

File No: Wi\_8\_f\_86\_b\_Geometrie\_Work  
File Title: Machine Shop

Rev No: r14a\_hp  
Rev Date: feb 2014

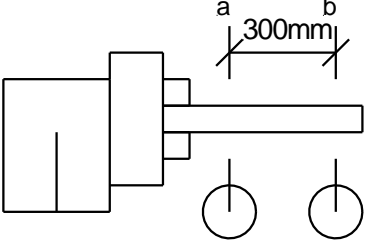
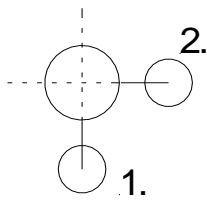
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LATHE NUMBER	LATHE DESCRIPTION	DATE
		Inspector:..... Date: Inspector:..... Date:

**G 1. Headstock Alignment**

Check the parallelism of the spindle centre line with the bed.

**TSLI 322 3.8**  
Aim ≤ 0.03 mm Max ≤ 0.05 mm

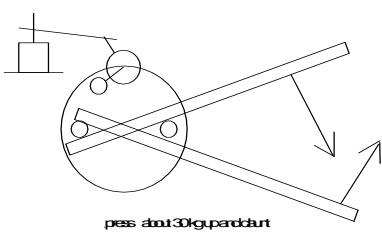
ACCEPTANCE CRITERIA	Test Result Ok 0 Not Ok 0	DONE BY (Sign)
	 Measuring tool gauge 0.01	Horizontal G1.1 = .....  Vertical G1.2 = .....

**G 3.0. Turret Indexing Slack**

**TSLI 322 3.4**  
Aim ≤ 0.02mm Max ≤ 0.05 mm

Check the rigidity of the tool post and the indexing accuracy.

With a lever try to move the turret in order to change the tool position. Place the dial indicator at the end of the tool.

ACCEPTANCE CRITERIA	Test Result Ok 0 Not Ok 0	DONE BY (Sign)
	Measuring tool gauge 0.01mm	Turret 1 G3.1 = .....  Turret 2 G3.2 = .....

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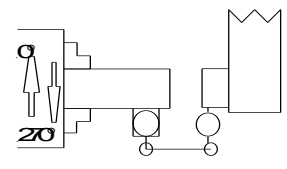
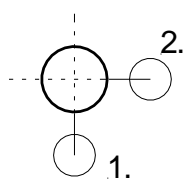
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**G 5.A. Turret Height**

**TSLI 322 3.5**

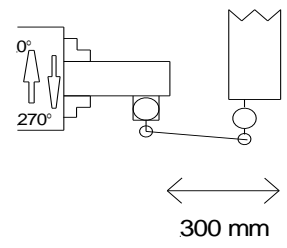
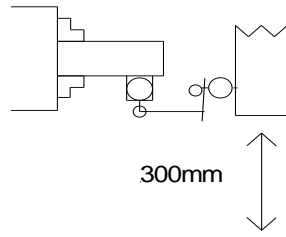
Od 75 ≤ Aim 0.04 mm Max 0.06mm Od > 75 Aim 0.08 mm Max 0.1 mm

ACCEPTANCE CRITERIA	Test Result		DONE BY (Sign)	
	Ok	Not Ok	0	0
 <p>Measuring gauge 0.01</p>			Turret 1 A 4.1 = ..... A 4.2 = ..... A 4.3 = ..... A 4.4 = .....	Turret 2 A 4.5 = ..... A 4.6 = ..... A 4.7 = ..... A 4.8 = .....

**G 5.B. Turret squareness X and Z axis**

**TSLI 322 3.3.1**

Aim ≤ 0.03 mm Max ≤ 0.05 mm

ACCEPTANCE CRITERIA	Test Result		DONE BY (Sign)
	Ok	Not Ok	
 <p>300 mm</p>	 <p>300mm</p>		9.B. Z axis ..... 9.B. X axis .....

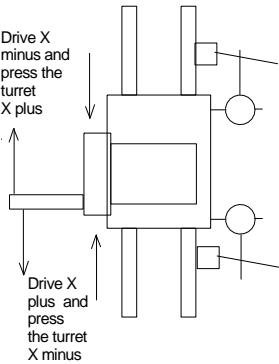
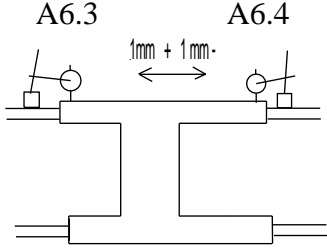
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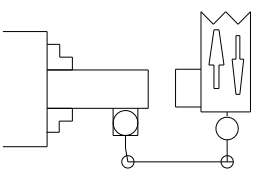
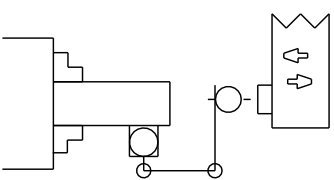
**G 6. Gages X and Z Axis**

**TSLI 322 3.10**  
Aim ≤ 0.03 mm Max ≤ 0.05 mm

ACCEPTANCE CRITERIA	Test Result Ok 0 Not Ok 0	DONE BY (Sign)
Measurement X Gages	Measurement Z Gages	Ref. Nr.
		X 1 Slide A 6.1 X1 = ..... A 6.2 X2 = ..... Z1 Slide A 6.3 Z1 = ..... A 6.4 Z2 = .....

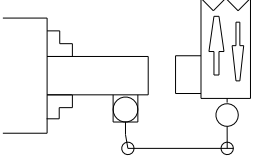
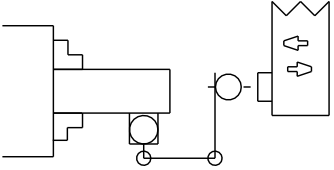
**G 7. Back Lash**

**TSLI 322 3.6.1**  
Aim ≤ 0.03 mm Max ≤ 0.04 mm

TEST	Test Result Ok 0 Not Ok 0	DONE BY (Sign)
Back Lash X 		Comp. .... A 7.0 X = .....
Back Lash Z 		Comp. .... A 7.0 Z = .....

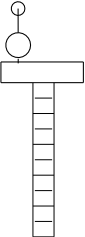
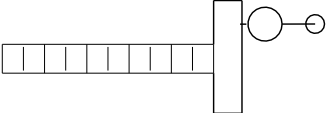
**G 7. A. Incrementation Control X and Z Axis**

**TSLI 322 3.9**  
 Aim ≤ 0.03 Max. ≤ 0.04 mm

TEST	Test Result		DONE BY (Sign)
	Ok 0	Not Ok 0	
Back Lash X 			Comp. .... A 7.0 X = .....
Back Lash Z 			Comp. .... A 7.0 Z = .....

**G 7.B. Ball Screw Back Lash**

**TSLI 322 3.6.2**  
 Aim ≤ 0.005 mm Max ≤ 0.01 mm

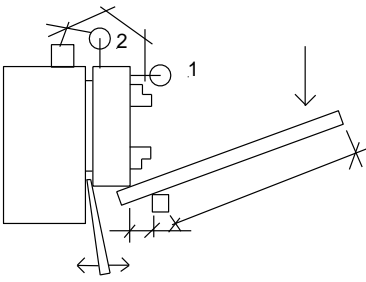
TEST	Test Result		DONE BY (Sign)
	Ok 0	Not Ok 0	
			A 7.1 X= .....
			A 7.1 Z = .....
	Measuring tool gauge 0.005		

**G 8. Spindle Bearing Slack**

**TSLI 322 3.7**

Aim ≤ 0.03mm, Max ≤ 0.05 mm

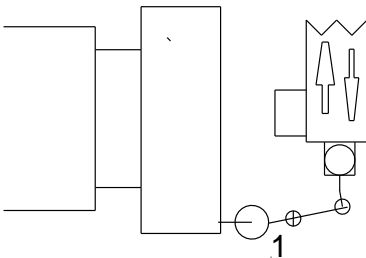
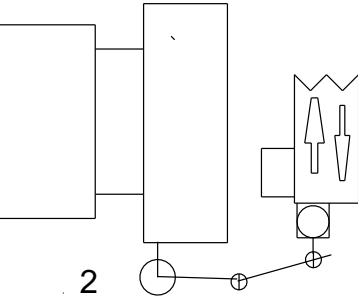
Check the concentricity and the rigidity of the spindle.

ACCEPTANCE CRITERIA	Test Result Ok 0 Not Ok 0	DONE BY (Sign)
	<p>2 Measuring tool gauge 0.01 with magnet</p>	<p>8.0 axial 1 .....</p> <p>8.0 radial 2 .....</p>

**G 9.A. Chuck Runout and concentricity (Centralization & fixation)**

**TSLI 322 3.11**

Aim ≤ 0.04 mm Max ≤ 0.06 mm

ACCEPTANCE CRITERIA	Test Result Ok 0 Not Ok 0	DONE BY (Sign)
		<p>Axial 9.a 1 .....</p> <p>Radial 9.a 2 .....</p>

**G 10. Carriage Slack on Slide-ways**

**TSLI 322 3.10**

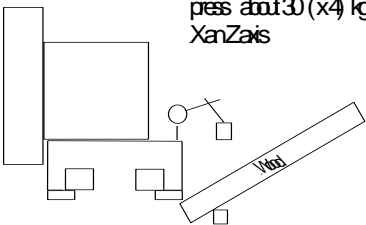
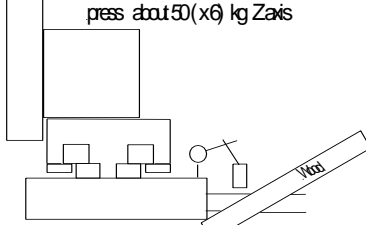
Aim ≤ 0.03 mm Max ≤ 0.05 mm

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Check for excessive gap between the slide-ways and the carriage by trying to move the carriage upwards with a lever on both sides of the bed.

ACCEPTANCE CRITERIA	Test Result Ok 0 Not Ok 0	DONE BY (Sign)
 <p>press about 30 (x4) kg XanZais</p> <p>Measuring tool gauge 0.01</p>	 <p>press about 50 (x6) kg Zais</p>	<p>X Front side A 10.1 A = ..... B..... Back side A 10.2 A = ..... B..... Z- Front side A 10.3 A = ..... B..... Back side A 10.4 A = ..... B.....</p>

**G 12. Summary of Adjustment Required on Lathe:**

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Date: .....

Name: Inspector 1 .....

Name Inspector 2.....

Inspector Nr: .....

Inspector Nr. ....

Sign. ....

Sign .....