

FCAA 7614



Registered Trade Mark.

standard metric accuracy chart

COLCHESTER BANTAM

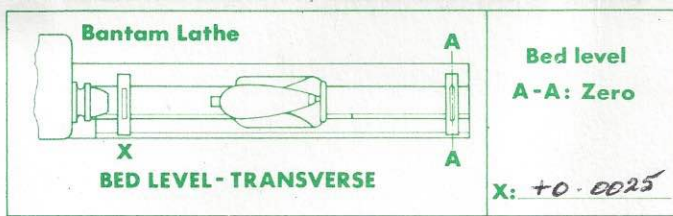
The limits shown are equivalent to, or closer than, the Schlesinger Finish Turning Lathe, the Salmon Sliding and Screw Cutting Lathe and the D.I.N. 8606 Standards of Accuracy.

THE COLCHESTER LATHE COMPANY LIMITED
COLCHESTER **ESSEX** **ENGLAND**

Telephone: Colchester 5161

Telex 98255

Telegrams: Lathes, Telex, Colchester



	ACTUAL ERROR	TEST	PERMISSIBLE ERROR <hr/> ACTUAL ERROR
<p>SPINDLE CENTER RUNOUT</p>	<p>Total Indicator Reading 0 to 0.01 mm</p> <hr/> <p>0.0020</p>	<p>TAILSTOCK SPINDLE ALIGNMENT - HORIZONTAL</p>	<p>Forward at end of Spindle when fully extended 0 to 0.01 mm</p> <hr/> <p>0.0025</p>
<p>SPINDLE NOSE RUNOUT</p>	<p>Total Indicator Reading 0 to 0.01 mm</p> <hr/> <p>0.0020</p>	<p>TAILSTOCK SPINDLE ALIGNMENT - VERTICAL</p>	<p>High at end of Spindle when fully extended 0 to 0.01 mm</p> <hr/> <p>0.0050</p>
<p>CAM ACTION OF SPINDLE</p>	<p>Total Indicator Reading 0 to .01 mm with Indicator on face of spindle</p> <hr/> <p>0.0025</p>	<p>TAILSTOCK TAPER ALIGNMENT - HORIZONTAL</p>	<p>End of 300 mm Test Bar 0 to + 0.01 mm</p> <hr/> <p>0.0075</p>
<p>SPINDLE TAPER RUNOUT</p>	<p>Total Indicator Reading at end of 300 mm Test Bar 0 to 0.02 mm at end of Spindle Nose 0 to 0.01 mm</p> <hr/> <p>0.0075 0.0050</p>	<p>TAILSTOCK TAPER ALIGNMENT - VERTICAL</p>	<p>High at end of 300 mm Test Bar 0 to 0.02 mm</p> <hr/> <p>0.0075</p>
<p>HEADSTOCK ALIGNMENT - VERTICAL</p>	<p>High at end of 300 mm Test Bar rising towards Tailstock End 0 to 0.02 mm</p> <hr/> <p>0.0075</p>	<p>VERTICAL ALIGNMENT OF HEAD AND TAIL CENTRES</p>	<p>High at Tailstock 0 to 0.02 mm</p> <hr/> <p>0.0150</p>
<p>CROSS SLIDE ALIGNMENT</p>	<p>At end of 300 mm Test Bar 0 to + 0.01 mm</p> <hr/> <p>0.0075</p>	<p>LEAD SCREW LEAD PER 300 mm</p>	<p>To face hollow or concave only on 300 mm diameter 0 to 0.02 mm</p> <hr/> <p>0.0125</p>
<p>HEADSTOCK ALIGNMENT - HORIZONTAL</p>	<p>At end of 300 mm Test Bar 0 to + 0.01 mm</p> <hr/> <p>0.0075</p>		<p>± 0.03 mm</p> <hr/> <p>0.030</p>

Inspected by