

ITEM 33686 COMPLEX MACHINE

Certification of Inspection

EX-WORK NO.

1908020

PEOPLE'S REPUBLIC OF CHINA

ITEM 33686 Complex Machine	Reading of inspection accuracy	Total 4 pages
		page 1

As a result of product is up to standard
after inspecting, permit the Complex Machine
be released from factory

Factory director:

Chief of inspection section:

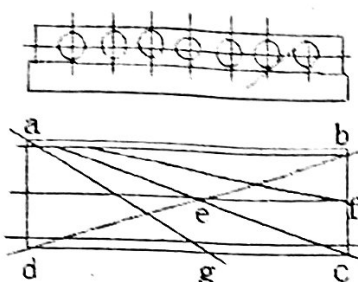
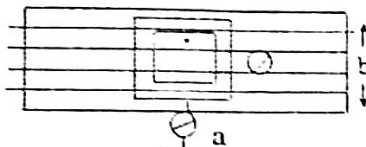
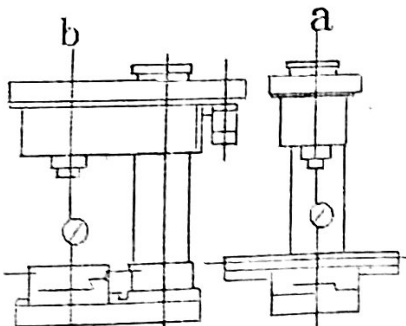
Date:

ITEM 33686
Complex Machine

Reading of inspection accuracy

Total 4 pages

page 2

NO.	Diagram of measuring method	Inspection item	Accuracy(mm)	
			Tolerance	Data
G1		Flatness of table	0.04	0.025
G2	 Adjust pin indicator to zero point along longitudinal axis	Verticality for cross slide table	a) Longitudinal 200 : 0.00	0
		a. longitudinal b. Cross	b) Cross 200 : 0.04	0.025
G3		Parallelism for cross slide table	a) 0.05	0.02
		a. Longitudinal b. Cross	b) 0.05	0.02

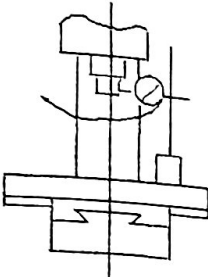
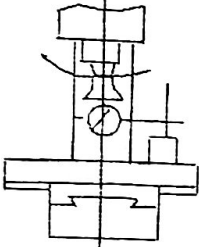
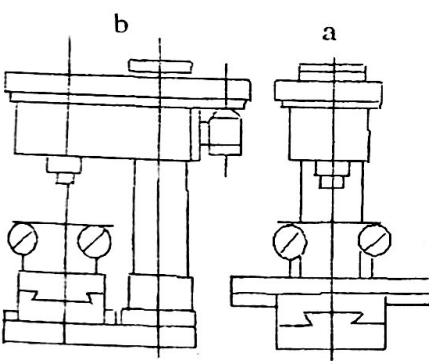
ITEM 33686

Complex Machine

Reading of inspection accuracy

Total 4 pages

page 3

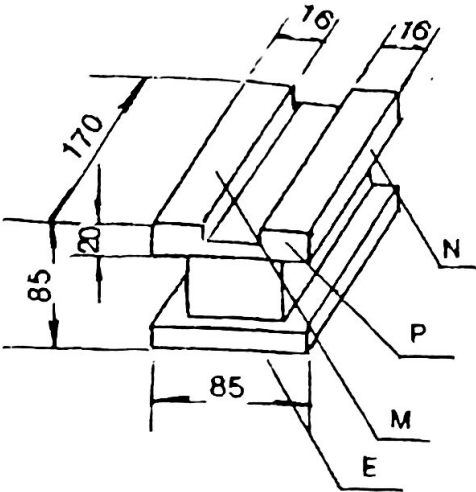
NO.	Diagram of measuring method	Inspection item	Accuracy(mm)	
			Tolerance	Data
G4		Radial swing of spindle taper hole axis	0.03	0.01
G5		Spindle axial shift	0.015	0.005
G6		Verticality of spindle turning axis of table D=200 a. Longitudinal b. cross	a) 0.08 b) 0.08	0.02 0.03

ITEM 33686
Complex Machine

Reading of inspection accuracy

Total 4 pages

page 4

NO.	Diagram of measuring method	Inspection item	Accuracy(mm)	
			Tolerance	Data
	 The diagram shows a 3D perspective of a mechanical part. It is a rectangular block with a total length of 170 and a total width of 85. The top surface is divided into three longitudinal sections. The two outer sections are 16 units wide each. The middle section is recessed. The front face is labeled with 'N' (top), 'P' (middle), 'M' (bottom), and 'E' (bottom edge). A dimension of 20 is shown for the height of the middle section. A dimension of 85 is shown for the width of the base.	Milling accuracy: a.Flatness of side 'M' b.Parallelism of side 'M' to side 'E' c.Verticallity of side 'N' to side 'M',side 'P' to side 'M',side 'N' to side 'P'	a.0.03 b.0.05 c.0.08/50	