



## MACHINING CENTER - HORIZONTAL & VERTICAL PREVENTATIVE MAINTENANCE REPORT

**Date:**

**Machine Type: MACHINING CENTER**

**Model and Control:**

**Serial Number:**

		Findings	Results
<b>Machine level</b>	<b>To be checked @ PM</b>		
X-Axis Plane			
Y-Axis Plane			
<b>Spindle runout</b>	<b>150mm from face</b>		
Check Spindle Orientation	<b>Visual</b>		
Check Spindle Nose Runout OD/FACE	<b>&lt;0.005mm</b>		
Check Spindle Taper Condition	<b>Visual</b>		
Check Tool Ejection Force or Stroke	<b>1677</b>		
Spindle Noise RUNOUT FACE	<b>Visual</b>		
Check Through The Spindle Seals			
Load @ Max R.P.M. 15000			
Geometry x-y			
Geometry x-z			
Geometry y-z			
<b>AMBIENT TEMP</b>			
<b>BEARING TEMP</b>			
<b>A.T.C.</b>			
Visually Check All Home Positions	<b>Visual</b>		
Visually Check Arm Grippers	<b>Visual</b>		
Visually Check All Tool Pots for Wear	<b>Visual</b>		
Visually Check Pull Studs	<b>Visual</b>		
Visually Check ATC Alignments	<b>Visual</b>		
<b>Axes</b>			
X Axes Backlash	<b>Record Value</b>		
Y Axes Backlash	<b>Record Value</b>		
Z Axes Backlash	<b>Record Value</b>		
B Axes Backlash Machine	<b>Record Value</b>		
Additional Axes Backlash	<b>Record Value</b>		



Findings

Results

		Findings	Results
<b>Hydraulics</b>			
Change the Return Filter			
Change the Hydraulic Fluids			
Check for Fluid Leaks			
<b>Spindle Cooler</b>			
Change the Fluids			
Clean the Suction Filter on Bottom of Pump			
Check the Cooling Control Settings	0*		
<b>Covers</b>			
Check All Wiper Conditions	Visual		
<b>Check all sliding covers</b>			
<b>A.P.C.</b>			
Check All Pallet Shifter Positions	Visual		
Check All Pallet Positions	Visual		
Check Pallet Parallelism			
<b>Electrics</b>			
Primary Incoming Voltage	208 +/- 10%		
Check Operation Heat Exchanger Fans			
Check MPS and Drive Fans for Operation	Visual		
Check Grounding of Machine	Visual		
Check Seals of OSP & CRT Cabinet	Visual		
Check the CRT Key Panel			
Check the Operation of the E-Stop			
Check Operation of the Light Tower			
<b>MAIN DOOR INTERLOCK</b>			
<b>MAG DOOR INTERLOCK</b>			
<b>COOLANT</b>			
<b>Clean Screens</b>			
<b>Around Spindle Flow</b>			
<b>Chip Wash Flow</b>			
<b>Lubrication</b>			
Grease X Y & Z Axis Linear Guides			
Remove excess Grease from Way Wipers			
Grease All Chains			
Grease ATC Cam Box			

