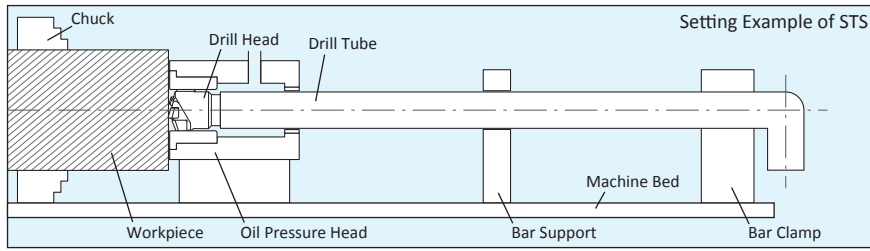


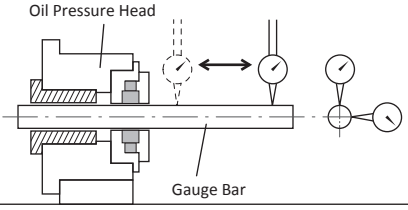
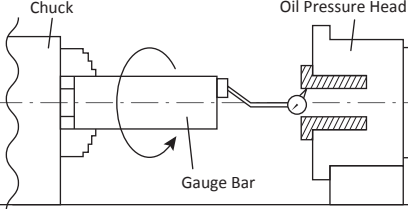
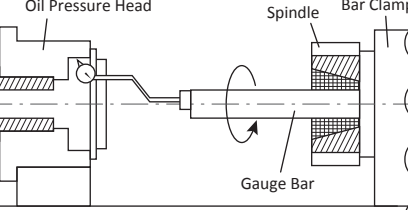
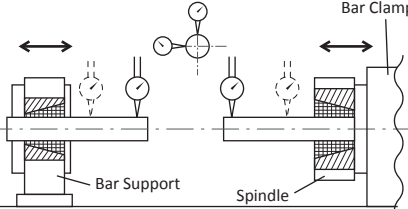
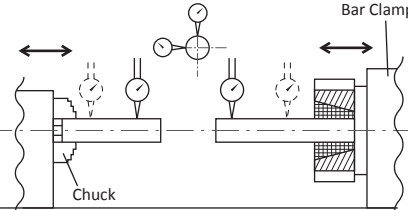


Machine Alignment Check Sheet [Workpiece-Rotating]



✓ For a precise deep hole drilling machine set up be sure to check and ensure the below points.

1	Machine bed should be parallel to side to side and front to back directions		Acceptable Limit (mm)	Measured Value (mm)	
			① Right & Left	0.015	Right & Left
			② Back & Front	0.03	Back & Front
2	Chuck runout should be within the acceptable limit		0.01		
3	Chuck and machine bed should be parallel		0.01		
4	Spindle taper runout should be within the acceptable limit		0.01		
5	Spindle end face runout should be within the acceptable limit		0.01		
6	Spindle and machine bed should be parallel		0.01		

	Check Point	Acceptable Limit (mm)	Measured Value (mm)
7	Oil pressure head and machine bed should be parallel 	0.02	
8	Chuck and oil pressure head should be in alignment 	0.02	
9	Spindle and oil pressure head should be in alignment 	0.02	
10	Spindle, bar support and machine bed should be parallel 	0.02	
11	Spindle, chuck and machine bed should be parallel 	0.02	