

SBL South Bend Lathe**10 K ACCURACY TEST REPORT**

CL 370RD

MODEL

NO 40969K

SERIAL NUMBER

4-1/2 U. D.

SIZE & BED LENGTH

SEP. 9, 1983.

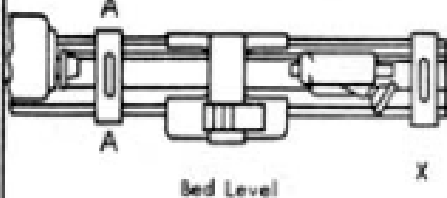
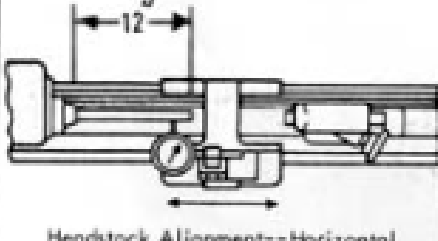
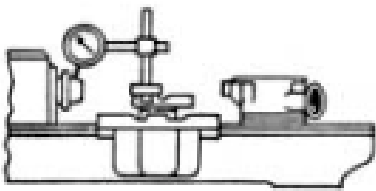

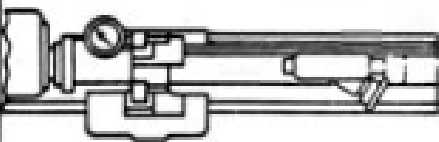

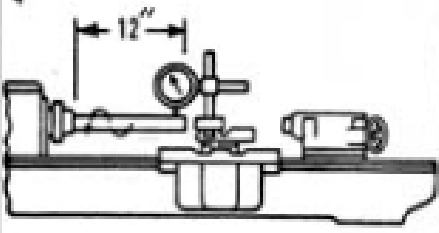
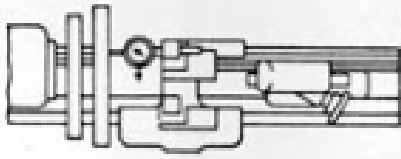
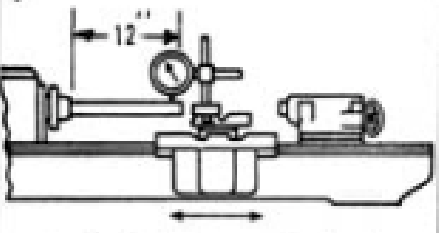
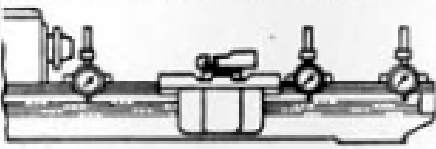
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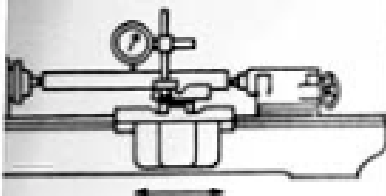
SOUTH BEND LATHE

AN EMPLOYEE-OWNED COMPANY

SOUTH BEND LATHE ACCURACY CHART

AMERICAN NATIONAL STANDARD ANSI B5-16-1952

TEST	MAXIMUM ALLOWABLE ERROR ACTUAL	TEST	MAXIMUM ALLOWABLE ERROR ACTUAL
<p>1</p>  <p>Bed Level</p>	<p>A-A=0 X=.0005</p> <hr/> <p>.0001</p>	<p>6</p>  <p>Headstock Alignment--Horizontal</p>	<p>.001</p> <hr/> <p>.0006</p>
<p>2</p>  <p>Spindle Nose Runout</p>	<p>.0004</p> <hr/> <p>.0002</p>	<p>7</p>  <p>Tailstock Spindle Alignment--Horizontal</p>	<p>.0005</p> <hr/> <p>.0003</p>
<p>3</p>  <p>Cam Action of Spindle</p>	<p>.0005</p> <hr/> <p>.0002</p>	<p>8</p>  <p>Tailstock Spindle Alignment--Vertical Spindle Fully Extended</p>	<p>.0008</p> <hr/> <p>.0006</p>
<p>4</p>  <p>Spindle Taper Runout</p>	<p>.0008</p> <hr/> <p>.0006</p>	<p>9</p>  <p>Cross Slide Alignment Concave Only</p>	<p>.001</p> <hr/> <p>.001</p>
<p>5</p>  <p>Headstock Alignment--Vertical</p>	<p>.001</p> <hr/> <p>.0006</p>	<p>10</p> <p>Readings for base length bed taken with lead screw stationary. Add 0.001 inch for each additional 4 feet of bed length.</p>  <p>Lead Screw Alignment</p>	<p>PARALLEL WITH WAY Horizontal - .004 Vertical - .004</p> <hr/> <p>H - .004 V - .004</p>

TEST	MAXIMUM ALLOWABLE ERROR ACTUAL	TEST	MAXIMUM ALLOWABLE ERROR ACTUAL	
 Vertical Alignment of Head and Tail Centers	.0015 			

This lathe was tested and inspected to the accuracy recorded in this report by:

INSPECTOR No.1

We at South Bend Lathe are sure you will have many years of satisfactory service from this machine.

We are constantly working to make South Bend Lathe machine tools the BEST on the market.

We welcome your comments and suggestions regarding this machine or our other products.

PLEASE RETURN ATTACHED CARD



TO
SBL Quality Assurance Dept.

Model No. _____

Serial No. _____

Comments: _____

Name _____

Customer _____

Address _____
