

WM210V

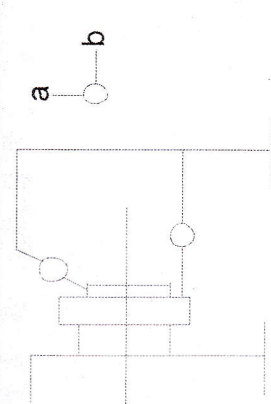
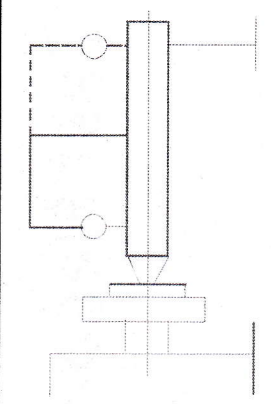
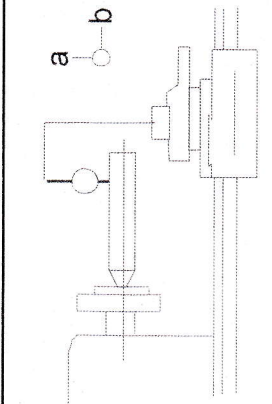
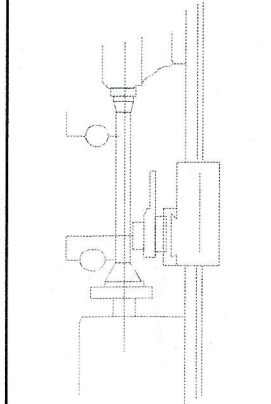
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Test Record

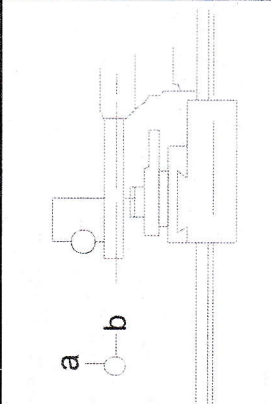
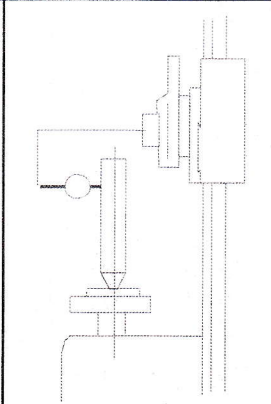
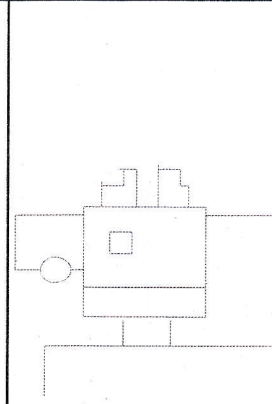
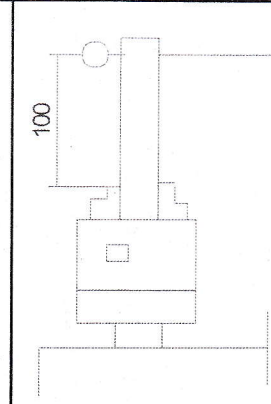
I. Visual Inspection		OK	IV. Electrical Inspection		OK
1. Correct label	<input checked="" type="checkbox"/>		1. Connection tightened	<input checked="" type="checkbox"/>	
2. Painting damage	<input checked="" type="checkbox"/>		2. Correct electrical elements	<input checked="" type="checkbox"/>	
3. Corrosion damage	<input checked="" type="checkbox"/>		3. Earth resistance	<input checked="" type="checkbox"/>	
4. Screw tightened	<input checked="" type="checkbox"/>		4. Insulation resistance	<input checked="" type="checkbox"/>	
II. Mechanical Inspection		OK	5. Tolerance voltage test	<input checked="" type="checkbox"/>	
1. Function of top slide	<input checked="" type="checkbox"/>		6. Function of F/R switch	<input checked="" type="checkbox"/>	
2. Function of cross slide	<input checked="" type="checkbox"/>		7. Emergency stop switch	<input checked="" type="checkbox"/>	
3. Function of carriage	<input checked="" type="checkbox"/>		8. Speed control knob	<input checked="" type="checkbox"/>	
4. Function of tailstock	<input checked="" type="checkbox"/>		9. Electrical control board	<input checked="" type="checkbox"/>	
5. Lubrication for sliding parts	<input checked="" type="checkbox"/>		10. Function of motor	<input checked="" type="checkbox"/>	
6. Parallelism of pulleys	<input checked="" type="checkbox"/>				
7. Spindle adjustment	<input checked="" type="checkbox"/>				
III. Active Inspection		OK	V. Final Inspection		OK
1. Function of apron	<input checked="" type="checkbox"/>		1. Correct accessories	<input checked="" type="checkbox"/>	
2. Running test	<input checked="" type="checkbox"/>		2. Correct documents	<input checked="" type="checkbox"/>	
3. Noise test	<input checked="" type="checkbox"/>		3. Machine cleanliness	<input checked="" type="checkbox"/>	
4. Function of change gear	<input checked="" type="checkbox"/>		4. Credibility antirust	<input checked="" type="checkbox"/>	
5. Cutting test	<input checked="" type="checkbox"/>		5. Correct mark	<input checked="" type="checkbox"/>	
Remark:					

Serial No.	2110029
Date	08.20.10
Inspector	W.G.Q

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NO.	INSPECTION ITEM	DIAGRAM	TOLERANCE(mm)	
			PERMISSIBLE	ACTUAL
1	Runout of spindle nose a radial plane b face plane		a 0.01 b 0.015	0.01 0.013
2	Runout of spindle taper hole a spindle nose b 250 distance		a 0.015 b 0.03	0.013 0.02
3	Parallelism of center line of spindle to carriage movement a in horizontal plane b in vertical plane		a 0.03/250 b 0.03/250	0.02 0.023
4	Difference between two centers (higher at tailstock)		0.02-0.05	0.04

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NO.	INSPECTION ITEM	DIAGRAM	TOLERANCE(mm)	
			PERMISSIBLE	ACTUAL
5	Parallelism of tailstock quill to carriage movement a in horizontal plane b in vertical plane		a 0.025/50 b 0.015/50	a 0.02 b 0.014
6	Parallelism of center line of spindle to top slide movement		0.04/50	0.03
7	Radial runout of chuck		0.04	0.037
8	Radial runout of ϕ 20 test bar		0.08/100	0.065