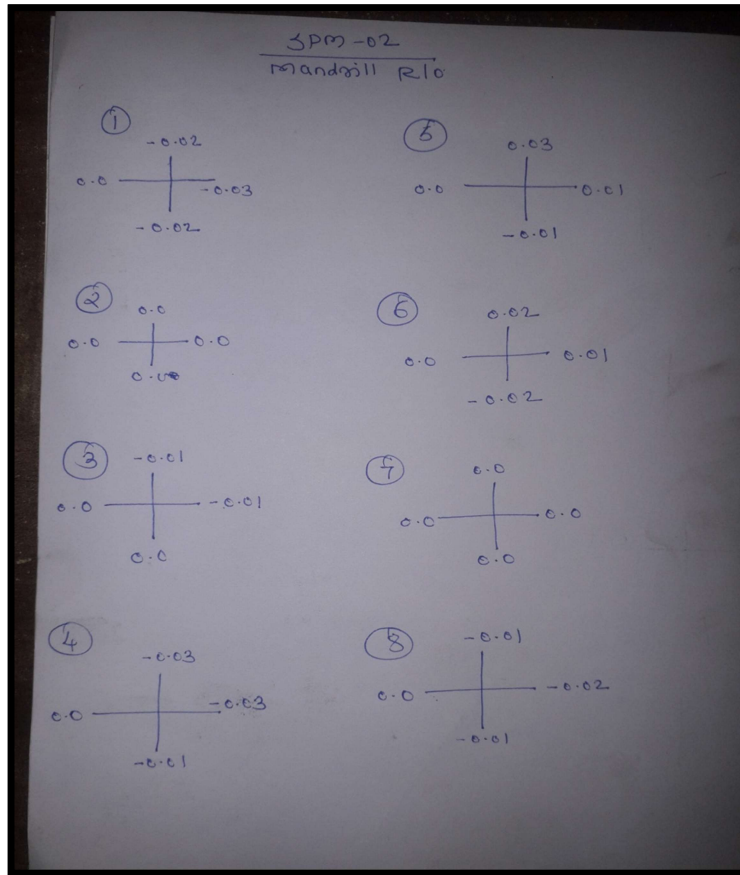


SPM Collet alignment done with Facing, Drilling & Tapping Spindle within 50 microns



SPM – Collet Alignment checked

Harshad Engineering Company, F-66, Satpur MIDC, Nashik		Month - NOV - 23.		HEC Plant - 3 (F-66)							
		Spindle-wise Runout on Ø14 mm Mandrel									
Sr. No.	Machine No.	Week -1		Week -2		Week -3		Week -4			
		Head Side Runout	Tail End side runout	Head Side Runout	Tail End side runout	Head Side Runout	Tail End side runout	Head Side Runout	Tail End side runout		
1	CNC1	0.02		0.03		0.02					
2	CNC2	0.03		0.02		0.01					
3	CNC3	0.01		0.02		0.03					
4	CNC4	0.02		0.03		0.02					
5	CS1	0.02	0.02	0.03	0.03	0.02	0.02				
6	SPM 2	1	0.03	5	0.03	1	0.01	5	0.03	1	5
		2	0.02	6	0.02	2	0.03	6	0.03	2	6
		3	0.02	7	0.03	3	0.02	7	0.02	3	7
		4	0.03	8	0.02	4	0.02	8	0.02	4	8
6	SPM 3	1	0.03	5	0.02	1	0.03	5	0.03	1	5
		2	0.02	6	0.02	2	0.02	6	0.02	2	6
		3	0.03	7	0.03	3	0.02	7	0.02	3	7
		4	0.02	8	0.02	4	0.03	8	0.03	4	8
6	SPM 4	1	0.03	5	0.02	1	0.03	5	0.03	1	5
		2	0.02	6	0.03	2	0.02	6	0.03	2	6
		3	0.02	7	0.03	3	0.03	7	0.02	3	7
		4	0.01	8	0.03	4	0.03	8	0.03	4	8
Checked By :-		<i>[Signature]</i>		<i>[Signature]</i>		<i>[Signature]</i>					

Spindle wise run out