

CERTIFICATE OF INSPECTION

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8L LATHE

SERIAL NUMBER:

DATE OF MANUFACTURE:

MACHINERY CERTIFICATION

Title	Seal or Signature	Date
Inspection Director		
Inspector		
Tormach QA Representative		

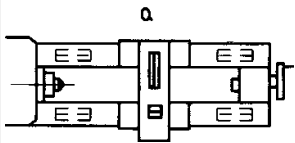
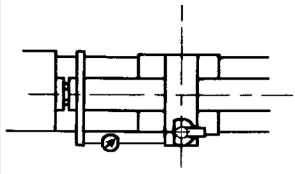
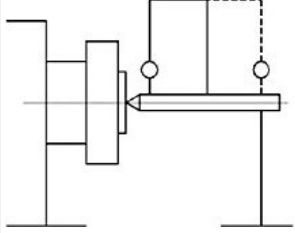
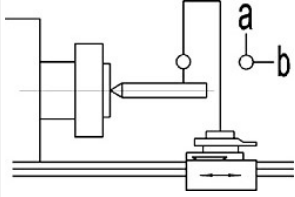
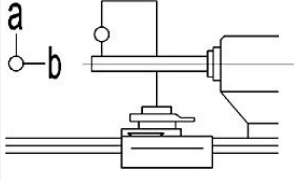
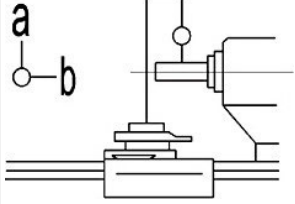
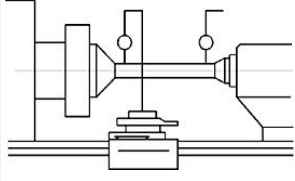
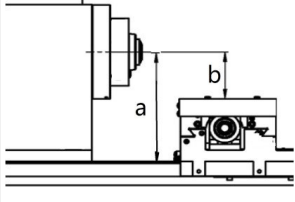
The above signatures certify this machine has passed all inspection requirements and is approved for delivery. See attached inspection documentation.

MADE IN CHINA

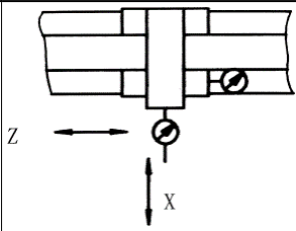
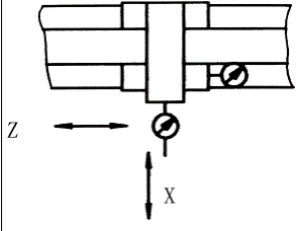
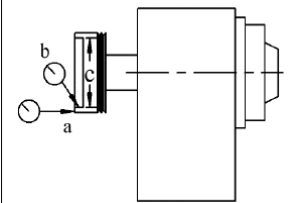
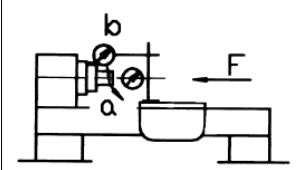


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QA 1: PRECISION INSPECTION

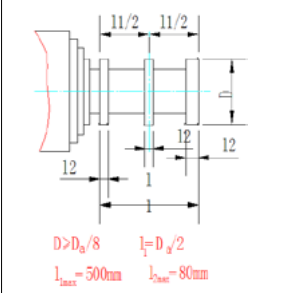
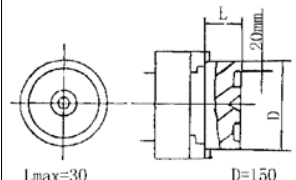
No.	Inspection Item	Tolerance (mm)	Actual (mm)
G1		a: Leveling the lathe	a: 0.04/300
G2		Perpendicularity of X-axis to spindle axis	0.03/100
G3		a: Runout of spindle taper hole a spindle nose b: 200 distance	a: 0.01 b: 0.03
G4		Parallelism of center line of spindle to carriage movement a: in horizontal plane b: in vertical plane	a: 0.03/200 b: 0.03/200
G5		Parallelism of tailstock quill to carriage movement a: in horizontal plane b: in vertical plane	a: 0.02/50 b: 0.02/50
G6		Parallelism of tailstock quill taper hole to carriage movement a: in horizontal plane b: in vertical plane	a: 0.02/5 b: 0.02/50
G7		Difference between two centers	0.02-0.06
G8		a: Distance from bed guide to spindle center b: Distance from table surface to spindle center	a: 105+1.0/-0 b: 53.5 +0.50/0

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No.	Inspection Item	Tolerance (mm)	Actual (mm)
G9		Forward/reverse lost motion of travel a: X-axis b: Z-axis	a: 0.03 b: 0.04
G10		Axis repeatability a: X-axis b: Z-axis	a: 0.015 b: 0.015
G11		Spindle drive pulley a: Perpendicularity of pulley face to axis rotation	a: 0.08
G12		Run-out at spindle end a: End play of the spindle	a: 0.01

Cut Testing

One machine is selected for each production batch (or each 20 machines produced, whichever is fewer). If the selected machine does not meet specification, then all machines in production batch must be completely inspected. If the selected machine does meet specification, all other machines in the production batch will be reported as not selected (NS).

No.	Inspection Item	Tolerance (mm)	Actual (mm)
P1		Accuracy of finishing outside circle a: Cylindricity b: Roundness	a: 0.01/50 b: 0.005
P2		Planeness of finishing end face	0.025/100

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QA 2: FUNCTION/APPEARANCE

No.	Test Name	Description	Completed
T1	Emergency Stop Switch	Check for function.	
T2	Spindle Direction	Wheel spins counterclockwise when viewed from front.	
T3	Spindle Motor Drive Program	After power cycling the variable frequency drive (VFD), verify the following settings: <ul style="list-style-type: none">• 00.011 (Machine Name) is 770• 00.012 (Parameter Version) is 3.05• 00.015 (Control Firmware Version) is 1.10.00 or greater• 00.016 (Power Firmware Version) is 1.10.00 or greater• 00.017 (User Program Version) is 7732	
T4	Power Disconnect	Check for function.	
T5	X Limit Switch	Check for function.	
T6	Z Limit Switch	Check for function.	
T7	Smooth Operation	X, Z, spindle operate smoothly; no unusual noise or vibration.	
T8	Spindle Encoder	Check for proper function.	
T9	Safety Signs	Safety sign (PN 34071) is installed in correct location.	
T10	Information Signs	Information signs are installed in correct locations.	
T11	Paint Quality	Paint meets appearance requirements.	
T12	Spindle Door Switch	Check for function.	
T13	Enclosure Door Switch	Check for function.	
T14	Drawtube Install	Drawtube with test collet and remove.	