


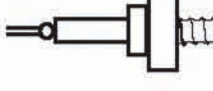
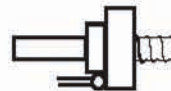
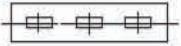
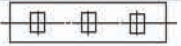



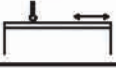

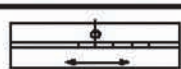
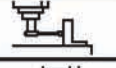

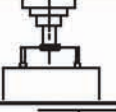



MACHINE TEST REPORT

MODEL NO.	
SERIAL #	
DATE:	

MANAGER	SUPERVISOR	INSPECTOR	CENTROID INSPECTOR

	SUBJECT OF THE TEST		ILLUSTRATION	SPECIFICATION	MEASURED
1	BACK LASH	X		.013mm/.0005"	
		Y		.013mm/.0005"	
		Z		.013mm/.0005"	
2	INDICATE END OF BALLSCREW FOR MOVEMENT	X		.005mm/.0002"	
		Y		.005mm/.0002"	
		Z		.005mm/.0002"	
3	YOKE FLEX	X		.005mm/.0002"	
		Y		.005mm/.0002"	
		Z		.005mm/.0002"	
4	TABLE FLATNESS	X		.002"/39.4" .05mm/1000mm	
		Y		.002"/39.4" .05mm/1000mm	
5	RADIAL RUNOUT OF SPINDLE			.0004" .01mm	
6	AXIAL RUNOUT OF SPINDLE			.0004" .01mm	
7	RADIAL RUNOUT OF SPINDLE TAPER			25mm - .01mm 300mm - .02mm	
8	PARALLELISM OF TABLE MOVEMENT OF X AXIS			.03mm/300mm MAX .04 .0012"/11.8"	
9	PARALLELISM OF TABLE MOVEMENT OF Y AXIS			.03mm/300mm MAX .04 .0012"/11.8"	
10	PARALLELISM OF "T" SLOT AND X AXIS			.03mm/300mm MAX .04 .0012"/11.8"	
11	SQUARENESS OF HEAD AND TABLE	X-Z		.02mm/300mm .0008"/11.8"	
		Y-Z		.02mm/300mm .0008"/11.8"	
12	SPINDLE SWEEP	X-Z		.02mm/300mm .0008"/11.8"	
		Y-Z		.02mm/300mm .0008"/11.8"	
13	SQUARENESS OF X AND Y MOVEMENT			.013mm/300mm .0005"/11.8"	
14	PUSH TABLE 50LB PUSH	X		.013mm/.0005"	
		Y		.013mm/.0005"	
15	LATERAL HEAD MOVEMENT, 50LB			0.008mm/0.0003"	
16	TABLE DROOP TEST - 2 x 150LB LOAD ON TABLE ON EACH END, 15" FROM CENTER OF TRAVEL			.025mm/0.001"	
17	Ball Bar Test				