



VERTICAL MACHINING CENTERS ACCURACY INSPECTION RECORD

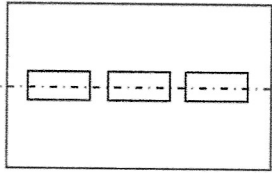
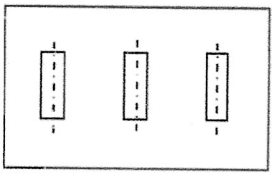
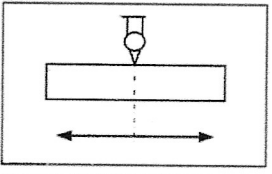
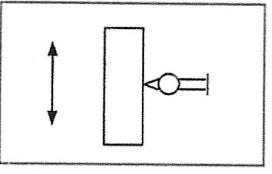
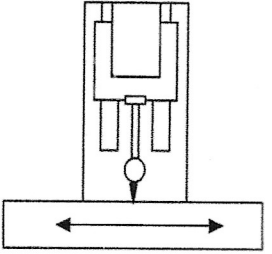
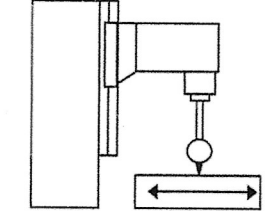
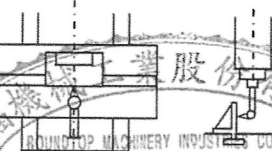
立式切削中心機 精度檢驗報告

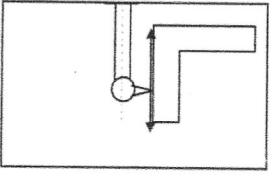
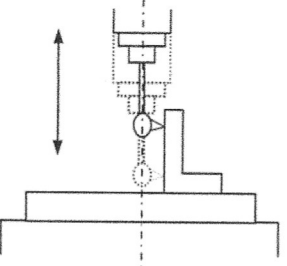

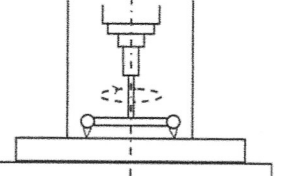
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JIS B6336-2

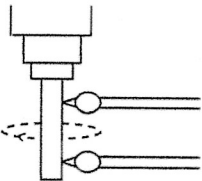
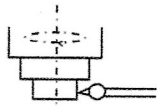
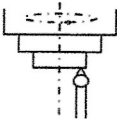
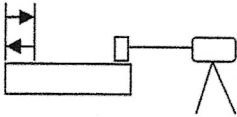
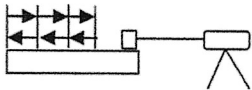

客 戶 Customer :
檢驗單位 Manufacture Department : Q.C
機 型 Model Number : VMC-2000SHD
機 號 Serial Number : VDB180076
製造日期 Completion Date : 2018.01



No	檢查項目 Inspection Item	測定方法圖 Figure	許可差 Tolerance	測定值 Measurement
1.	Flatness of Table 床台 X, Y 軸方向平面度	X 	0.05/M	0,03
		Y 	0.04/M	0,03
2.	Straightness of Table Movement in X-Y Plane 床台 X, Y 軸方向運動真直度	X 	0.01/500mm	0,005
		Y 	0.01/500mm	0,003
3.	Parallelism of X-axis Movement of Table to Its Upper Surface 床台 X 軸方向運動與床台面之平行度		0.03 /1M	0,012
4.	Parallelism of Y-axis Movement of Table to Its Upper Surface 床台 Y 軸方向運動與床台面之平行度		0.03 /1M	0,015
5.	Parallelism of X-axis Movement of Table to Side of Middle T Slot of Table 床台 X 軸方向運動與基準 T 型槽之平行度	 品檢課專用章 NO.1066, ZHONGSHAN RD., SHENGANG DIST., TAICHUNG CITY 42952, TAIWAN (R.O.C.) TEL (04) 25624721 FAX (04) 25610476	0.03/1M	0,02

No	檢查項目 Inspection Item		測定方法圖 Figure	許可差 Tolerance	測定值 Measurement
6	Squareness of X-axis Movement to Y-axis Movement X軸及Y軸運動之直角度	X-Y PLANE		0.015/300mm	0,004
7.	Straightness of Z-axis Movement 主心軸頭於Z軸方向之真直度	X-Z PLANE		0.01/300mm	0,004
		Y-Z PLANE			0,003
8.	Squareness of Z-axis Movement to Table Surface 主心軸頭Z軸方向運動與床台之直角度	X-Z PLANE		0.015/300mm	0,007
		Y-Z PLANE			0,005
9.	Squareness of Upper Surface of Table to Center Line of Main Spindle 床台面與主心軸中心線之直角度	X		0.02/300mm	0,015
		Y			0,017



No	檢查項目 Inspection Item	測定方法圖 Figure	許可差 Tolerance	測定值 Measurement	
10	Main Spindle Taper Hole Run-out 主心軸孔之擺幅		0.008 mm 近端	0,007	
			0.02 mm 末端 300 mm	0,018	
11	Run-out of Spindle 主心軸外面及端面偏擺		0.01	0,003	
			0.01	0,002	
12	Repeatability of Linear Movement 直線運動之反覆定位精度		0.006/M	X Axis	
		Y Axis			
		Z Axis			
13	Positioning Accuracy 直線運動之定位度		0.012/M	X Axis	
				Y Axis	
				Z Axis	
Chief 主管單位		Supervisor 主管		Inspector 操作者	
 <p> 喬福機械工業股份有限公司 ROUNDTOP MACHINERY INDUSTRIES CO., LTD. 品檢課專用章 NO.1066, ZHONGSHAN RD., SHENGANG DIST., TAICHUNG CITY 42952, TAIWAN (R.O.C.) TEL (04) 25624721 FAX (04) 25610476 </p>					