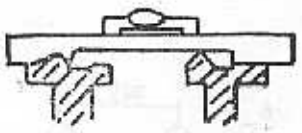
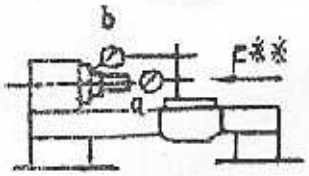
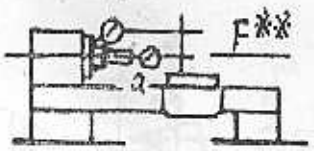
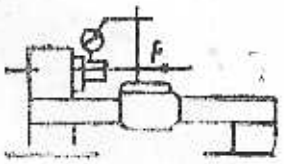
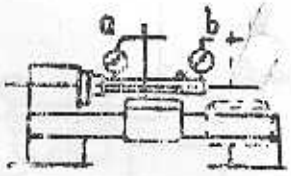
Grizzly
IMPORTS, INC

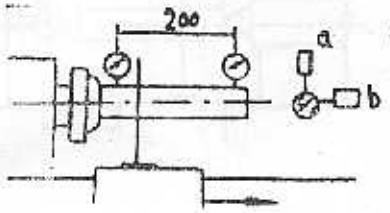
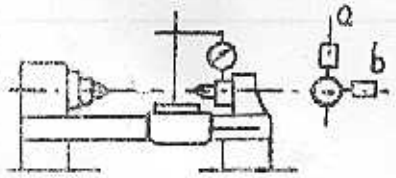
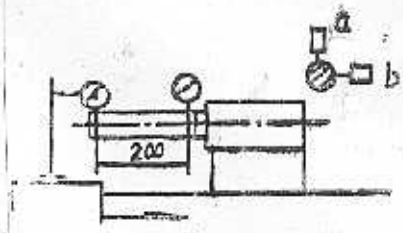
INSPECTION RECORD

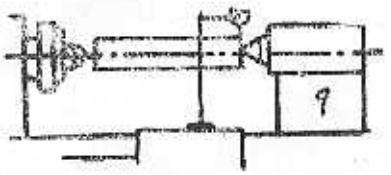
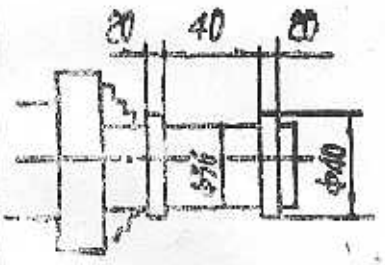
of

PRECISION BENCH LATHE

MODEL	G 4000
MFG NO.	0468
DATE	
INSPECTOR	F. W
PLANT MANGER	R C C

NO.	Diagram of measuring method	Inspection item	Tolerance (mm)	Data
G1		Parallelism of transverse direction.	0.05	0.05
G2		Spindle longitudinal runout.	0.02	0.016
G3		Spindle face runout.	0 02	0.014
G4		Spindle nose runout.	0.02	0.012
G5		Spindle taper runout. a. At end of spindle nose. b. At end of spindle 300mm test bar.	a. 0.015 b. 200:0.03	0.012 0.022

NO.	Diagram of measuring method	Inspection item	Tolerance (mm)	Data
G6		Parallelism of spindle centre line to longitudinal motion of carriage: a. In vertical plane. (upward) b. In horizontal plane. (forward)	a. 200:0.018 b. 200:0.015	0012 0011
G7		Parallelism of centre line of tailstock spindle to longitudinal motion of carriage: a. In vertical plane. (upward) b. In horizontal plane. (forward)	a. 40:0.015 b. 40:0.015	0012 0014
G8		Parallelism of centre line of tailstock spindle hole to longitudinal motion of carriage.	a. 125:0.03 b. 125:0.03	0024 0022

NO.	Diagram of measuring method	Inspection item	Tolerance (mm)	Data
G9		Difference in centre height between head-stock and tailstock. (tailstock upward)	0.06	004
P1		Accuracy of outside round cutting: a. Roundness. b. Cylindricity.	a. 0.015 b. 80:0.02	0012 0015

Inspector T- W

Date 07 96