

# Lathe Testing Procedure

SN. 7936

## 1. Test Program

Test program should run for 4 hours without any issues.

Steve approved last cycle after 4 hour test. (X) *[Signature]*

## 2. Tolerance tests

Get Steve to supervise test

a.) Check backlash on all axis.

Manufacture's readings

| Axis | Max backlash | Readings |
|------|--------------|----------|
| X    |              |          |
| Y    |              |          |
| Z    |              |          |
| B    |              |          |
| X2   |              |          |
| Y2   |              |          |
| Z2   |              |          |

Machine Maxx readings

| Axis | Max backlash | Readings |
|------|--------------|----------|
| X    |              | 0.0001   |
| Y    |              | 0.0001   |
| Z    |              | 0.0001   |
| B    |              | 0.0001   |
| X2   |              | N/A      |
| Y2   |              | N/A      |
| Z2   |              | N/A      |

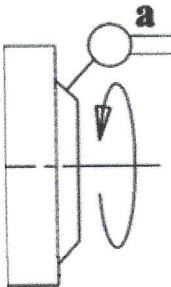
b.) Check spindle runout

Manufacture's readings

|      | Max allowance | Readings |
|------|---------------|----------|
| main |               |          |
| sub  |               |          |

Machine Maxx readings

|      | Max allowance | Readings |
|------|---------------|----------|
| main |               | 0.0002   |
| sub  |               | 0.0002   |



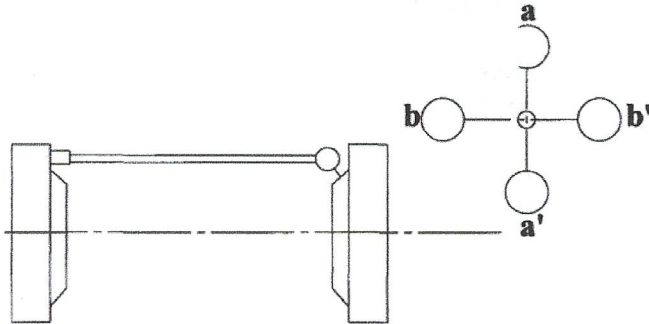
c.) Check spindle alignment

Manufacturer's readings

|   | Max allowance | Readings |
|---|---------------|----------|
| a |               |          |
| b |               |          |

Machine Maxx readings

|   | Max allowance | Readings |
|---|---------------|----------|
| a |               | 0.0002   |
| b |               | 0.0001   |



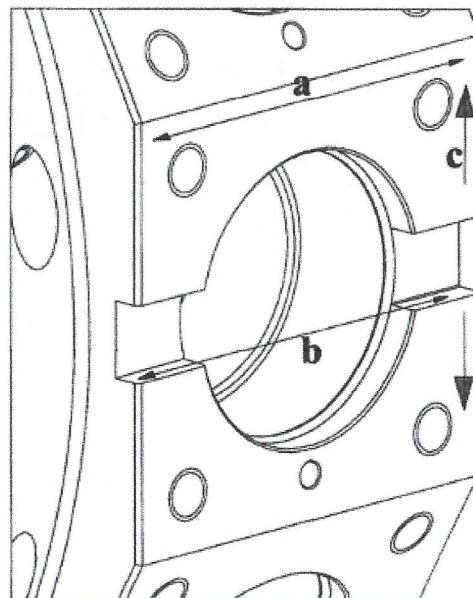
d.) Check turret alignment.

Manufacturer's readings

|   | Max allowance | Readings |
|---|---------------|----------|
| a |               |          |
| b |               |          |
| c |               |          |

Machine Maxx readings

|   | Max allowance | Readings |
|---|---------------|----------|
| a |               | 0.0001   |
| b |               | 0.0002   |
| c |               | 0.0002   |



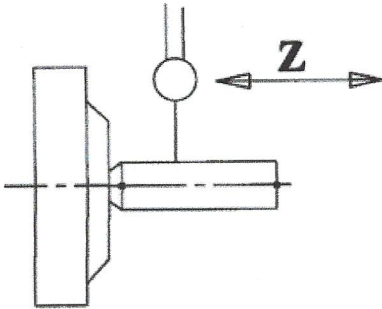
e.) Check spindle taper.

Manufacture's readings

|      | Maxx allowance | Readings |
|------|----------------|----------|
| main |                |          |
| sub  |                |          |

Machine Maxx readings

|      | Maxx allowance | Readings |
|------|----------------|----------|
| main |                | 0.0002   |
| sub  |                | 0.0004   |



f.) Check Z axis ways.

|             | Maxx allowance | Readings |
|-------------|----------------|----------|
| Head 1 to B |                | 0.0003   |
| Head 2 to B |                | N/A      |

Steve (X)

3. S ram backup.

*Lake Shore*

Signature

2/5/2021

Date