

## Preventive Cum Predictive Maintenance Checksheet of CNC M/c

Doc. No. :

Rev. No. :

Done Date :-

S. No.	POINTS TO BE CHECKED	CATEGORY	METHOD	STANDARD	STATUS BEFORE PM	STATUS AFTER PM	REMARKS
1	To clean machine & control panel & servo voltage stabliser	Q	with air	should be cleaned			
2	To check all indication lamp are working properly.	Q	visual	working condition			
3	To check any leakage (Oil, Air & Coolant) in machine.	Q	visual	no any leakage			
4	To check Hyd. & Lube oil level. If reqd. top up.	Q	visual	level indictor high			
5	To check functioning of all limit switches & proximity sensors.	Q	operate	working condition			
6	To check servo motors encoder & power cable connected properly.	Q	manual	should be tight			
7	To check functioning of Tail stock.	Q	operate	working condition			
8	To check functioning of chuck cylinder.	Q	operate	working condition			
9	To check all hydraulic system working properly	Q	operate	hyd pres.>20kg/cm2			
10	To clean heat exchanger cooling fan.	Q	with air	should be cleaned			
11	To check condition of spindle driving & encoder timing belt. If reqd. replace them.	Q	visual	good condition			
12	To check working condition & clean spindle motor fan.	Q	with air	should be clean & working			
13	To check condition of Turret if any noise bearing should be replace	Q	hearing	no any noise			
14	to check turret motor & encoder wire shoul be tight	Q	screw driver	should be tight			
15	To clean all motor cooling fan & covers.	Q	manual	should be cleaned			
16	To check earthing of Machine.	Q	multimeter	less then 2volt			
17	To check LM guideways & grease them.	Q	manual	should be lubricated			
18	To check all contactor & plug in relay conditions. If reqd. change or clean contacts.	H	operate	working condition			
19	To check condition of Ball Screw & its bearing. If reqd. Grease or replace them.	H	manual	should be lubricated			
20	To check functioing of Voltmeter, Ammeter & Pressure gauge. If reqd calibrate or replace them.	Y	visual	working condition			
21	To check axis repeatability.	Y	daile	should be < 0.020			
22	To clean Hyd. Tank & check its oil condition. If reqd. replace Hyd. Oil.	Y	manual	oil condition good			
23	To check condition of all motor bearings. If reqd. grease or rplace them.	Y	hearing	no any noise			
24	To clean cabinet cooling fan & drive fans.	Y	manual	should be cleaned			
<b>Checked By :-</b>					<b>Done By :-</b>		

Q :-QUARTERLY    H :-HALF YEARLY    Y :- YEARLY

NOTE : CHECK FOR NORMAL WORKING OF MACHINE AFTER PREVENTIVE MAINTENANCE