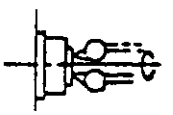
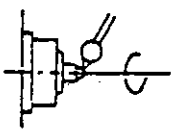
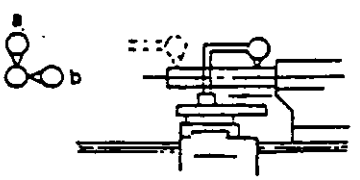
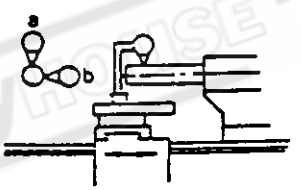
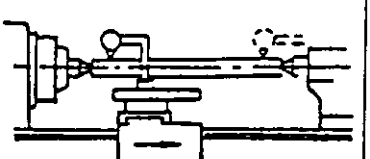
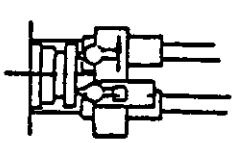
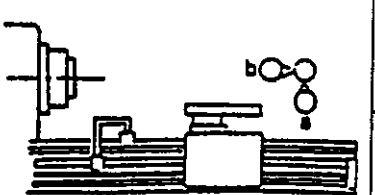
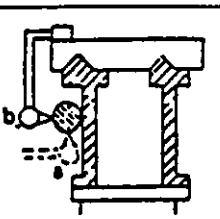
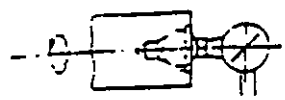
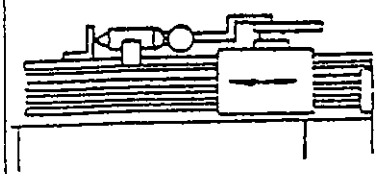
TOLERANCE PERMISSIBLE DIAGRAM

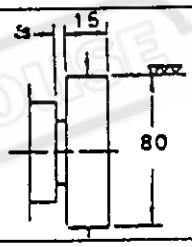
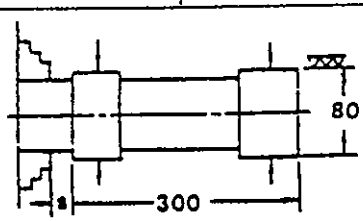
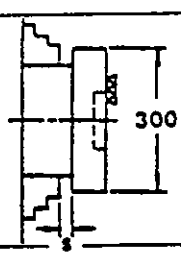
1.ACCURACY TEST.(mm)

NO.	INSPECTION ITEM		DIAGRAM	TOLERANCE PERMISSIBLE
1	Straightness of bed slideway	a.Longitudinal direction (In vertical Llane'		0.04
		b.Transverse direction (In veritical plane)		0.04
2	Parallelism of bed slideways.			0.02
3	Spindle nose runout			0.01
4	Spindle taper hole runout	a.Nearest spindle nose		0.01
		b.At a distance of 300nn		0.02
5	Parallelism of center line of main spindle to longitudinal motion of carriage	a.In vertical plane		0.025
		b.In horizontal plane		0.025
6	Movement of compound slide parallel with main spindle in vertical plane (Hand feed)			0.01/150

NO.	INSPECTION ITEM		DIAGRAM	TOLERANCE PERMISSIBLE
7	Main spindle for axial slip. mearsured at 2 points, displaced by 180°			0.015
8	True running of center point of main spindle.			0.015
9	Parallelism of tailstock spindle with bed ways.	a.In vertical plane (Front end rising)		0.015/100
		b.In horizontal pland(Front end inclined to wards the direction of tool p\resure.		0.015/100
10	Parallelism of bed ways with center line of tailstock spindle hole.	a.In vertical plane (Free end of mandrel rising)		0.02/300
		b.In borizontal pland (Free end of mandrel inclined to wards tailstockend)		0.02/300
11	Difference in center hight between headstock and tailstock (Mandrel rising towards tailstock end)			0.025
12	Squareness of motion of cross slide with center line of main spindle			0.02/300
13	Parallelism of center line of lead screw end bearing to carriage slide ways	a.In vertical plane		0.1
		b.In horizontal plane		0.1
14	Diviations in alignment of center line of lead screw end bearing with center line of half nut.	a.In vertical plane		0.15
		b.In horizontal plane		0.15

NO.	INSPECTION	DIAGRAM	TOLERANCE PERMISSIBLE
15	Axial displacement of lead screw by turning		0.01
16	Pitch error of lead screw		0.03/300

2.PRACTICAL

NO.	JESTING ITEM	DIAGRAM	TOLERANCE PERMISSIBLE
1	Accuracy of outside turning		0.01
2	Accuracy of cylindrical turning		0.025
3	Accuracy of face turning		0.02

3. CHECK OF MOTOR SPECIFICATION

ITEM	HP	Ph	V	Hz	R.P.M.
Rating	2 / 3	1 / 3		50 / 60	1420 / 1700
Actual	V	✓	415	✓	✓