

mm, MM

inch, CM

Measurement

Millimeter

millimeter/inch conversion

inch/mm

Measurement

MM

LATHE ACCURACY TEST REPORT

0001

00.00

0001

TYPE	CZ-300/A	
SERIES NO.	93004	
DATE	93.6.1	

MANAGER

Q. C. CHIEF

INSPECTOR

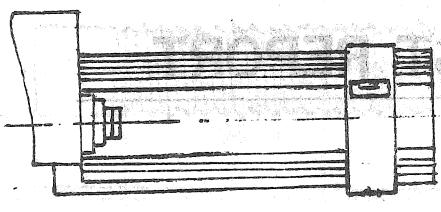
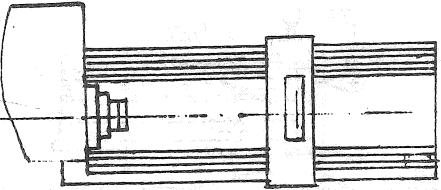
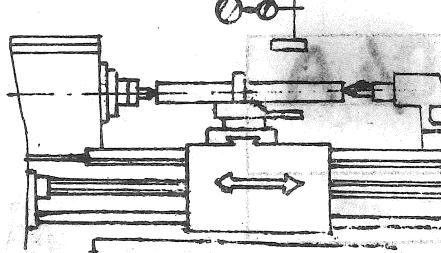
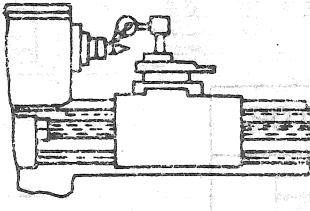
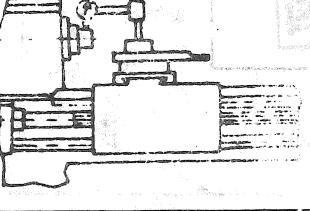
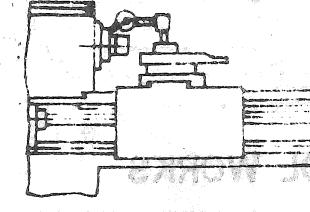
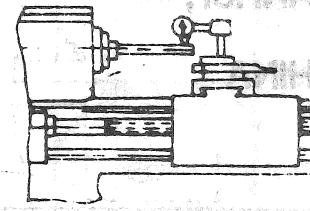


CHIZHOU HOUSEHOLD MACHINE—TOOL WORKS

16 DONGHU ROAD, GUICHI CITY, ANHUI,

THE PEOPLE'S REPUBLIC OF CHINA

UNIT : mm

NO	Diagram	Inspection Item	Tolerance	Measurement
1		Bedways alignment in vertical plane	0.04 1000	0.035
2		Bedways alignment in horizontal plane	0.06 1000	0.05
2		Horizontal alignment of head and tailstock centres	0.03	0.025
3		Spindle Center runout	0.015	0.01
4		Spindle nose runout	0.01	0.006
5		Cam action of spindle	0.015	0.01
6		Spindle taper bore runout	0.03 300	0.025

mm, THRU

UNIT : mm

NO	Diagram	Inspection Item	Tolerance	Measurement
7		a. Head stock alignment in vertical plane	0—0.025 300	0.02
		b. Headstock alignment in horizontal plane	0—0.025 300	0.022
8		Upper slide alignment in vertical plane	0.03 300	0.025
9		a. Tail — stock spindle alignment in vertical plane	0—0.02 100	0.015
		b. Tail — stock spindle alignment in horizontal plane	0—0.02 100	0.016
10		a. Tail — stock spindle sleeve alignment in vertical plane	0—0.03 300	0.025
		b. Tail — stock spindle sleeve alignment in horizontal plane	0—0.03 300	0.02
11		Vertical alignment of head and tailstock centers	0—0.04	0.035

mm : THRU

UNIT : mm

NO	Item No.	Diagram	Inspection Item	Tolerance	Measurement
12			Accuracy of Lead Screw Pitch (accumulate tolerance)	0.05 300	0.04
13			Lead screw cam action	0.025 1000	0.02
14			a. In vertical plane Lead screw alignment b. In horizontal plane	0.15 0.15	0.10
			a. In vertical plane Alignment of lead screw with half nut b. In horizontal plane	0.20 0.20	0.14
15			Accuracy of outside round cutting	0.01	0.008
16			Accuracy of cylindrical cutting	0.02 300	0.015
17			Accuracy of face plate cutting	0.025 300	0.018