VMC INSPECTION REPORT

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INSPECTOR	Tim Sarr
DATE	9/15/26
SERIAL #	1205374

VF-1 ☐ VF-2 ☐ VF-3 ☐ VF-4 ☒ VF-5 ☐ VF-6 ☐ VF-7 ☐ VF-8 ☐ VF-9 ☐ VM-2 ☐ VM-3 ☐ VM-6 ☐ B ☐ D ☐ SUPER SPEED ☐ YT ☐

Y-Axis Pitch

F .0007

M .0001

B .0000

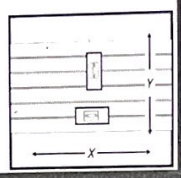


1. FLATNESS OF TABLE TRAVEL MOVEMENTS

Read Level at Front, Middle, Back for both X & Y Axis Directions.

Federal Level: Record the values.
Bubble Level: Draw in the bubble position.

(NTE 0.0005 / 10") for Federal Level
(NTE 0.0015 / 10") for Digi-Pas Level
(NTE 12.7µm / 250mm)

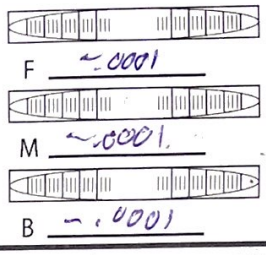


Y-Axis Roll

F ~.0001

M ~.0001

B ~.0001



2. FLATNESS OF TABLE

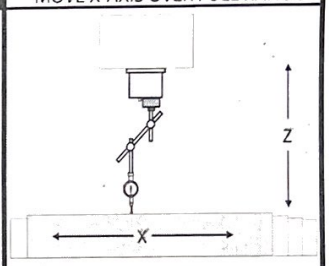
MOUNT INDICATOR TO SPINDLE HEAD AND MOVE X & Y-AXIS OVER FULL RANGE.

.0002	~.0004	.0001	.0003	~.0002	~.0001			
~.0005	~.0002	~.0002	~.0003	~.0004	~.0002			
C	C	C	O	O	~.0002			

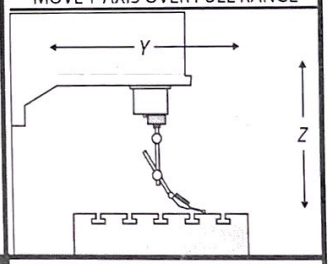
*Probe damaged when arrived @ PI.

FULL TRAVEL: _____
(NTE 0.001 MAX)(NTE 25.4µm) VF-1/2
(NTE 0.0015 MAX)(NTE 38.1µm) VF-3/4/5/6
(NTE 0.002 MAX)(NTE 50.8µm) VF-7/8/9
(NTE 0.002 MAX)(NTE 50.8µm) VF-2YT PP

MOVE X-AXIS OVER FULL RANGE



MOVE Y-AXIS OVER FULL RANGE

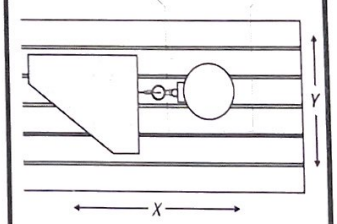


3. INSPECT SQUARENESS OF X-AXIS TO Y-AXIS

ALIGN PRECISION SQUARE WITH X-AXIS INDICATE ALONG Y-AXIS.

MEASURED VALUE: +.0002
(NTE 0.0005 / 10")
(NTE 12.7µm / 250mm)

X-AXIS INDICATE ALONG Y-AXIS



4. T-SLOT STRAIGHTNESS

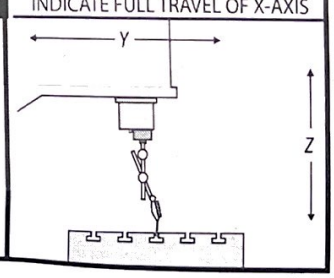
PLACE INDICATOR IN CENTER T-SLOT OF MILL TABLE. INDICATE OVER FULL TRAVEL OF X-AXIS.
ON PALLET POOLS: PLACE INDICATOR ON FRONT EDGE OF PALLET POOL PALLET.

FULL TRAVEL
READING 0.001 MAX. (VF1-5) .0002
(NTE 25.4µm)

FULL TRAVEL
READING 0.0015 MAX. (VF 6-9) _____
(NTE 38.1 µm)

FULL TRAVEL
READING 0.002 MAX. (VF-2YT PP) _____
(NTE 50.8µm)

INDICATE FULL TRAVEL OF X-AXIS



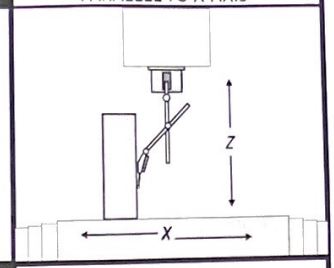
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5.A SQUARENESS OF Z-AXIS MOTION TO X-AXIS

PLACE A CYLINDER SQUARE CENTERED ON TABLE. ADJUST CYLINDER TOP TO WITHIN 0.0000 FOR X-Y MOTION (NO MEASURABLE CHANGE IN X/Y MOTION).
INDICATE THE SIDE OF THE CYLINDER SQUARE IN X DIRECTION. MOVE Z.
VERIFY THE CYLINDER SQUARE IS IN LINE WITH THE SPINDLE CENTERLINE.

MEASURED VALUE: .0001 Z-AXIS TILT RELATIVE TO X-AXIS
(NTE 0.0005 / 10")
(NTE 12.7µm / 250mm)

PARALLEL TO X-AXIS

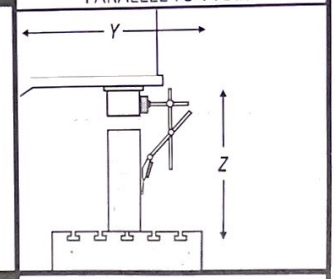


5.B SQUARENESS OF Z-AXIS MOTION TO Y-AXIS

INDICATE THE SIDE OF THE CYLINDER SQUARE IN Y DIRECTION. MOVE Z.
VERIFY THE CYLINDER SQUARE IS IN LINE WITH THE SPINDLE CENTERLINE.

MEASURED VALUE: .001 Z-AXIS TILT RELATIVE TO Y-AXIS
(NTE 0.0005 / 10")
(NTE 12.7µm / 250mm)

PARALLEL TO Y-AXIS



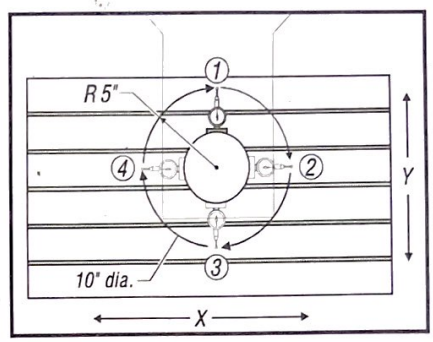
6. SPINDLE SWEEP

SPINDLE SWEEP X/Z PLANE

(1) POSITION INDICATOR WITHIN 5" RADIUS.

(2) SET ZERO AT A QUADRANT.

(3) MEASURE EACH 3 REMAINING POSITIONS.



(X) MEASURED DIFFERENCE: .0008
(NTE 0.0005 / 10" dia.)
(NTE 12.7µm / 250mm)

(Y) MEASURED DIFFERENCE: .001
(NTE 0.0005 / 10" dia.)
(NTE 12.7µm / 250mm Ø)

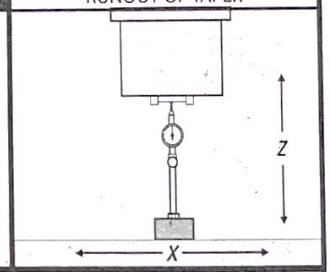
7.A SPINDLE RUNOUT AT TAPER

MEASURED VALUE: .0001

(RUNOUT OF TAPER 0.0002" [5.08µm]TIR)

* Spindle has .0004-.0005" Lostmotion

RUNOUT OF TAPER

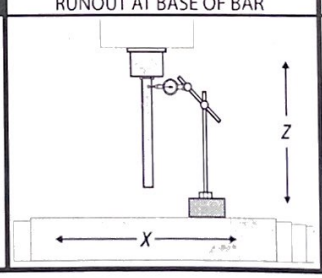


7.B SPINDLE RUNOUT ON TEST TOOL BAR

(1) MEASURED VALUE: .0001
(RUNOUT AT BASE OF BAR 0.0005 [12.7µm] TIR)

(2) MEASURED VALUE: .0001
(RUNOUT AT 6" FROM BASE 0.001 [25.4µm] TIR)

RUNOUT AT BASE OF BAR



RUNOUT AT 6 INCHES FROM BASE

