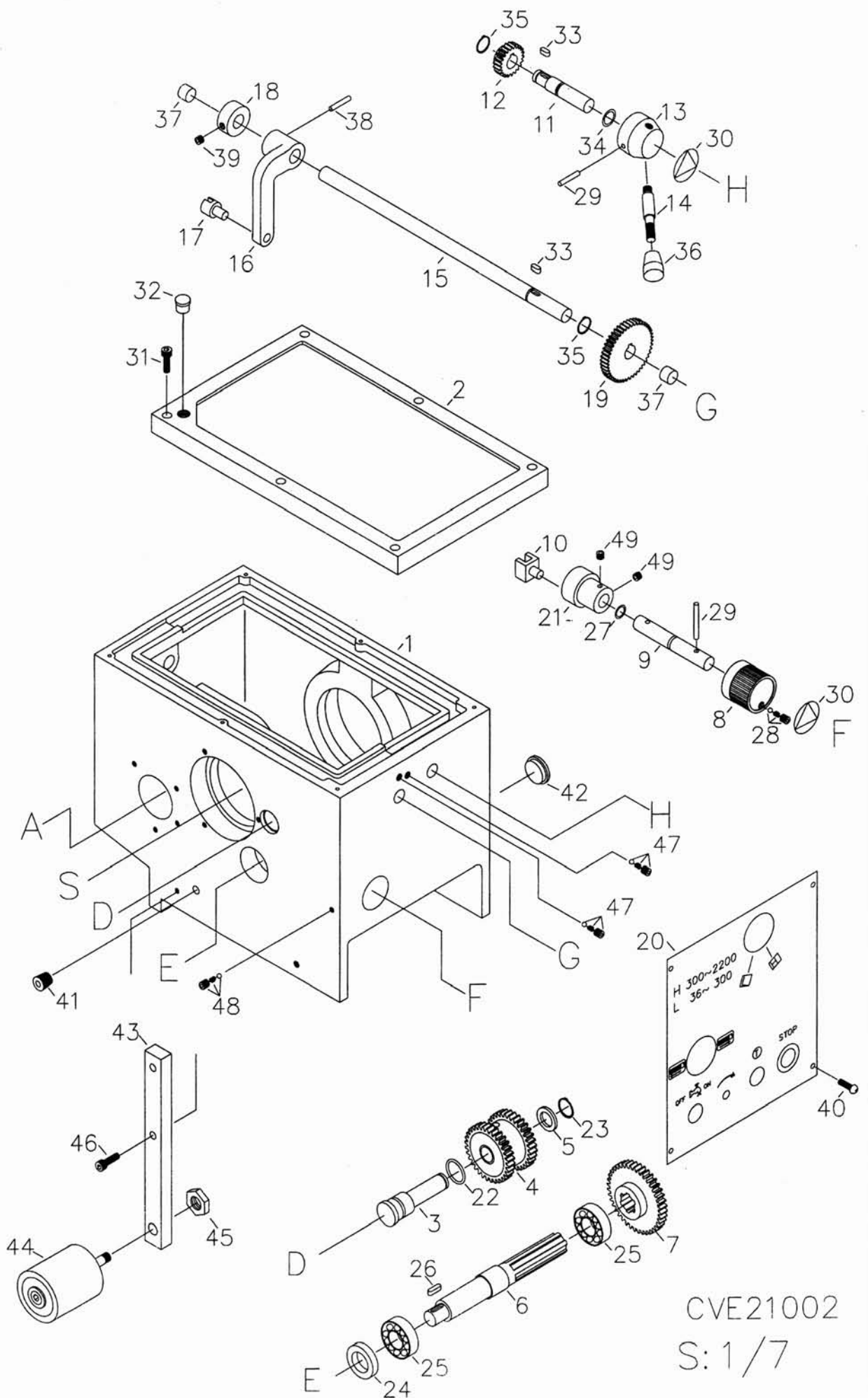


Mechanical Parts List

When ordering parts, please specify the following:

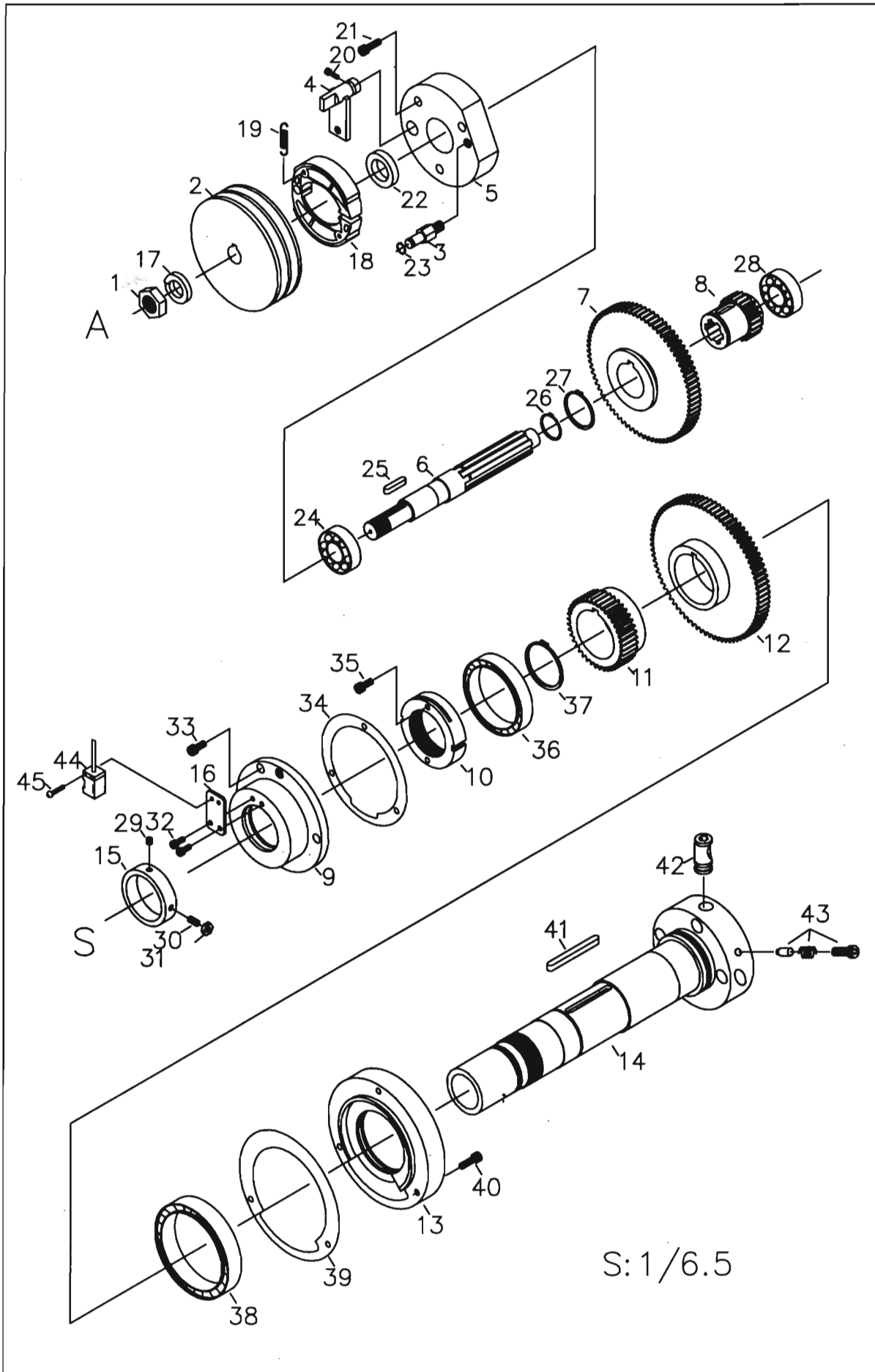
- 1. Model & year of production**
- 2. Serial number**
- 3. Part number, page number & description**
- 4. Quantity**



CVE21002
 S: 1/7

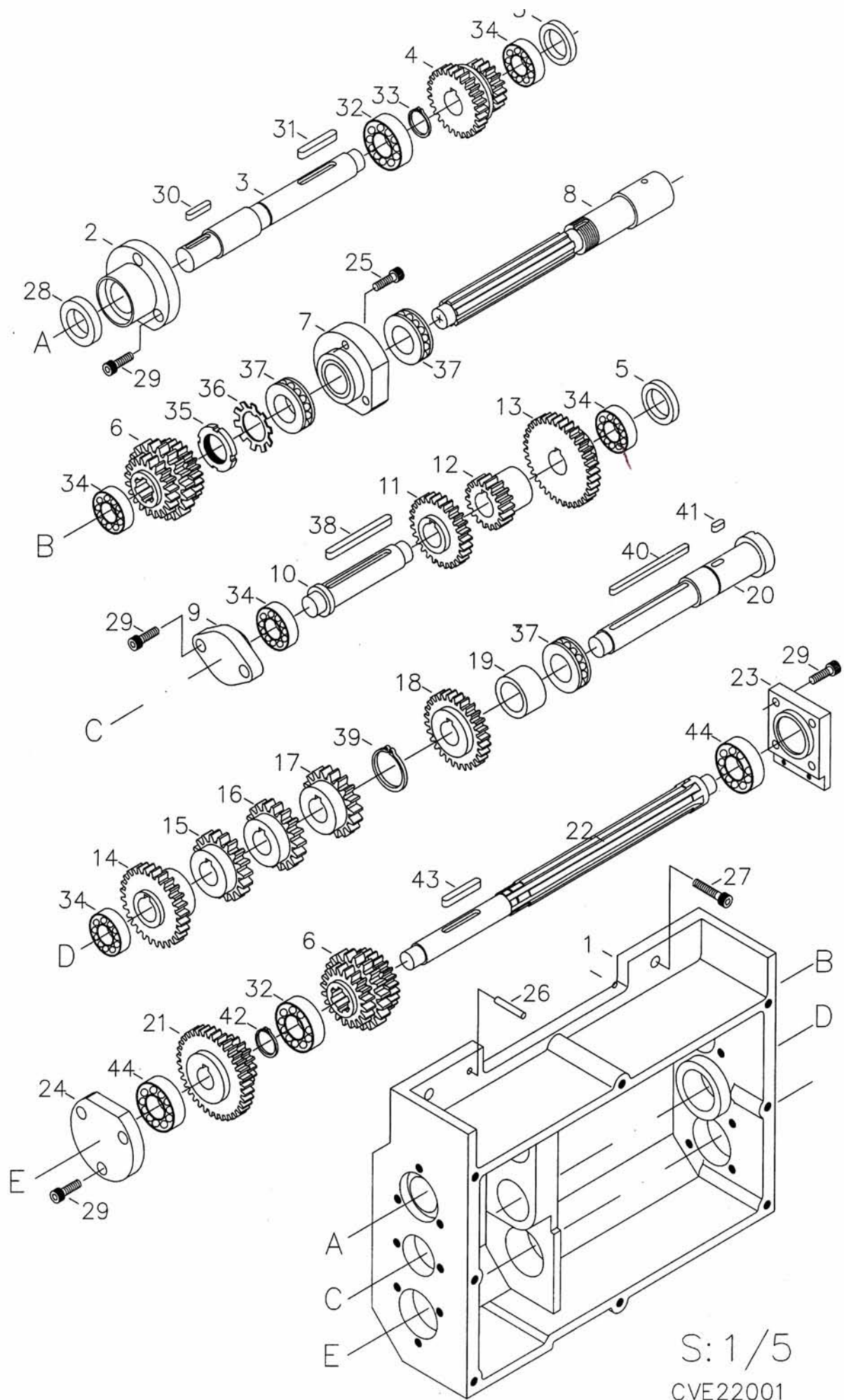
HEADSTOCK (CASTNG & CONTROLS)

REF.NO.	PART NO.	DESCRIPTION		Q'TY
1	VE2101	HEADSTOCK CASTING		1
2	VE2134	HEADSTOCK COVER		1
3	VE2116	SHAFT		1
4	VE2117	GEAR		1
5	VE2118	WASHER		1
6	VE2119	SHAFT		1
7	VE2120	GEAR		1
8	VE2122	HANDLE		1
9	VE2121	SHAFT		1
10	VE2124	GEAR SHIFT FORK		1
11	VE2125	SHAFT		1
12	VE2127	GEAR		1
13	VE2126	HANDLE		1
14	VE2128	CONTROL LEVER		1
15	VE2129	SHAFT		1
16	VE2130	FORK ARMS		1
17	VE2131	GEAR SHIFT FORK		1
18	VE2132	COLLAR		1
19	VE2133	GEAR		1
20	VE2145	DATA PLATE		1
21	VE2123	FORK ARMS		1
22	VE2175	OIL RING		1
23	VE2176	SNAP RING	S18	1
24	VE2177	COLLAR OIL SEAL		1
25	VE2178	BEARING	6005	2
26	VE2179	KEY	5X18L	1
27	VE2180	OIL RING		1
28	VE2181	STEEL BALL SPRING & SET SCREW		4
29	VE2182	SPRING PIN		2
30	VE2183	INDICATOR PLATE		2
31	VE2184	CAP SCREW	M6X25L	6
32	VE2185	PLUG		1
33	VE2186	KEY	5X12L	2
34	VE2187	OIL RING		1
35	VE2188	SNAP RING	S15	1
36	VE2189	PVC KNOB		1
37	VE2190	OIL RING		2
38	VE2191	SPRING PIN		1
39	VE2192	SET SCREW	M8X10L	1
40	VE2193	SCREW		4
41	VE2194	PLUG		1
42	VE2195	OIL SIGHT		1
43	VE2196	ROD		1
44	VE2197	BELT REGULATING SLEEVE		1
45	VE2198	NUT		1
46	VE2199	CAP SCREW	M8X30L	2
47	VE2135	STEEL BALL SPRING & SET SCREW		1
48	VE2136	STEEL BALL SPRING & SET SCREW		1
49	VE2137	SET SCREW	M8X10L	2



HEADSTOCK (SPINDLE & GEARS)

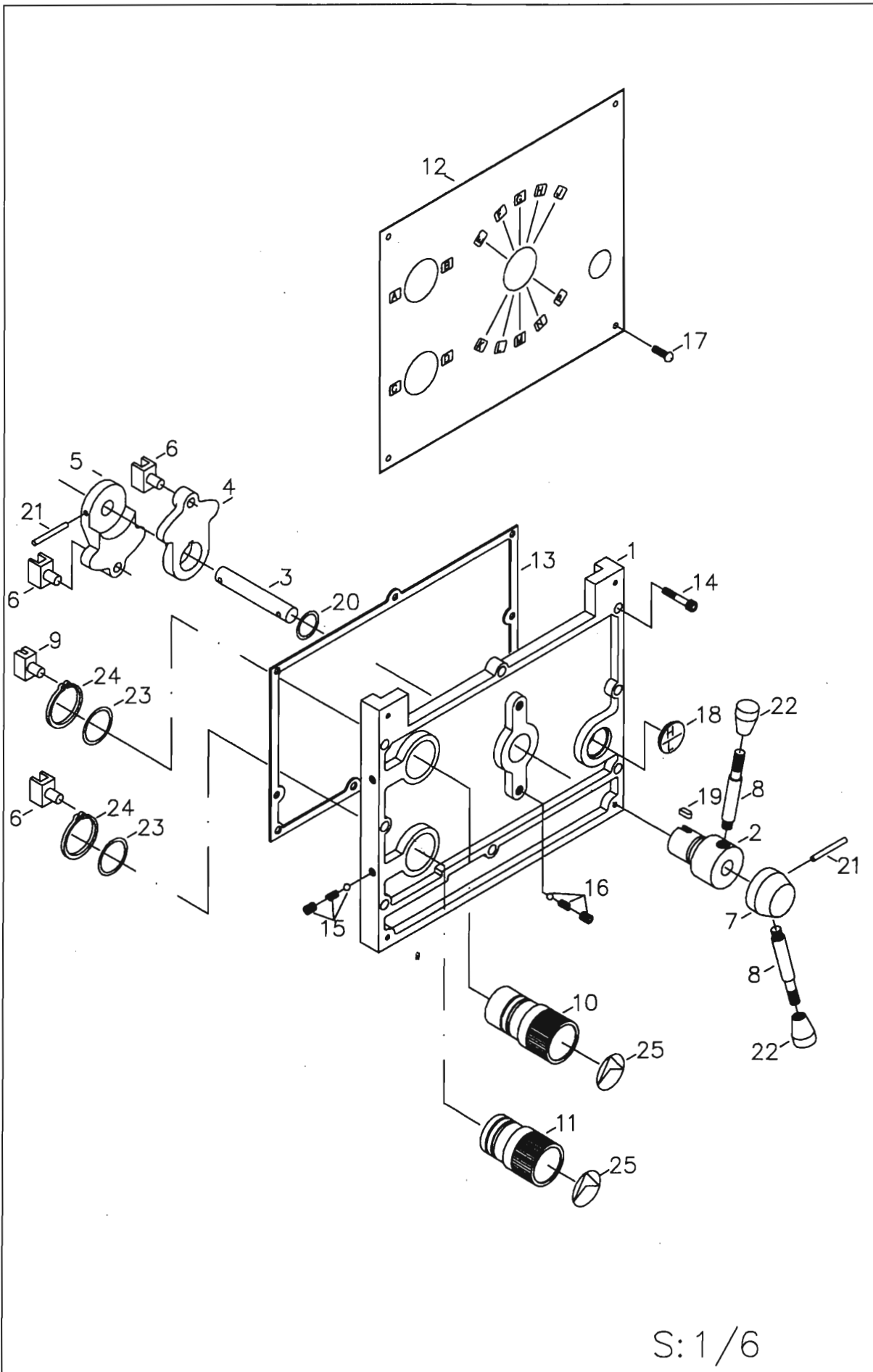
REF.NO.	PART NO.	DESCRIPTION	Q'TY
1	VE2109	NUT	1
2	VE2108	V-BELT PULLY	1
3	VE2106	SHAFT	1
4	VE2107	SHAFT AND LEVER	1
5	VE2105	BEARING CAP	1
6	VE2102	SHAFT	1
7	VE2104	GEAR	1
8	VE2103	GEAR	1
9	VE2115	COVER(BACK)	1
10	VE2114	LOCK NUT	1
11	VE2113	GEAR	1
12	VE2112	GEAR	1
13	VE2110	COVER (FRONT)	1
14	VE2111	MAIN SPINDLE	1
15	VE2138	COLLAR	1
16	VE2139	INDEXING BLOCK	1
17	VE2146	WASHER	1
18	VE2147	BRAKE SHOE ASSY	1
19	VE2148	SPRING	2
20	VE2149	CAP SCREW	M6X12L 1
21	VE2150	CAP SCREW	M6X35L 3
22	VE2151	COLLAR OL SEAL	1
23	VE2152	SNAP RING	1
24	VE2153	BEARING	1
25	VE2154	KEY	6X30L 1
26	VE2155	SNAP RING	1
27	VE2156	SNAP RING	1
28	VE2157	BEARING	1
29	VE2158	SETSCREW	1
30	VE2159	SETSCREW	1
31	VE2160	NUT	1
32	VE2161	CAP SCREW	2
33	VE2162	CAP SCREW	M6X20L 3
34	VE2163	GASKET	1
35	VE2164	CAP SCREW	M6X18L 2
36	VE2165	BEARING	1
37	VE2166	SNAP RING	S56 2
38	VE2167	BEARING	1
39	VE2168	GASKET	1
40	VE2169	CAP SCREW	M6X25L 3
41	VE2170	KEY	8X60L 1
42	VE2171	CAM	1
43	VE2172	DETENT PLUNGER, SPRING AND SCREW	3
44	VE2173	SENSOR SCAN FQP2-1604N-A3U2 10-30VDC NPN	1
45	VE2174	SCREW	2



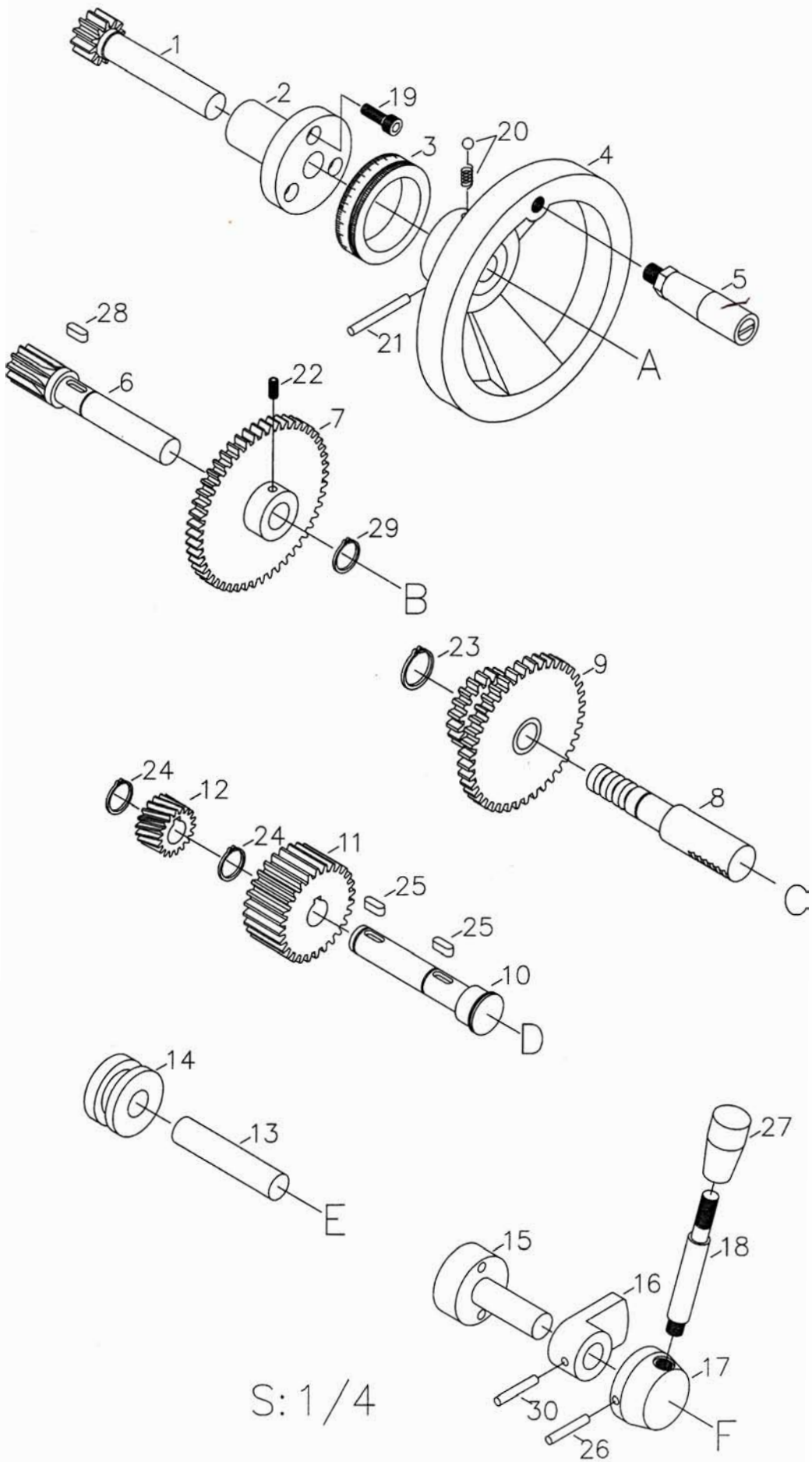
S: 1/5
CVE22001

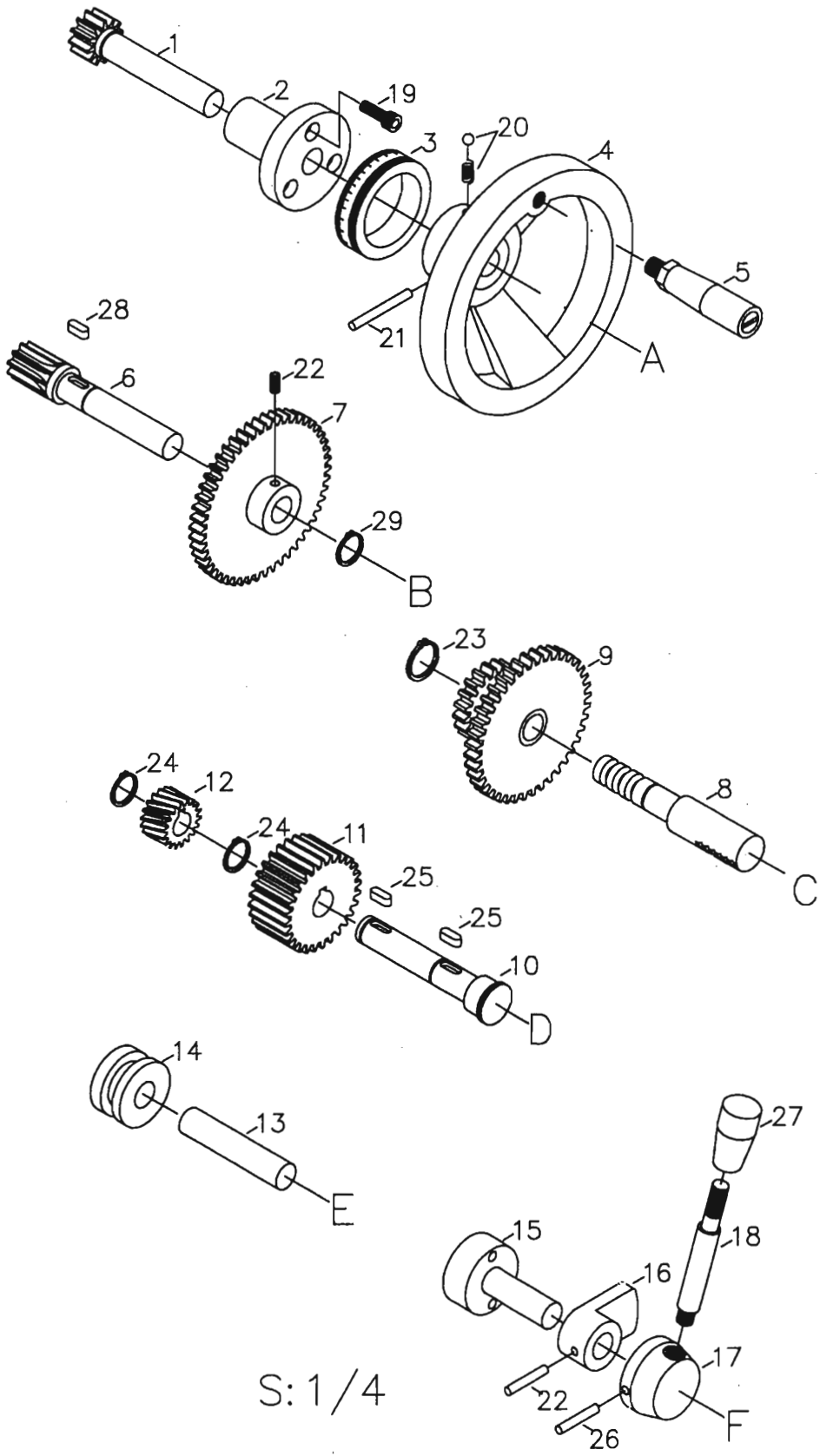
GEAR BOX (GEAR & SHAFT)

REF.NO.	PART NO.	DESCRIPTION		Q'TY
1	VE2201	GEAR BOX CASTING		1
2	VE2204	COVER		1
3	VE2203	SHAFT		1
4	VE2205	GEAR		1
5	VE2206	SPACER		1
6	VE2209	GEAR		2
7	VE2208	COVER		1
8	VE2207	SHAFT		1
9	VE2214	COVER		1
10	VE2210	SHAFT		1
11	VE2211	GEAR		1
12	VE2212	GEAR		1
13	VE2213	GEAR		1
14	VE2216	GEAR		1
15	VE2217	GEAR		1
16	VE2218	GEAR		1
17	VE2219	GEAR		1
18	VE2220	GEAR		1
19	VE2221	SPACER		1
20	VE2215	SHAFT		1
21	VE2223	GEAR		1
22	VE2222	SHAFT		1
23	VE2225	COVER		1
24	VE2224	COVER		1
25	VE2254	CAP SCREW	M6X25L	3
26	VE2255	PIN		2
27	VE2256	CAP SCREW	M8X30L	4
28	VE2257	OIL SEAL		1
29	VE2258	CAP SCREW	M6X20L	15
30	VE2259	KEY	5X18L	1
31	VE2260	KEY	6X40L	1
32	VE2261	BEARING	6004	2
33	VE2262	SNAP RING	S20	1
34	VE2263	BEARING	6003	4
35	VE2264	NUT		1
36	VE2265	WASHER		1
37	VE2266	THRUST		3
38	VE2267	KEY	6X65L	1
39	VE2236	SNAPRING		1
40	VE2237	KEY	5X85L	1
41	VE2238	KEY	5X12L	1
42	VE2239	SNAP RING	S20	1
43	VE2240	KEY		1
44	VE2268	BEARING	6302	2



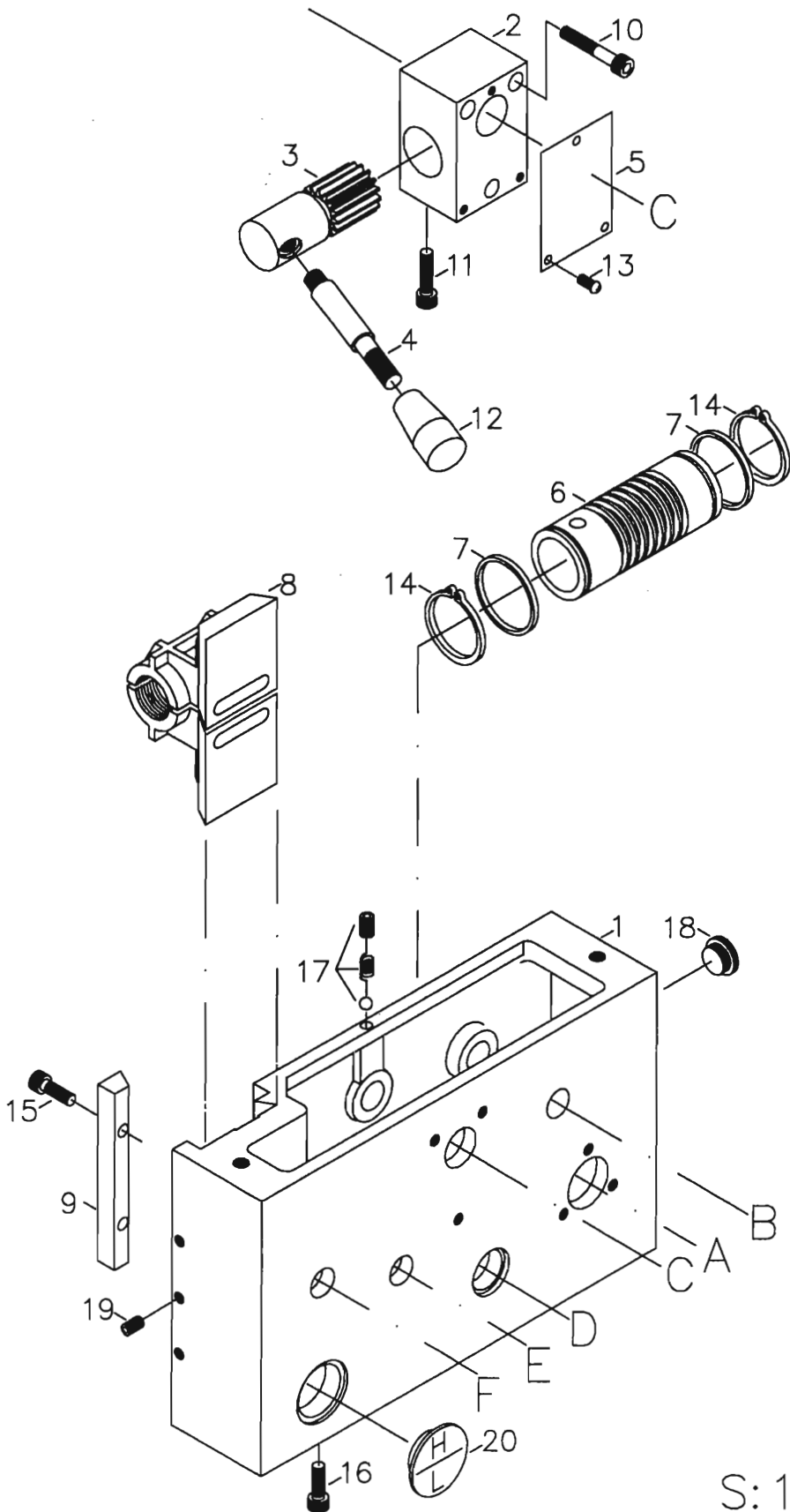
S: 1/6



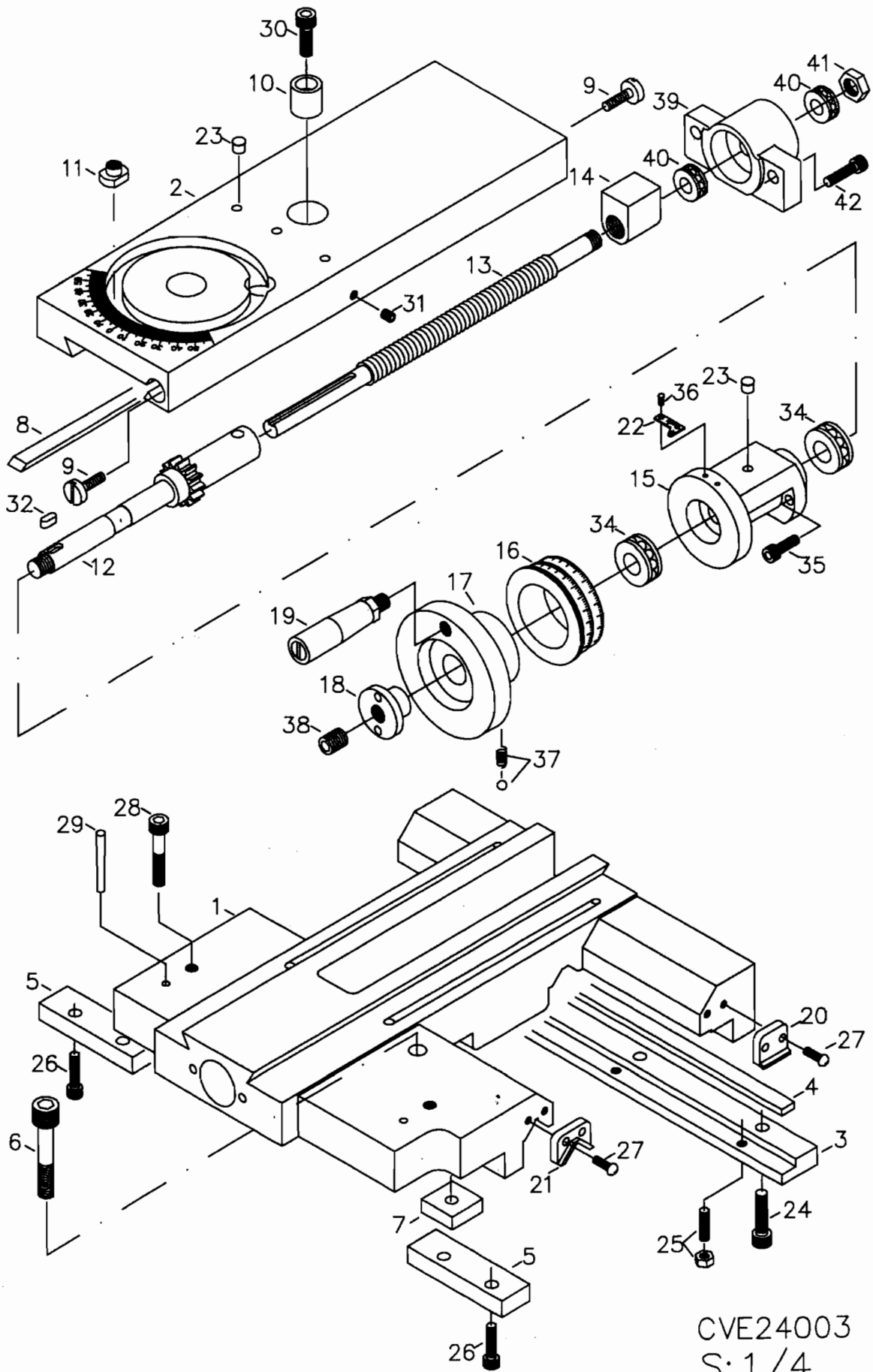


S: 1/4

RIGHT APRON (CASTING)



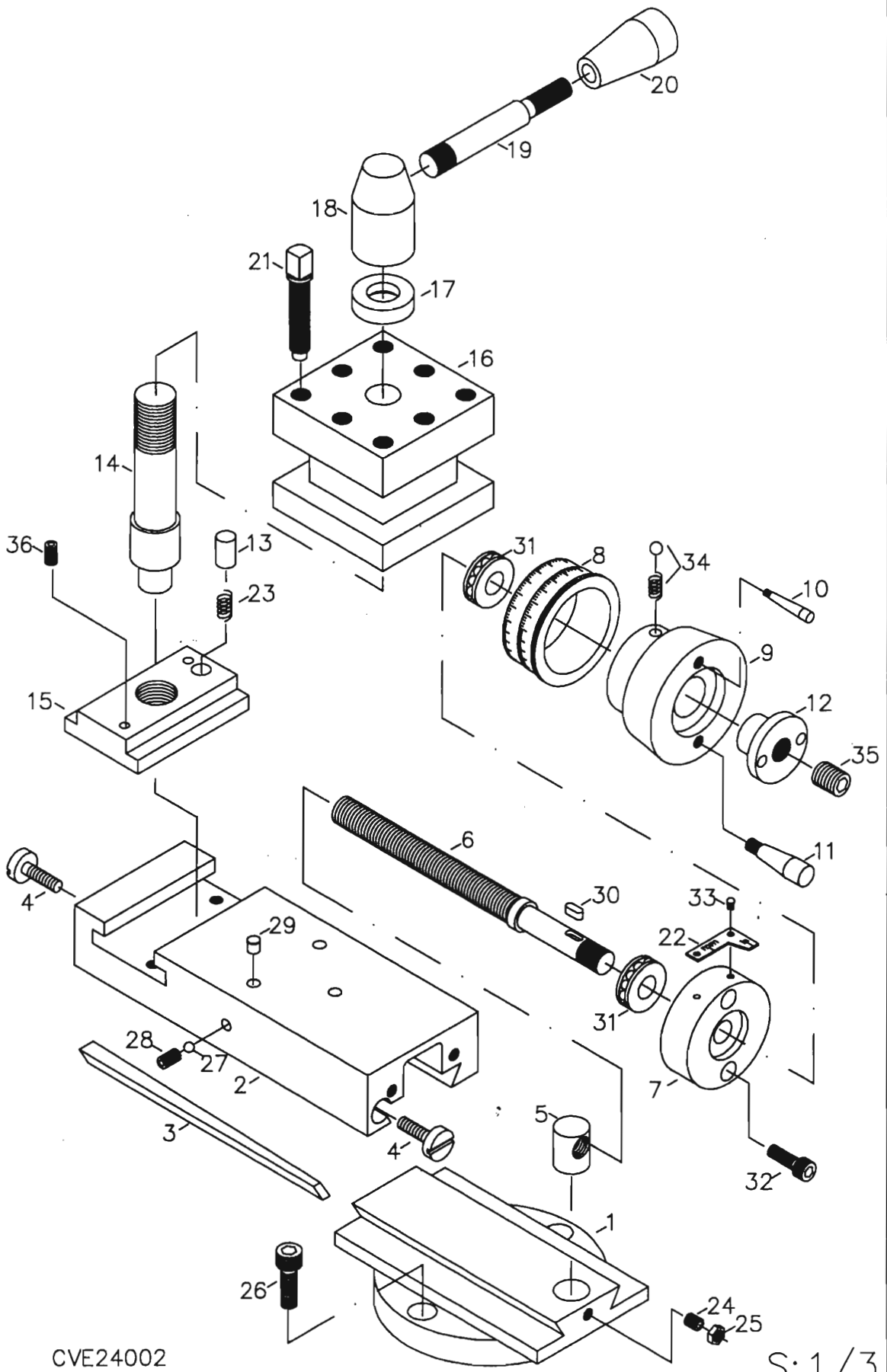
S: 1/4



CVE24003
 S: 1/4

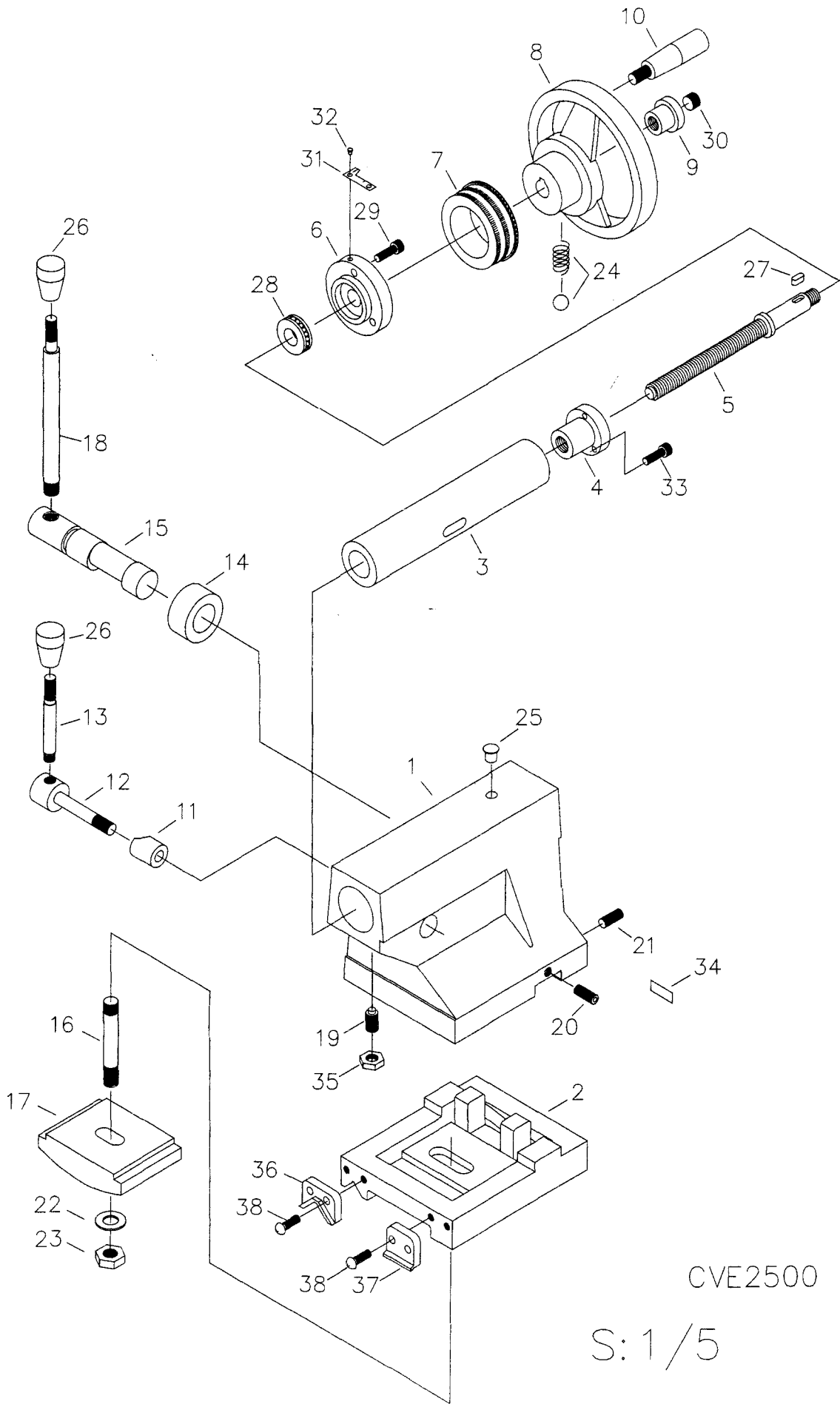
SADDLE & CROSS-SLIDE

REF. NO.	PART NO.	DESCRIPTION	Q'TY
1	VE2401	SADDLE CASTING	1
2	VE2402	CROSS-SLIDE	1
3	VE2403	CLAMP REAR	1
4	VE2404	GIB	1
5	VE2405	CLAMP FRONT	2
6	VE2406	CAP SCREW	7/16X2 1/2
7	VE2407	WASHER	1
8	VE2408	GIB	1
9	VE2409	GIB SCREW	1
10	VE2410	COLLAR	1
11	VE2419	NUT	2
12	VE2459	GEAR SHAFT	1
13	VE2458	SCREW	1
14	VE2413	NUT	1
15	VE2414	KEEP ASSY	1
16	VE2415	INDEX RING	1
17	VE2416	HAND WHEEL	1
18	VE2417	PLUG	1
19	VE2418	HANDLE	1
20	VE2439	WIPER	2
21	VE2440	WIPER	2
22	VE2465	DIAL	1
23	VE2450	OILER	1/4 IN
24	VE2467	CAP SCREW	M8X20L
25	VE2468	SCREW AND NUT	M6X16L
26	VE2469	CAP SCREW	M8X18L
27	VE2470	SCREW	8
28	VE2466	CAP SCREW	M8X40L
29	VE2467	PIN	#3X45L
30	VE2473	CAP SCREW	M8X25L
31	VE2461	CAP SCREW	MBX20L
32	VE2460	KEY	5X12L
33	VE2476	SCREW	1
34	VE2457	THRUST	2902
35	VE2458	CAP SCREW	M6X25L
36	VE2468	NAIL	2 MM
37	VE2456	STEEL BALL AND SPRING	1
38	VE2455	SCREW	M12X12L
39	VE2460	KEEP ASSY	1
40	VE2482	THRUST	51101
41	VE2483	NUT	1
42	VE2484	CAP SCREW	M6X35L



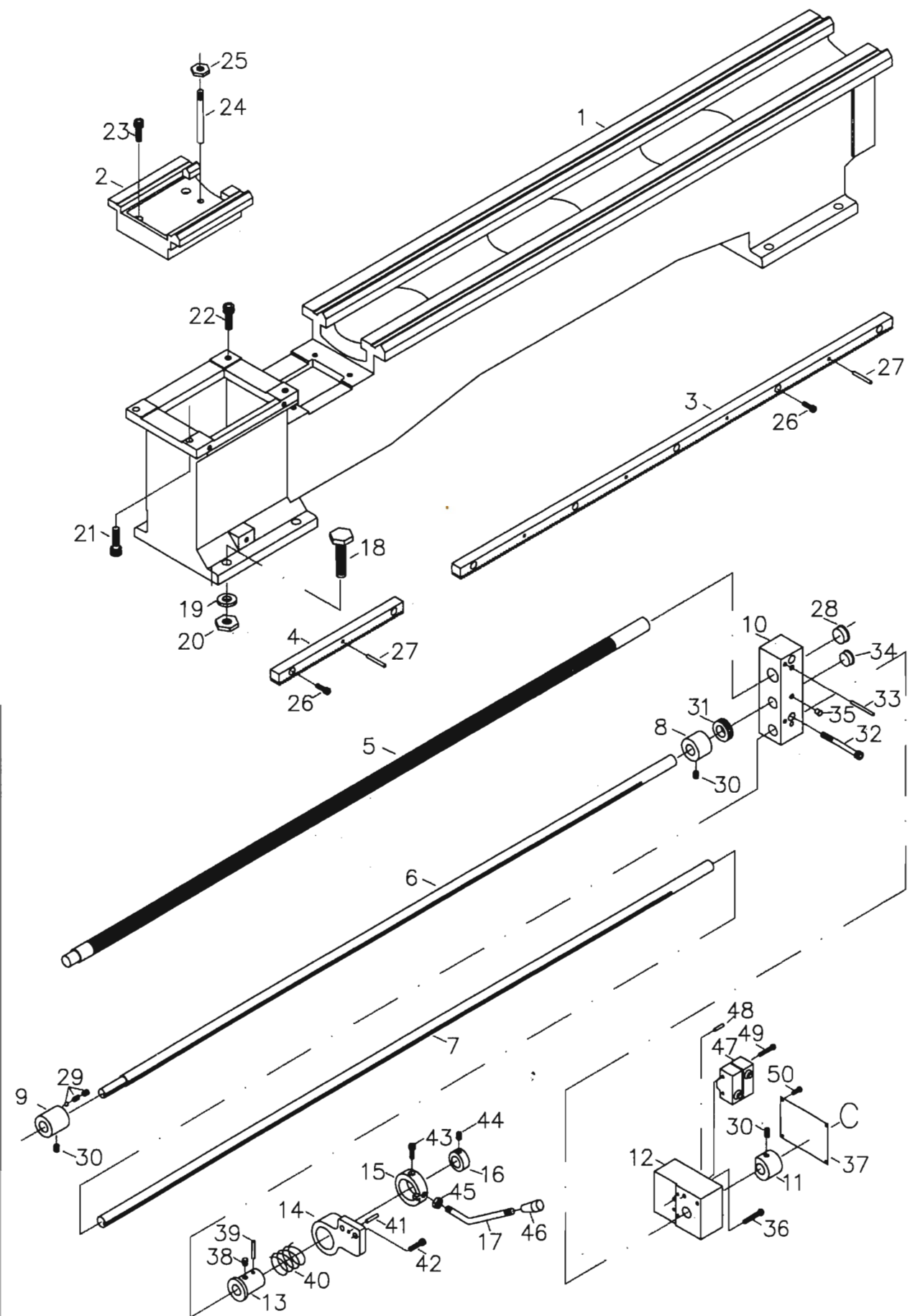
CVE24002

S: 1/3



CVE2500

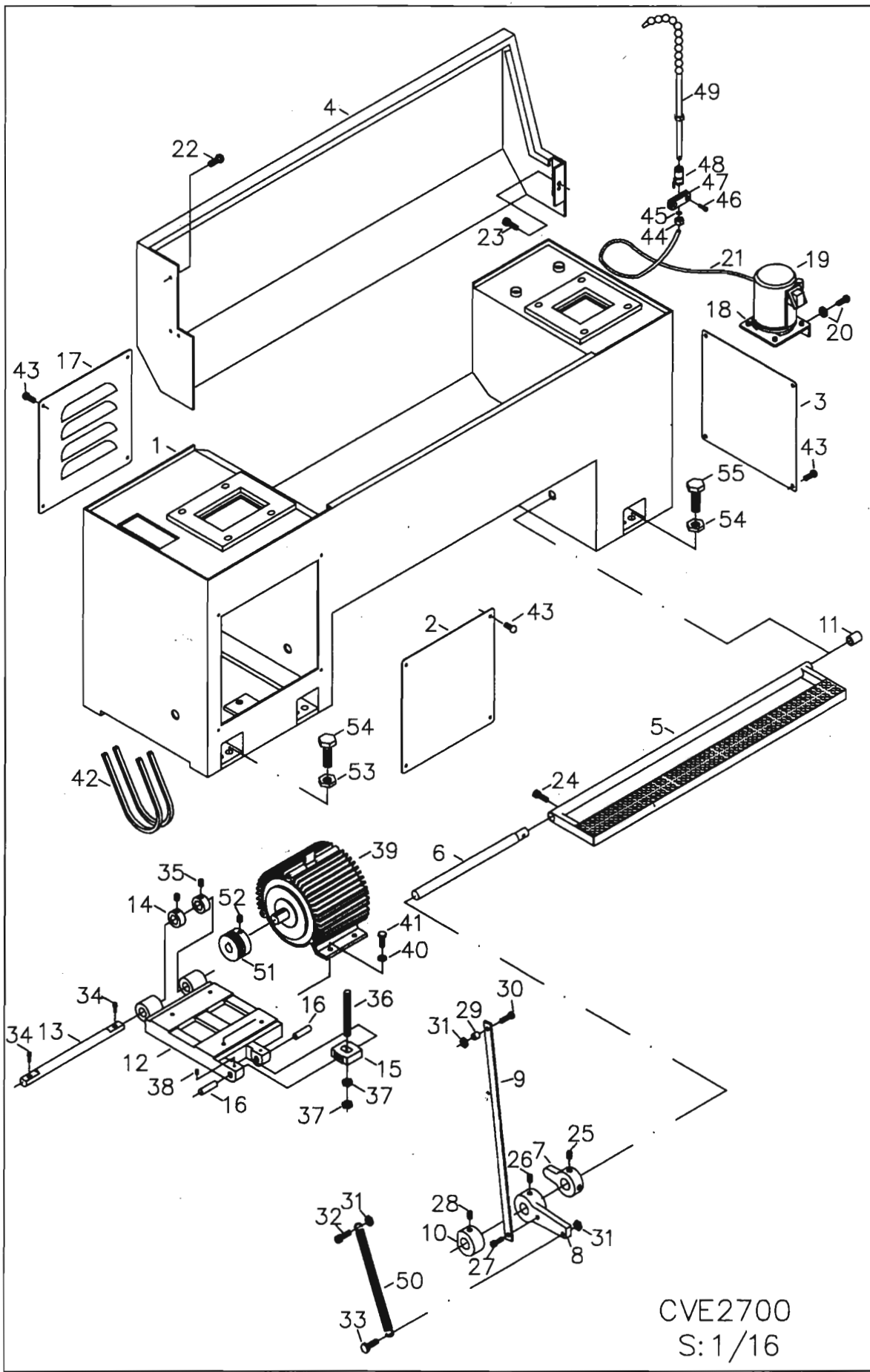
S: 1/5



S: 1/10

BED RACK LEAD SCREW AND SHAFTS

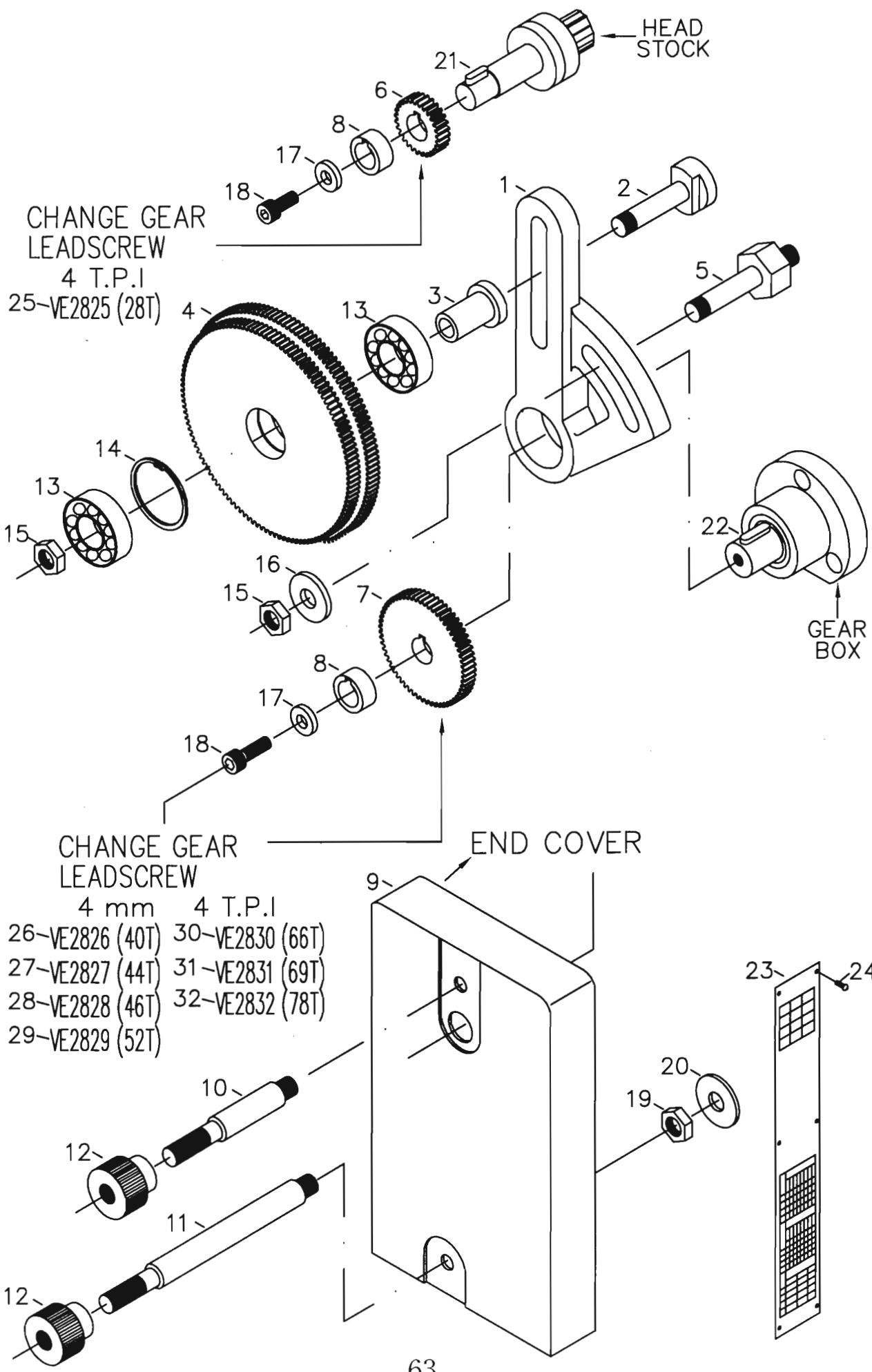
REF.NO.	PART NO.	DESCRIPTION	Q'TY
1	VE2601	BED	1
2	VE2602	GAP	1
3	VE2603	RACK	1
4	VE2604	RACK	1
5	VE2605	LEAD SCREW	1
6	VE2606	SHAFT	1
7	VE2607	FOR/REW CONTROL, THIRD-ROD SHAFT	1
8	VE2609	COLLAR	1
9	VE2608	COLLAR	1
10	VE2617	END BRACKET	1
11	VE2611	BUSH	1
12	VE2236	BOX	1
13	VE2612	BUSHING	1
14	VE2613	BRACKET	1
15	VE2614	BUSH	1
16	VE2615	BUSH	1
17	VE2616	LEVER	1
18	VE2634	SCREW	1/2"X2" 8
19	VE2621	WASHER	8
20	VE2622	NUT	1/2" 8
21	VE2623	CAP SCREW	M12X40 2
22	VE2624	CAP SCREW	M12X40L 2
23	VE2632	CAP SCREW	M10X35L 4
24	VE2629	SCREW TAPER PIN	#6X64L 2
25	VE2630	NUT	M8 2
26	VE2636	CAP SCREW	M6X20L 7
27	VE2635	PIN	5X28 5
28	VE2633	PLUG	1
29	VE2638	STEEL BALL AND SPRING	2
30	VE2635	SETSCREW	M8X12L 1
31	VE2640	THRUST	51104 2
32	VE2651	SCREW	M8X60L 2
33	VE2635	PIN	5X50 2
34	VE2658	PLUG	3
35	VE2649	PLUG	3/8" 1
36	VE2641	CAP SCREW	M6X16L 2
37	VE2642	COVER	1
38	VE2628	SET SCREW	1
39	VE2629	PIN	1
40	VE2643	SPRING	1
41	VE2646	PIN	5X28 1
42	VE2644	CAP SCREW	M8X20L 2
43	VE2645	CAP SCREW	M6X12L 1
44	VE2648	SET SCREW	M8X10L 1
45	VE2647	NUT	1
46	VE2630	PVC KNOB	1
47	VE2652	SWITCH	2
48	VE2653	PIN	#5X20L 2
49	VE2654	SCREW	M4X40L 2
50	VE2655	SCREW	M5X10L 2



CVE2700
 S:1/16

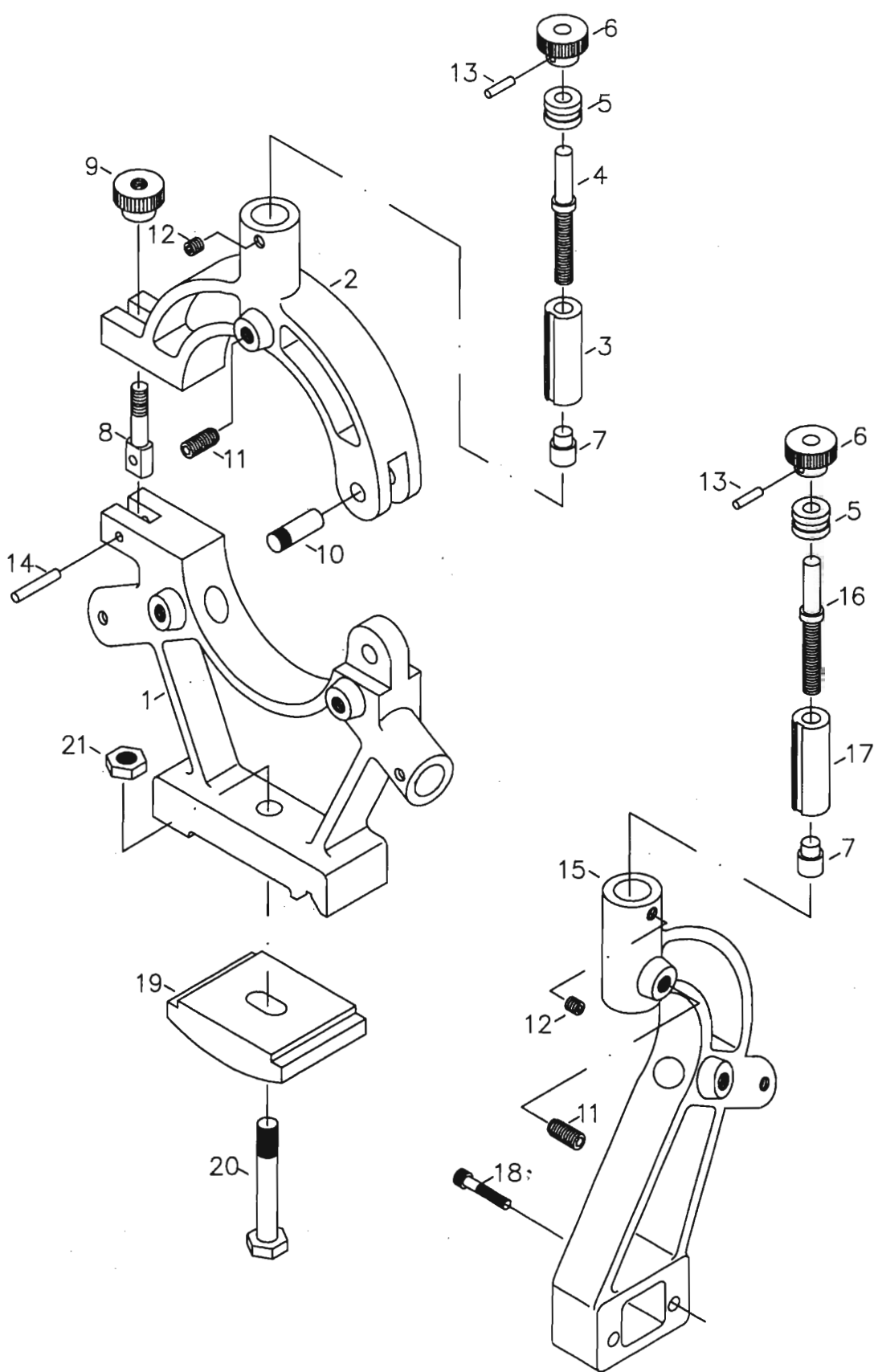
COOLANT PUMP

REF.NO.	PART NO.	DESCRIPTION		Q'TY
1	VE2701	PEDESTAL		1
2	VE2708	COVER		1
3	VE2709	COVER		1
4	VE2705	SPLASH GUARD		1
5	VE2703	FOOT BRAKE PEDAL		1
6	VE2715	CONNECTOR SHAFT		1
7	VE2714	LEVER		1
8	VE2713	LEVER		1
9	VE2711	BAR		1
10	VE2712	COLLAR		1
11	VE2716	COLLAR		1
12	VE2722	MOTOR PLATE		1
13	VE2723	SHAFT		1
14	VE2725	COLLAR		2
15	VE2724	CLAMP		1
16	VE2726	SHAFT		2
17	VE2708	COVER		1
18	VE2706	PLATE		1
19	VE2717	COLLANT PUMP		1
20	VE2733	SCREW AND WASHER		2
21	VE2734	PIPE		1
22	VE2735	CAP SCREW	M6X12L	3
23	VE2736	CAP SCREW	M8X20L	1
24	VE2737	CAP SCREW	M8X20L	2
25	VE2742	SET SCREW	M10X20L	2
26	VE2743	SET SCREW	M10X40L	2
27	VE2731	CAP SCREW	M8X10L	1
28	VE2742	SET SCREW	M10X20L	1
29	VE2742-1	WASHER		1
30	VE2743	SCREW		1
31	VE2746	NUT		3
32	VE2738	SCREW	M8X25	1
33	VE2739	SCREW	8X30	1
34	VE2747	SCREW	M10X40L	2
35	VE2748	SET SCREW	M12X12L	2
36	VE2749	SCREW		1
37	VE2750	NUT	M16	2
38	VE2751	SET SCREW	M8X10L	2
39	VE2752	MOTOR		1
40	VE2753	WASHRER		4
41	VE2754	SCREW		4
42	VE2755	V-BELT		2
43	VE2756	SCREW		12
44	VE2757	NUT		1
45	VE2758	RING		1
46	VE2759	CAP SCREW	M6X30L	2
47	VE2760	BRACKET		1
48	VE2761	KNOB		1
49	VE2720	HOSE		1
50	VE2745	SPRING		1

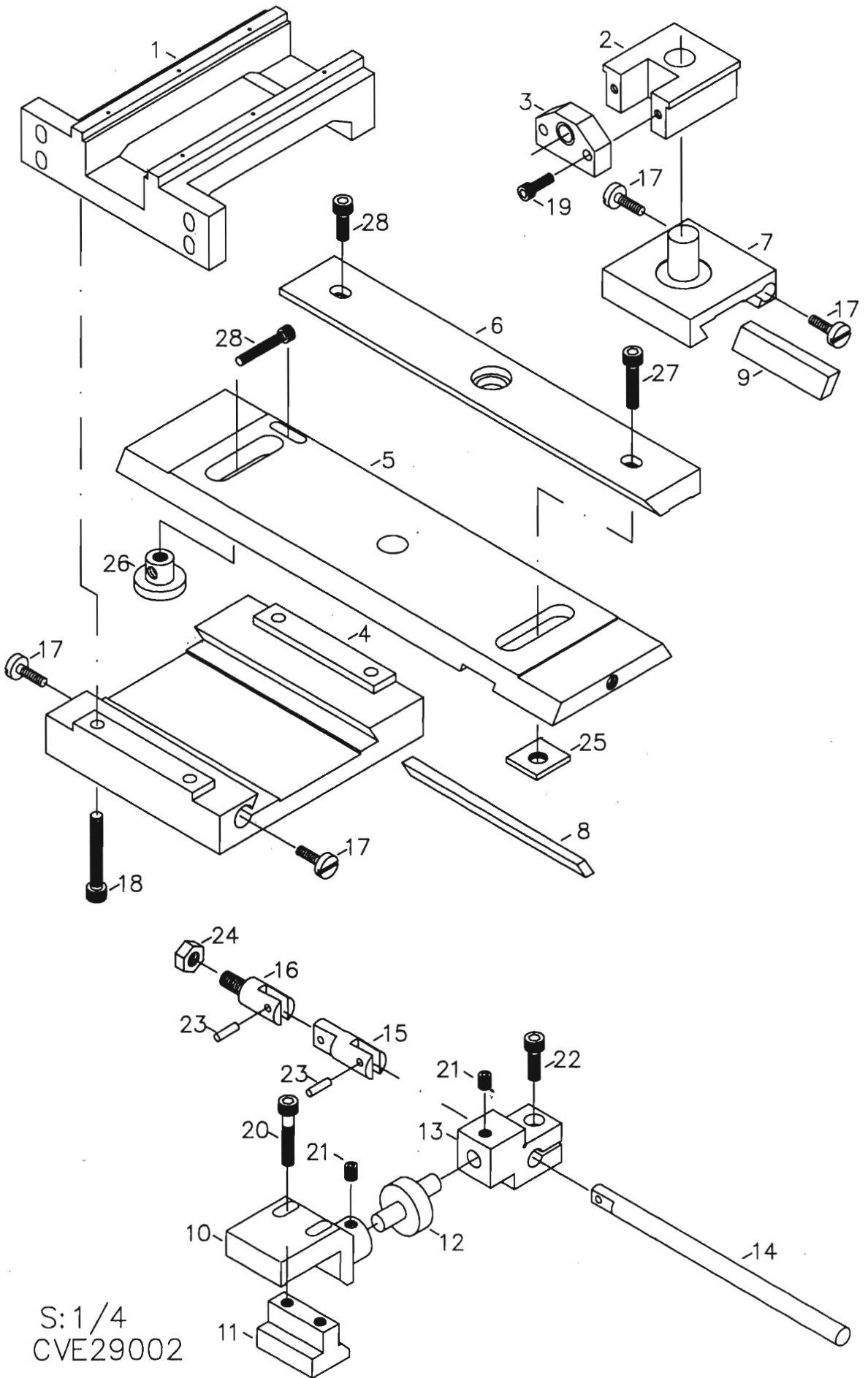


CHANGE GEAR
LEADSCREW
4 T.P.I
25-VE2825 (28T)

CHANGE GEAR
LEADSCREW
4 mm 4 T.P.I
26-VE2826 (40T) 30-VE2830 (66T)
27-VE2827 (44T) 31-VE2831 (69T)
28-VE2828 (46T) 32-VE2832 (78T)
29-VE2829 (52T)

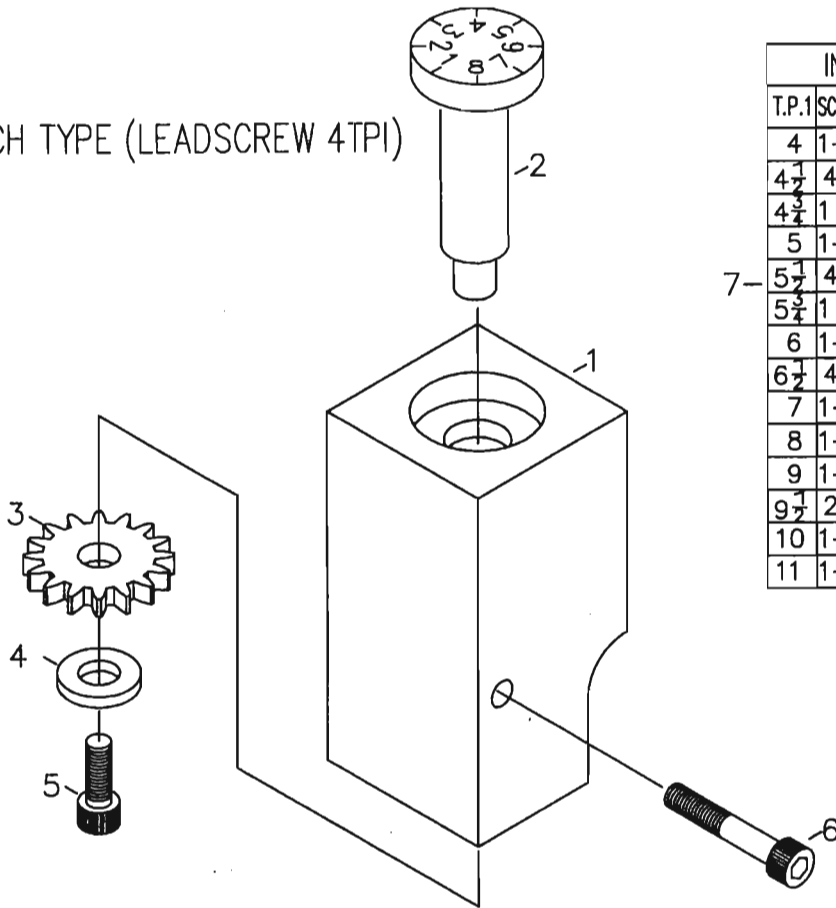


S: 1/4



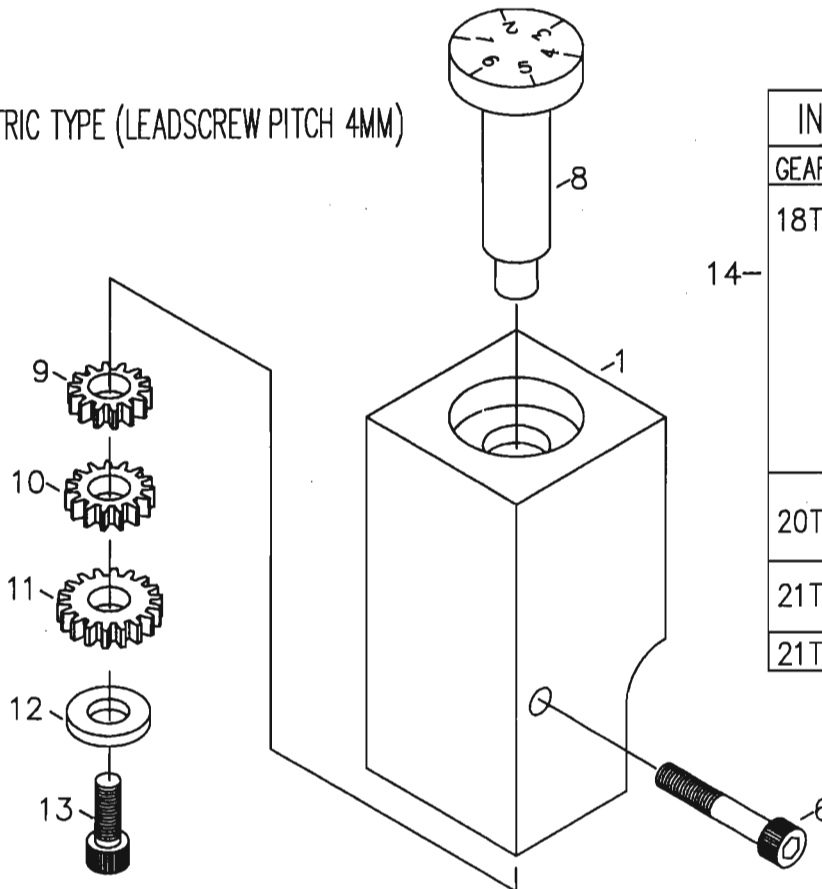
S: 1/4
 CVE29002

INCH TYPE (LEADSCREW 4TPI)



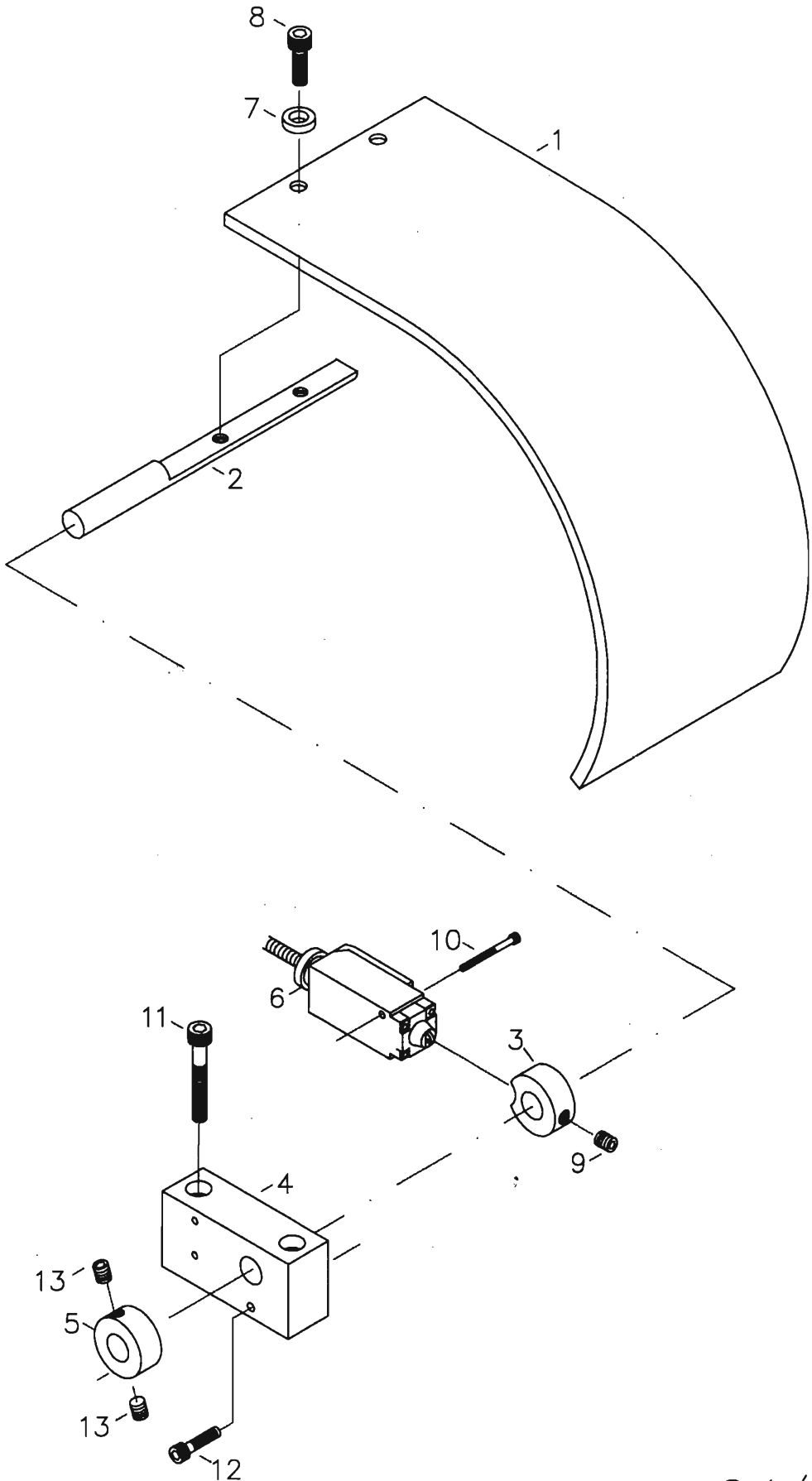
INDICATOR TABLE					
T.P.1	SCALE	T.P.1	SCALE	T.P.1	SCALE
4	1-8	11	4,8	36	
4 $\frac{1}{2}$	4,8	12	1-8	38	
4 $\frac{3}{4}$	1	13	1-4	40	
5	1-4	14	1-8	44	
5 $\frac{1}{2}$	4,8	16	1-8	46	
5 $\frac{3}{4}$	1	18	1-8	48	
6	1-8	19	1-4	52	1-8
6 $\frac{1}{2}$	4,8	20	1-8	56	
7	1-4	22	1-8	64	
8	1-8	23	1-4	72	
9	1-4	24		76	
9 $\frac{1}{2}$	2,4	26		80	
10	1-8	28		96	
11	1-4	32		104	

METRIC TYPE (LEADSCREW PITCH 4MM)



INDICATOR TABLE			
GEAR	PITCH		SCALE
18T	0.45	0.9	1, 4
	2.25	4.5	
	0.3	0.6	1, 3, 5
	0.25	0.75	
	0.5	1.5	
20T	1	3	1-6
	2	6	
	4		
20T	1.25	5	1, 4
	2.5		
21T	1.75	7	1, 3, 5
	3.5		
21T	0.7		1, 4

S: 1/2



S: 1/4

CVE29004

ELECTRIC EQUIPMENT

CONSTRUCTION

The electric equipment consists of spindle motor, control panel, magnetic contactor, magnetic switch, control cable and transformer.

- 1. The spindle motor is totally enclosed, 3 phase, 3 HP w/4 poles.**
- 2. The control panel includes power on and off switches, coolant switch, and pilot lamp.**
- 3. The magnetic control panel has spindle motor, reversible magnetic valve, and subsidiary magnetic contactor.**
- 4. The forward and reverse motor control lever is controlled by a micro-switch.**
- 5. A micro switch for foot brake pedal is fitted separately. When the pedal is pushed, the magnetic switch on the spindle motor will cut off automatically.**

RUNNING STEPS

- 1. A power switch is fitted on the control panel. Turn this switch on , then the pilot lamp will come on.**
- 2. Push or pull the motor control level on the apron will start the spindle.**
- 3. When emergency stop is needed, step on the foot brake, then the power to the spindle will shut off automatically. Meanwhile, the brake is activated to stop the spindle.**
- 4. Usually, when the machine needs to stop, move the motor control lever to the middle position. Then the magnetic switch will be cut off, and the machine will stop running.**
- 5. Upon operation is complete, be sure to put the power switch on the control panel to the off position.**

DISMOUNTING THE GAP BED

First take off the four screws mounted on the surface, and remove the pin in the middle, then move the gap bed horizontally to get it off the machine. Be careful with its pin and edges! Hold the gap bed carefully, and do not bump it! Follow the opposite steps to put the gap bed back to the machine. Before re-mounting, gap bed and bed ways have to be cleaned.

NOTES

- 1. Be sure to operate the machine carefully and maintain it well. If so, the machine's longevity and precision can be assured.**
- 2. Everyday, when the operation is complete, be sure to clean out the chips on the machine, and oil the slideways to prevent rust. Turn off the power when done!**
- 3. Everyday, before operation, please make sure to check oil level on each gauge, and fill them if necessary. Especially the gear box, which is easily forgotten by the operator, please fill in oil every morning and in the afternoon before running the machine.**
- 4. For a new machine, after operation of three months, the oil in the headstock must be replaced or filtered if it will be re-used again. This is done so to protect the gears inside the headstock and reduce its noise level.**
- 5. If headstock is over heated, highly wobbled, oil leaked and oil short, please stop the machine and arrange a technician to solve the problem immediately.**
- 6. While clamping the work piece, please do not hit it with hammer or heavy material, otherwise the spindle might be damaged and loose its accuracy.**
- 7. After operation, hand tools, cutting tools, and clamping kits should be placed back to the original area. Please do not leave anything on the slideway or bed ways. This is to prevent collision of tools to the ways that ultimately will affect the accuracy of the machine.**
- 8. Besides the operator, please do not let anybody adjust or move the position of handles or controlling levers, or operate the machine.**
- 9. Please make a schedule of maintenance, and do it according to the schedule. This will elongate the life of the machine and prolong its accuracy.**

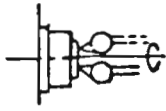
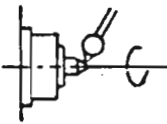
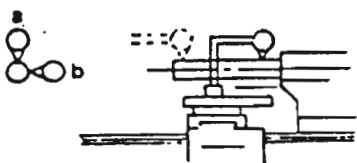
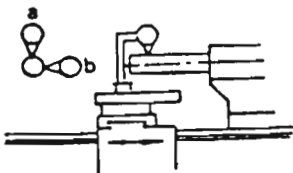
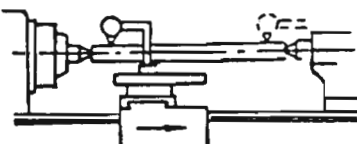
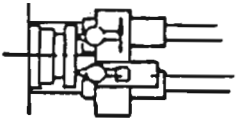
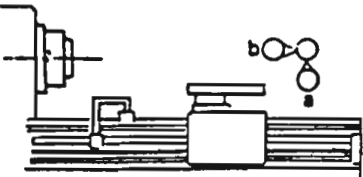
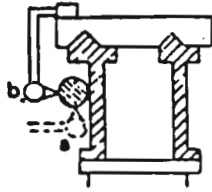
TROUBLE SHOOTING

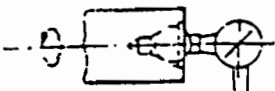
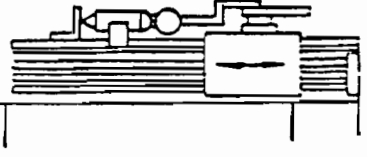
TROUBLES	FACTORS	REMEDY
HEADSTOCK BEARINGS ARE OVER HEATED	<ol style="list-style-type: none"> 1. OIL LEVEL IN HEADSTOCK IS TOO LOW. 2. OIL VISCOSITY IS WRONG. 3. OIL PIPE IS OBSTRUCTED OR LEAKED. 4. MAIN SPINDLE IS WOBBLING OR OVER LOADED. 5. OIL FILTER IS OBSTRUCTED. 	<ol style="list-style-type: none"> 1. CHECK IF OIL LEVEL IN CORRECT POSITION AND FILL IT UP IF NECESSARY. 2. CHECK IF THE RECOMMENDED OIL IS USED. 3. CLEAN OIL PIPE OR REPLACE A NEW ONE IF NEED. 4. CHECK IF THE SPINDLE IS LOCKED UPON FREE RUNNING. 5. FILTER THE OIL OR REPLACE NEW OIL.
OIL LEAKAGE ON SPINDLE FLANGE OR GEAR BOX COVER	<ol style="list-style-type: none"> 1. BOLT IS LOOSE. 2. OIL PACKING IS WORN. 3. OIL VOLUME IS OVER. 4. OIL SEAL IS CRACKED. 5. THE SURFACE FINISH IS COARSE. 	<ol style="list-style-type: none"> 1. LOCK THE BOLT. 2. REPLACE THE PACKING. 3. LOWER THE OIL. 4. REPLACE OIL SEAL. 5. CORRECT THE FINISH.
CHATTER	<ol style="list-style-type: none"> 1. WORKPIECE IS NOT CLAMPED SECURELY. 2. WORKPIECE LEAVES TOO LONG AT LEFT SIDE OF THE CLAMPING POSITION. 3. IMPROPER CUTTING TOOL IS USED. 4. CUTTING TOOL IS TOO HIGH OR TOO LOW TO THE CENTER OF SPINDLE. 5. CHIP IS NOT REMOVED FREELY FROM THE TOOL. 6. WORKPIECE IS TOO LONG. 	<ol style="list-style-type: none"> 1. CLAMP IT SECURELY. 2. LESSEN THE LENGTH TO AVOID Wobble HAPPENED. 3. SELECT SUITABLE CUTTING TOOL ACCORDING TO MATERIAL OF WORKPIECE AND THE CUTTING SPEED. FOR SMALL DIAMETER OF WORKPIECE, A SMALL ANGLE OF CUTTING TOOL TO BE USED. IF OPPOSITE, USE THE BIG ANGLE OF CUTTING TOOL. 4. ADJUST THE CUTTING TOOL TO THE CENTER OF SPINDLE. 5. MOUNT A CHIP CUTTER OR ADJUST THE FRONT ANGLE OF CUTTING TOOL. 6. USE A CENTER TO SUPPORT LONGER WORKPIECE.
BENT FINISH ON LONG WORKPIECE CUTTING	<ol style="list-style-type: none"> 1. MATERIAL IS OVER HEATED. 2. DEEP CUT IS MADE. 3. HOT IS HAPPENED TO THE CENTER AND WORKPIECE. 	<ol style="list-style-type: none"> 1. USE COOLANT OIL FOR CUTTING. 2. REDUCE THE DEPTH FOR EACH CUTTING. 3. USE ROLLING CENTER FOR HIGH SPEED RUNNING.
PRECISION IS GETTING WORSE	<ol style="list-style-type: none"> 1. WORKPIECE IS NOT BALANCE CLAMPED. 2. ALWAYS HIT THE WORKPIECE BY HAMMER. 3. CENTER OF SPINDLE IS NOT ALIGNMENT WITH THE CENTER OF TAILSTOCK. 4. MACHINE IS OUT OF THE HORIZONTAL. 	<ol style="list-style-type: none"> 1. CLAMP WORKPIECE IN BALANCE 2. DO NOT HIT IT BY HAMMER. 3. ADJUST THE TAILSTOCK TO ALIGNMENT WITH THE CENTER OF SPINDLE. 4. CHECK PERIODICALLY HORIZONTAL OF MACHINE.
LEVER SWITCH IS HARD OPERATED	<p>THE OPERATOR IS NOT FAMILIAR WITH OPERATION OF THE MACHINE.</p>	<p>THE LEVER SWITCH IS FITTED WITH A SAFETY DEVICE. DURING OPERATION, THE LEVER MUST BE MOVED SLIGHTLY TO RIGHT THEN OPERATE UPWARD OR DOWNWARD FOR RUNNING THE SPINDLE CLOCKWISE AND ANTICLOCKWISE.</p>

TOLERANCE PERMISSIBLE DIAGRAM

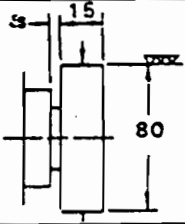
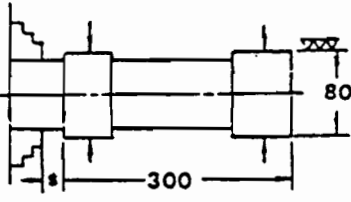
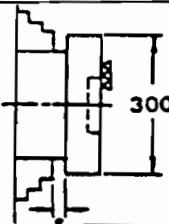
1.ACCURACY TEST.(mm)

NO.	INSPECTION ITEM		DIAGRAM	TOLERANCE PERMISSIBLE
1	Straightness of bed slideway	a.Longitudinal direction (In vertical Llane'		0.04
		b.Transverse direction (In veritical plane)		0.04
2	Parallelism of bed slideways.			0.02
3	Spindle nose runout			0.01
4	Spindle taper hole runout	a.Nearest spindle nose		0.01
		b.At a distance of 300nn		0.02
5	Parallelism of center line of main spindle to longitudinal motion of carriage	a.In vertical plane		0.025
		b.In horizontal plane		0.025
6	Movement of compound slide parallel with main spindle in vertical plane (Hand feed)			0.01/150

NO.	INSPECTION ITEM		DIAGRAM	TOLERANCE PERMISSIBLE
7	Main spindle for axial slip. measured at 2 points, displaced by 180°			0.015
8	True running of center point of main spindle.			0.015
9	Parallelism of tailstock spindle with bed ways.	a. In vertical plane (Front end rising)		0.015/100
		b. In horizontal plane (Front end inclined to wards the direction of tool pressure.)		0.015/100
10	Parallelism of bed ways with center line of tailstock spindle hole.	a. In vertical plane (Free end of mandrel rising)		0.02/300
		b. In horizontal plane (Free end of mandrel inclined to wards tailstock end)		0.02/300
11	Difference in center height between headstock and tailstock (Mandrel rising towards tailstock end)			0.025
12	Squareness of motion of cross slide with center line of main spindle			0.02/300
13	Parallelism of center line of lead screw end bearing to carriage slide ways	a. In vertical plane		0.1
		b. In horizontal plane		0.1
14	Diviations in alignment of center line of lead screw end bearing with center line of half nut.	a. In vertical plane		0.15
		b. In horizontal plane		0.15

NO.	INSPECTION	DIAGRAM	TOLERANCE PERMISSIBLE
15	Axial displacement of lead screw by turning		0.01
16	Pitch error of lead screw		0.03/300

2. PRACTICAL

NO.	TESTING ITEM	DIAGRAM	TOLERANCE PERMISSIBLE
1	Accuracy of outside turning		0.01
2	Accuracy of cylindrical turning		0.025
3	Accuracy of face turning		0.02

3. CHECK OF MOTOR SPECIFICATION

ITEM	HP	Ph	V	Hz	R.P.M.
Rating	2 3	1 3		50 60	1420 1700
Actual					