



48V / 48 APC / 48V-15K

Vertical machining center

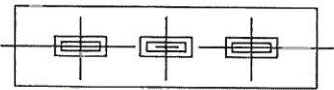
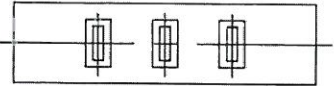
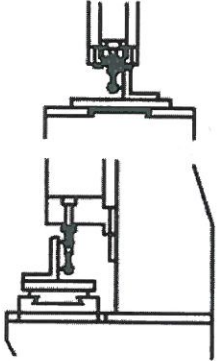
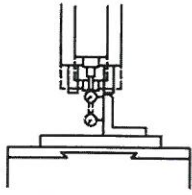
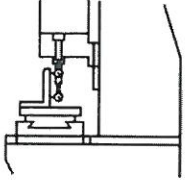
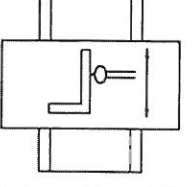
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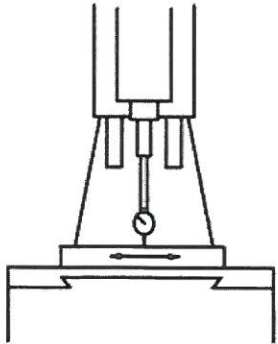
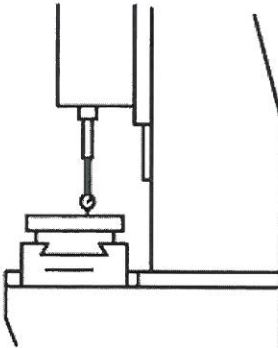
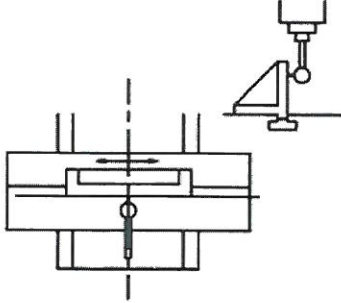
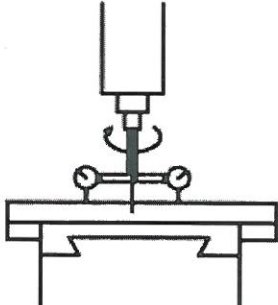
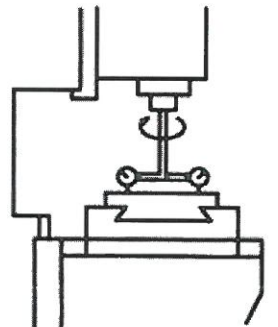
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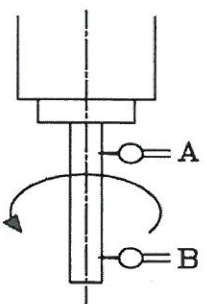
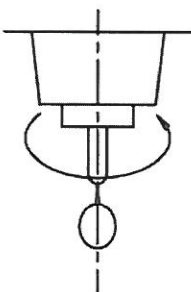
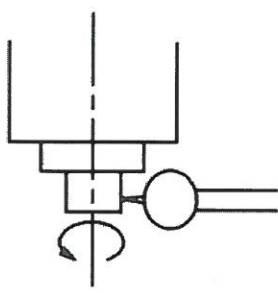
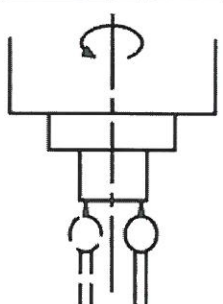
Machine No

NVLB8C0002

Final inspection record

No	Object	Diagram	Permissible Deviation	Measured values in μm
1	Level	X - Z X - Z plane	 Travel between 0 ~ 1'000 mm 0.05 mm Travel between 1'000 ~ 2'000 mm 0.06 mm	0,02
	Gauge: Level	Y - Z Y - Z plane	 0.04 mm/m	0,02
2	Straightness of Z-axis Movement	Z - X Z - X plane	 0.01 mm / 300 mm	0,002
	Gauge: Squareness Gauge 400 mm Dialer 0.001 mm	Z - Y Z - Y plane		0,002
3	Squareness	X - Z	 0.02 mm / 300 mm	0,005
	Gauge: Squareness Gauge 400 mm Dialer 0.001 mm	Y - Z	 0.02 mm / 300 mm	0,007
		X - Y	 0.02 mm / 300 mm	0,005

No	Object	Diagram	Permissible Deviation	Measured values in μm	
4	Parallelism of X-axis Movement and Table Surface Gauge: Dialer 0.001 mm		Travel between 0 ~ 1'000 mm 0.03 mm Travel between 1'000 ~ 2'000 mm 0.04 mm	0,010	
5	Parallelism of Y-axis Movement and Table Surface Gauge: Dialer 0.001 mm		0.03 mm	0,011	
6	Parallelism of X-axis Movement to T slot Gauge: Dialer 0.001 mm		Travel between 0 ~ 1'000 mm 0.03 mm Travel between 1'000 ~ 2'000 mm 0.04 mm	0,010	
7	Squareness of spindle and Table Surface Gauge: Dialer 0.001 mm	X - Z X - Z plane		0.02 mm / 300 mm	0,012
		Y - Z Y - Z plane		0.02 mm / 300 mm	0,006

No	Object	Diagram	Permissible Deviation	Measured values in μm
8	Run-out of Spindle with 300 mm Test Arbor Gauge: Dialer 0.001 mm Test Bar		A. 0.008 mm B. 300 mm 0.02 mm	0,002 9,005
9	Run-out of Spindle Axial Movement Gauge: Dialer 0.001 mm Test Bar		0.005 mm	0,002
10	Run-out of Spindle Gauge: Dialer 0.001 mm		0.01 mm	0,002
11	Run-out of Spindle Nose Gauge: Dialer 0.001 mm		0.01 mm	0,002

Date

30/05/2018

SCHAUBLIN MACHINES SA

MA. Caroli

Checked by

MA. CAROLI

Checking and machining as per SCHAUBLIN MACHINES SA standards.



**SCHAUBLIN
MACHINES SA**

Rue principale 4
CH-2735 Bévillard

Tel. (+41) 32 491 67 00
Fax (+41) 32 491 67 08

sales@smsa.ch
www.smsa.ch