

CNC Single Column Vertical Lathe  
Model: CK-5120

## Certificate of Quality

Max. Swing Diameter: 2000mm

Table Diameter: 1800mm

Serial Number: 20130716

Year: 2013

# ACCUT

Accut Machinery Co., Ltd.  
The People's Republic of China

The document applies to C-51 / CK-51 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:

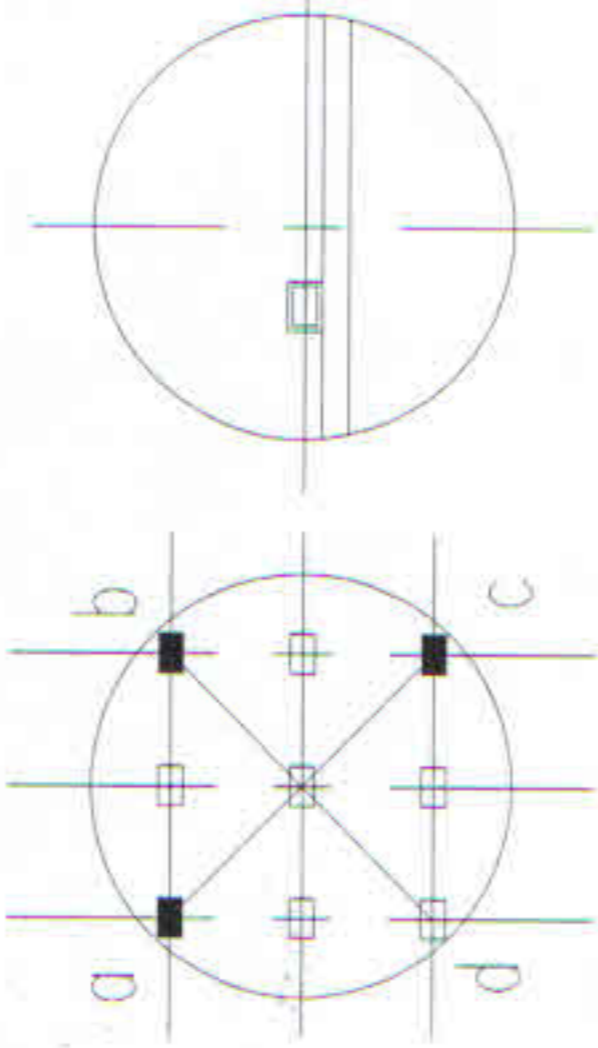
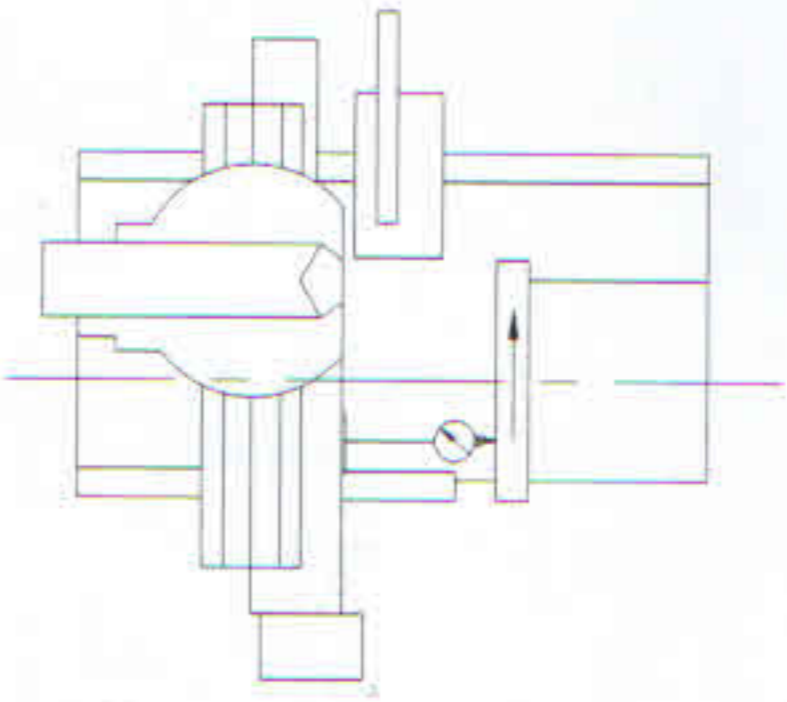


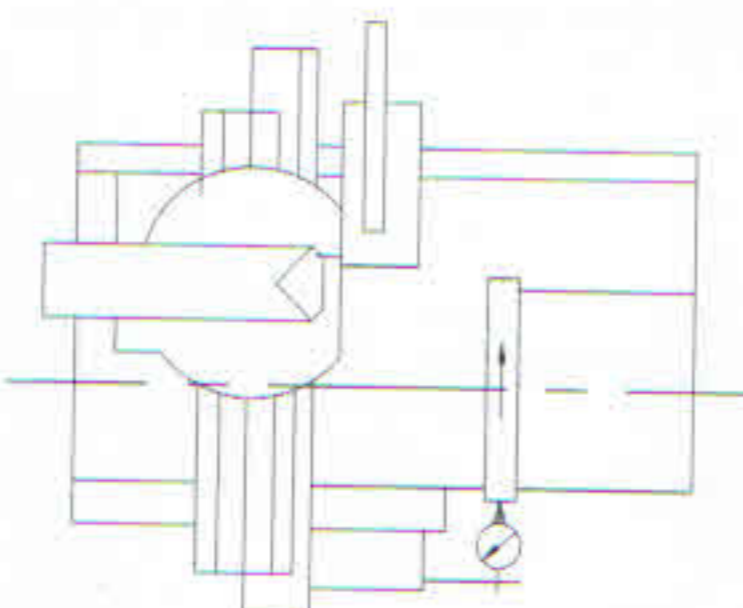
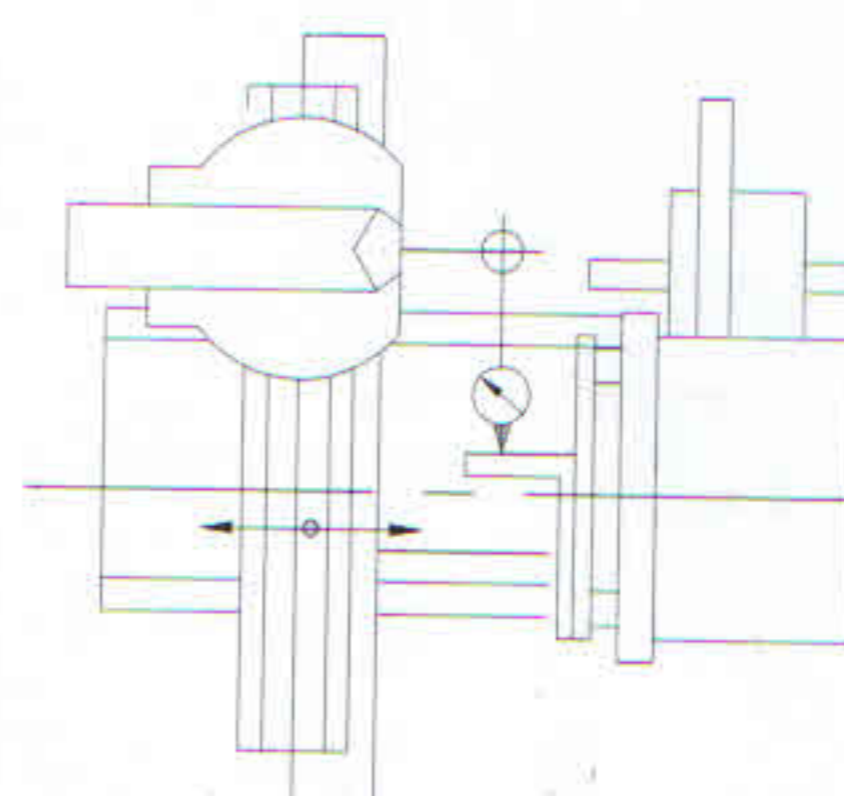
Inspector:

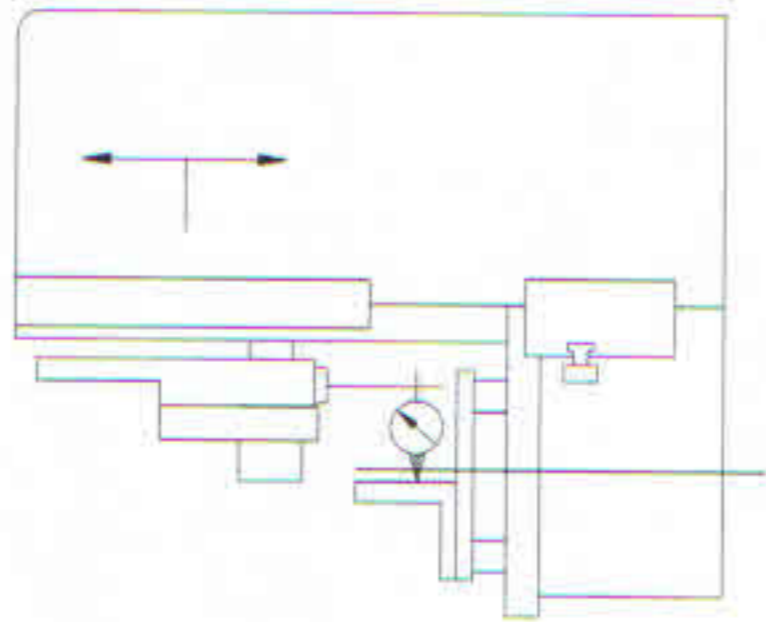
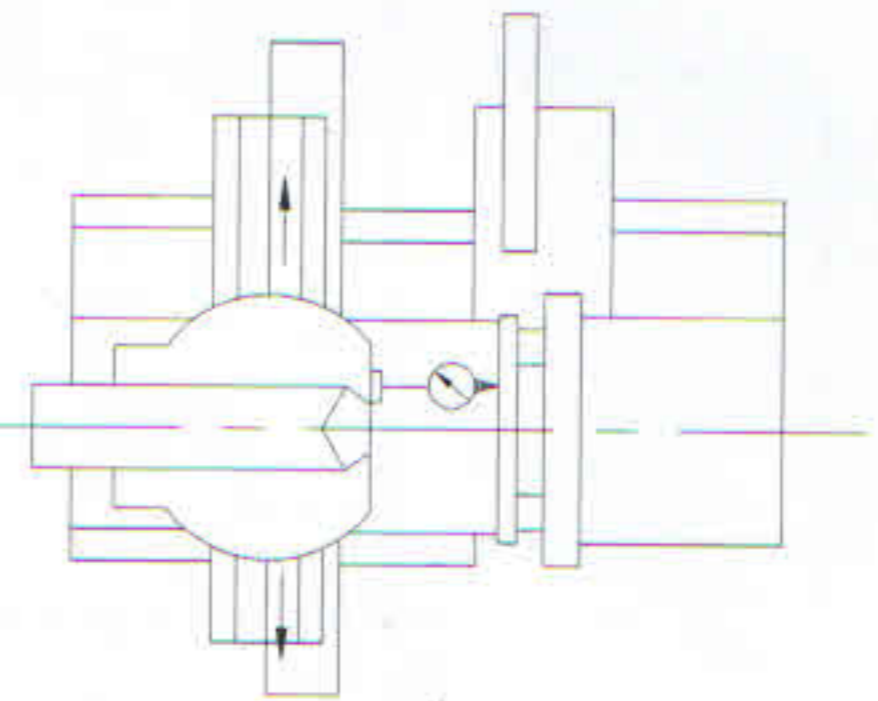
**Inspector:**

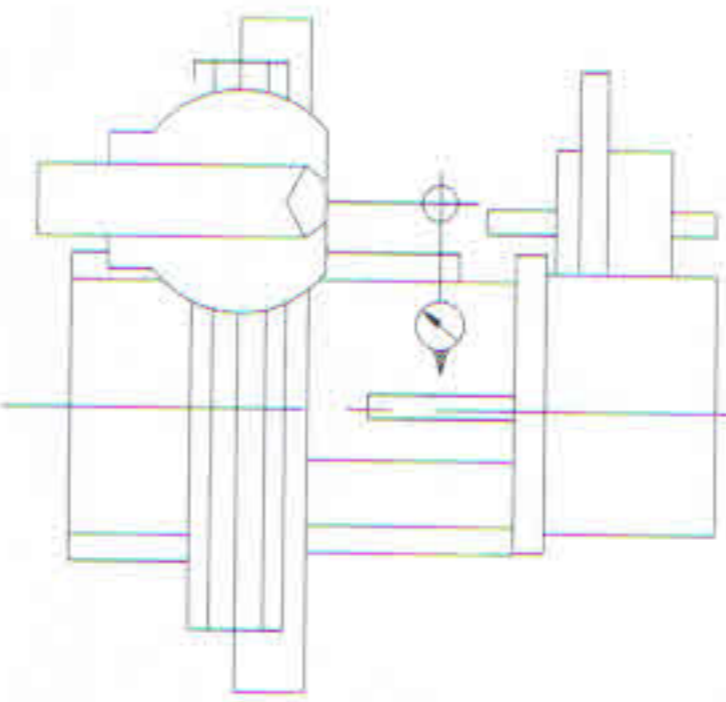
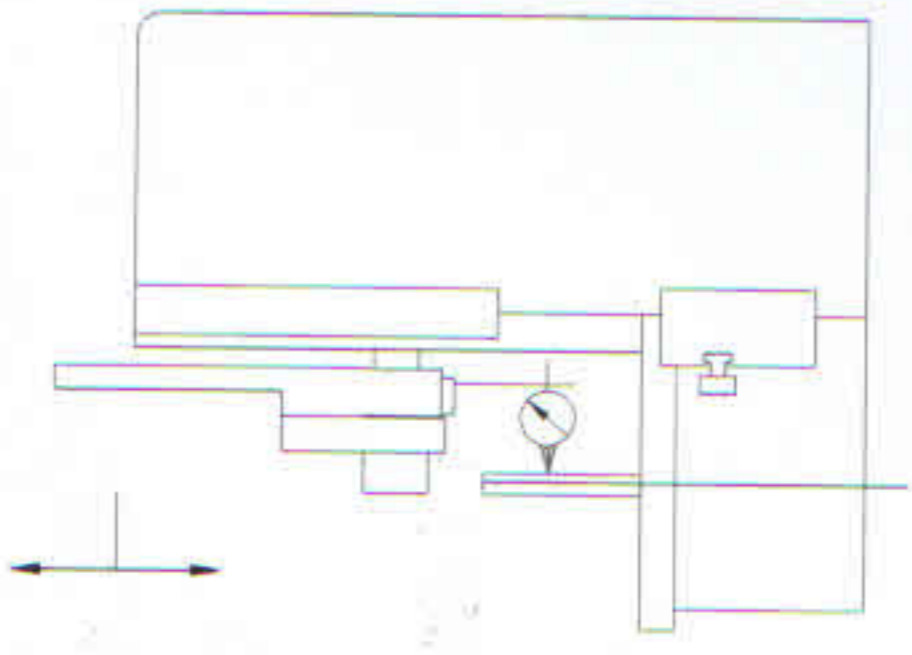
2013年7月5日

Enclosure: Test chart

Geometrical Tolerance				
No.	Testing item	Diagram	Tolerance allowed (mm)	Actual value(mm)
G1	Flatness of working table		0.03mm within 1000mm diameter, 0.01mm more per extra 1000mm (flat or concave only).  Local tolerance allowed: 0.01 / 300	<del>0.02</del> / 1800 PASS
G2	Axial run-out of working table		0.02mm within 1000mm diameter, 0.01mm more per extra 1000mm.	0.02 / 1800 PASS

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.	0.015/1800
G4	Parallelism of vertical travel of cross rail and spindle axis (A) in plane parallel to cross rail		0.04 / 1000	0.03/1000

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	0.05/1000 ASSI
G5	Parallelism of horizontal travel of vertical tool head and working table		Travel ≤ 1000: 0.03 > 1000-2000: 0.06 > 2000-3000: 0.10	0.07/1000

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	<del>0.02</del> / 1000
G6	Parallelism of vertical travel of ram and spindle axis (B) in plane vertical to cross rail		0.05 / 1000	PASS / 0.04 / 1000