

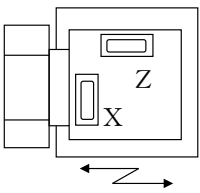
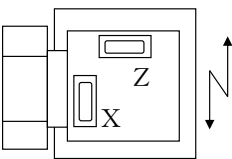
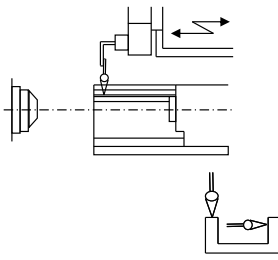
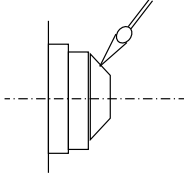
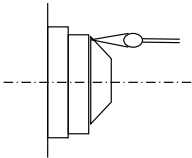
檢 查 成 績 表

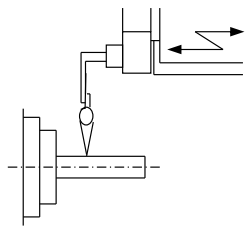
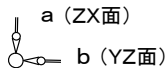
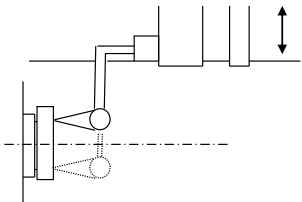
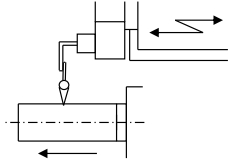
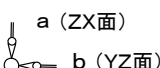
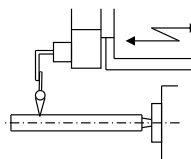
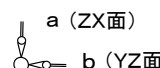
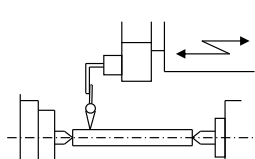
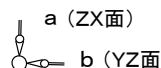
INSPECTION REPORT

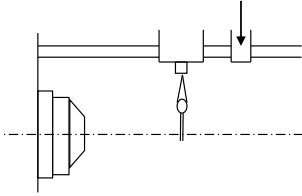
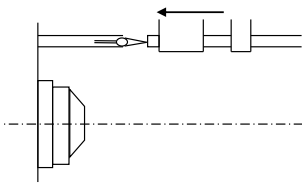
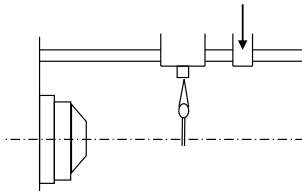
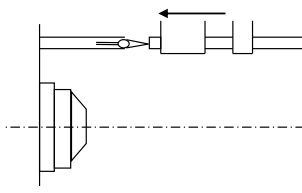
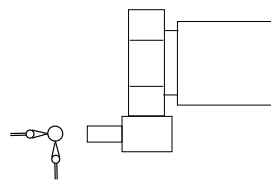
機械名 MACHINE TYPE	CNC精密旋盤 CNC Precision Lathe
形式 MACHINE MODEL	<i>GSL-15PLUS</i>
機械番号 MACHINE NUMBER	1590411
検査年月日 INSPECTION DATE	3/23/2023

数値制御旋盤検査成績表 INSPECTION REPORT

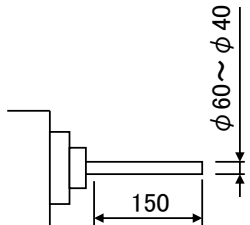
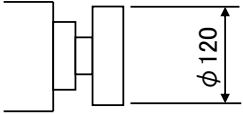
静的精度検査 STATISTICAL INSPECTION RESULT

番号 No.	検査事項 INSPECTION ITEM		測定方法図 ILLUSTRATION OF MEASURING METHOD	単位 UNIT mm	
				許容値 TOLERANCE	測定値 MEASUREMENT
1	往復台のZ軸運動 の角度偏差 Checking the angular deviations of the Z-axis motion	YZ面内 (Z軸方向) in the YZ plane		0.04/m	0.010
		XY面内 (X軸方向) in the XY plane		0.04/m	0.020
2	タレットスライド のX軸運動の角度 偏差 Checking the angular deviations of the X-axis motion	YZ面内 (Z軸方向) in the YZ plane		0.04/m	0.010
		XY面内 (X軸方向) in the XY plane		0.04/m	0.030
3	ベッド滑り面の平行度 Parallelism of bed slide way		0.01	0.004	
4	主軸外面の振れ Run-out of centring diameter		0.008	0.001	
5	主軸端面の振れ Cammng of the spindle face		0.01	0.001	

番号 No.	検査事項 INSPECTION ITEM	測定方法図 ILLUSTRATION OF MEASURING METHOD	単位 UNIT mm		
			許容値 TOLERANCE	測定値 MEASUREMENT	
6	往復台のZ軸運動 と工作主軸の回転 中心線との平行度 Checking the parallelism between the Z-axis motion (carriage) and the workhead spindle axis of rotation	a YZ面内 in the YZ plane		0.012/200	0.008
	b ZX面内 in the ZX plane			0.010/200	0.004
7	工作主軸とX軸の運動との直角度 Checking the squareness between the workhead spindle and the X- axis motion		0.005/100	0.004	
8	心押台の運動と往 復台のZ軸運動と の平行度 Checking the parallelism between the tailstock sleeve motion and Z-axis motion of the carriage	b ZX面内 in the ZX plane		0.005/50	0.004
	a YZ面内 in the YZ plane			0.006/50	0.002
9	心押軸穴と往復台の Z軸運動との平行度 Checking the parallelism between the tailstock-sleeve internal-taper bore and the Z-axis motion of the carriage	b ZX面内 in the ZX plane		0.012/200	0.008
	a YZ面内 in the YZ plane			0.012/200	0.002
10	主軸台と心押台と の両心の高さの差 Difference of center height between spindle and tail stock spindle	b ZX面内 in the ZX plane		0.01	0.004
	a YZ面内 in the YZ plane			0.020	0.012

位置決め精度検査 INSPECTION RESULT OF POSITIONING ACCURACY					
番号 No.	検査事項 INSPECTION ITEM		測定方法図 ILLUSTRATION OF MEASURING METHOD	単位 UNIT mm	
				許容値 TOLERANCE	測定値 MEASUREMENT
1	位置決め精度 Positioning accuracy		 <p>X軸方向 X axial direction</p>	0.007/50	0.002
				 <p>Z軸方向 Z axial direction</p>	0.008/100
繰返し精度検査 INSPECTION OF REPEATABILITY					
番号 No.	検査事項 INSPECTION ITEM		測定方法図 ILLUSTRATION OF MEASURING METHOD	単位 UNIT mm	
				許容値 TOLERANCE	測定値 MEASUREMENT
1	繰返し精度 Repeatability		 <p>X軸方向 X axial direction</p>	±0.003	±0.001
				 <p>Z軸方向 Z axial direction</p>	±0.003
2	刃物台の割出の繰返し精度 Repeatability of turret indexing			±0.005	± 0.001

工作精度検査 INSPECTION OF MACHINING ACCURACY

番号 No.	測定方法図 ILLUSTRATION OF MEASURING METHOD	切削条件 CUTTING CONDITION	単位 UNIT mm	
			許容値 TOLERANCE	測定値 MEASUREMENT
1		材質 BsBM Parts material 工具 K10 Tools (Cutters) 切削速度 400m/min Cutting speed 切り込み 0.02mm Cutting depth 送り 0.08mm/rev Feedrate	真円度 0.003 Circularity 円筒度 0.010 Cylindricity	<div style="border-bottom: 1px solid black; padding-bottom: 5px;">0.001</div> <div style="border-bottom: 1px solid black; padding-bottom: 5px;">0.004</div> 仕上り状態 Surface condition <i>good</i>
2		材質 BsBM Parts material 工具 K10 Tools (Cutters) 切削速度 400m/min Cutting speed 切り込み 0.02mm Cutting depth 送り 0.05mm/rev Feedrate	平面度 0.005 Flatness	<div style="border-bottom: 1px solid black; padding-bottom: 5px;">0.002</div> 仕上り状態 Surface condition <i>good</i>

決裁者
Approved by:

 [WF]

金平 克史 (K. Kanahira)
 品質保証部長
 General Manager, Quality control department