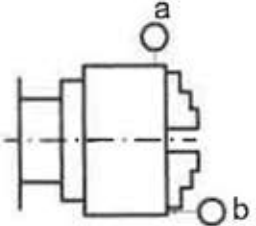
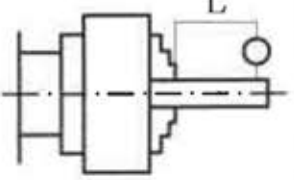
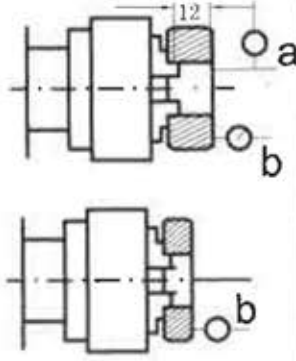
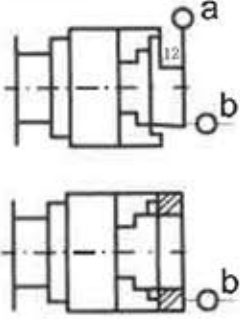


TEST ITEMS OF CHUCK AND ITS ACCURACY

mm

Test Item	Diagram of Test	Chuck Dia D	a	b	Test Data	
					a	b
a. Radial runout b. End face runout		$D \leq 160$	0.03	0.03		
		$160 < D \leq 250$	0.04	0.04		
		$250 < D \leq 400$	0.06	0.06		
		$400 < D \leq 630$	0.08	0.08		
a. Radial runout		$D \leq 160$	0.080	L=50		
		$160 < D \leq 250$	0.100	L=50		
		$250 < D \leq 400$	0.125	L=75		
		$400 < D \leq 630$	0.160	L=100		
a. Radial runout b. End face runout		$D \leq 160$	0.075	0.040		
		$160 < D \leq 250$	0.075	0.050		
		$250 < D \leq 400$	0.10	0.060		
		$400 < D \leq 630$	0.125	0.080		
a. Radial runout b. End face runout		$D \leq 160$	0.075	0.040		
		$160 < D \leq 250$	0.075	0.050		
		$250 < D \leq 400$	0.10	0.060		
		$400 < D \leq 630$	0.125	0.080		

Kitchen & Walker (Registered Trademark of Chester Machine Tools)

Midlands Factory & Showroom:

Unit 4 Plant Lane Business Park, Zones 2/3 Burntwood Business Park, Off Ring Road, Burntwood, Staffs, WS7 3GN.

T: +44 (0)1543 448940 e:sales@chestermachinetools.com