

| No. | Object of testing   | Drawing | Tolerance [ mm ]   | Measured error [ mm ]                                |
|-----|---|---------|--|--|
| 1   | Periodical axial slip of spindle and run out of spindle   |         | A: 0,009<br>B: 0,01  | A: 0.008<br>B: 0.001                                 |
| 2   | Run out of spindle nose centring taper  |         | 0,009  | 0.009  |
| 3   | Run out of internal taper of spindle  |         | A: 0,015<br>B: 0,03  | A: 0.01<br>B: 0.018                                  |
| 4   | Parallelism of receiving taper in tailstock<br>A = senkrecht vertical plane<br>B = waagrecht horizontal plane                                     |         | A: 0,025/50<br>B: 0,015/50                                   | A: 0.015<br>B: 0.012                                 |
| 5   | Headstock and tailstock centres for same height above reference plane<br>Receiving taper in spindle (MT 3)<br>Receiving taper in tailstock (MT 2) |         | A: 0,03  | A: 0.03  |
| 6   | Parallelism of spindle axis<br>A = senkrecht vertical plane<br>B = waagrecht horizontal plane   |         | A: 0,03/250<br>B: 0,03/250                                   | A: 0.025<br>B: 0.025                                 |
| 7   | Parallelism of spindle axis with longitudinal movement of upper slide   |         | 0,04/75  | 0.03   |
| 8   | Run out of jaw chuck  |         | 0,04   | 0.035  |
| 9   | Run out of jaw chuck<br>Test pin<br>A: Ø 20mm<br>B: Ø 30mm  |         | A)<br>1: 0,04<br>2: 0,08/100<br>B)<br>1: 0,04<br>2: 0,08/100 | A)<br>1: 0.04<br>2: 0.06<br>B)<br>1: 0.04<br>2: 0.06 |