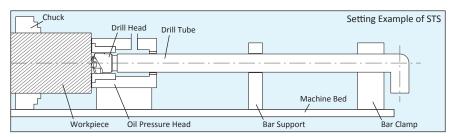
UNITAC



STS (Single Tube System)



Machine Alignment Check Sheet [Workpiece-Rotating]



For a precise deep hole drilling machine set up be sure to check and ensure the below points

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✓ Fo	For a precise deep hole drilling machine set up be sure to check and ensure the below points. Page 1/					
	Check Point		Acceptable Limit (mm)	Measured Value (mm)		
1	Machine bed should be parallel to side to side and front to back directions	Level Machine Bed	① Right & Left 0.015	Right & Left		
		□ □ □ □ □	Back & Front 0.03	Back & Front		
2	Chuck runout should be within the acceptable limit	Chuck Gauge Bar	0.01			
3	Chuck and machine bed should be parallel		0.01			
4	Spindle taper runout should be within the acceptable limit	Spindle Bar Clamp	0.01			
5	Spindle end face runout should be within the acceptable limit		0.01			
6	Spindle and machine bed should be parallel	Bar Clamp Gauge Bar Collet	0.01			

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	Check Point		Acceptable Limit (mm)	Measured Value (mm)
7	Oil pressure head and machine bed should be parallel	Oil Pressure Head Gauge Bar	0.02	
8	Chuck and oil pressure head should be in alignment	Chuck Oil Pressure Head	0.02	
9	Spindle and oil pressure head should be in alignment	Oil Pressure Head Spindle Bar Clamp	0.02	
10	Spindle, bar support and machine bed should be parallel	Bar Clamp Bar Support Spindle	0.02	
11	Spindle, chuck and machine bed should be parallel	Bar Clamp	0.02	

