

OPERATOR'S MANUAL

VM18L



**Keep Read and Understand the Operation Manual and Safety Information
Before Operated!**

NOTE

The information contained in this handbook is intended as a guide to the operation of these machines and does not form part of any contract. The data it contains has been obtained from the machine manufacturer and from other sources. Whilst every effort has been made to ensure the accuracy of these transcriptions it would be impracticable to verify each and every item. Furthermore, development of the machine may mean that the equipment supplied may differ in detail from the descriptions herein. The responsibility therefore lies with the user to satisfy himself that the equipment or process described is suitable for the purpose intended.

LIMITED WARRANTY

We Make every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follow: **ONE YEAR LIMITED WARRANTY ON ALL PRODUCTS UNLESS SPECIFIED OTHERWISE.** This Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and tear, repair or alterations outside our facilities, or to a lack of maintenance.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, the product or part must be returned to us for examination, postage prepaid. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will either repair or replace the product, or refund the purchase price if we cannot readily and quickly provide a repair or replacement, if you are willing to accept a refund. We will return repaired product or replacement at our expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of our's warranty, then the user must bear the cost of storing and returning the product.

The manufacturers reserve the right to change specifications at any time as they continually strive to achieve better quality equipment.

Copyright. The copyright of this instruction book is the property of us and may not be reproduced or copied without prior consent of us.

WARNING!

Read and understand the entire instruction manual before attempting set-up or operation of this mill/drill

1. **This machine is designed and intended for use by properly trained and experienced personnel only.** If you are not familiar with the proper safe use of mill/drills, do not use this machine until proper Training and knowledge has been obtained.
2. **Keep guards in place.** Safety guards must be kept in place and in working order.
3. **Remove adjusting keys and wrenches.** Before turning on machine, check to see that any adjusting wrenches are removed from the tool.
4. **Reduce the risk of unintentional starting.** Make sure switch is in the OFF position before plugging in the tool.
5. **Do not force tools.** Always use a tool at the rate for which it was designed.
6. **Use the right tool.** Do not force a tool or attachment do a job for which it was not designed.
7. **Maintain tools with care.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubrication and changing accessories.
8. **Always disconnect the tools from the power Source before adjusting or servicing.**
9. **Check for damaged parts.** Check for alignment of moving parts, breakage of parts, mounting, and any Other condition that may affect the tools operation.
10. **Turn power off. Never leave a tool unattended.** Do not leave a tool until it comes to a complete stop.
11. **Keep work area clean.** Cluttered areas and bench Invite accidents.
12. **Do not use in a dangerous environment.** Do not Use power tools in damp or wet locations, or expose Them to rain. Keep work area well lighted.
13. **Keep children and visitors away.** All visitors should be kept a safe distance from the work area
14. **Make the workshop child proof.** Use padlocks, . master switches and remove starter keys.
15. **Wear proper apparel.** Loose clothing, gloves, neckties, rings, bracelets, or other jewelry may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair. Do not wear any glove.
16. **Always use safety glasses.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are not safety glasses. accessories may be hazardous.
17. **Do not overreach.** Keep proper footing and balance at all times.
18. **Do not place hands near the cutterhead** while the machine is operating.
19. **Do not perform any set-up work while machine is operating.**
20. **Read and understand all warnings posted on the machine.**
21. **This manual is intended to familiarize you with the technical aspects of this mill/drill.** It is not, nor was it intended to be, a training manual.
22. **Failure to comply with all of theses warnings may result in serious injury.**
23. **Some dust created** by power sanding, sawing, grinding, drilling and other construction activites contains chemicals known to cause cancer, birth defects or other reproductive harm.
24. **Your risk from those exposures** varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well ventilated are, and work with approved safety equipment

MAIN TECHNICAL SPECIFICATION

Model	VM18L	
Max. Drilling Capacity	11/16"	18mm
Max. End Milling Capacity	5/8"	16mm
Max. Face Milling Capacity	1-31/32"	50mm
T-Slot Size	3 @ 25/64" slots	3 @ 10mm slots
T-Slot Centers	1-3/8"	35mm
Table Size	19-11/16" × 5-33/64"	500 × 140mm
Table Travel (X,Y)	8-21/32" × 6-19/64"	220 × 160mm
X/Y-Axis Travel per Handwheel Revolution	0.1"	
Spindle Stroke	1-31/32"	50mm
Distance from Spindle to Column	6-11/16"	170mm
Distance from Spindle nose to table	10-53/64"	275mm
Drawbar Thread Size	7/16"	
Drawbar Length	9-1/5"	234mm
Head Tilt (Left/Right)	90 Deg.	
Spindle Taper	R8	
Number of Spindle Speeds	Variable	
Vertical Spindle Speeds	100 - 2250 RPM	
Motor Type	Brushless 1HP	
Power Requirement	Single Phase 110V 60Hz	
Rated Current	10A	
Packing Size	20" × 21-1/4" × 32-7/8"	
Net Weight	154.4 lbs.	
Gross Weight	196.2 lbs.	

The specifications in this manual are given as general information and are not binding. WEISS reserves the right to effect, at any time and without prior notice, changes or alterations to parts, fitting and accessory equipment deemed necessary for any reason whatsoever.

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WARNING

Read and understand the entire contents of this Manual before attempting set-up or operation!
Failure to comply may cause serious injury!

VM18L -Mill/Drill Machine

- 1 7/16" Drawbar
- 1 Test Flow Chat
- 1 Operator manual
- 1 Toolbox & Tools

Toolbox Contents (Fig. 01)

- 1 Oil Gun
- 1 R8 Arbor
- 2 Double End Spanner (17-19, 22-24mm)
- 6 Hex Socket Wrench (2.5,3,4,5,6,8mm)
- 1 Flat Blade Screwdriver
- 1 Cross Blade Screwdriver
- 4 Handle
- 2 M8 "T" Screw
- 2 M8 Washer
- 2 M8 Nut



Fig. 01

Unpacking and Clean-up

1. Finish removing the wooden crate from around the mill/drill.
2. Unbolt the machine from the crate bottom.
3. Sling mill/drill with the proper equipment.
4. Clean all rust protected surfaces using a mild commercial solvent, kerosene or diesel fuel. Do not use paint thinner, gasoline, or lacquer thinner. These will damage painted surfaces. Cover all cleaned surfaces with a light film of machine oil.

Assembly

1. Screw handles (A, Fig.02) onto handwheel (B, Fig.3) and tighten.
2. Repeat for remaining handles of table.

Installation



WARNING!

Machine is heavy! Use an appropriate lifting device and use extreme caution when moving the machine to its final location. Failure to comply may cause serious injury!

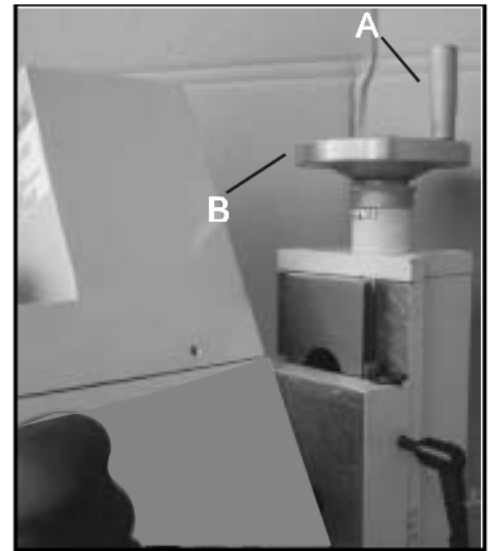


Fig. 02

1. The location for the mill/drill should be well lit, dry, and have room enough to allow the head to rotate 360°.
2. Carefully lift the mill/drill with properly rated equipment to a sturdy stand or working bench. For best performance, through bolt the mill/drill to a stand.
We do not recommend that unattached machines be operated, as the machine will move during operation!
3. Before bolting the mill/drill to a bench or stand, the unit must be level in both directions. Place a level on the table in both directions.
4. If the table of mill is not to level, shim under the low corner(s) until level. Tighten the fastening bolts. Check for level again. Adjust as necessary until the mill/drill is level. Check again when securing bolts are tightened.

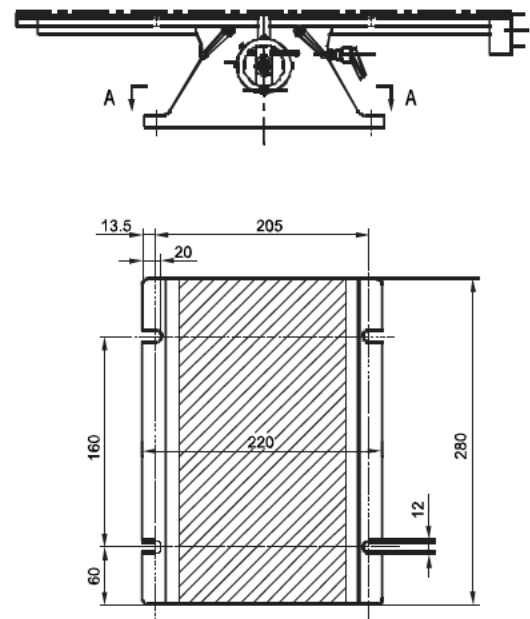


Fig. 03

Installation Drawing (Fig. 03)

The installation drawing described below may differ from the real dimensions. The tolerances are in the range of the general tolerances according to DIN 7168.

Controls

Longitudinal Handwheel (A, Fig. 04)

Located on two side of the table. Moves table side to side.

Cross Feed Handwheel (B, Fig. 04)

Located on the front of the base. Moves table toward, or away from the column.

Head Elevating handwheel (C, Fig.05),

Locate on the right of column. The head can be adjusted up or down to suit height requirements for different workpieces. Turn it clockwise to up head on the column and counter-clockwise to down. **When the head is at the desired height, lock in place with the locks.**

Caution: Have to loosen the locks for the slideways before above operation!

Adjustable Table Stops (D, Fig.06)

Located on table front. Adjust to stop table at any setting along the longitudinal axis.

Table locks

Longitudinal table locks (E, Fig. 06) are located on front of the table. Cross-feed table locks (F, Fig.05) are located on the right side under the table. Turn clockwise to lock the slideways.

Mill Head locks (G, Fig.07)

Located on the right of column. Turn clockwise to lock the mill head.

Quill Lock Lever (H, Fig. 07)

Located on the left of the mill head. The height of the spindle can be locked with the quill lock lever. Set the desired height with the quill lever and turn the lever down. Turn clockwise to lock the quill, reverse to loosen.

Caution: For best results. All milling operations should be done with the quill/spindle as close to the head assembly as possible. Lock spindle, table and mill head in place before starting milling operations!

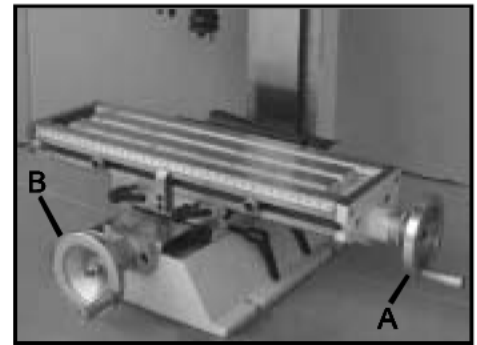


Fig. 04

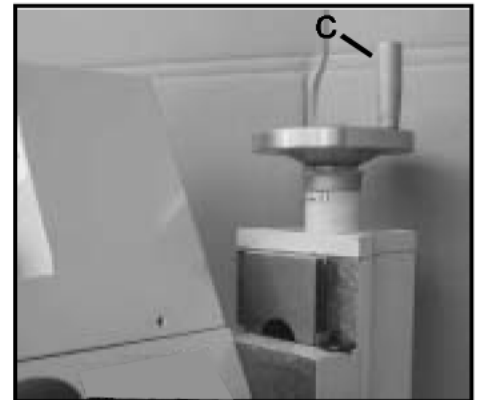


Fig. 05

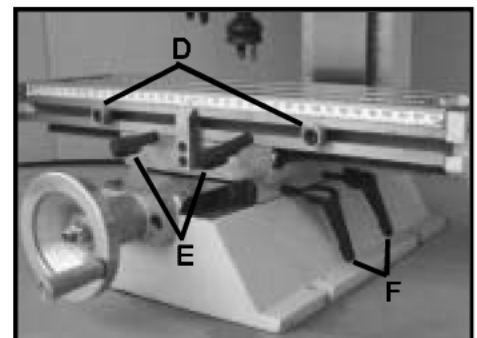


Fig. 06

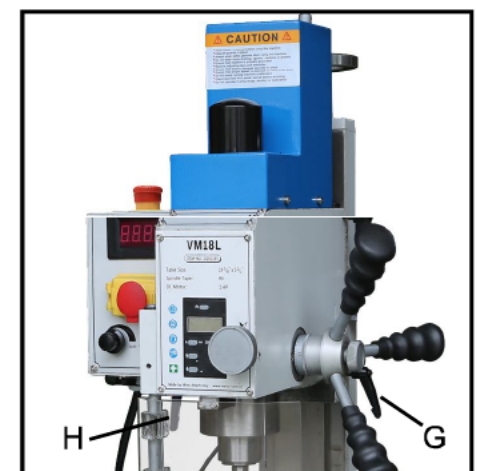


Fig. 07

Down feed Handles: (J, Fig. 08):

Located on the right side of the head casting. Counter-clockwise movement advances the quill toward the table. The graduated dials (K, Fig. 08) on the handle base can be indexed or “zeroed” to help make accurate and convenient movements.

Mill Head Rotation

The head is designed to tilt 90° either left or right, enabling it to perform task such as angle drilling or horizontal slotting. Loosen the lock nuts (L, Fig. 09) under the head. Rotate the head to its desired position, using the reference guide (M, Fig.09). Once in place, re-tighten the lock nuts.

Note: make sure to provide support for the head so it doesn’t unexpectedly rotate on its own. Always maintain control of the head.

Keep in mind that the head must be dialed in when it’s returned to the “zero” position if high levels of accuracy are required. If you are able to use an angle vise to accomplish your milling operation without tilting the mill head, you will save yourself a good amount of set-up time.



Fig. 08

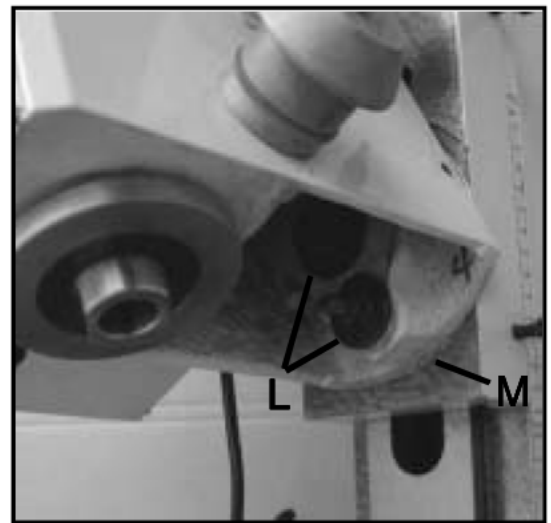


Fig. 09

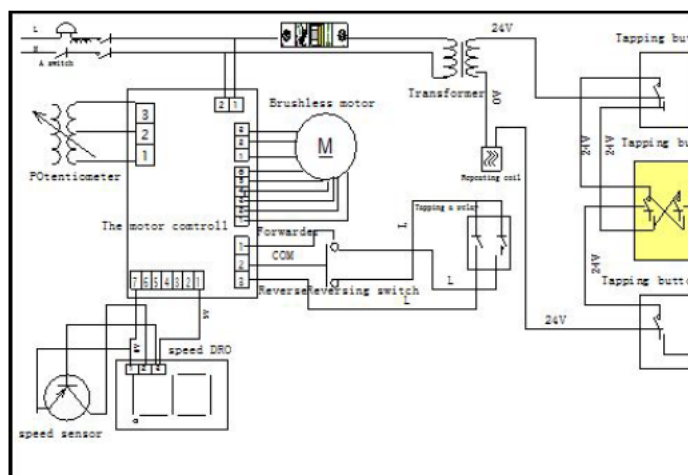
ELECTRICAL CONNECTIONS

WARNING!

A qualified electrician must make all electrical connections!

Failure to do so may cause serious injury!

Before connecting the machine to the mains, make sure that the electrical values of the mains supply are the same as those for the machine's electrical components. Use the wiring diagram (Fig. 11) for connecting the lathe to the mains supply.



WARNING!

Make sure the machine is properly ground!

Failure to do so may cause serious injury and damage to user!

Brushless Motor

Model 80BL-5550, 110V, 1HP

Make sure that all 2 phase (L, N) are connected.
Defective or incorrect connection will render the
guarantee null and void.

Indicators are:

Motor runs hot immediately (3-4 minutes).

Motor doesn't run silently and has no power.

Magnetic Switch (A, Fig.12) has the function of emergency stopping and the protective function to the machine and electric components. Green push button marked “I” to start the motor, Red push button marked “O” to switch the motor off.

Speed Control Knob (B, Fig. 12) turn it clockwise to increase the spindle speed, reverse to decrease. The knob should be turned to zero each time the machine is stopped. Always start the machine with the knob set at zero.

F/R switch (C, Fig.12) changing the position of switch will reverse the direction of the motor. F-forward direction. R- reverse direction.

Fuse Base (D, Fig. 13) located on the back plate of electrical box. Fuse what rate is 8A is put in the base. Turn counter-clockwise the button to open and change the fuse, reverse to retighten.

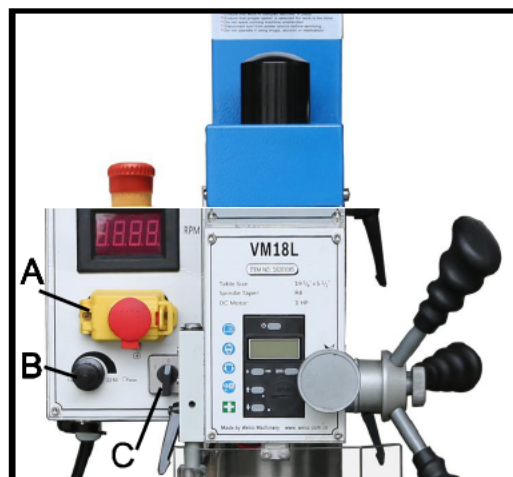


Fig.12

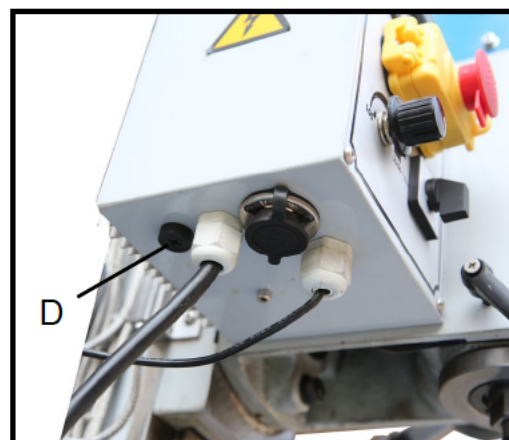


Fig.13

⚠ WARNING!

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Arbor Replacement

1. Disconnect machine from the power source, unplug.
2. Remove the cover of drawbar onto the motor cover (A, Fig. 14).
3. Hold the flat of spindle (B, Fig.15) to keep it from moving while loosening the drawbar (C, Fig 16) with the 22-25 spanner in toolbox.
4. Loosen the drawbar approximately three to four full turns.
5. Tap the drawbar head with a rubber mallet to dislodge the arbor.
6. Grasp the arbor with one hand while loosening the drawbar with the other. Continue to loosen the drawbar until the arbor can be withdrawn from the spindle. Wipe out the spindle with a clean dry rag.
7. Wipe down the new arbor with a clean dry rag and place the arbor into the spindle. Thread the drawbar into the arbor. Tighten the drawbar with a spanner while holding the spindle.

WARNING!

Do not loosen the drawbar more than three or four turns before hitting with a rubber mallet. Damage to the drawbar threads may occur!

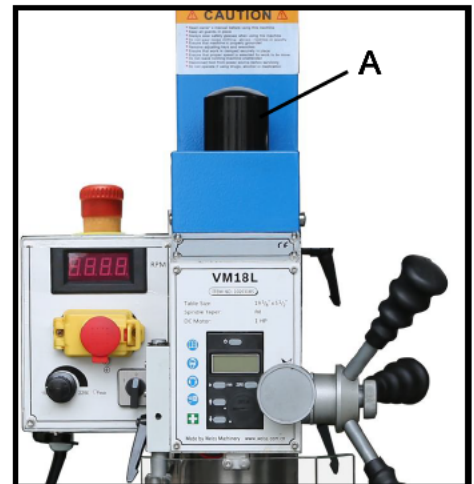


Fig. 14

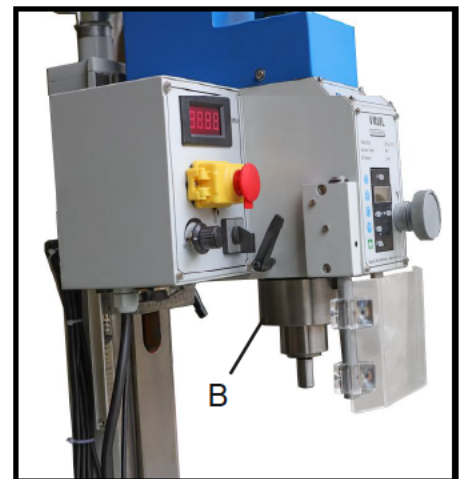


Fig. 15



Fig. 16

Gibs Adjustment

After a period of time, movement of the table over the ways will cause normal wear. Adjust the gibs to compensate for this wear.

1. The horizontal gib adjustment screw (A, Fig.17) is found to the rear right on table. The traverse gib adjustment screw (B, Fig.17) is found on the right side of saddle under the table. The vertical gib adjustment screw (C, Fig.18) is found onto the column.
2. Loose the screw from small end of taper gibs. Turn the screw from large end of taper gibs slightly clockwise to tighten. Turn the table handwheels and check the tension.
3. Re-adjust as required.

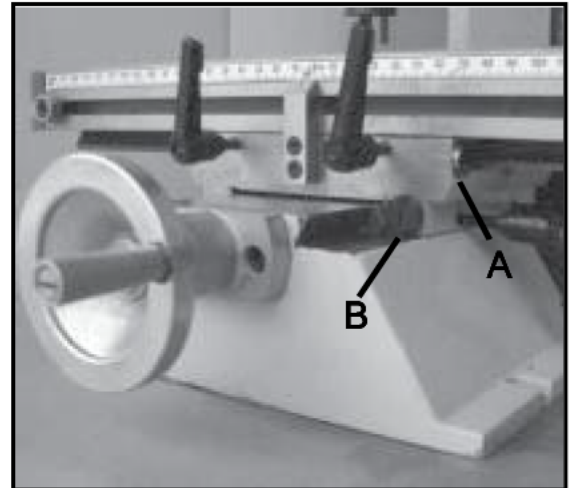


Fig. 17

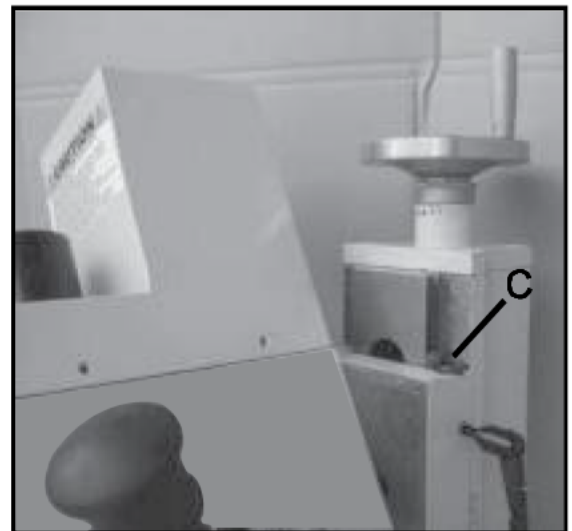


Fig. 18

Maintenance

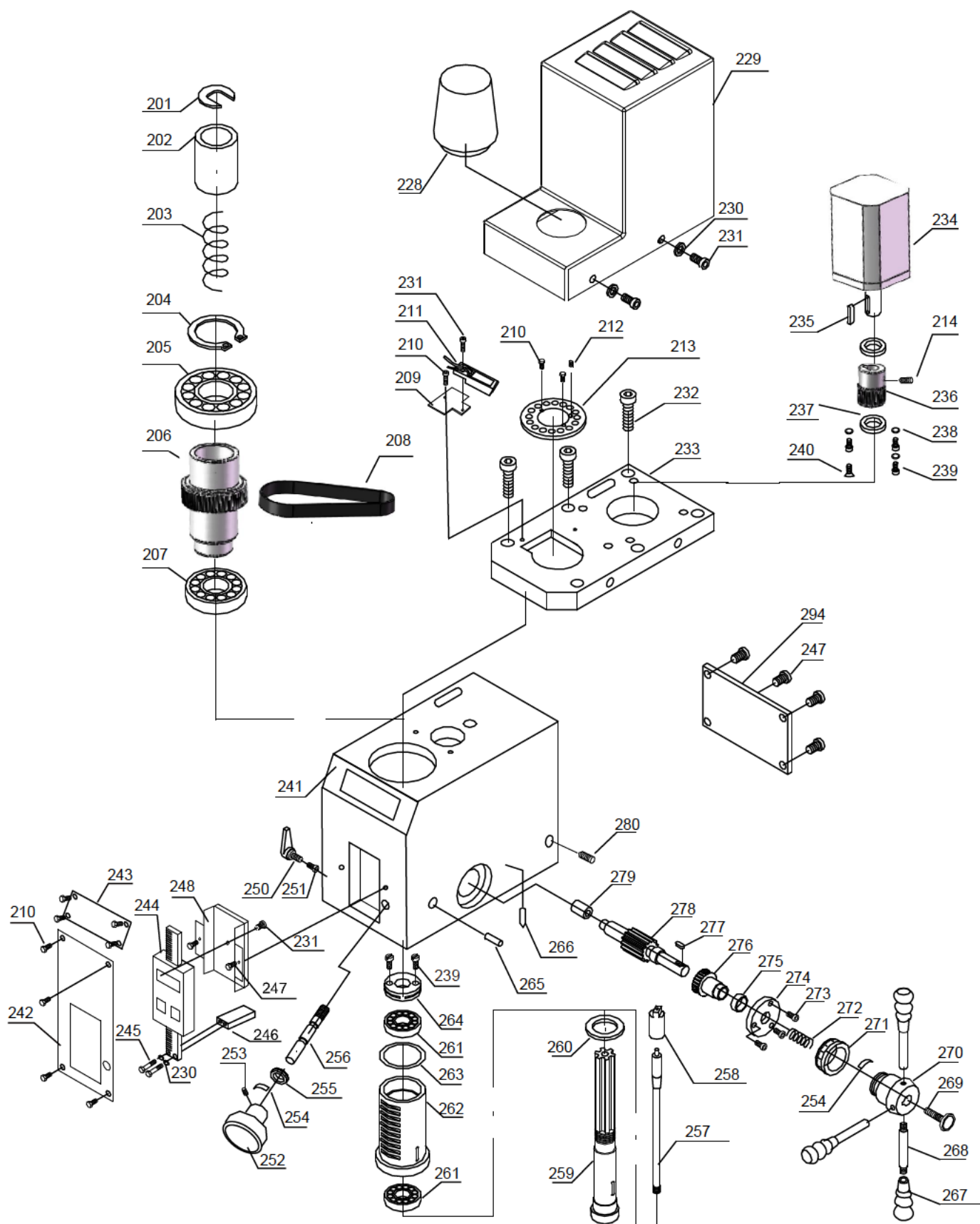
Keep the maintenance of the machine tool during the operation to guarantee the accuracy and service life of the machine.

1. In order to retain the machine's precision and functionality, it is essential to treat it with care, keep it clean and grease and lubricate it regularly. Only through good care, you can be sure that the working quality of the machine will remain constant. **Disconnect the machine plug from the mains supply whenever you carry out cleaning, maintenance or repair work!**
2. Lubrication all slideways lightly before every use. The leadscrew must also be lightly lubricated with lithium base grease.
3. During the operation, the chips what falls onto the sliding surface should be cleaned timely, and the inspection should be often made to prevent chips falling into sliding ways. Asphalt felt should be cleaned at certain time. **Do not remove the chips with your bare hands. There is a risk of cuts due to sharp-edged chips.**
4. After the operation every day, eliminate all the chips and clean different part of the machine and apply machine oil to prevent rusting.
5. In order to maintain the machining accuracy, take care of the arbor, drawbar, the surface of the worktable and the guide way and avoid mechanical damage and the wear due to improper guide.
6. If the damage is found, the maintenance should be done immediately.

Trouble Solution

Problem	Possible Cause	Solution
Too chatters	Gibs too loose on table, column Unused feeds not locked Mill head not locked Quill too loose Tool not on center Improper tool shape, tool dull	Readjust gibs Lock all axes but the one moving Lock mill head Tighten quill lock Center tool reshape, sharpen, or replace tool
Depth of cut is not consistent	Quill moving Setup wrong	Lock quill Make sure setup is parallel to table
Hole is off center or bit wanders	Bit dull Bit not mounted correctly in chuck Chuck loose in spindle Drawbar not secured Bearing loosen or worn Cutting too fast	Use sharp bits Remount tool Remount chuck on arbor Tighten drawbar Tighten or replace bearings Reduce speed
Bit turns erratically or stops	Bit fed into work too fast	Reduce feed rate
Chuck is difficult to tighten or loosen	Chuck sticking Debris in chuck	Apply lubricant Clean chuck
Chuck wobbles	Chuck loose on arbor Drawbar not tight	Clean arbor and remount Clean spindle and replace drawbar
Turn on machine and nothing happens	Machine unplugged Loose electrical connections	Plug in machine Tighten wiring connections

MILLING & DRILLING MACHINE
Mill Head Assembly



HEAD ASSEMBLY

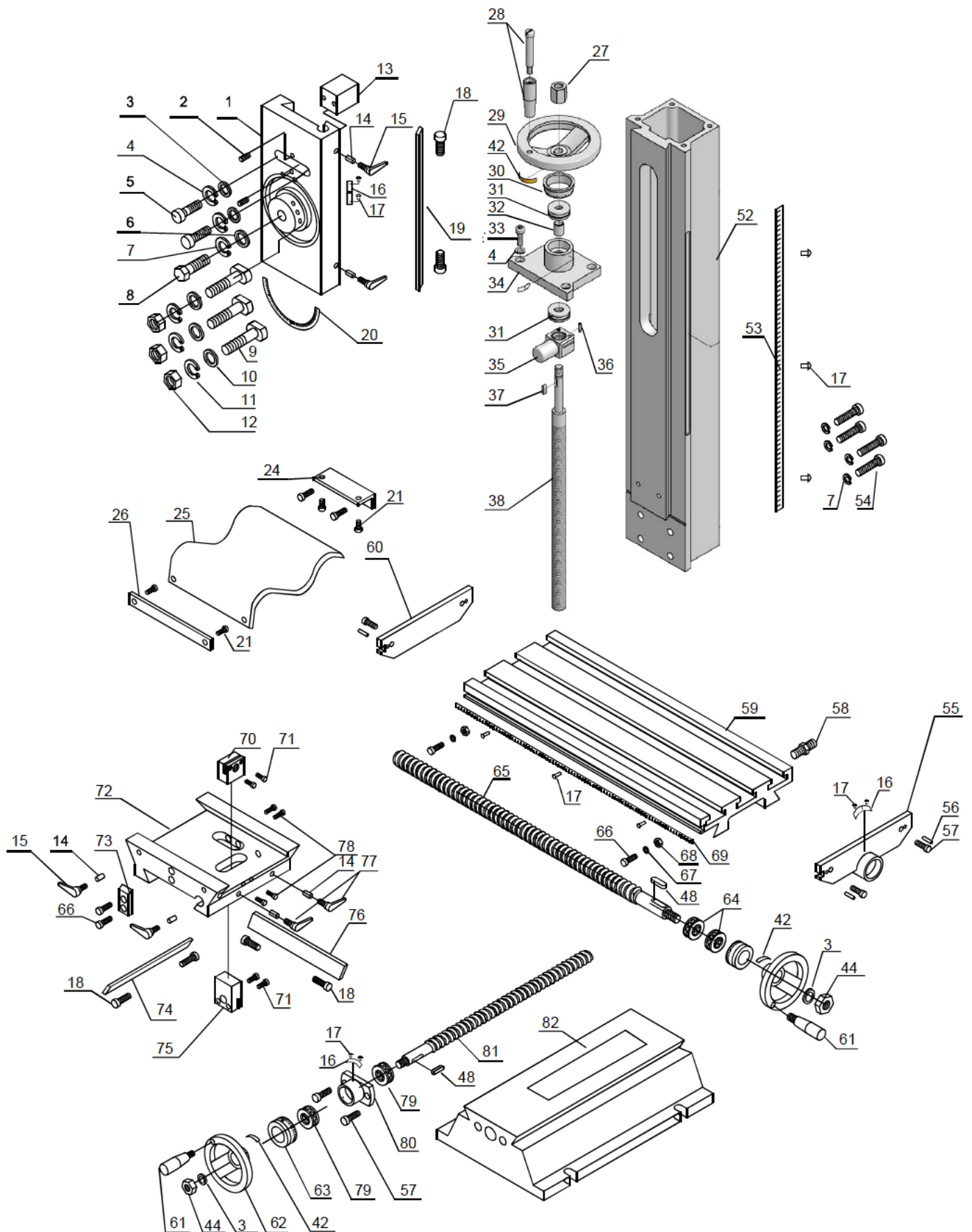
Parts No.	Description	Specification	Qty	Code NO.
201	Position Washer		1	30212101
202	Bush	Φ35 45#steel	1	30212102
203	Spring	2.5×Φ28×100	1	50670125
204	Snap Ring	Φ45	1	50640834
205	Bearing	6209-2RZ/Z2	1	50406209
206	Pulley		1	30212203
207	Bearing	6007/2RZ	1	50406007
208	Belt	3M-339	1	50668603
209	Bracket		1	30212204
210	Hex Head Cap Screw	M3×6	11	50611903b
211	Sensor		1	51809011
212	Magnetic Cylinder		1	30212205
213	Ring		1	30212108
214	Set Screw	M5×8	1	50618752a
228	Drawbar Cover		1	30213110
229	Motor Cover		1	30211111
230	Washer	Φ4	8	50635804
231	Hex Head Cap Screw	M4×8	7	50619041b
232	Hex Head Cap Screw	M6×16	6	50619062
233	Motor Plate		1	30211112
234	Motor	80BL-5550	1	38014431
235	Key	4×16	1	50644023
236	Pulley		1	30212206
237	Snap Ring	Φ10	1	50640808
238	Washer	Φ5	4	50637905
239	Hex Head Cap Screw	M5×12	5	50619052
240	Screw	M5x10	1	50615262
241	Mill Head		1	30211114

Parts No.	Description	Specification	Qty	Code NO.
242	Label		1	39211100
243	Label		1	39211000
244	Digital Scale		1	23070100
245	Hex Head Cap Screw	M4×50	2	50619049B
246	Base		1	30212115
247	Screw	M4×8	8	50615251
248	Bracket		1	30213116
249	Plate		1	30212117
250	Locking Lever	M8×20	1	50661066
251	Brass Pin		1	30212118
252	Knob		1	30212119
253	Set Screw	M5×6	1	50618850A
254	Spring Piece		2	50674004
255	Dial		1	30212120
256	Worm Shaft		1	30212121
257	Drawbar	7/16"	1	30212005
258	Retainer cup			
259				
261				
262	Sleeve		1	30211125
263	Rubber Ring	58×2.65	1	50650138
264	Adjusted Nut		1	30212126
265	Pin	A6×35	1	50642306
266	Pin	2×10	1	30213127
267	Handle		3	30213128
268	Handle Lever		3	30213129
269	Locking Knob	M8	1	30213130
270	Base		1	30212131
271	Dial		1	30212132

Parts No.	Description	Specification	Qty	Code NO.
272	Spring	1.2×Φ11×30	1	50670112
273	Hex Head Cap Screw	M4×10	3	50619042B
274	Flange		1	30212133
275	Washer	Φ25	1	30212134
276	Worm Gear	25T	1	30212135
277	Key	4×12	1	50644021
278	Gear Shaft		1	30212136
279	Block		1	30212137
280	Screw	M6×16		50618864A
294	Plate for Head		1	30211146

MILLING & DRILLING MACHINE

Column, Table, Base Assembly



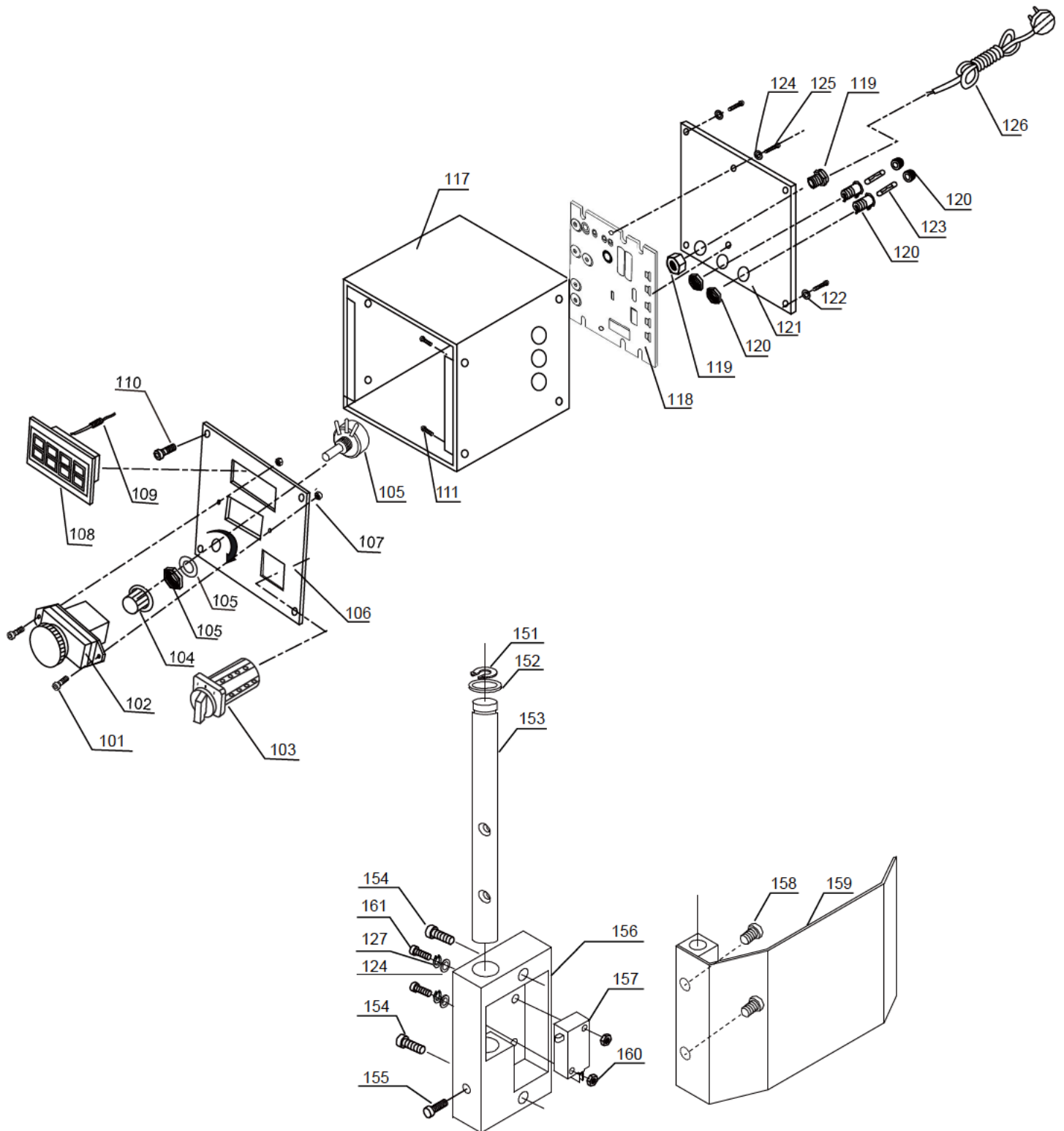
COLUMN, TABLE, BASE ASSEMBLY

Parts No.	Description	Specification	Qty	Code NO.
1	Vertical Slide		1	30211201
2	Screw	M6×16	2	50618864A
3	Washer	Φ8	6	50637908
4	Spring Washer	Φ8	6	50637808
5	Hex Head Cap Screw	M8×25	2	50619073
6	Washer	Φ12	1	30213202
7	Spring Washer	Φ12	5	50637812
8	Screw	M12×40	1	50612864
9	T-Bolt	M8×60	3	50611323
10	Washer	Φ8	3	30211203
11	Spring Washer	Φ8	3	50637808
12	Nut	M10	3	50630210
13	Block		1	30211204
14	Brass Pin	Φ5×10	6	30212206
15	Locking Lever	M6×16	4	50661063
16	Postion label		5	3L922001
17	Rivet	2×3	16	50626720
18	Gib Screw		6	30212207
19	Gib		1	30211208
20	Angle Indicate Label		1	30211903
21	Hex Head Cap Screw	M5×10	12	50619051B
22	Dust Cover	120×400mm	1	30212209
23	Nut	M5	2	50634805
24	Bracket		1	30211210
25	Dust Cover		1	30211211
26	Connect Plate		1	30211212
27	Nut			30211201
28	Handle	M6x50	1	30213223
29	Handwheel		1	30211202
30	Dial		1	30213214
31	Bearing	51203	1	50451203

Parts No.	Description	Specification	Qty	Code NO.
32	Steel Spacer Bush	SF-1B1015	1	30211203
33	Hex Head Cap Screw	M8×12	4	50619070b
34	Bracket		1	30211204
35	Nut	Φ5	4	50637905B
36	Hex Head Cap Screw	M4×12	2	50619043
37	Key	A 4×16	1	50644023
38	Vertical Leadscrew		1	30211205
52	Column		1	30211228
53	Label		1	30211904
54	Hex Head Cap Screw	M12×90	4	50619098A
55	Right Bracket		1	30211301
56	Pin	A6×16	4	50642300
57	Hex Head Cap Screw	M6×14	6	50619061
58	Pipe Fittings		1	30212302
59	Working Table	WMD20V	1	30211303
	Working Table(L)	WMD20LV	1	30211303L
60	Left Bracket		1	30211304

Parts No.	Description	Specification	Qty	Code NO.
61	Handle	M8×63	2	30213223
62	Handwheel		2	30213306
63	Dial		2	30212307
64	Bearing	51200	3	50451200
65	Longitudinal Leadscrew	WMD16V	1	30211308
	Longitudinal Leadscrew(L)	WMD16LV	1	30211308L
66	Hex Head Cap Screw	M6×10	4	50619058B
67	Bush	Φ15 45#steel	2	30212309
68	Nut		2	30212310
69	Scale		1	30211905
70	Longitudinal Nut		1	30211311
71	Adjusted Screw	M4×14	4	50619044
72	Cross Slide		1	30211312
73	Position Block		1	30211313
74	Cross Gib		1	30211314
75	Cross Nut		1	30211315
76	Longitudinal Gib		1	30211316
77	Locking Lever	M6×25	2	50661065
78	Hex Head Cap Screw	M6×25	4	50619064
79	Bearing	51100	2	50451100
80	Bearing Housing		1	30211317
81	Cross Leadscrew		1	30211318
82	Base		1	30211319

VM18L MILL ELECTRICAL BOX ASSEMBLY



ELECTRICAL BOX ASSEMBLY

Parts No.	Description	Specification	Qty	Code NO.
101	Hex Head Cap Screw	M4×10	2	50619042b
102	Magnetic Swich	KJD17GF 110V/60Hz	1	38055083
103	F/R Switch	ZH-DC-3-06 240~400V	1	38062053
104	Timing Knob		1	51820901
105	Potentiometer	WX14-12 4k7	1	51820047
106	Electrical Plate		1	30211910
107	Nut	M4	2	50630204b
108	Speed Display		1	38150001
109	Cable		1	38141002
110	Hex Head Cap Screw	M4×6	8	50619040b
111	Hex Head Cap Screw	M5×8	4	50619050b
117	Electrical Box		1	30211950
118	Speed Control Board		1	38080002
119	Strain Relief		1	38109101
120	Fuse Holder		2	38131520
121	Cover		1	30211951
122	Washer	Φ4	4	50637904b
123	Fuse	10A	2	38130020
124	Washer	Φ3	6	50637903b
125	Hex Head Cap Screw	M3×8	2	50619032b
126	Plug		1	38100131
127	Spring Washer	3	2	50637803b
151	Snap Ring	Φ12	1	50640810
152	Washer	Φ12	1	50637712
153	Rod		1	30213960
154	Hex Head Cap Srew	M5x16	2	50619053b
155	Set Screw	M5×10	1	50618852a
156	Bracket		1	30213961
157	Micro Switch		1	38060101
158	Screw	M4×10	2	50615253
159	Protective Cover		1	30213962
160	Nut	M3	6	50630203b
161	Hex Head Cap Screw	M3×18	6	50619036b

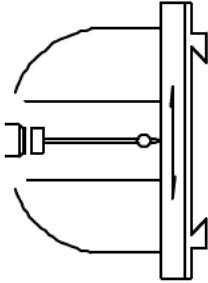
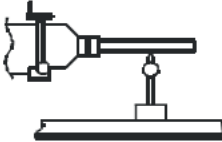
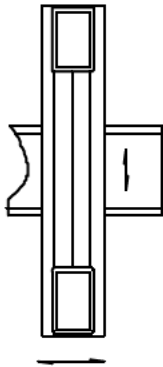
1. Visual Inspection	OK	4. Electrical Inspection	OK
a. Correct label	☐	a. CE electrical units	☐
b. Painting damage	☐	b. Function of source switch	☐
c. Corrosion damage	☐	c. High/low speed switch	☐
d. Screw tightened	☐	d. Emergency stop button	☐
2. Mechanical Inspection	OK	e. Function of power lighting	☐
a. Spindle up and down	☐	f. Function of forward button	☐
b. Spindle fine down feed	☐	g. Function of reverse button	☐
c. Mill head up and down	☐	h. Function of stop button	☐
d. Table move left and right	☐	i. Function of elevating switch	☐
e. Clearance of longitudinal leadscrew	☐	j. Function of tapping switch	☐
f. Saddle move front and back	☐	k. Function of safety cover	☐
g. Clearance of cross leadscrew	☐	l. Function of power feed	☐
h. Locks for spindle,table ,mill heac	☐	m.Function of motors	☐
g. Correct dials	☐	n. Function of SINO DOR	☐
3. Active Inspection	OK	5. Final Inspection	OK
a. Function of mill head	☐	a. Correct accessories	☐
b. Function of selecting speed levers	☐	b. Correct documents	☐
c. Running test	☐	c. Machine cleanness	☐
d. Noise test	☐	d. Credibility antitrust	☐
e. Leaky test	☐	e. Correct mark	☐
Remark:			

Test Record

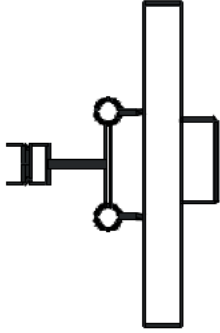
VM18L

Serial No.	
Date	
Inspector	

VM18L

NO.	INSPECTION ITEM	DIAGRAM	TOLERANCE(mm)	
			PERMISSIBLE	ACTUAL
1	Flatness of table		0.04/500	
2	Parallelism of T slot to table movement		0.05/500	
3	Parallelism of table to table movement a in longitudinal b in cross		a 0.025/200 b 0.025/200	
4	Runout of spindle hole a at spindle nose b 300 distance		a 0.01 b 0.02/150	
5	Squareness of table longitudinal and cross movement		0.025/200	

VM18L

NO.	INSPECTION ITEM	DIAGRAM	TOLERANCE(mm)	
			PERMISSIBLE	ACTUAL
6	Squareness of spindle axis to table a right & left b forward & backward		a 0.05/200 b 0.05/200	