

PCNC1100 NC MILLING MACHINE

CERTIFICATE OF INSPECTION

SERIES:

MADE IN CHINA

This is to certify that this machine is qualified in precision inspection and permitted
for delivery.

Attached with the “Precision Inspection Form”

Inspection Director: (Seal)

Date

Inspector: (Seal)

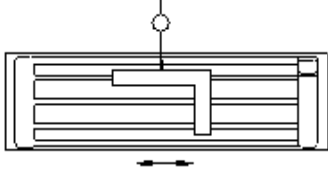
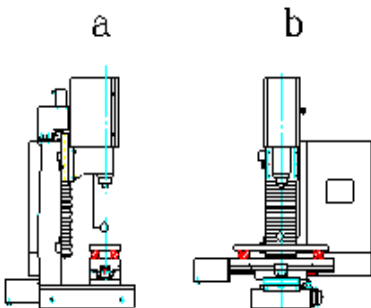
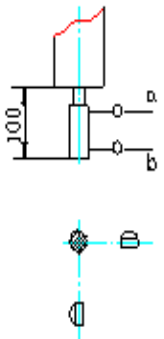
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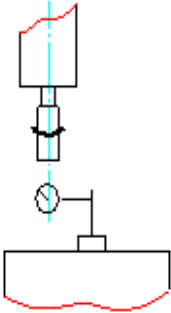
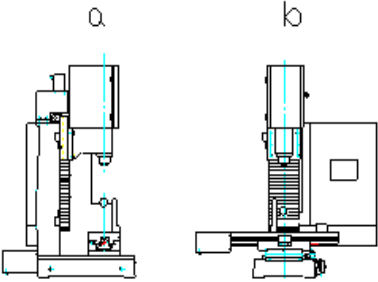
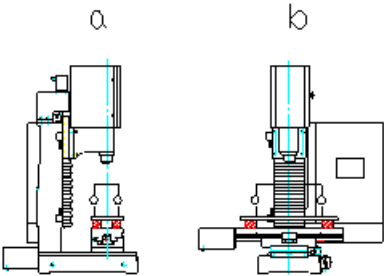
Tormach Quality Representative: (Seal)

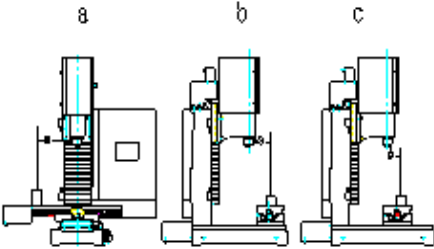
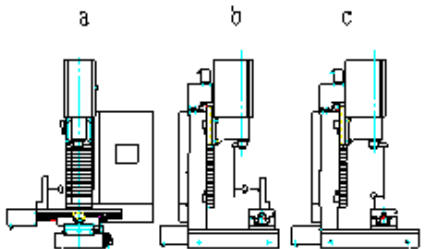
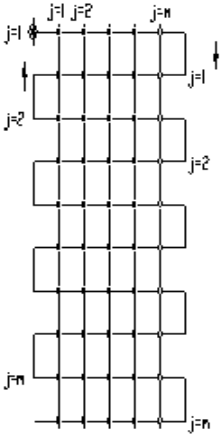
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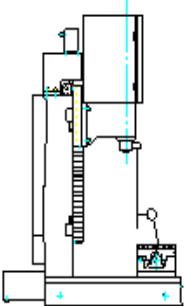
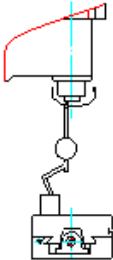
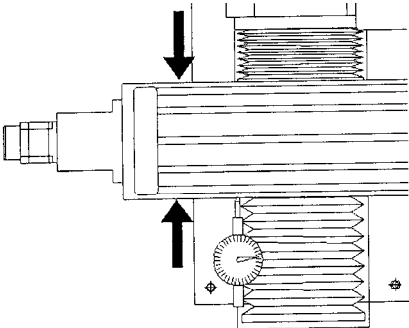
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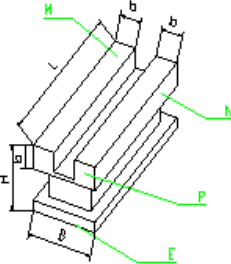
Registered Date: Feb. 5, 2002

No.	Inspection Sketch	Inspection Item	Allowable Error/mm	Actual Measure/mm
G1		<p>The perpendicularity of the longitudinal traverse to cross traverse of the working table</p>	<p>0.04/200</p>	
G2		<p>The parallelism of the working table surface to working table traverse a: Cross Direction; b: Longitudinal Direction;</p>	<p>a: Within the measure length of 100: 0.04/100 b: Within a random measure length of 200: 0.03/200 Within the total travel length: ≤400 0.04 > 400 0.06</p>	
G3		<p>The radial run-out on the axis of spindle conical hole: a: At the place near spindle end; b: At the place of 100mm away from the spindle end;</p>	<p>a: 0.02 b: 0.03</p>	

No.	Inspection Sketch	Inspection Item	Allowable Error/mm	Actual Measure/mm
G4		Axial float of Spindle	0.015	
G5		<p>The perpendicularity of the vertical shifting of spindle box to the surface of working table</p> <p>a: Within cross plane; b: Within longitudinal plane;</p>	<p>a: 0.035/150 b: 0.035/150</p>	
G6		<p>The perpendicularity of the axis of revolution of spindle to the surface of working table</p> <p>a: Within cross plane; b: Within longitudinal plane;</p>	<p>a: 0.04/200 b: 0.04/200</p>	

No.	Inspection Sketch	Inspection Item	Allowable Error/mm	Actual Measure/mm
G7		The reverse idle stroke of the rectilinear motion coordinate	a:0.03 b:0.03 c:0.04	
G8		Resetting accuracy	0.02	
G9		<p>Setting accuracy</p> <p>(For each 20 sets of the machines, one set should be inspected; For each production batch less than 20 sets of the machines, one set should be inspected. If the selected test machine does not meet specification in this inspection, then all of these machines must be completely inspected. If the selected test machine does meet specification, all other machine will be reported as NS, indicating the machine was Not Selected for the sample test.)</p>	0.03/200	

No.	Inspection Sketch	Inspection Item	Allowable Error/mm	Actual Measure/mm
G10		<p>The parallelisms of the central section of working table or the reference of T-slot to the cross (X direction) traverse of the working table.</p>	<p>At any measuring length of 200; 0.015/200</p>	
G11		<p>Spindle face flatness</p>	<p>0.02</p>	
G12		<p>Lateral displacement of work table</p>	<p>0.04</p>	

No.	Inspection Sketch	Inspection Item	Allowable Error/mm	Actual Measure/mm
P1	 <p data-bbox="349 1176 625 1438"> Size of test piece (bulk piece) $L \times B \times H$ $L \geq 1/3$ longitudinal travel $H \geq L/3$ $B \geq L/3$ $b \geq 16\text{mm}$ Material: HT150 </p>	<p data-bbox="738 420 982 1690"> Milling Accuracy: a: Flatness of Surface M; b: Parallelism of Surface M to Surface E; c: Perpendicularities of Surface P to Surface M, and Surface N to Surface P. (For each 20 sets of the machines, one set should be inspected; For each production batch less than 20 sets of the machines, one set should be inspected. If the selected test machine does not meet specification in this inspection, then all of these machines must be completely inspected. If the selected test machine does meet specification, all other machine will be reported as NS, indicating the machine was Not Selected for the sample test.) </p>	<p data-bbox="1006 693 1128 798"> a.0.04/150; b.0.06; c.0.06/50 </p>	

Certificate of Inspection Additions

Number	Test Name	Description	Completed
T1	Spindle Speed	Minimum and maximum speeds calibrated	
T2	Spindle Direction	CW and CCW correct	
T3	Spindle Door Switch	Spindle drive contactor opens when spindle access door is opened	
T4	Spindle Key Switch	Spindle drive contactor opens when spindle lockout key switch is operated	
T5	Coolant Outlet	Coolant outlet operational in manual and automatic	
T6	Safety Signs	Safety signs 30223,30224 and 30225 have been installed	
T7	Information Signs	Information signs 30222 and 30226 have been installed	
T8	Computer Outlet	Computer outlet and switch operate	
T9	Probe Input	Probe input check for operation	
T10	X Limits	X left and X right limits operate	
T11	Y Limits	Y front and Y back limits operate	
T12	Z Limits	Z up and Z down limit switches operate	
T13	Belt Position Change	Belt position can be changed without binding or collision	
T14	Smooth Operation	X, Y, Z and spindle operate without unusual noise or vibration	
T15	24 Hour Test	24 hour run test has been completed	
T16	Adjusting Screw of Gib	Position of Adjusting Screw	
T17	T-slot of Work Table	Width of T-Slot	
T18	Test the resistance from every prong of the plug to the ground copper plate.	If the test result is zero, the machine needs to be repaired.	

Packing list

NO.	Name	Specification and mark	Quantity	Remark
1	Draw bar	XK712.F-1	1	
2	Allen wrench	4. 5. 6. 8. 10	1 for each	
3	Double open end wrench	13×16	1	
4	Philips screw driver	100	1	

Note: The keys for control cabinet and spindle switch are in the accessory box.