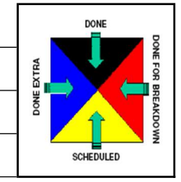
A.M. Calendar

Inline Crankshaft Gage, Op. 178

SHIFT

Activity	Description	C, I, or L	Duration (mins)	Shift	Loc.	Status
Machine	Verify guards and interlocks are in place and properly secured.	**S-1**	2		All	Up
Machine	Verify that all E-Stop pushbuttons operate properly.	**S-2**	2		All	Up
Fixture	Visually inspect measuring pieces, and if necessary, clean them.	**C-1**	3		Inside	Down
Fixture	Clean the setting masters.	**C-2**	2		Inside	Down
Machine	Clean all sensors and proximity switches (with damp cloth, then wipe with lint-free rag).	**C-3**	3		Inside	Down
Machine	Inspect all sensors and proximity switches for loose or damaged connections.	**I-1**	3		Inside	Down
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
Pneumatic	Visually inspect the filter/regulator (set to 60 psi (.41 MPa).	**I-3**	2		Outside	Up
Pneumatic	Visually inspect the precision regulators (set to 35 psi (.24 MPa).	**I-4**	3		Outside	Up
Machine	Clean the HMI and Dynics screens with a lint-free cloth.	**C-4**	1		Outside	Up
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
Fixture	Visually inspect the gear motor oil level and top off if necessary.	**L-2**	2		Inside	Down
Machine	Wipe down exterior machine of prints and streaks.	**C-5**	5		Outside	Up
Fixture	Visually inspect shock absorbers while machine is running, making sure there is not a hard hit.	**I-5**	2		Inside	Up
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
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
Fixture	Visually inspect the gripper jaws for any broken, worn, or missing details.	**I-8**	2		Inside	Down
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
Fixture	Visually inspect the head and tailstock for excessive wear, damage, looseness or missing details.	**I-10**	2		Inside	Down
Fixture	Inspect all pneumatic cylinders for misalignment, and coupling damage.	**I-11**	3		Inside	Down
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
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
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
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
Pneumatic	Visually inspect the advance Heidenhain probes precision regulator (set to 26 psi (.18 MPa).	**I-15**	3		Outside	Up
Laser	Clean and inspect the F-Theta lens using compressed air.	**C-7**	5		Inside	Down
Laser	Clean the cover of the laser marking head with a lint-free cloth and a mild detergent. (Monthly)	**C-8**	5		Inside	Down
Laser	Inspect the fume extraction system hoses and filters and replace if necessary.	**I-16**	3		Inside	Down
Laser	Inspect all fiber and external cables for damage, looseness, or kinks and repair if necessary. (Yearly)	**I-17**	3		Outside	Down
Fixture	Clean linear rails at the swivel bearing with a clean soft rag. (Semi-Annually)	**C-9**	4		Inside	Down
Fixture	Clean linear rails at the headstock and tailstock with a clean soft rag. (Semi-Annually)	**C-10**	8		Inside	Down

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

NOTES / SUGGESTIONS: