

Vertical Lathe Machine  
Model: KDM-16

# Certificate of Quality

Max. Swing Diameter: 1600mm

Table Diameter: 1400mm

Serial Number:

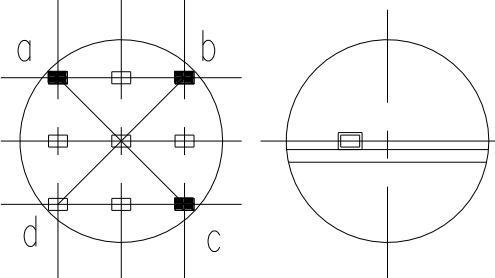
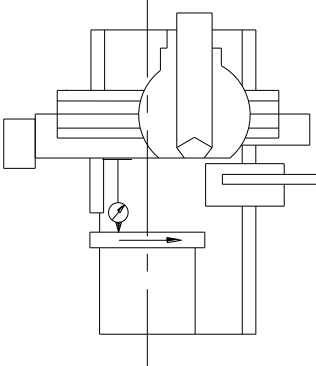
The document applies to KDM-12/16/20/23/26 series vertical turning lathe. The standard JB/B 4116-96 Geometric Accuracy Test Standard prevails in the test or is taken as reference if the machine is not so covered. The machine is fully tested and found qualified for delivery.

Manager:

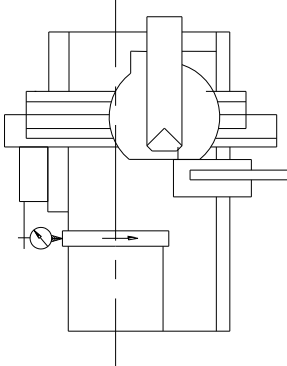
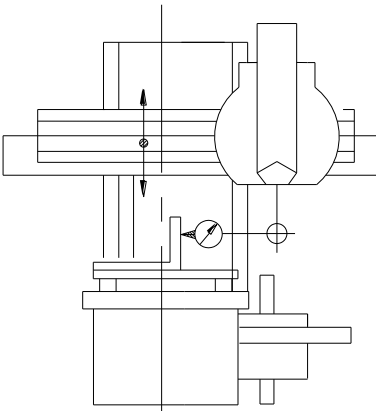
Inspector:

Enclosure: Test chart

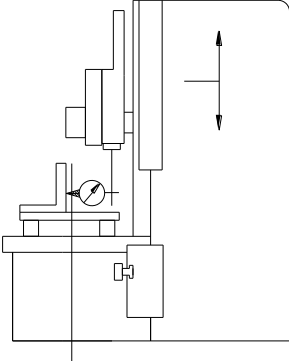
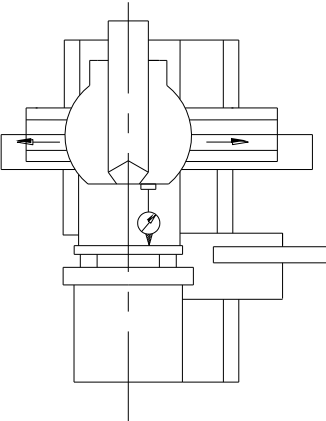
## Geometrical Tolerance

No.	Testing item	Diagram	Tolerance allowed (mm)	Actual value(mm)
G1	Flatness of working table		<p>0.03mm within 1000mm diameter, 0.01mm more per extra 1000mm (flat or concave only).</p> <p>Local tolerance allowed: 0.01 / 300</p>	
G2	Axial run-out of working table		<p>0.02mm within 1000mm diameter, 0.01mm more per extra 1000mm.</p>	

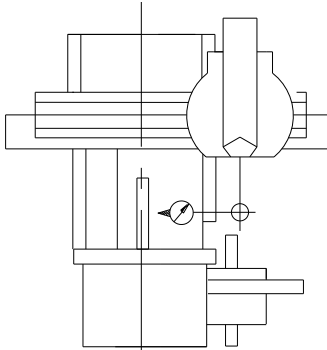
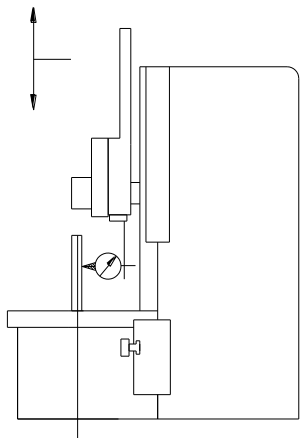
**Geometrical Tolerance**

No.	Testing item	Diagram	Tolerance allowed (mm)	Actual value(mm)
G3	Radial run-out of working table		0.02mm within 1000mm diameter, 0.01mm more per extra 1000mm.	
G4	Parallelism of vertical travel of cross rail and spindle axis  (A) in plane parallel to cross rail		0.04 / 1000	

## Geometrical Tolerance

No.	Testing item	Diagram	Tolerance allowed (mm)	Actual value(mm)
G4	Parallelism of vertical travel of cross rail and spindle axis (B) in plane vertical to cross rail		0.06 / 1000	
G5	Parallelism of horizontal travel of vertical tool head and working table		Travel $\leq$ 1000: 0.03 > 1000-2000: 0.06 > 2000-3000: 0.10	

**Geometrical Tolerance**

No.	Testing item	Diagram	Tolerance allowed (mm)	Actual value(mm)
G6	Parallelism of vertical travel of ram and spindle axis  (A) in plane parallel to cross rail		0.03 / 1000	
G6	Parallelism of vertical travel of ram and spindle axis  (B) in plane vertical to cross rail		0.05 / 1000	

