



Enabling Your Ideas

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# Certificate of Inspection

**Eight-position Turret**

**Serial Number:**

**Made in China**

Tormach Inc.  
1071 Uniek Drive, Waunakee, WI 53597  
Phone: 608.849.8381 / Fax: 209.885.4534

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Specifications subject to change without notice.  
TD10419\_Turret\_CertInspect\_0316A



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## Part A: Certification

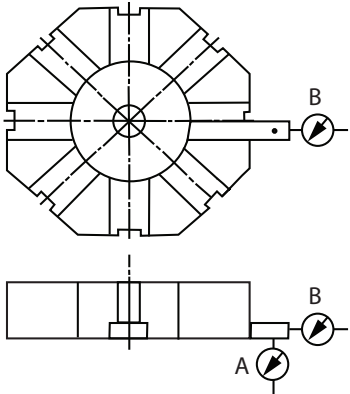
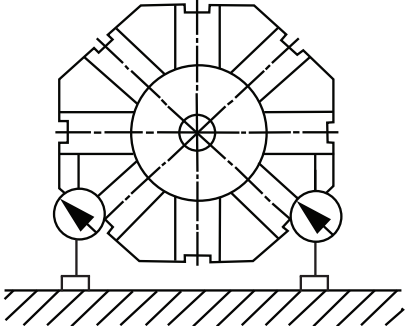
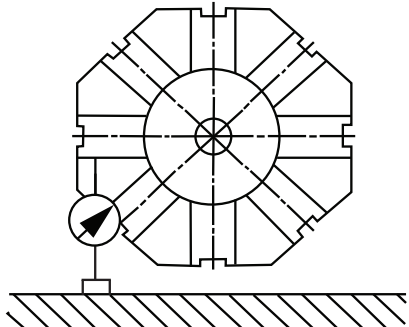
### Machinery Certification

Title	Seal or Signature <sup>1</sup>	Date
Inspection Director		
Inspector		
Tormach QA Representative		

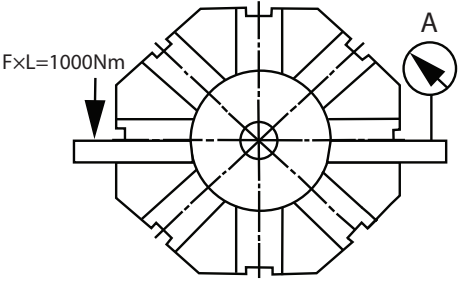
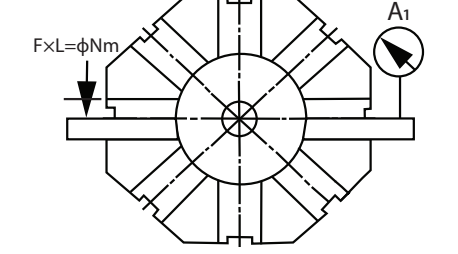
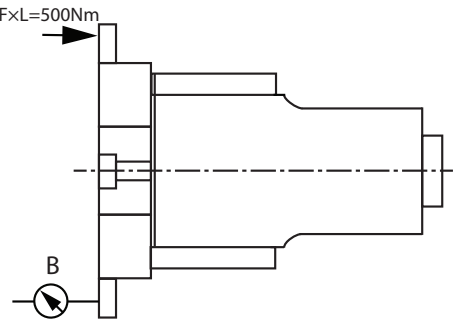
<sup>1</sup>The above signatures certify this machine has passed all precision-inspection requirements and is approved for delivery. See attached inspection documentation.

## Part B: Quality Detail

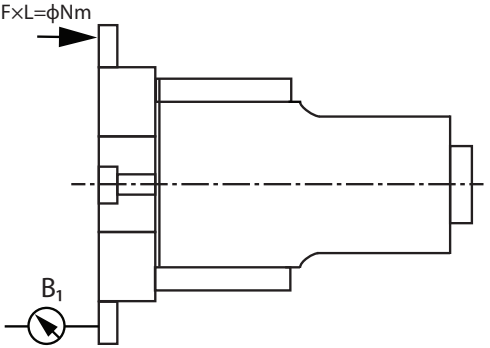
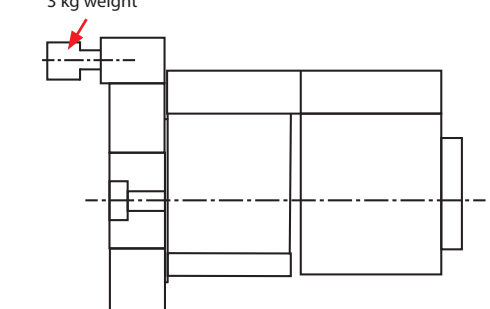
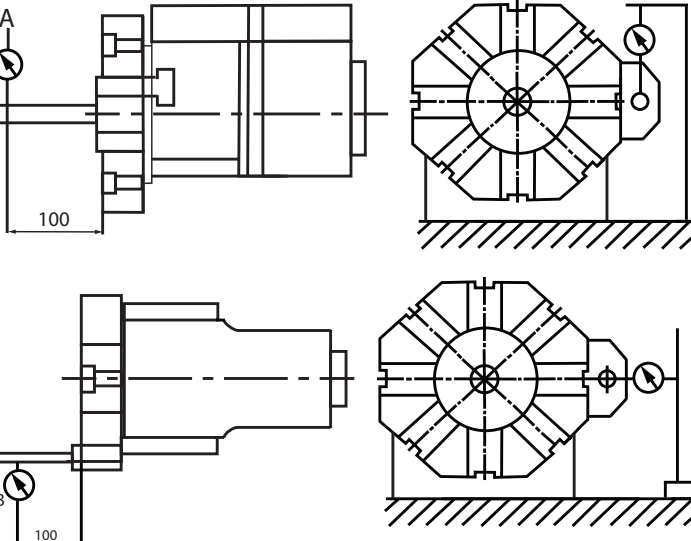
### QA I: Precision Inspection

No.	Inspection Sketch	Inspection Item	Allowable Error (mm)	Actual (mm)
G1		Position repeatability of test bar	<b>a: and b:</b> Two directions 0.005	
G2		Parallelism of tool holder base level to reference surface	0.1	
G3		Tool holder base height variation for all slots	0.05	

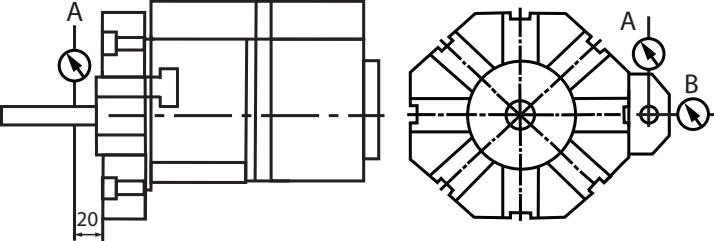
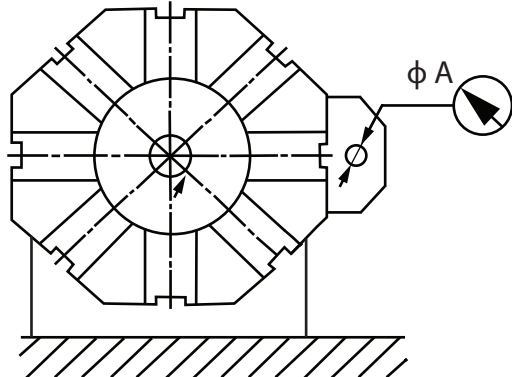
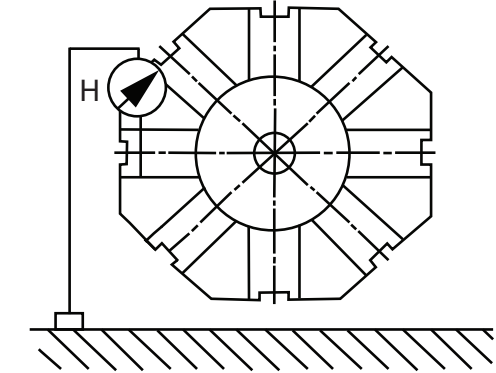
## QA I: Precision Inspection

No.	Inspection Sketch	Inspection Item	Allowable Error (mm)	Actual (mm)
G4		Compliance under load, tangential	$a = 0.05$	
G5		Residual compliance, tangential	$a_1 = 0.015$	
G6		Compliance under load, axial	$b = 0.05$	

## QA I: Precision Inspection

No.	Inspection Sketch	Inspection Item	Allowable Error (mm)	Actual (mm)
G7		Maximum residual compliance, axial	$b_1 = 0.015$	
G8		Inertia test	No malfunction	
G9		Colinearity of center line of test bar to reference surface  <b>a:</b> in vertical plane  <b>b:</b> in horizontal plane	<b>a:</b> 100: 0.02  <b>b:</b> 100: 0.02	

## QA I: Precision Inspection

No.	Inspection Sketch	Inspection Item	Allowable Error (mm)	Actual (mm)
G10		<p><b>a:</b> Equidistance of tool holder bore center line to base</p> <p><b>b:</b> Radial runout of test bar at 20 mm</p>	<p><b>a:</b> 0.02</p> <p><b>b:</b> 0.02</p>	
G11		Bore diameter	<p><b>a:</b> 19.05 H7 (+0.0210)</p>	
G12		The height of the bottom of slot from reference surface	<p><b>H:</b> 60.95<sup>+0.1</sup></p>	<p>H<sub>1</sub>=</p> <p>H<sub>2</sub>=</p> <p>H<sub>3</sub>=</p> <p>H<sub>4</sub>=</p> <p>H<sub>5</sub>=</p> <p>H<sub>6</sub>=</p> <p>H<sub>7</sub>=</p> <p>H<sub>8</sub>=</p>



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## QA 2: Packing List

No.	Name	Specification and Mark	Quantity	PN
1	Eight-position turret		1	34947
2	Boring Bar Holder (pre-installed)		3	33237
3	OD Turning/Facing Tool Holder (pre-installed)		1	33238
4	Coolant fitting (pre-installed)		1	—
5	Eye bolt		1	—
6	Shackle		1	—
7	M10 Flat Washers		6	32473
8	M10 x 30 mm Socket Head Cap Screws		6	34621