

INSPECTION RECORD

of

PRECISION BENCH LATHE

ACCORDING TO CNS INSPECTION STANDARD OF LATHE

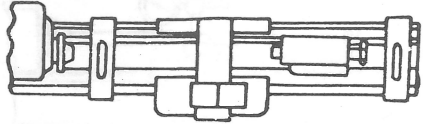
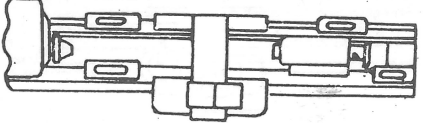
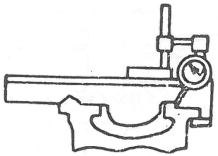
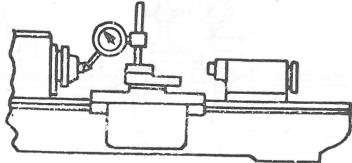
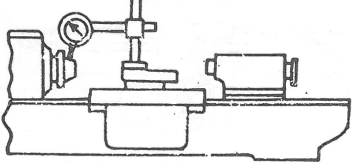
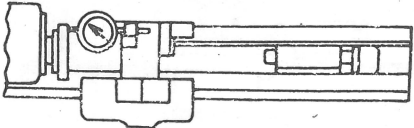
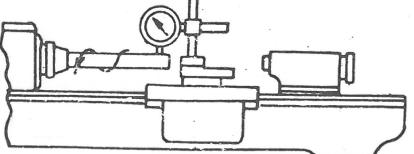
MODEL : JET-1236 P.Y.

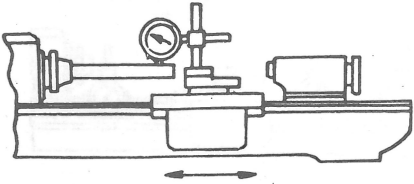
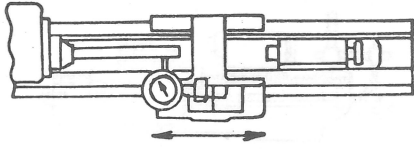
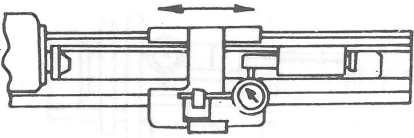
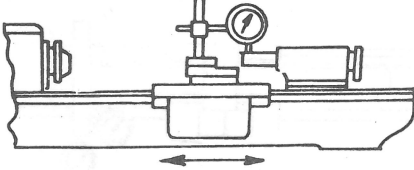
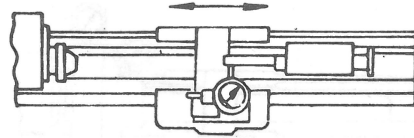
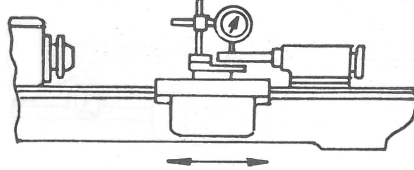
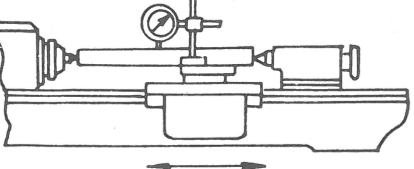
MFG NO : L83-04-179

DATE : June 1983

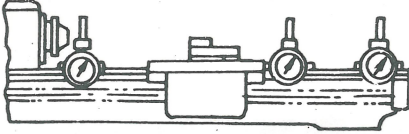
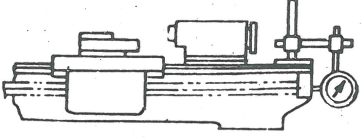
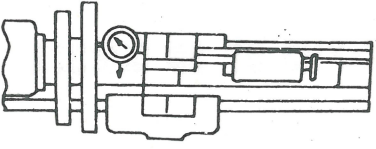
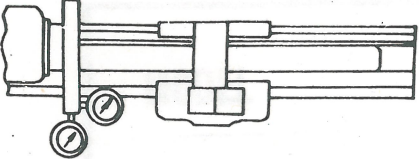
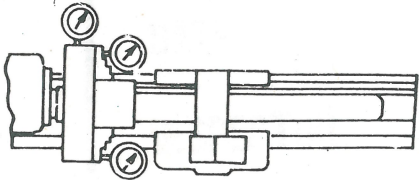
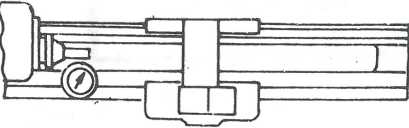
INSPECTOR : W. Ch. Lee.

PLANT MANGER : K. Y. Lee.

Test	Item	Measured Value
 <p>1. BED LEVEL- TRANSVERSE DIRECTION</p>	<p>When using precision level all readings to be within 0.0008" in 12"</p>	<p><u>0.0007"</u></p>
 <p>2. BED LEVEL- LONGITUDINAL DIRECTION</p>	<p>When using precision level along bed maximum reading to be within 0.0008" in 12"</p>	<p><u>0.0005"</u></p>
 <p>3. TAILSTOCK WAY ALIGNMENT</p>	<p>Maximum reading along length of bed 0.0008" in 36"</p>	<p><u>0.0008"</u></p>
 <p>4. SPINDLE CENTER RUNOUT</p>	<p>Total indicator reading 0 to 0.0006"</p>	<p><u>0.0004"</u></p>
 <p>5. SPINDLE NOSE RUNOUT</p>	<p>Total indicator reading 0 to 0.0004"</p>	<p><u>0.0002"</u></p>
 <p>6. CAM ACTION OF SPINDLE</p>	<p>Total indicator reading with indicator on rear side of test plate 0 to 0.0006"</p>	<p><u>0.0003"</u></p>
 <p>7. SPINDLE TAPER RUNOUT</p>	<p>Total indicator reading at end of 12" test bar 0 to 0.0008" at end of spindle nose 0 to 0.0008"</p>	<p><u>0.0006"</u> <u>0.0007"</u></p>

Test	Item	Measured Value
 <p>8. HEADSTOCK ALIGNMENT VERTICAL</p>	Height at end of 12" test bar 0 to 0.001"	<u>0.0008"</u>
 <p>9. HEADSTOCK ALIGNMENT HORIZONTAL</p>	At end of 12" test bar 0 to 0.001"	<u>0.001"</u>
 <p>10. TAILSTOCK SPINDLE ALIGNMENT HORIZONTAL</p>	Forward at end of spindle when fully extended 0 to 0.0006"	<u>0.0003"</u>
 <p>11. TAILSTOCK SPINDLE ALIGNMENT VERTICAL</p>	Height at end of spindle when fully extended 0 to 0.0006"	<u>0.0004"</u>
 <p>12. TAILSTOCK TAPER ALIGNMENT HORIZONTAL</p>	End of 12" test bar 0 to 0.001"	<u>0.0007"</u>
 <p>13. TAILSTOCK TAPER ALIGNMENT VERTICAL</p>	Height at tailstock 12" test bar 0 to 0.001"	<u>0.0005"</u>
 <p>14. VERTICAL ALIGNMENT OF HEAD AND TAIL CENTERS</p>	Height at tailstock 0 to 0.001"	<u>0.0007"</u>

unit: inch

Test	Item	Measured Value
 <p>15. LEAD SCREW ALIGNMENT</p>	<p>Parallel with ways 0 to 0.004" horizontal 0 to 0.004" vertical</p> <p>Alignment of half nut horizontal or vertical 0 to 0.006"</p>	<p><u>0.003"</u> <u>0.002"</u></p> <p>0.006"</p>
 <p>16. LEAD SCREW CAM ACTION</p>	<p>Maximum 0.0004"</p>	<p><u>0.0001"</u></p>
 <p>17. CROSS SLIDE ALIGNMENT</p>	<p>To face hollow or conave only on 12" diameter 0 to 0.0008"</p>	<p><u>0.0007"</u></p>
 <p>18. FACE PLATE RUNOUT</p>	<p>On diameter 0 to 0.0004" On face at nominal diameter 0 to 0.0004"</p>	<p><u>0.0003"</u> <u>0.0002"</u></p>
 <p>19. CHUCK-RUNOUT</p>	<p>Face and periphery 0.003" Face of steps 0.003" Bar test 3" from end of jaw bar diameter same as hole 0.003"</p>	<p><u>0.002"</u> <u>0.003"</u></p> <p>0.001"</p>
 <p>20. COLLET CHUCK RUNOUT</p>	<p>1" from collect chuck 0 to 0.001"</p>	<p><u>0.0009"</u></p>