

Model #: \_\_\_\_\_

Frame Serial #: \_\_\_\_\_

CENTROID Inspector: \_\_\_\_\_

Factory Supervisor: \_\_\_\_\_

**Machine Test Report**      **LEVEL MACHINE BEFORE beginning test.**

Subject of the test		Illustration	Specification	Measured
1.	Table Flatness (Do not move table during flatness test)		< X .002" / 39.4" < .05mm / 1000mm	<b>Max X=</b>
			< Y .002" / 39.4" < .05mm / 1000mm	<b>Max Y=</b>
2.	Z axis Linear rails equidistant to X axis		<.0127mm <.0005"	<b>Left Z rail to X=</b> <b>Right Z rail to X=</b>
3.	Slider face parallel to X axis Perpendicular to Y axis		< .0127 mm / 300mm	<b>Slider to X=</b>
				<b>Slider to Y=</b>
4.	Push Table 50lb push		< .013mm (.0002")	<b>X=</b>
			< .013mm (.0002")	<b>Y=</b>
5.	Lateral Head Movement, 50lb (Push slider for headless)		< 0.008mm (0.0003")	
6.	Table Droop Test 200lb load (Vito) on end of table		< .02mm < .0008"	
7.	Parallelism of "T" Slot & X axis Over full length of table.		< .04mm / full table length .0015" / full table length	
8.	Radial Runout of Spindle Taper (Omit for headless)		Top @25mm < .00254mm (.0001") Bottom@300mm < 0.01mm (.0004")	<b>TOP=</b> <b>BOT=</b>
9.	Spindle Sweep (Omit for headless)		< .02mm / 300mm < .0008"/11.8"	<b>X-Z=</b>
			< .02mm / 300mm < .0008"/ 11.8"	<b>Y-Z=</b>

**BALLBAR Test Report.**

Perform CENTROID "report" file 1<sup>st</sup>. Note: 12" bar, Full Z circle, No laser comp, No backlash comp

Description	Specification	Measured		
1.) Circularity	<.025 mm (.001")	<b>X=</b>	<b>Y=</b>	<b>Z=</b>
2.) Cyclic Error	< .025 mm (.001")	<b>X=</b>	<b>Y=</b>	<b>Z=</b>
3.) Backlash	<.010 mm (.0004")	<b>X=</b>	<b>Y=</b>	<b>Z=</b>
4.) Straightness	<+/- .005mm (.0002")	<b>X=</b>	<b>Y=</b>	<b>Z=</b>
5.) Squareness	< .0005" / 1" < .0127 mm / 25.4mm	<b>XY=</b>	<b>XZ=</b>	<b>YZ</b>