

Schaublin 100CNC

2180123



SCHAUBLIN MACHINES SA

Vertical machining center

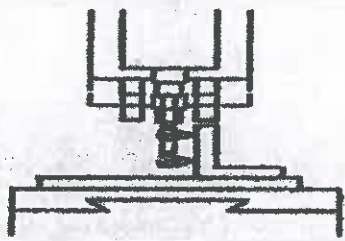
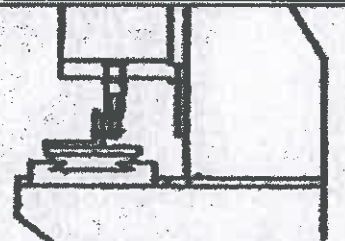
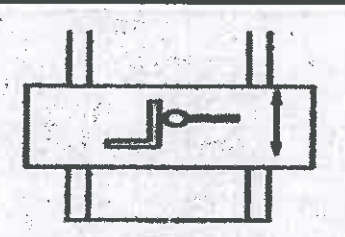
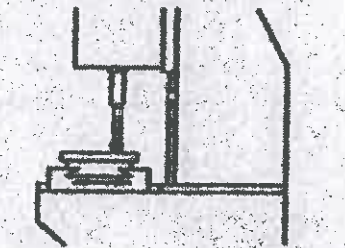
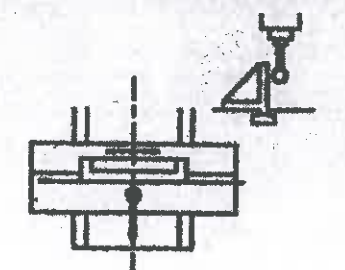
60-CNC / 100-CNC

BL n°: 350110

Machine n°: NVCA1D0082/04.01

Final Inspection Record

N°	Object	Diagram	Permissible Deviation	Measured
1	Level		Travel below 1000mm 0.05mm Travel below 1000~2000mm 0.06mm	0,031M
	Gauge: Level		0.04mm/M	0,041M
2	Straightness of Z-axis Movement		0.01/300mm	0/150mm
	Gauge: Squareness Gauge 400mm Dialer 0.001mm			Z-Y plane
3	Parallelism of X-axis Movement and Table		Travel between 0~1000mm 0.03mm 1000mm~2000mm 0.04mm	0,05

N°	Object	Diagram	Permissible Deviation	Measured
4	Squareness Gauge : Squareness Gauge 400mm Dialer 0.001mm		0.02mm/300mm	0,04
			0.02mm/300mm	0,01
			0.02mm/300mm	0,01
5	Parallelism of Y-axis Movement and Table Surface Gauge: Dialer 0.001mm		0.03mm	<0,02
6	Parallelism of X-axis Movement to T Slot Gauge : Dialer 0.001mm		1000mm 0.03mm Travel between 0~1000mm 0.03mm 1000mm~2000mm 0.04mm	<0,01



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N°	Object	Diagram	Permissible Deviation	Measured
7	Squareness of Spindle and Table Surface		0.02mm/300mm	0,004
	Gauge: Dialer 0.001mm		0.02mm/300mm	0,02
8	Run-out of Spindle with 300mm Test Arbor		A: 0.008mm	0,001
	Gauge: Dialer 0.001mm Test Bar		B: 0.02mm	0,010
9	Run-out of Spindle Nose		0.01mm	<0,01

Date : 21.08.2018 **SCHAUBLIN MACHINES SA**

Checked by :
 Wüthrich CNC Service pm pm
 Thomas Wüthrich

Inversions :

X 0,005
 Y 0,007
 Z 0,006