

# Okuma

Type of Machine:

L B 10

nominal size:

No. of Machine:

1343

## TEST RECORD

MESSRS:

OKUMA MACHINERY WORKS LTD.





TEST CHART  
FOR  
NUMERICALLY CONTROLLED LATHE

Messrs.

Type of Machine:

L B 10

Nominal size:

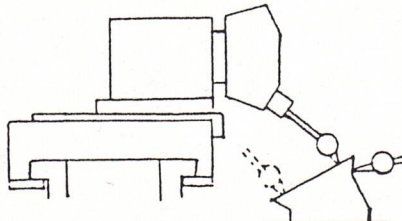
Serial No. of Machine:

1343

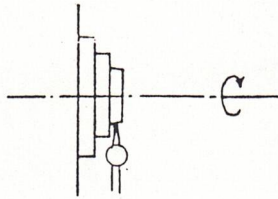
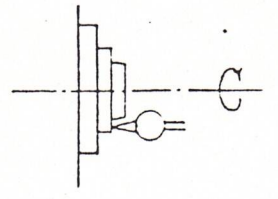
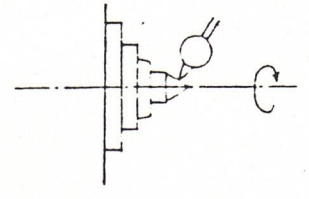
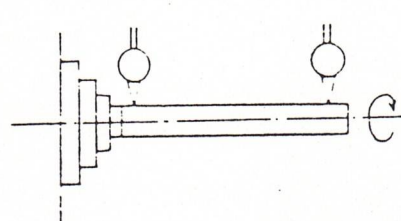
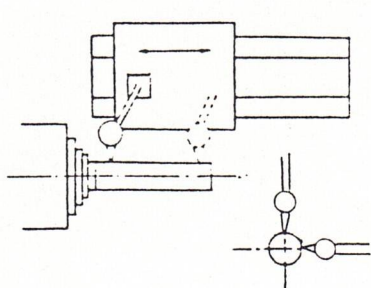
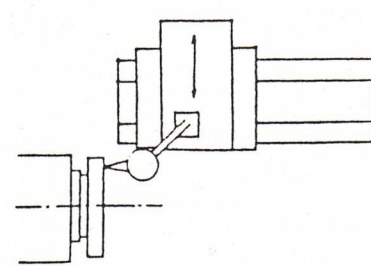
## ACCURACY TEST

Date: JUL.19.1985

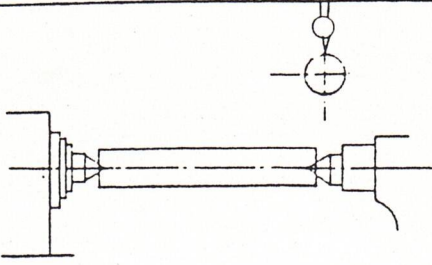
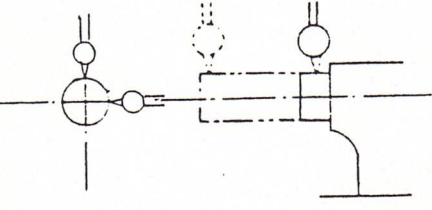
Unit: mm

Test applied			Tolerance	Measurement
No.	Item	Illustration		
1	Straightness of bed slide ways (Bed level)	a. Z-axis direction (in vertical plane)	Overall length of travel 0.04/m Convex only	0.03
		b. X-axis direction (in vertical plane)	Overall length of travel 0.04/m	0.02
		c. X-axis direction (in horizontal plane)	Overall length of travel 0.01	0.003
2	Parallelism of bed slideways		Overall length of travel 0.02	0.01



Test applied			Tolerance	Measurement
No	Item	Illustration		
3	Spindle nose for true running (Spindle nose runout)		0.01	0.003
4	Spindle for axial slip (Cam action of spindle)		0.015	0.003
5	Spindle center runout		0.015	-
6	Taper of spindle for true running (Spindle taper hole runout)		0.01 per 200	0.004
	a. at end of spindle nose b. at free end of test bar		0.015 per 200	0.01
7	Parallelism between spindle axis and upper saddle movement		0.01 per 200 high at free end of test bar	0.008
	a. in vertical plane b. in horizontal plane		0.01 per 200 forward at free end of test bar	0.007
8	Perpendicularity between spindle axis and upper cross-slide movement		0.01 per 150  to face concave only	0.006



Test applied.			Tolerance	Measurement
No	Item	Illustration		
9	Perpendicularity between spindle axis and lower cross-slide movement		0.03 - 0.05 high at tail-stock	0.04
10	Parallelism between saddle in movement and tailstock spindle centerline		0.01 per 60 high at free end	0.006
	a. in vertical plane b. in horizontal plane		0.01 per 60 forward at free end	0.008

Note: 1. Z-axis direction means a direction parallel with the spindle centerline and also a direction square with the Z-axis direction is X-axis direction.

2. "In vertical plane" of test items 1, 7 and 10 means a spindle centered plane perpendicular with the cross-slide ways and also the "In horizontal plane" means a spindle centered plane parallel with the cross-slide ways.

3. Test items are applied only for the machine having a corresponding functions and equipment.

4. Each measurement shall be done under normal condition of machine before warming-up running.

5. Tolerance and measurement values of test item 1 are maximum reading difference of spirit level and are followed in accordance with JIS B6202 Standards.

Approved by: \_\_\_\_\_

Inspected by: \_\_\_\_\_

Checked by: \_\_\_\_\_

Inspection Division  
OKUMA MACHINERY WORKS LTD.