

# A.M. Calendar

# IPS Bore Gage Machine, Op. 68

# SHIFT

Activity	Description	C, I, or L	Duration (mins)	Shift	Loc.	Status	Oct-11																														
							1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31
Machine	Verify guards and interlocks are in place and properly secured.	S-1	2		All	Up	1-31																														
Machine	Verify that all E-Stop pushbuttons operate properly.	S-2	2		All	Up	1-31																														
Fixture	Visually inspect the collusion protection sleeves for damage.	I-1	1		Inside	Down	1-31																														
Fixture	Visually inspect the part rest buttons, locators, and pins for damage and/or missing details.	I-2	2		Inside	Down	1-31																														
Fixture	Clean all sensors and proximity switches (with damp cloth, then wipe with lint-free rag).	C-1	2		Inside	Down	1-31																														
Machine	Inspect all sensors and proximity switches for loose or damaged connections.	I-3	3		Inside	Down	1-31																														
Pneumatic	Check all hoses lines, fittings, cables and pneumatic elements for correct fit (also verify that hoses are properly secured). (Quarterly)	I-4	3		All	Down	1-31																														
Pneumatic	Visually inspect the filter/regulator (set to 60 psi (.41 MPa)).	I-5	2		Outside	Up	1-31																														
MCP	Clean the MCP power monitor screen with a clean dry cloth. DO NOT USE DETERGENTS. THE CLOTH MUST BE DRY, NO LIQUIDS.	C-2	2		Outside	Up	1-31																														
Machine	Clean the HMI and Dynics screens with a damp clean cloth and dishwashing liquid or foaming screen cleaning agent. Switch off or Lock the HMI before cleaning!	C-3	2		Outside	Down	1-31																														
Fixture	Visually inspect the IPS axis slide unit to make sure there are no pits or damage, as well as a film of lubrication exists on the rails.	I-6	2		Inside	Down	1-31																														
MCP	Clean the Hoffman filter using warm water and a mild detergent (monthly).	C-4	5		Inside	Down	1-31																														
Fixture	Clean the through-beam sensors with a clean lint-free cloth. Do not use any solvents or cleaning agents which could damage the plastic lens.	C-5	2		Outside	Down	1-31																														
Fixture	Visually inspect shock absorbers while machine is running, making sure there is not a hard hit.	I-7	2		Inside	Up	1-31																														
Fixture	Visually inspect the index drive for damage and remove any deposits of dust. Also inspect electrical cables for damage (semi-annually).	I-8	3		Inside	Down	1-31																														
Fixture	Inspect the index drive for play in the dwell position (semi-annually).	I-9	3		Inside	Down	1-31																														
Fixture	Visually inspect the SEW gearmotor for proper oil level.	L-1	2		Inside	Down	1, 8, 15, 22, 29																														
Fixture	Visually inspect the belt for wear and/or damage.	I-10	2		Inside	Down	1, 8, 15, 22, 29																														
Fixture	Inspect the belt for proper tension by pressing your thumb on the belt. There should only be a 1-2mm deflection when the belt is pressed (quarterly).	I-11	2		Inside	Down	1, 8, 15, 22, 29																														
Fixture	Check the tightness of all the fastening bolts (inspect the match marks) and tighten if necessary (semi-annually).	I-12	10		Inside	Down	1, 8, 15, 22, 29																														
Machine	While the machine is running, listen for any unusual noise, such as worn bearings or slides not being lubricated.	I-13	5		Outside	Up	1, 8, 15, 22, 29																														
Fixture	Lubricate the linear bushings or shaft with lithium-soap group grease No.2 (quarterly).	L-2	5		Inside	Down	1, 8, 15, 22, 29																														
Fixture	Clean linear rails with a clean soft rag (semi-annually).	I-14	5		Inside	Down	1, 8, 15, 22, 29																														
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NOTES / SUGGESTIONS:

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