CERTIFICATE OF INSPECTION

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AF50 AUTOFEED BANDSAW

SERIAL NUMBER:

DATE OF MANUFACTURE:

MACHINERY CERTIFICATION

Title	Seal or Signature	Date
Inspection Director		
Inspector		
Tormach QA Representative		

The above signatures certify this machine has passed all inspection requirements and is approved for delivery. See attached inspection documentation.

MADE IN CHINA

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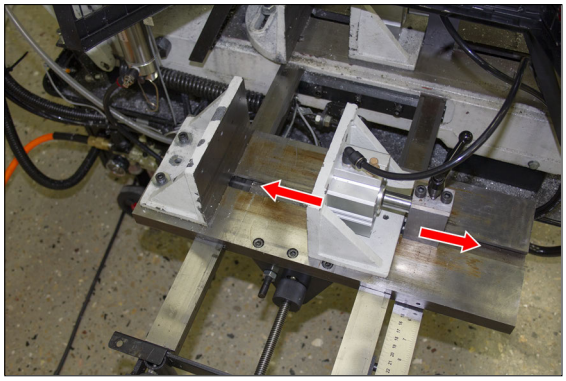
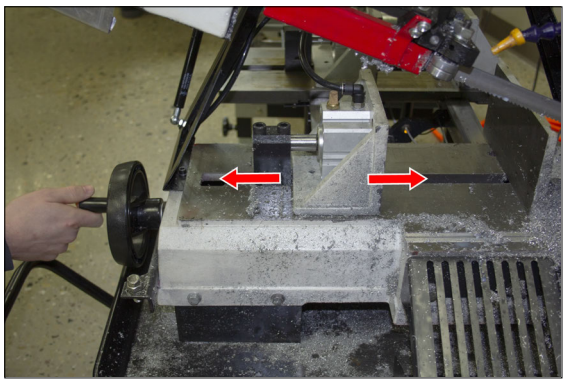
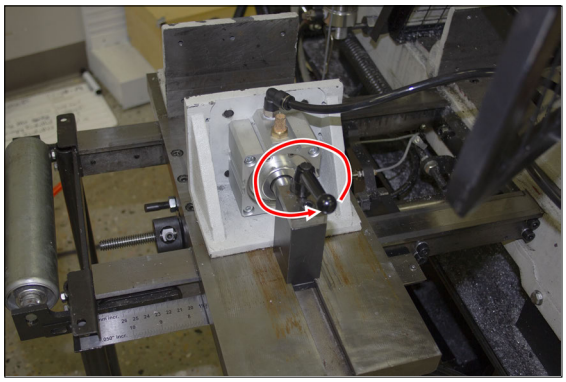
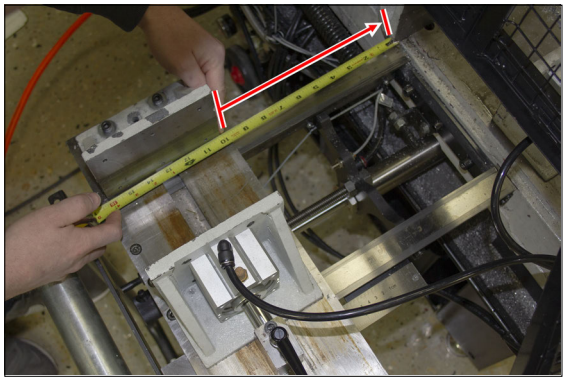
QA1: GENERAL INSPECTION

No.	Test Name	Description	Photo	Completed
1	Clamp Movement	Move both clamps throughout the entire travel of their slots, and verify that they move freely.	 	
2	Transport Clamp Function	• Lock the transport clamp into position. • Move the transport clamp in a circle to verify that it can be adjusted without obstruction.		
3	Maximum Stroke Length	Move the speed nut as far back on its screw as possible. Then, pull back the infeed table, and use a tape measure to verify that the maximum stroke length is at least 10 in. (254 mm). Measure from the face of the fixed jaw to the face of the adjustable jaw, as shown in the photo.		

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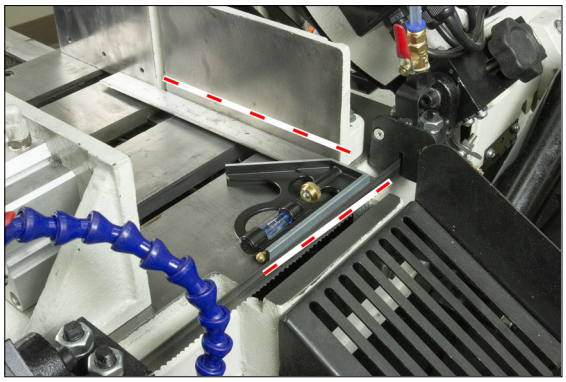
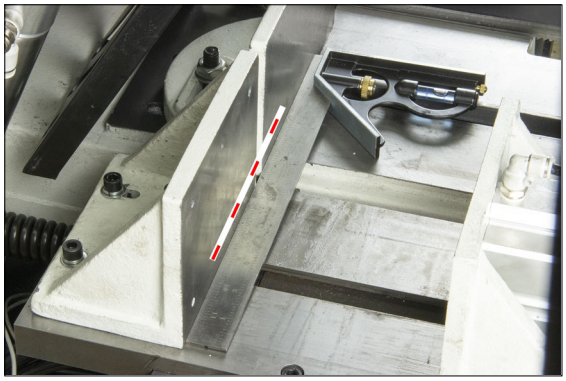
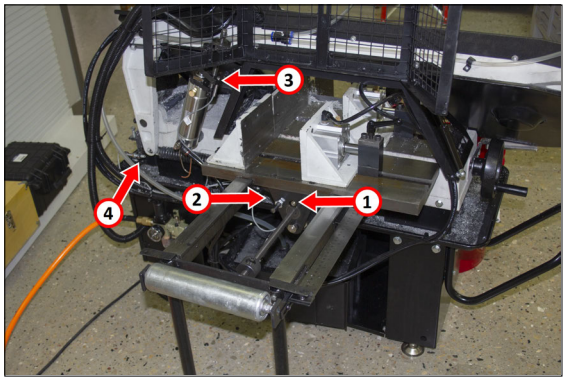
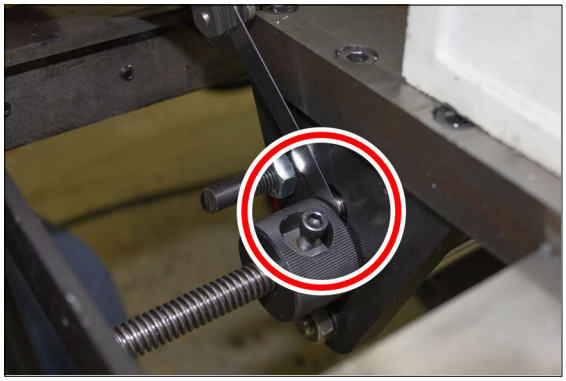
No.	Test Name	Description	Photo	Completed
4	Fixed Jaw Alignment	Use a square to verify that the fixed jaws are perpendicular to the blade.		
5	Infeed Jaw Alignment	Use a square to verify that the infeed fixed jaw is aligned with the saw fixed jaw.		
6	Proximity Switch Gap	On each of the four proximity switches, use a feeler gauge to verify that there's a 0.5 mm-0.75 mm gap. Complete this procedure for each proximity switch, including switch B3 on the electrical schematic.	 	

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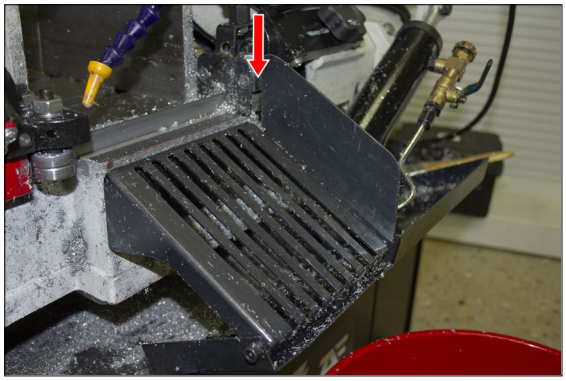
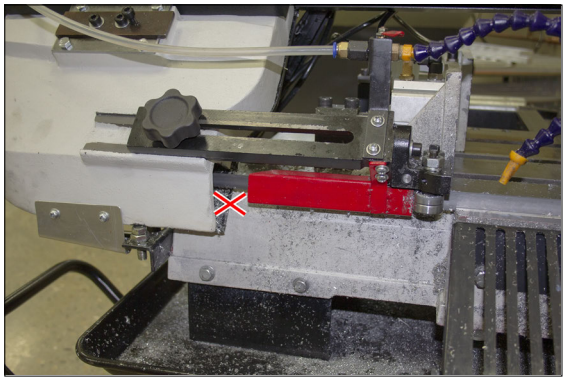
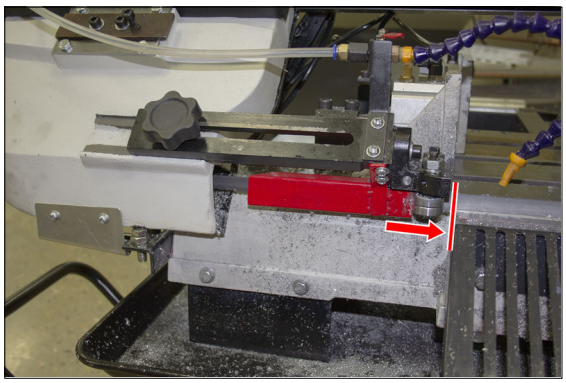
No.	Test Name	Description	Photo	Completed
7	Motion Guard: Shock Function	Open the lid of the motion guard and verify that it remains raised.		
8	Outfeed Guide Installation	Verify that the outfeed guide is installed as shown in the photo.		
9	Blade Extension Cover	Verify that the blade extension cover is long enough to cover the blade when the guide is fully extended. In the photo, the blade extension cover isn't the correct length.		
10	Movable Blade Guide Slot	Verify that the bearings on the saw guide reach the table surface.		

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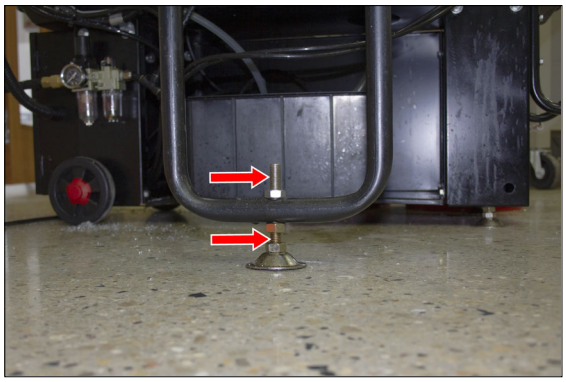
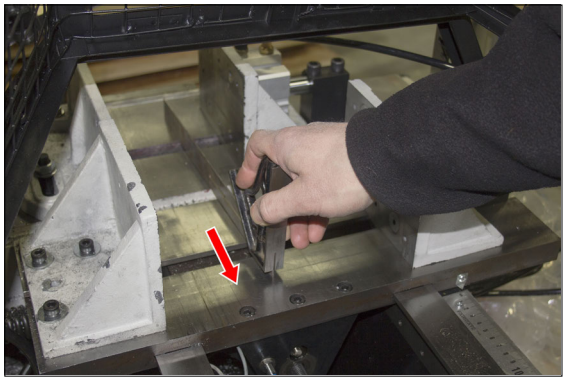
No.	Test Name	Description	Photo	Completed
11	Infeed Leg Adjustment Range	With the infeed leg on the floor, verify that there's adjustment space — both up and down — on its screw.		
12	Coolant Pump Cord Length	Move the coolant pump assembly out and set it on the floor, and verify that its cord is long enough to facilitate a coolant change.		
13	Air Lines/Wire Routing	Verify that all air lines and wires are neat and secure, and that none are pinched or have kinks.		
14	Infeed Table Height	Use a straight edge to verify that the infeed table is flush and parallel with the saw.		
15	Plastic Cover Installation Height	Push the buttons on the control panel, and verify that the buttons are easy to push. This indicates that there's not too much distance between the plastic cover and the buttons.		

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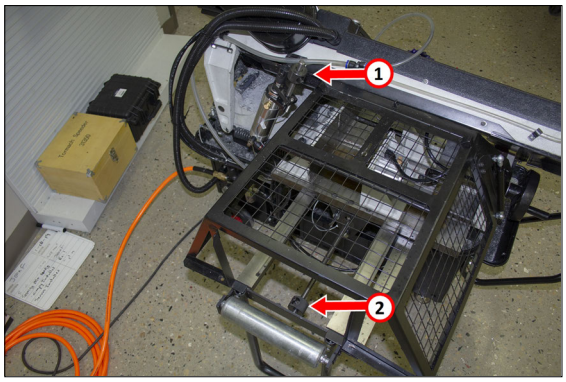
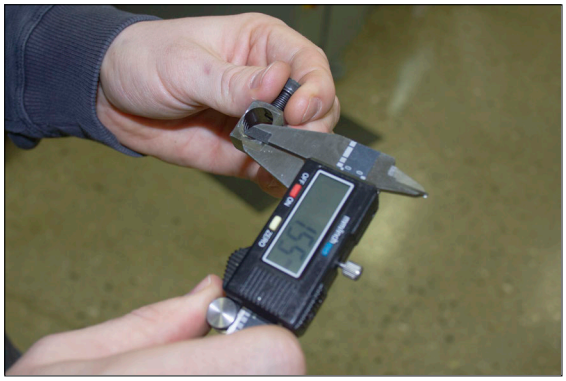
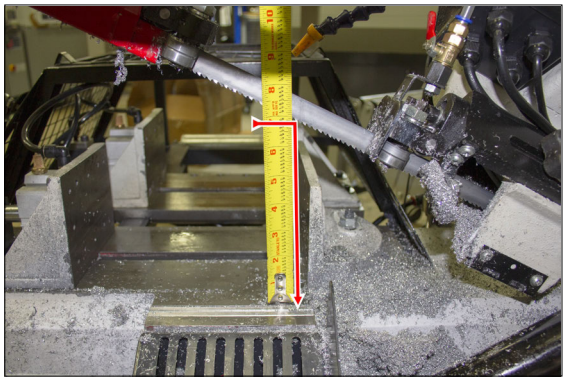
No.	Test Name	Description	Photo	Completed
16	Speed Nuts Thread Engagement	On both of the two speed nuts, remove the internal nut and verify that the threads are 1.5 mm deep.	 	
17	Full Cut Height	• Lift the saw to it's full cut height, and use a measuring tape to verify that there's 6.5 in. of clearance between the table and the blade. You must measure this distance at the fixed jaw, as shown in the image. • With the saw still lifted, inspect the **LIFT** proximity sensor's wire to verify that it's the correct length, and that it has some extra slack.		
18	Clean Electrical Cabinet	Verify that all electronics and pneumatics are secured and that the electrical cabinet is, overall, clean.		

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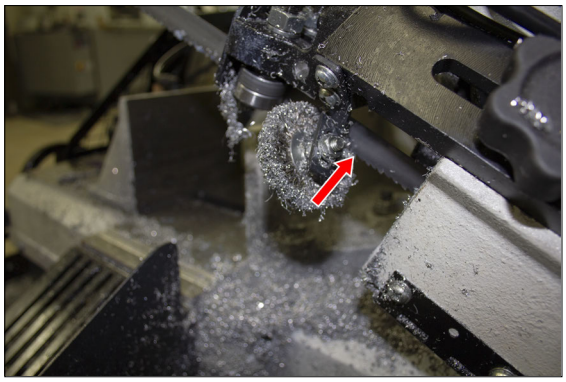
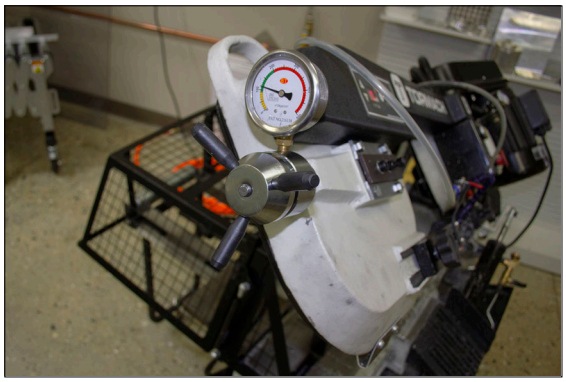
No.	Test Name	Description	Photo	Completed
19	Blade Brush Installation	Verify that the blade brush contacts the blade.		
20	Drip Guard Installed	Verify that the drip guard is installed, and that there are no pinched wires.		
21	Blade Tensioner Operation	Test the blade tensioner's operation: verify that, as you tighten the blade, the pressure increases.		
22	Hardware and Fasteners Tightened	Verify that all hardware and fasteners are appropriately tightened and, where necessary, use Loctite.		
23	Crate Support Installed	Verify that an additional foot is installed on the bottom of the shipping crate for support and stiffness.		

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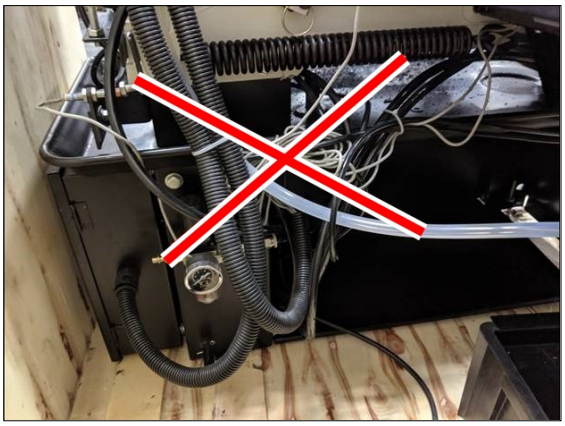
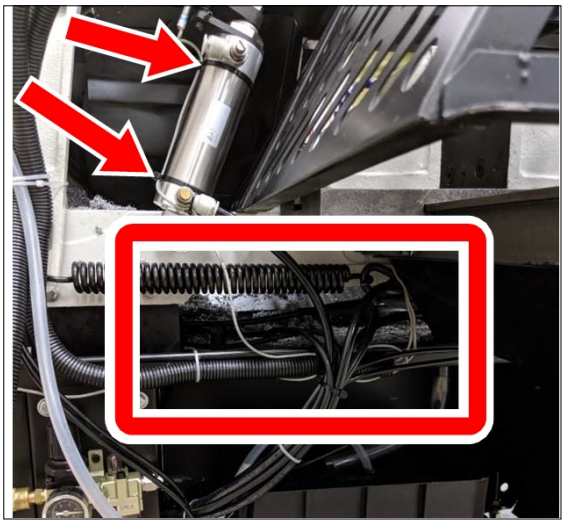
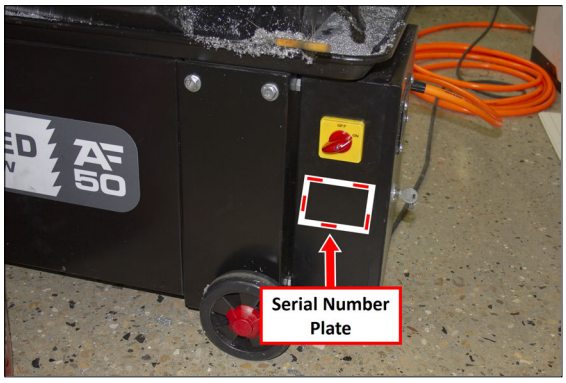
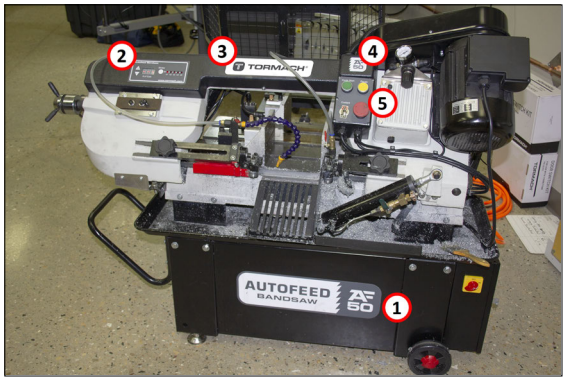
No.	Test Name	Description	Photo	Completed
24	Control Box Cover Installed	Verify that the control box cover is installed. Examine the cover near the screw holes, and verify that the cover isn't cracked. **Note:** The cover cracks if the screws are overtightened.		
25	Back of Control Panel Stickers Covered	Put tape over the back side of the control panel sticker, and verify that none of the stickers are exposed. This indicates that other components on the machine won't get stuck and break.		

No.	Test Name	Description	Photo	Completed
26	Proximity Switch Wiring	Verify that the proximity switch wiring is neat and secure. In cases of excess wiring, do one of the following: • Cut the proximity wire to the correct length. • Organize excess proximity wiring under the top plastic cover.	 	

QA2: APPEARANCE INSPECTION

No.	Test Name	Description	Photo	Complete
1	General Condition	Verify that the machine has the correct paint colors and finish.		
2	Serial Number Plate	Verify that the serial number plate is installed in the correct location and with the correct information.		
3	Decals	Verify that the decals are applied as shown in the image.		

QA3: FUNCTIONALITY TESTS

No.	Test Name	Description	Complete
1	Clamp (Initial)	1. Set the gap between the fixed and movable jaws to 10 mm. 2. Set the clamp pressure to 100 psi. 3. Activate the clamps, and verify that they hold position.	
2	Clamp (Additional)	1. Set the gap between the fixed and movable jaws to 10 mm. 2. Set the clamp pressure to 0 psi. 3. Activate the clamps, and verify that they don't move. 4. Set the clamp pressure to 50 psi.	
3	Multiple Stroke Test (at 10 in., the full length of travel) Pause function test included	1. Set the cut length to 10 in. 2. Set the stroke count to 5. (graphic) 3. Set the cut counter to 2. 4. Run the saw to verify that all strokes have a smooth travel. 5. Test the functionality of the **Pause** button. 6. Verify that the saw lift operates smoothly.	
4	Ruler Position Accuracy	Verify rule calibration.	
5	Manual Mode Function	1. Set the saw to manual mode using the two-button push method. 2. Verify that saw motor turns off at the bottom of the cut.	
6	Coolant Pump	Do a dry run of the coolant pump.	
7	Automatic Mode Cut (85 psi set at the main regulator)	1. Cut five pieces at 50 mm in automatic mode. 2. Verify that the part length is repeatable. 3. Verify rule calibration. 4. Listen for air leaks. 5. Verify a smooth motion of travel. 6. Verify that saw motor stops when counter reaches **0**.	