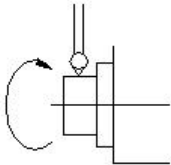
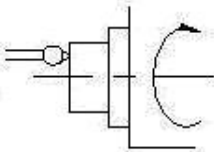
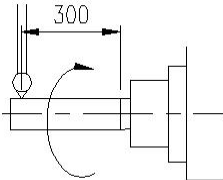
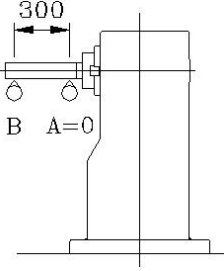


# TEST CHART FOR DEEP BORING RIGHT ANGLE MILLING

## HEAD

No.	Inspection item	Measuring method	Figure	Tolerance Permissible (mm)	Actual value measured (mm)
1	Run-out of the external centering surface.	Fix an accuracy gauge to external diameter of the spindle nose, and take the measurement of the maximum difference of readings during the rotation of the spindle as the value required.		0.01	
2	Beat of the end face of the main spindle	Fix an accuracy gauge to touch the end face of the main spindle, and take the beat measurement of the maximum difference of readings during the rotation of the main spindle as the determination of value.		0.01	
3	Main spindle hole run-out	Install a test bar at the main spindle hole. Then turn the main spindle test bar. The maximum measured value at 300mm of the test bar from precision scale.		At point 300mm 0.02	

<p><b>4</b></p>	<p>The degree of parallel of the fixed face and spindle</p>	<p>Place the milling head on the surface of the platform and measure the run out of spindle. Measure point B first and back to zero after take the intermediate value, then move to point A and read the value.</p>		<p><b>B-A=0.02</b></p>	
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