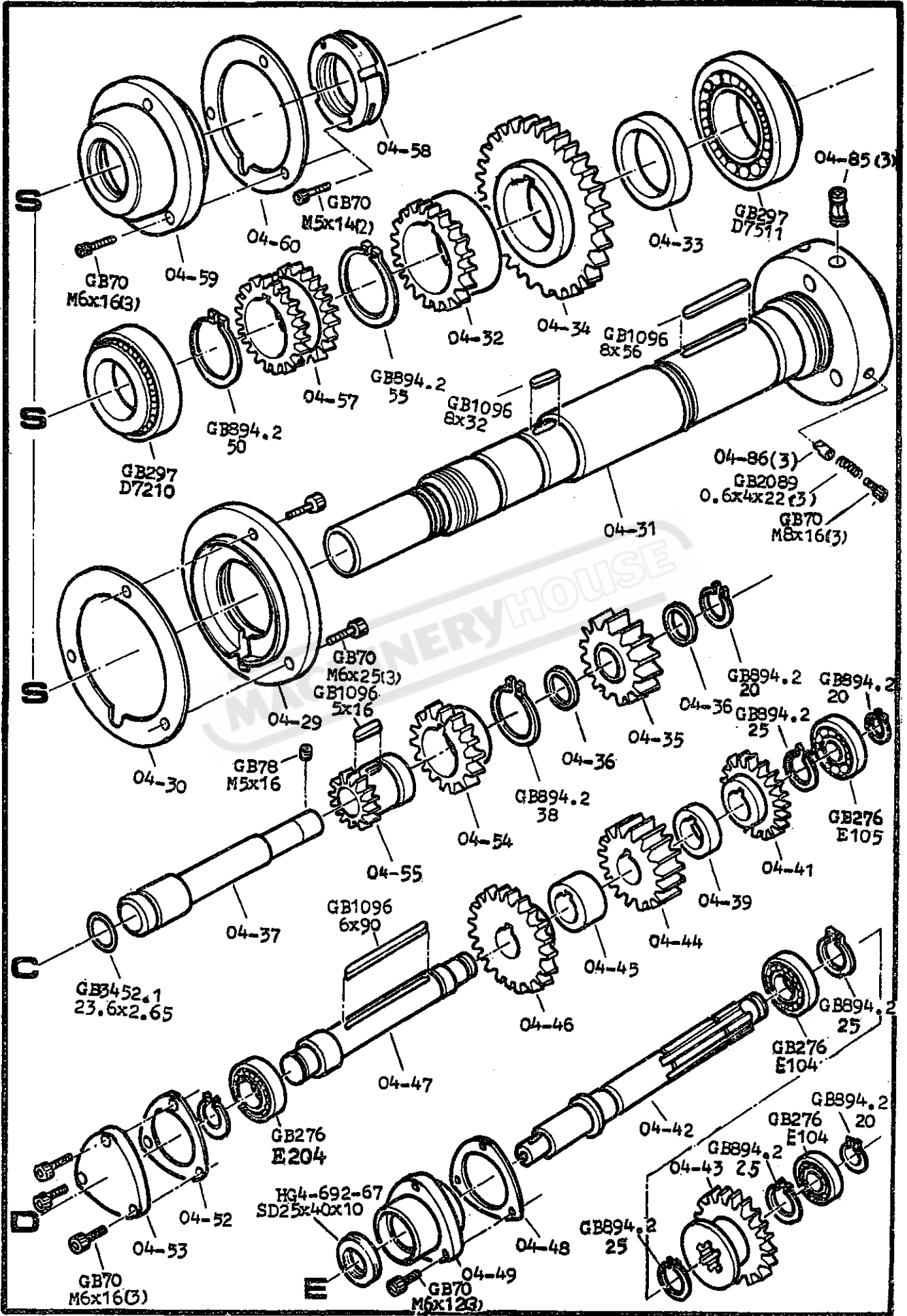
# HEADSTOCK



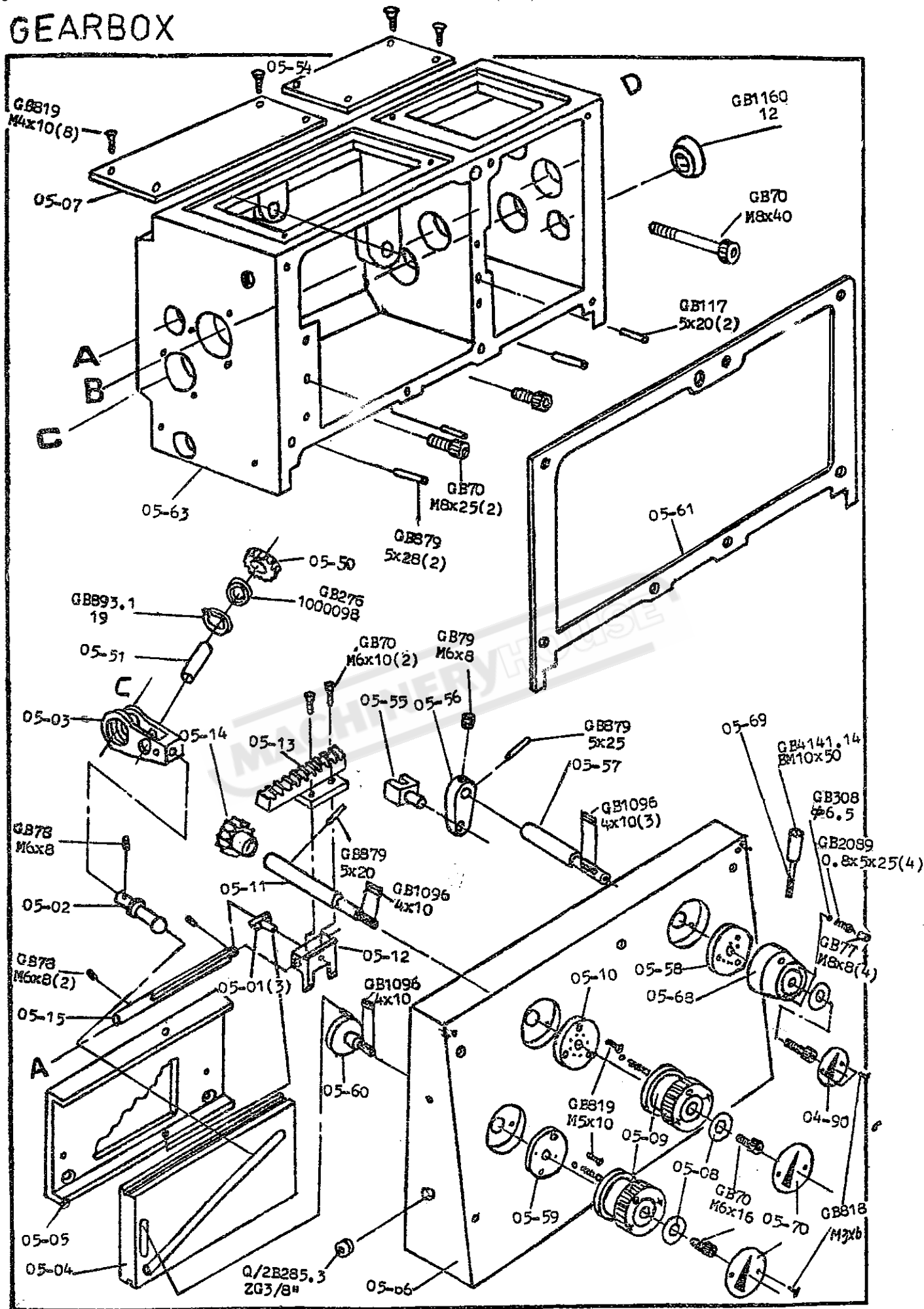
# HEADSTOCK



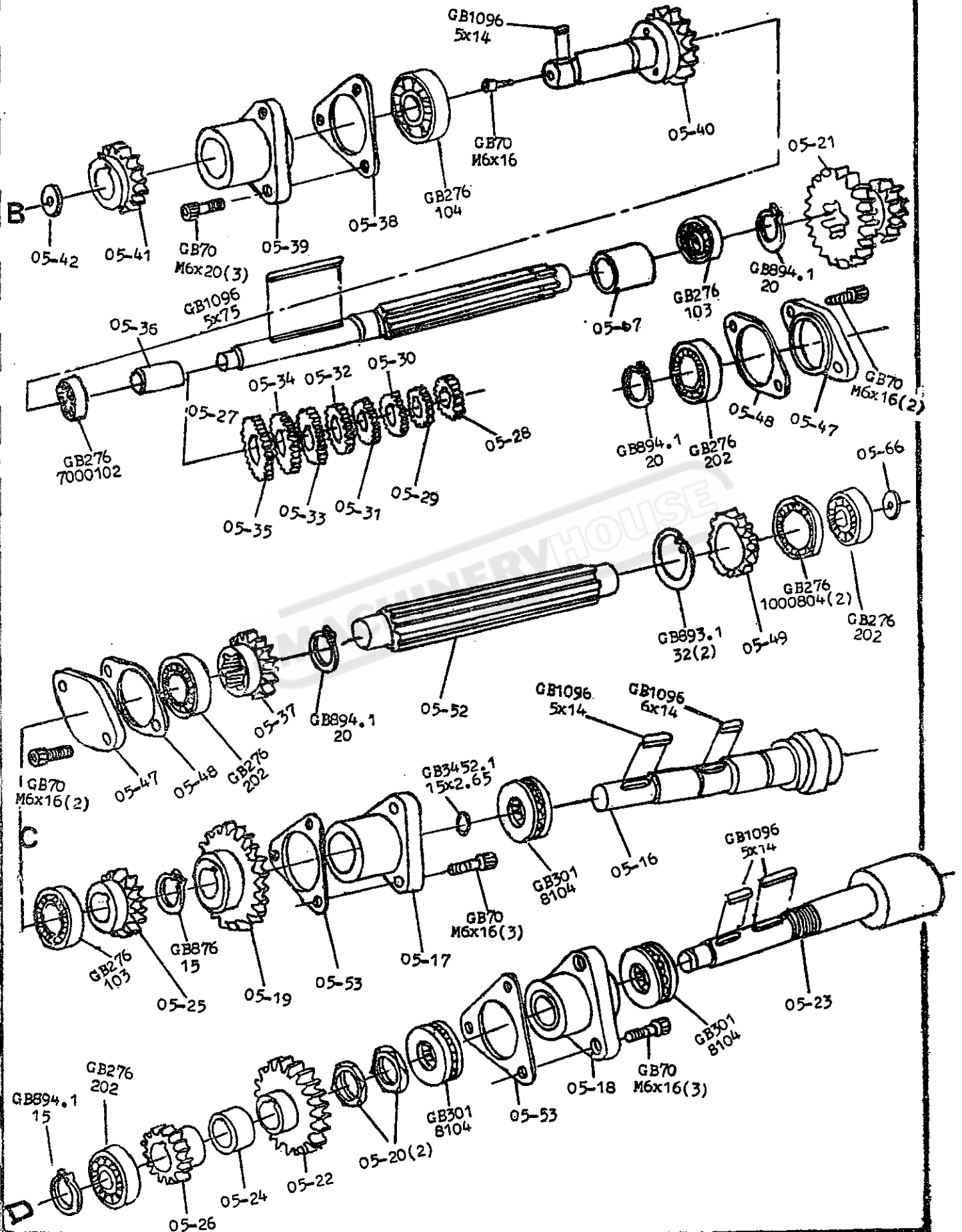
# HEADSTOCK



# GEARBOX

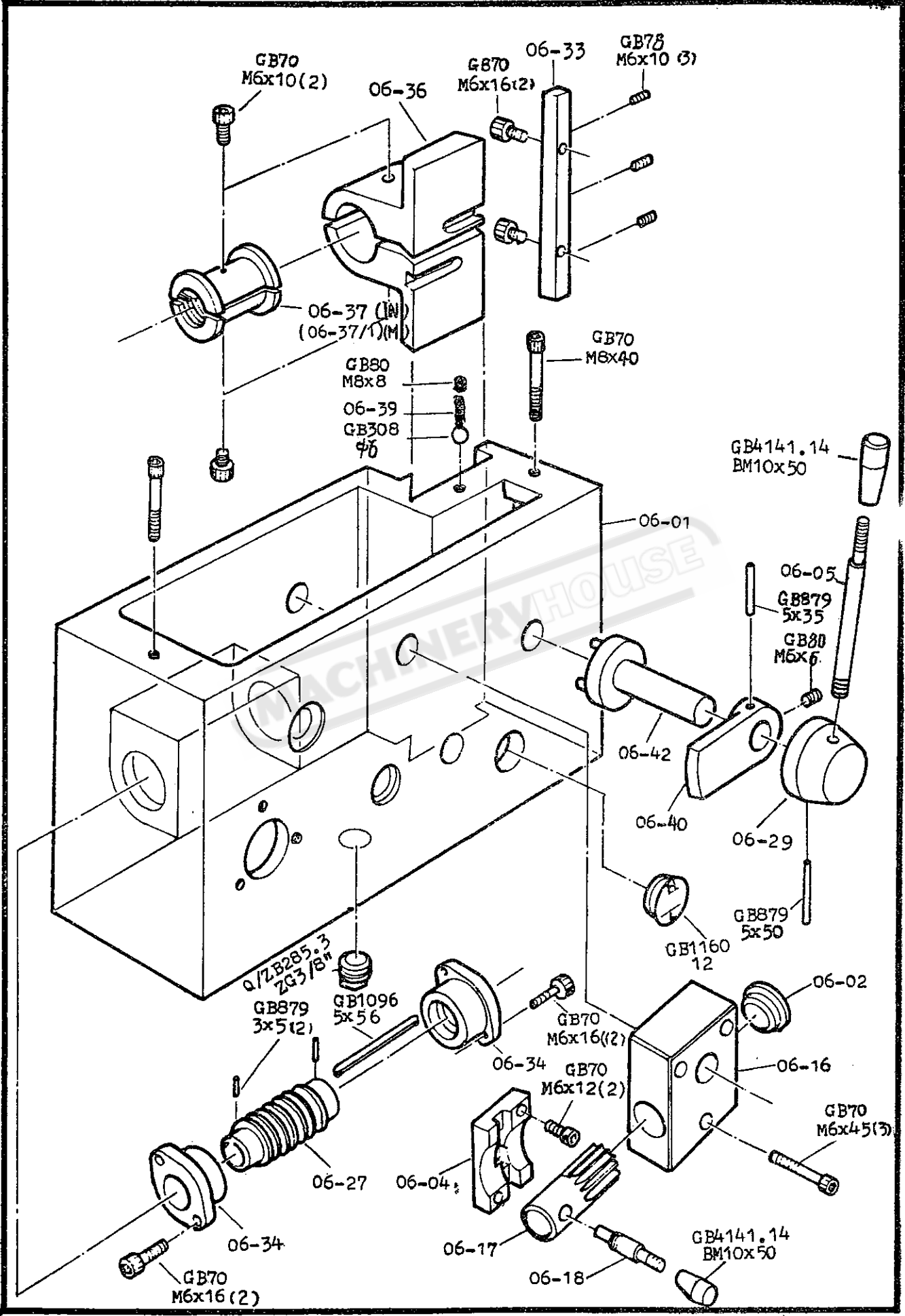


# GEARBOX Inch system

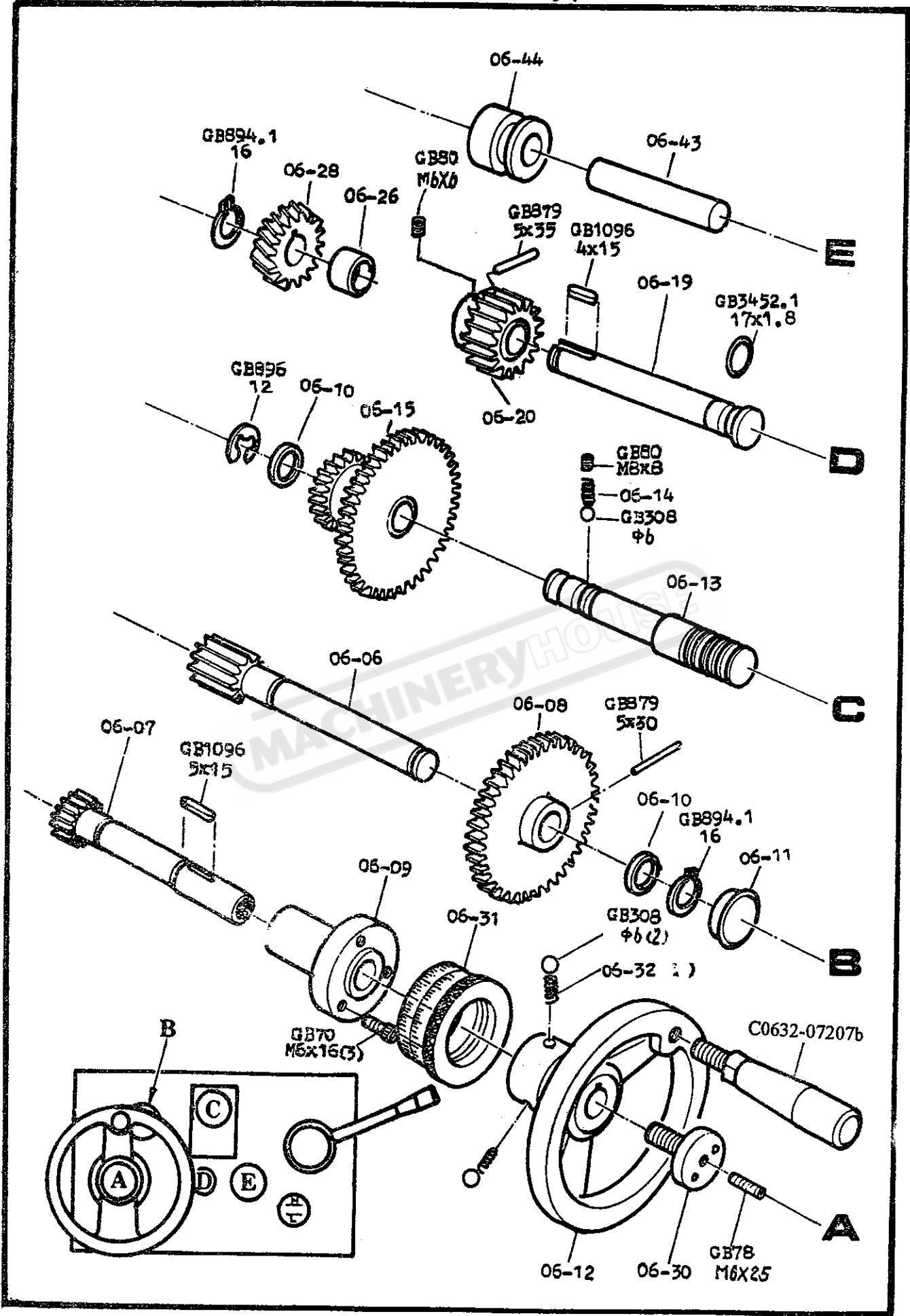




# APRON Left hand, Lever type

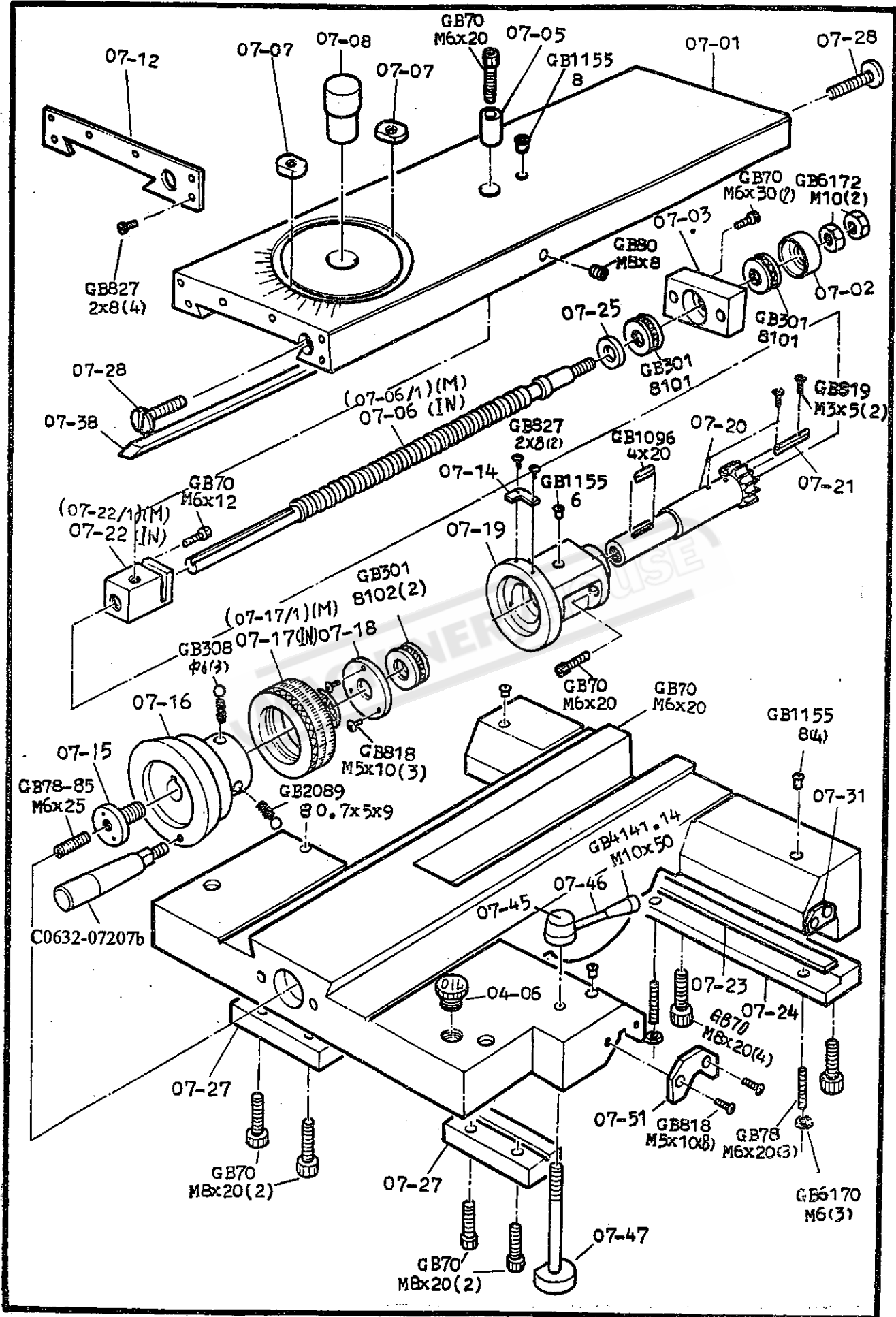


# APRON Left hand, Lever type

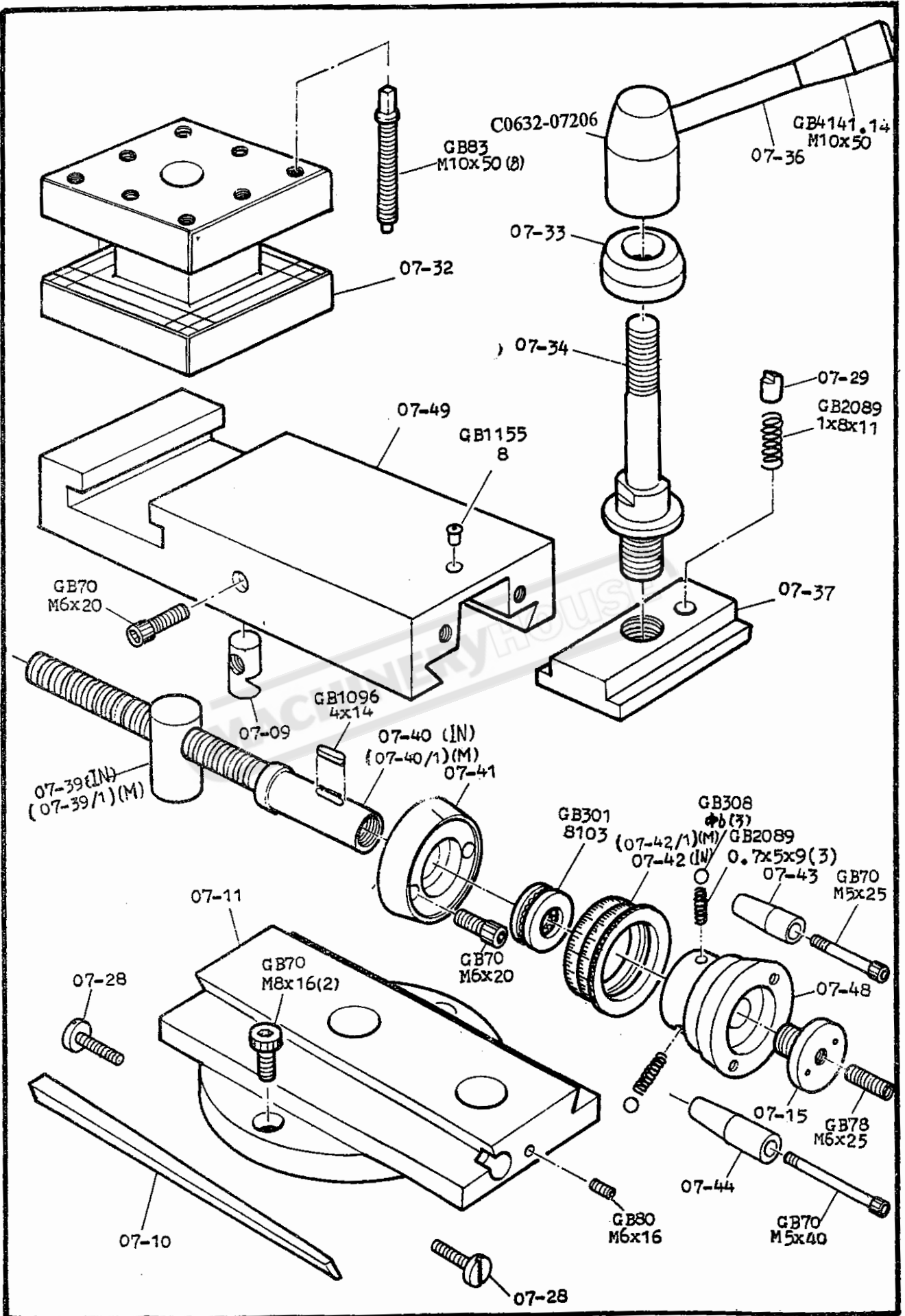




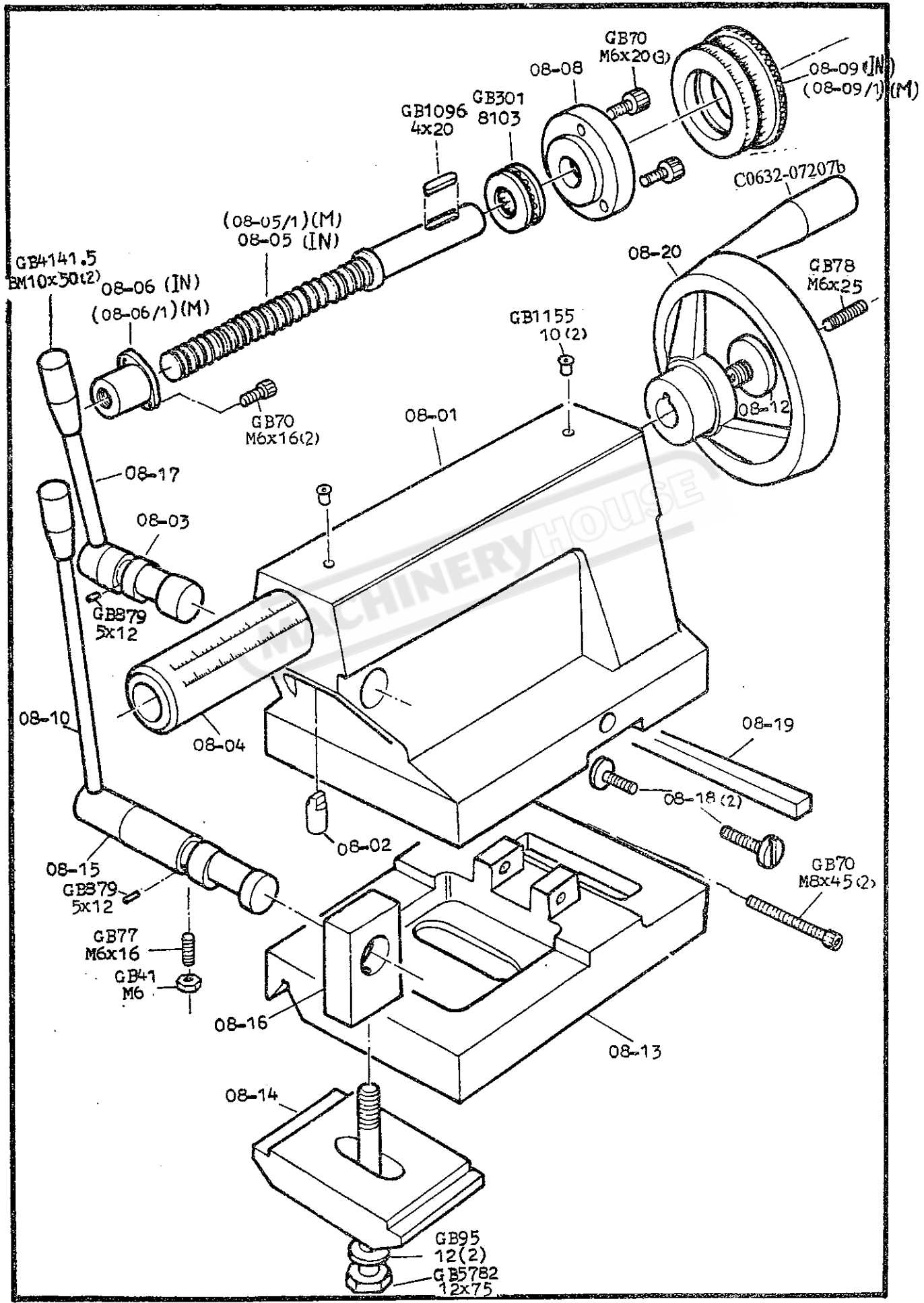
# SADDLE & CROSS-SLIDE Telescopic type



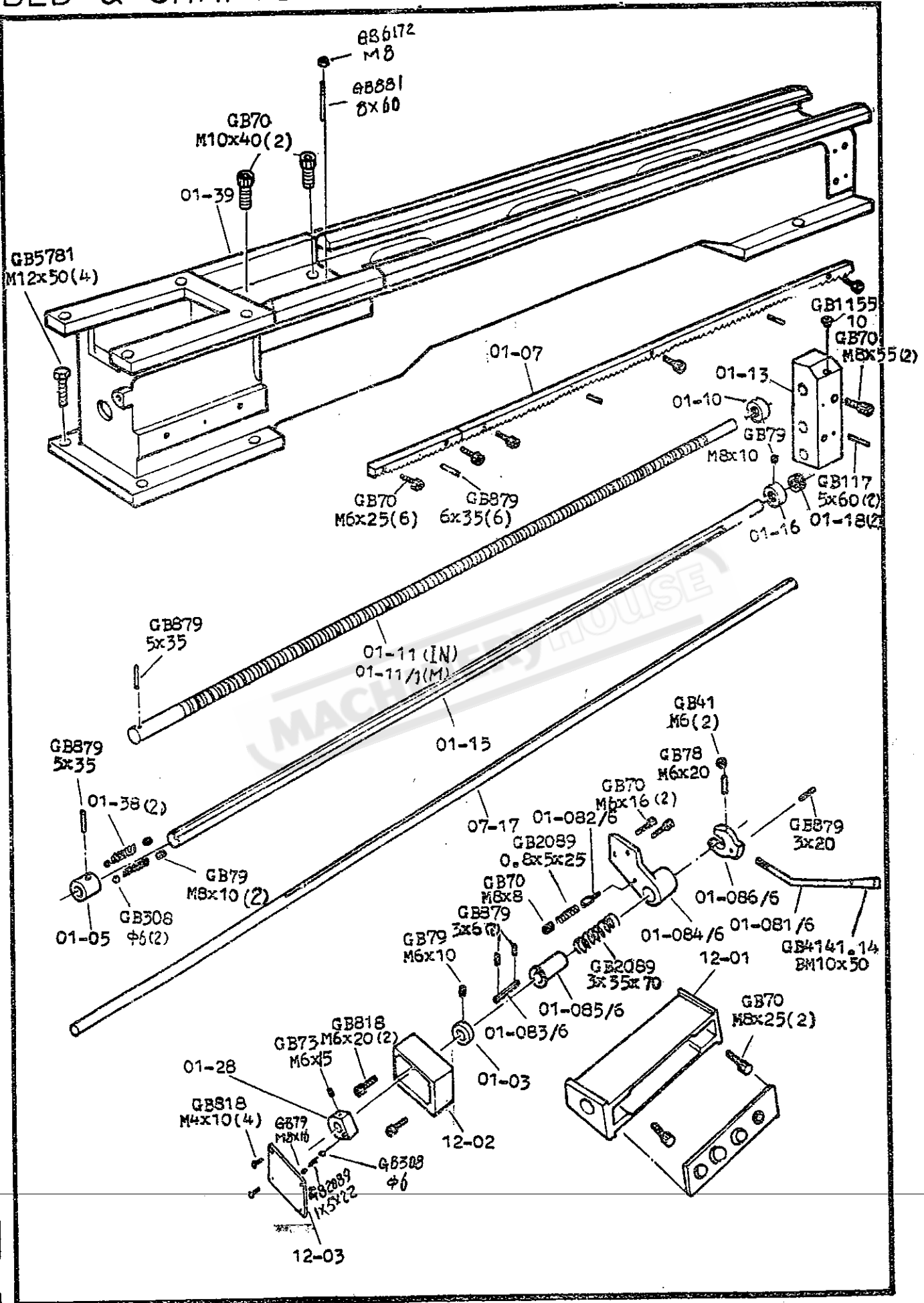
# TOP SLIDE, TOOL POST



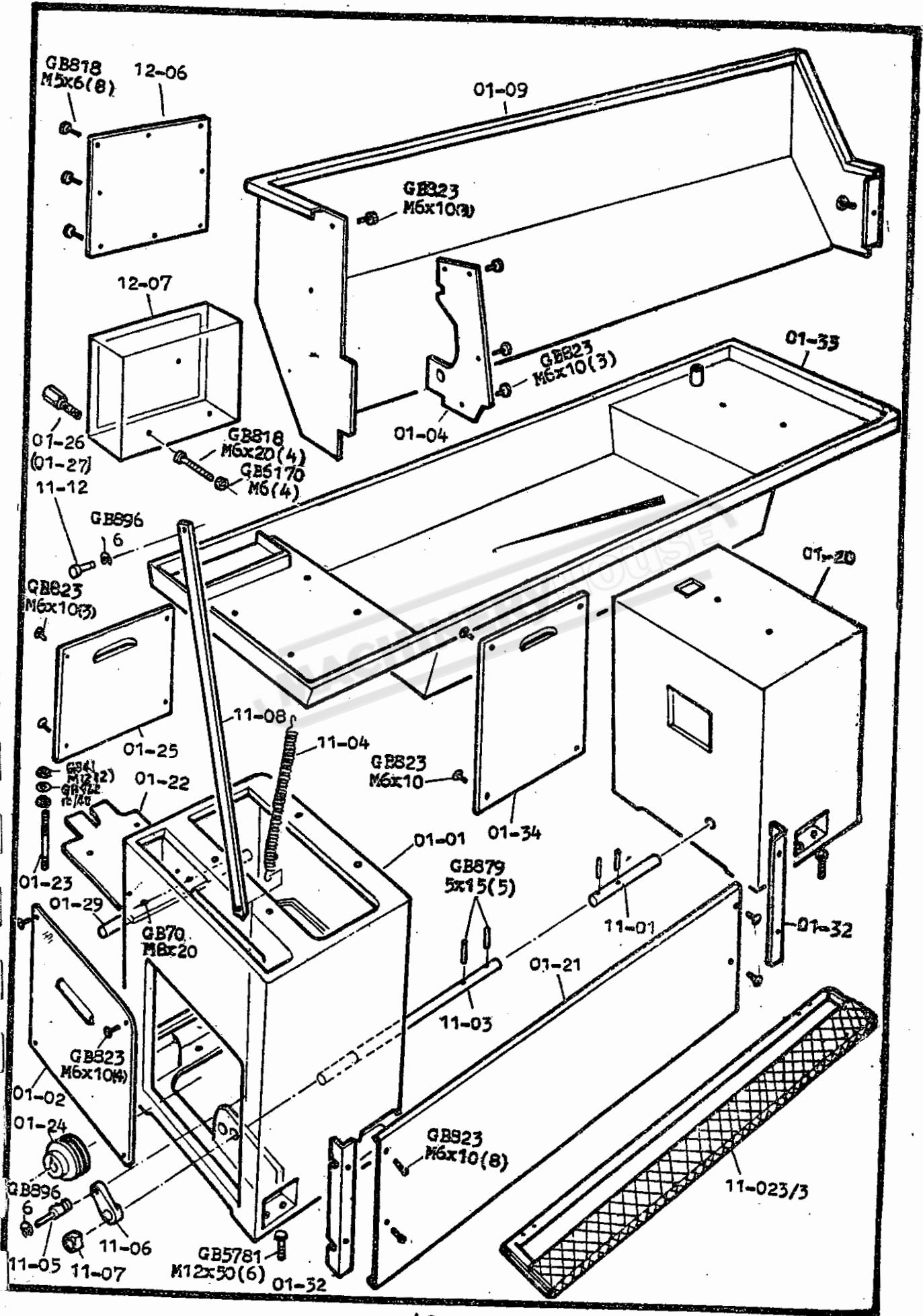
# TAILSTOCK



# BED & SHAFTS

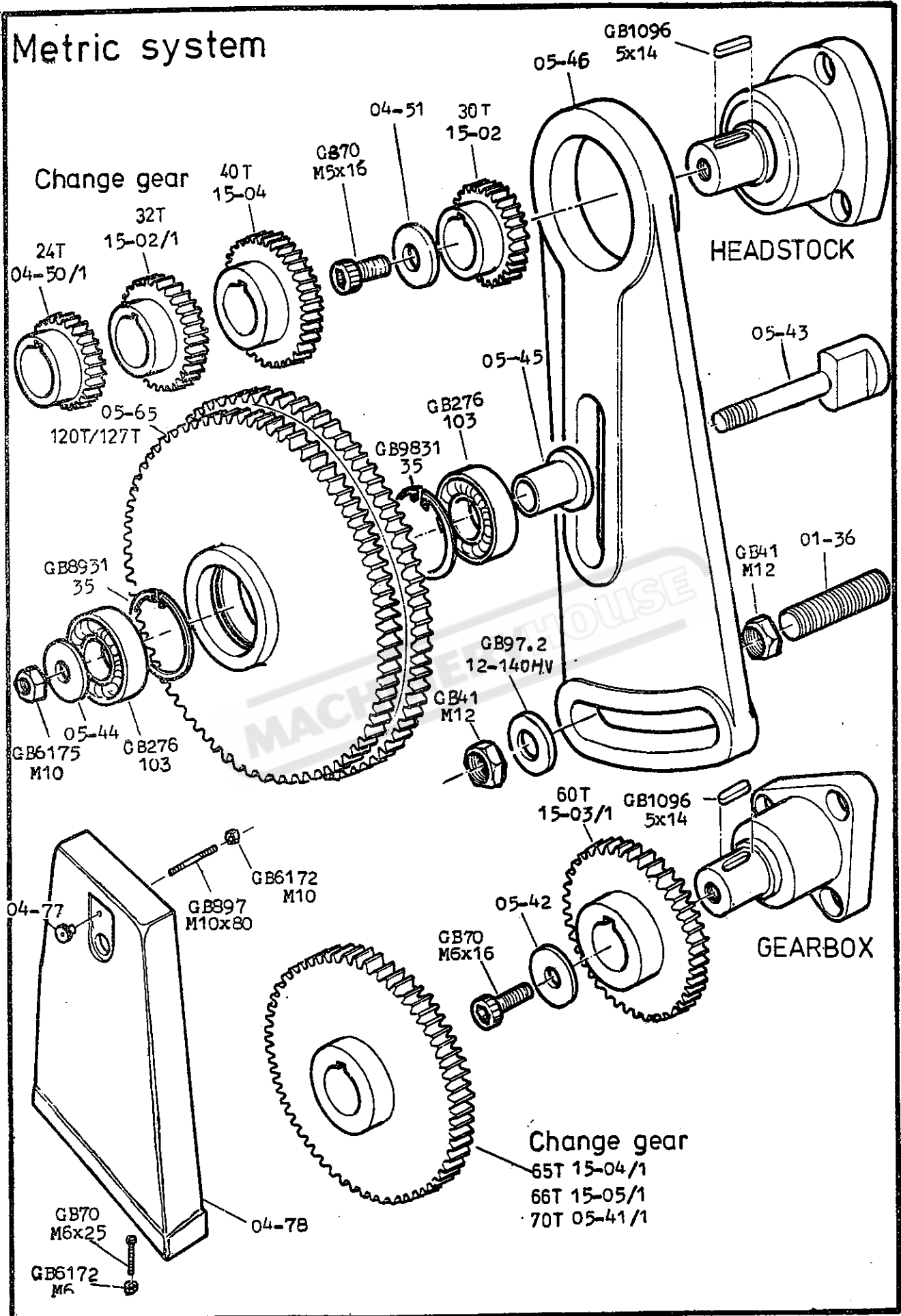


# CABINET & PANELS



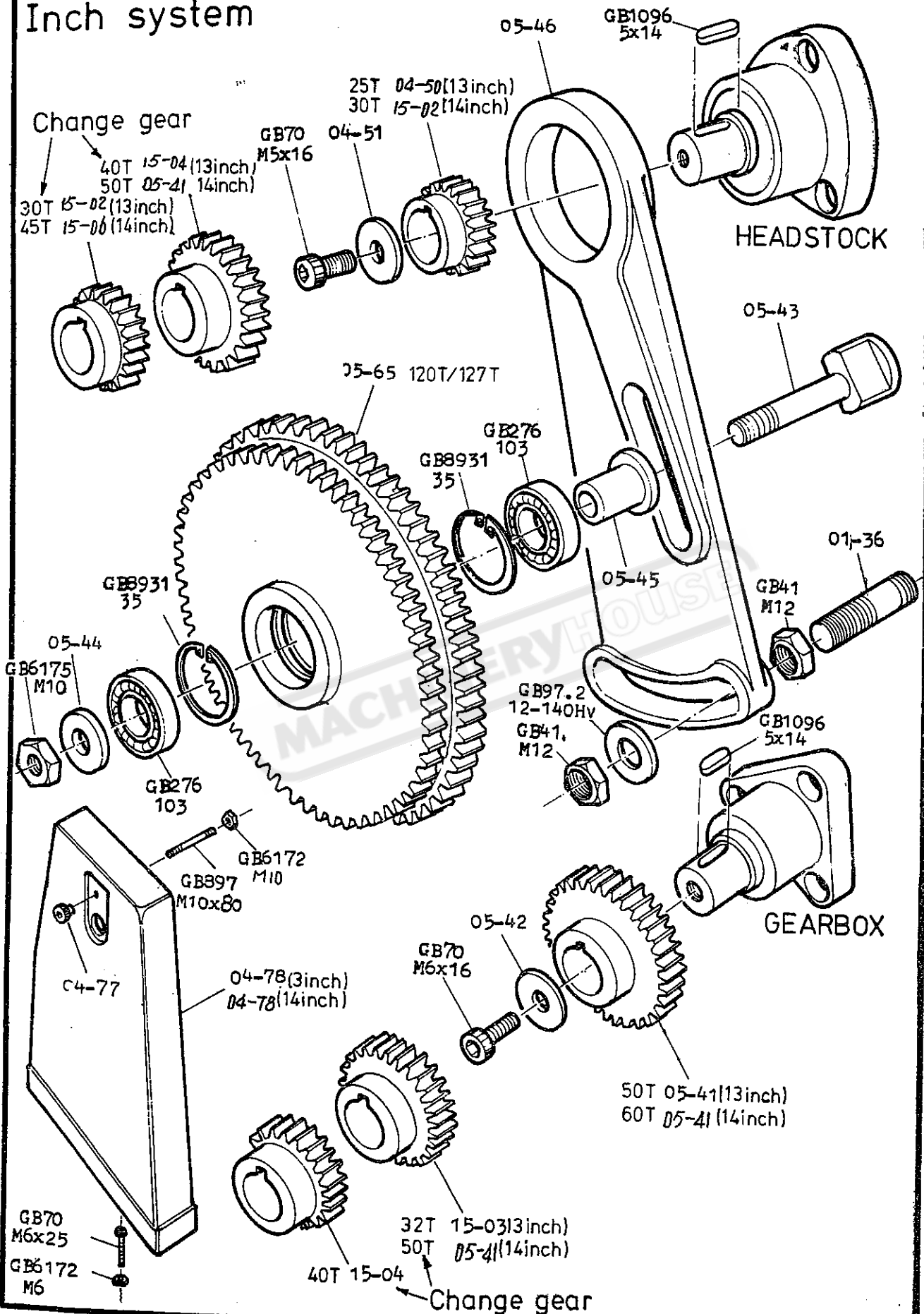
# SWING FRAME, END GEARS & COVER

## Metric system



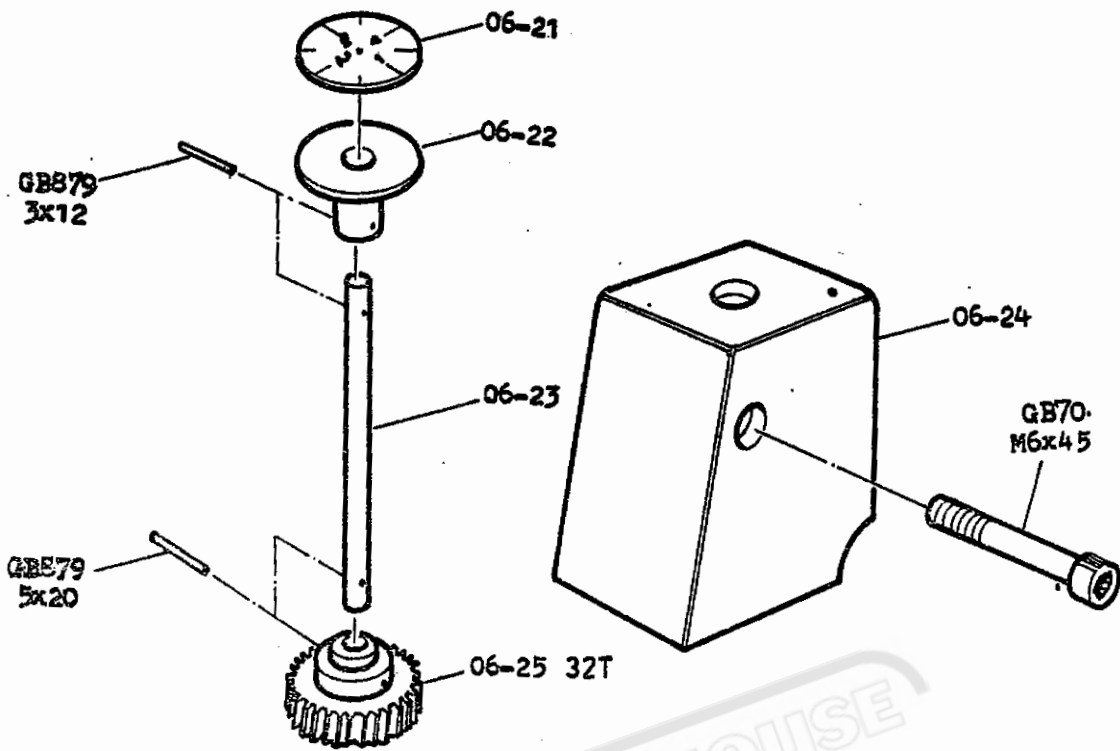
# SWING FRAME, END GEARS & COVER

## Inch system

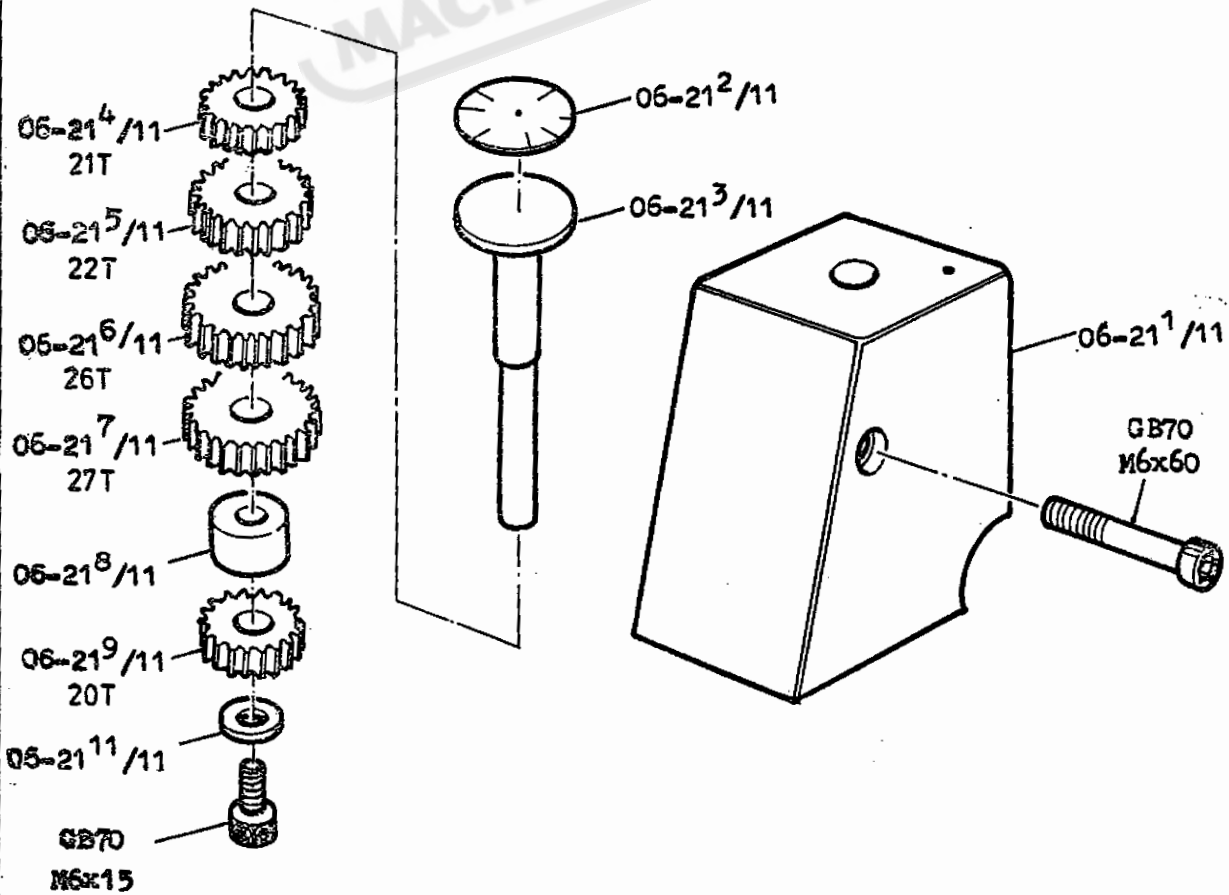


# THREADING DIALS

## INCH



## MM





# APPEARANCE INSPECTION SHEET

Machine Type :

Machine No:

Area	Inspection Item	Result		
		Good	fair	bad
Sand Casting	1. No sand hole.			
	2. No crack and discontinuity.			
	3. No deformation.			
	4. No sharp conner and edge.			
	5. Sands removed.			
Finished Surface	1. Flatness.			
	2. Smoothness.			
	3. No tool mark.			
	4. Chamfer.			
Connecting Surface	1. No gap.			
	2. No step.			
Fasteners	1. Bolts and screws.			
	2. Nuts.			
	3. Pins.			
	4. Keys.			
Assemblies	1. Gear mating.			
	2. Pulleys and belts.			
	3. Handles and levers.			
	4. Gages and indicators.			
	5. Switches.			
	6. Grommets.			
Painting	1. Smoothness.			
	2. Brightness.			
	3. No cracks.			
Plating & Black finish	1. Smoothness.			
	2. Evenness.			
	3. No Peel-off.			

chief engineer:

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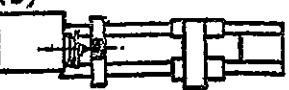
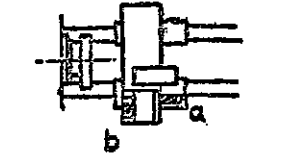

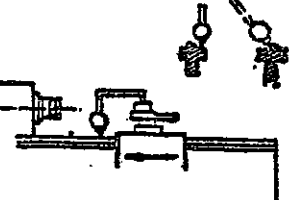
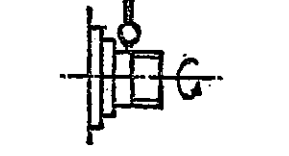
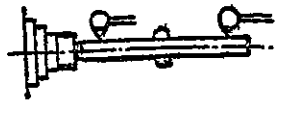
inspecting engineer:

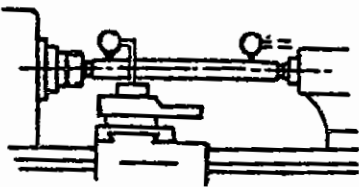
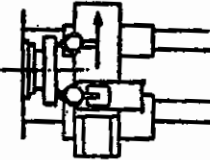
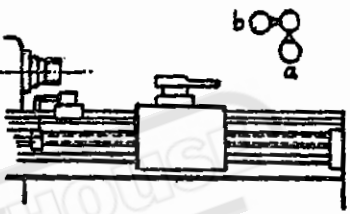
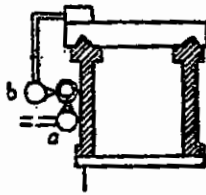
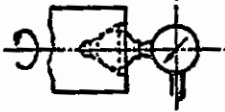
# STATIC ACCURACY TEST

Machine Type :

Machine No:

Unit: mm

NO.	Inspection Item	Diagram of measuring method	Tolerance.	Inspection record	
1.	Straightness of bed slide-ways.	a. Longitudinal direction (in vertical plane)	(a)   (b) 	0.02  protruding	0.016
	b. Transverse direction (in vertical plane)		0.04/m	0.028	
	c. Longitudinal direction (in horizontal plane)		0.01	0.006	
2.	Parallelism of bed slideways		0.02	0.013	
3.	Spindle nose runout		0.01	0.007	
4.	Spindle taper hole runout		At fixed end of test bar : 0.01 At point of 300mm : 0.02	0.006  0.018	

11.	Difference in centre height between headstock and tailstock.		0.02	0.01 b	
12.	Squareness of motion of cross slide with centre line of main spindle.		0.02/300	0.015	
13.	Parallelism centre line of lead screw end bearing to carriage slideways.	In vertical plane		0.10	0.0 b
In horizontal plane		0.10		0.08	
14.	Deviation in alignment of centre line of lead screw end bearing with centre line of half nut.	In vertical plane		0.15	0.1}
In horizontal plane		0.15		0.1}	
15.	Axial slip of lead screw.		0.01	0.00 b	
16.	Accuracy of outside turning.	Roundness		0.01	0.08
Cylindricity		0.02/300		0.015	
17.	Accuracy of face turning.		0.02/300	0.01 b	