

X4 Finished Inspection Table

Inspection batch:

Product No.:

voltage:

delivery country:

Spindle Model:

一、 Appearance inspection

Serial number	Test item	Test results	remark
J1	Without the appearance of paint off, paint color uniform, no oil, cutting and other debris		
J2	There should be no appearance of the surface of machine tools did not provide for the raised pattern, depression, and other rough mouth injury.		
J3	Shield machine should be flat and should not warp, sag.		
J4	Machine tool parts, Combined with the edge of the exposed surface should be combined with neat, symmetrical, there should be no obvious dislocation.		
J5	Exposed welds should be repaired straight, evenly.		
J6	Machine parts exposed surface there should be no bump, corrosion. Screws, rivets, end pin no sprains, wounds, such as hammer defects.		
J7	Plated pieces、Blue pieces、Black pieces of color should be consistent, protective layer should not fade, fall off the phenomenon.		
J8	Electrical, lubrication and cooling pipes, etc. should be arranged over the exposed parts of the compact, neatly arranged.		
J9	Sign on the machine should be clear and durable. Signs should be clearly fixed in position and location should be correct, the formation of a solid, non-skew.		

二、 Electrical equipment safety Detection

Serial number	Test item	Qualified value	Measured values	remark
1J	Insulation Resistance: electrical machines of different polarity between conductors or between conductor and casing value of insulation resistance.	$\geq 20M\Omega$		
2J	Withstanding Voltage: The machine should be subject to the exchange of electrical voltage 2000V, the voltage withstand test lasted 1min. Leakage current measurement	Don't puncture $\leq 0.5mA$		
3J	Leakage current: 1.06 times the rated input voltage, current in the test after the imposition of 5s, the measurement of leakage current.	$\leq 3mA$		
4J	Grounding resistance: the leak detection devices and equipment can be conductive part of the total resistance between the earthing terminal.	$\leq 0.1\Omega$		
5J	Power: No-load operation of machine tools, spindle speed 5000 rev / min when the output power	260W~410W		
6J	Noise test (in semi-anechoic environment, with the noise source 1 m area of the hemisphere, taking a five-point measurement, taking the arithmetic mean.)	$\leq 85dB$		

三、 Machine tool accuracy Detection

Serial number	Test item	Tolerance (mm)	Measured (mm)	remark
J1	Flatness table	0.05		
J2	The vertical of the longitudinal movement of the table lateral movement	0.04/100		
J3	Table moving parallel to the face of severe a: Horizontal b: Vertical	a: 0.03/100 b:0.05/100		
J4	The central or base table T-slots on the table parallel degree of longitudinal movement	0.06/200		
J5	The vertical column and table error	0.04/100		
J6	The work spindle axis of the vertical surface a: In the horizontal plane b: In the vertical plane	a: 0.03/100 $\alpha \leq 90^\circ$ b: 0.02/100		
J7	Spindle rotation without noise, flexible, non-Shen points.			
J8	Repeat positioning accuracy of machine tools	XAxis \leq 0.03 YAxis \leq 0.03 ZAxis \leq 0.15		

四、 Check the box outside the axis

Serial number	Test item	Test results	remark
J1	Outside the box on the check mark whether or not to comply with the national		
J2	Outside the box to check whether the strong and reliable		

examiner:

date: