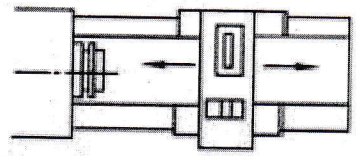
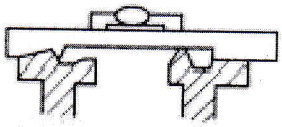
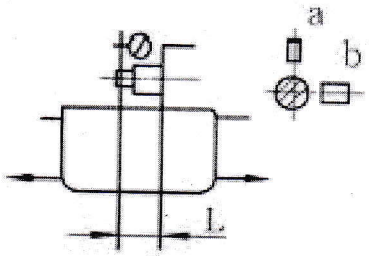
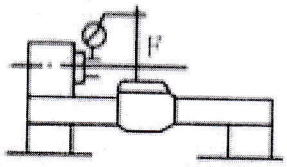
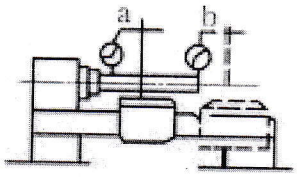
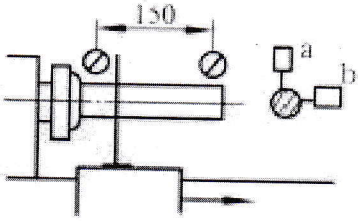
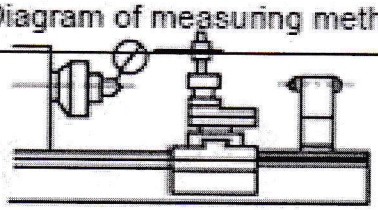
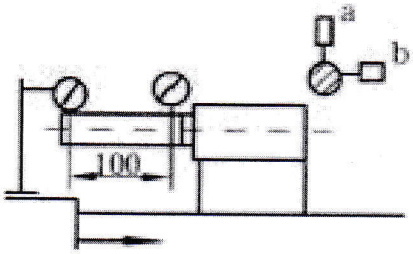
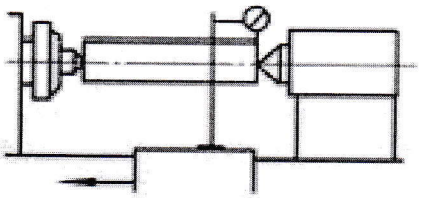
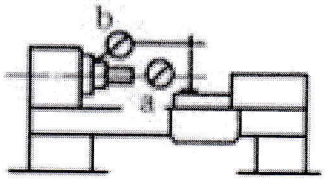
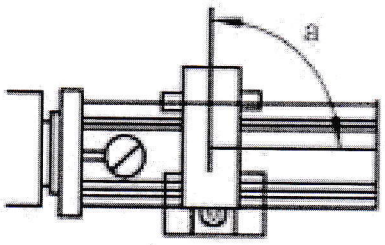
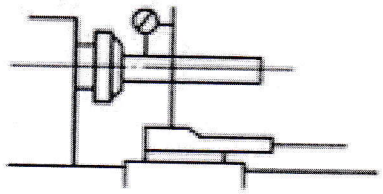
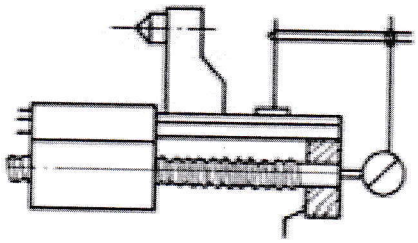
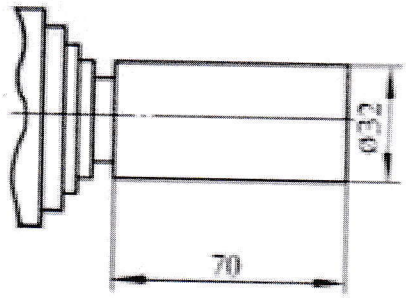
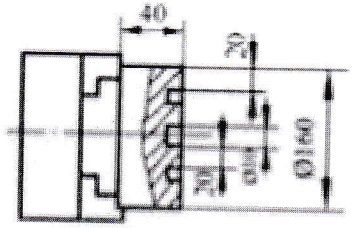
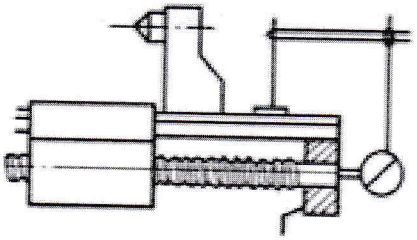
TEST PROTOCOL

No.	Diagram of measuring method	Inspection item	Tolerance	Data
G1	a. 	a. Alignment of longitudinal bed slide ways in vertical place	Full travel 0.25 (+)	
	b. 	b. Parallelism of transverse direction	1000:0.06	
G2		Parallelism of tailstock to longitudinal motion of carriage. a. In vertical plane b. In horizontal plane	a. 500:0.03 b. 500:0.025	
G3		Spindle nose run out	0.015	001
G4		Spindle taper run out a. At the end of spindle nose b. At the end of 300mm test bar	a. 0.01 b. 300:0.03	0,01 0,03
G5		Parallelism of spindle center line to longitudinal motion of carriage a. In vertical plane (upward) b. In horizontal plane (forward)	a. 300:0.02 b. 300:0.02	0,04

No.	Diagram of measuring method	Inspection item	Tolerance	Data

No.	Diagram of measuring method	Inspection item	Tolerance	Data
G6		Spindle center run out	0.02	
G7		Parallelism of center line of tailstock spindle to longitudinal motion of carriage a. In vertical plane b. In horizontal plane	a. 200:0.03 b. 200:0.03	
G8		Difference in center height between headstock and tailstock (tailstock upward)	0.06	
G9		Spindle a. Axial run out b. Run out on spindle base plane	a. 0.015 b. 0.02 (axial run out included)	
G10		Verticality of cross slide to spindle center line	0.02/150 a ≥90°	

G11		Parallelism of top slide to spindle center line	0.04	
G12		Lead screw cam action	0.03	
G13		Accuracy of outside round cutting a. Roundness b. Cylindricity	a. 0.015 b. 300:0.04	
G14		Flatness of the face for finishing cutting (concave)	0.015 (for Ø 160mm)	
G15		Precisely thread cutting on work piece between tow centers (steel)	7g	

Date: _____ Supervisor: _____