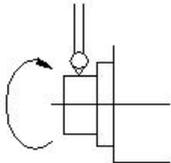
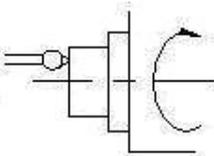
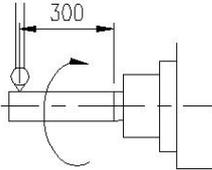
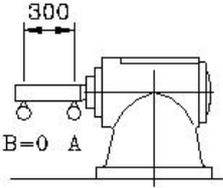


TEST CHART FOR ANGULAR HEAD

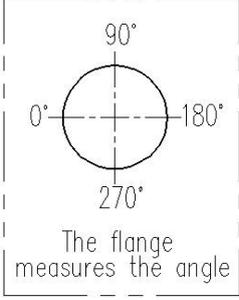
No.	Inspection item	Measuring method	Figure	Tolerance Permissible (mm)	Actual value measured (mm)	
1	Run-out of the external centering surface.	Fix an accuracy gauge to external diameter of the spindle nose, and take the measurement of the maximum difference of readings during the rotation of the spindle as the value required.		0.01		
2	Beat of the end face of the main spindle	Fix an accuracy gauge to touch the end face of the main spindle, and take the beat measurement of the maximum difference of readings during the rotation of the main spindle as the determination of value.		0.01		
3	Main spindle hole run-out	Install a test bar at the main spindle hole. Then turn the main spindle test bar. The maximum measured value at 300mm of the test bar from precision scale.		At point 300mm 0.02		
4	The degree of parallel of the fixed face and spindle	Place the milling head on the surface of the platform and measure the run out of spindle. Measure point B first and back to zero after take the intermediate value, then move to point A and read the value(positive or negative).		B-A=0.02		
5	Noise measuring	Put the decibel table on the machine distanced 500m/m		Tolerance noise	Speed	Decibe I

		from up, front, left, right to get the max. value.		volume 80 decibel		
					(r.p.m)	(dB)

TEST CHART FOR ANGULAR HEAD N75C

No.	Inspection item	Measuring method	Figure	Tolerance Permissible	Actual value measured
6	Temperature rising measuring	Change the revolving speed of machine head to the max. then make use of temperature rising meter to measure the room temperature and the main shaft of machine head. A、B、C three points. The fetch supreme numerical deducting room temperature is temperature rising.		Tolerance temp. rising 30°C	°C

No.	Inspection item	Figure	Tolerance Permissible (mm)	Actual value measured (mm)
7	The degree of parallel of the fixed face and spindle		0° 0.02/300mm	Direction a
				Direction b
	Measuring method		90° 0.02/300mm	Direction a
				Direction b
	Place the milling head on the surface of the platform and measure the run out of spindle.		180° 0.02/300mm	Direction a
				Direction b

	<p>Measure point B first and back to zero after take the intermediate value, then move to point A and read the value. (Plus-minus value)</p>	 <p>The flange measures the angle</p>	<p>270° 0.02/300mm</p>	<p>Direction a</p>	
				<p>Direction b</p>	