

A.M. Calendar

Inline Crankshaft Gage, Op. 118

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	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 that all E-Stop pushbuttons operate properly.	S-2	2		All	Up	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
Fixture	Visually inspect measuring pieces, and if necessary, clean them.	C-1	3		Inside	Down	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
Fixture	Clean the setting masters.	C-2	2		Inside	Down	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	Clean all sensors and proximity switches (with damp cloth, then wipe with lint-free rag).	C-3	3		Inside	Down	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	Inspect all sensors and proximity switches for loose or damaged connections.	I-1	3		Inside	Down	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
Pneumatic	Check all hoses lines, fittings, cables and pneumatic elements for correct fit (also verify that hoses are properly secured). (Quarterly)	I-2	3		All	Down	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
Pneumatic	Visually inspect the filter/regulator (set to 60 psi (.41 MPa).	I-3	2		Outside	Up	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
Pneumatic	Visually inspect the precision regulators (set to 35 psi (.24 MPa).	I-4	3		Outside	Up	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	Clean the HMI and Dynics screens with a lint-free cloth.	C-4	1		Outside	Up	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
Fixture	Visually inspect the SKF lubrication unit to ensure that the oil level is between the minimum and maximum markers.	L-1	2		Inside	Down	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
Fixture	Visually inspect the gear motor oil level and top off if necessary.	L-2	2		Inside	Down	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	Wipe down exterior machine of prints and streaks.	C-5	5		Outside	Up	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
Fixture	Visually inspect shock absorbers while machine is running, making sure there is not a hard hit.	I-5	2		Inside	Up	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
Fixture	Visually inspect slide horizontal and vertical slide units, making sure there are no pits or damage, as well as a film of lubrication exists.	I-6	3		Inside	Down	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
Fixture	Visually inspect the synchronous belt for any wear, cuts, missing teeth or other damage as well as looseness. (Yearly)	I-7	2		Inside	Down	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
Fixture	Visually inspect the gripper jaws for any broken, worn, or missing details.	I-8	2		Inside	Down	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
Fixture	Visually inspect prism and prism covers for wear or damage, and verify that both springs exist and are not worn. Clean surface with a soft rag.	I-9	2		Inside	Down	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
Fixture	Visually inspect the head and tailstock for excessive wear, damage, looseness or missing details.	I-10	2		Inside	Down	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
Fixture	Inspect all pneumatic cylinders for misalignment, and coupling damage.	I-11	3		Inside	Down	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	While the machine is running, listen for any unusual noise, such as worn bearings or slides not being lubricated.	I-12	5		Outside	Up	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
Fixture	Clean the sampling points on the measuring element with a small clean brush. Ethanol can be used as a detergent.	C-6	5		Inside	Down	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
Fixture	Visually inspect the contact pins and locators on the measuring gantry setup and make sure they are not loose or damage.	I-13	2		Inside	Down	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
Fixture	Visually inspect the curve rollers for uniformity and wear traces (matte surface). Check all key sets and measuring pieces for wear. (Semi-Annually)	I-14	4		Inside	Down	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
Pneumatic	Visually inspect the advance Heidenhain probes precision regulator (set to 26 psi (.18 MPa).	I-15	3		Outside	Up	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
Fixture	Clean linear rails at the swivel bearing with a clean soft rag. (Semi-Annually)	C-7	4		Inside	Down	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
Fixture	Clean linear rails at the headstock and tailstock with a clean soft rag. (Semi-Annually)	C-8	8		Inside	Down	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

NOTES / SUGGESTIONS:
