

**PREVENTATIVE MAINTENANCE
MILLS 24-POINT INSPECTION**

SERVICE DATE: _____ / _____ / _____	SUPPORT TICKET #: _____
COMPANY: _____	CUSTOMER #: _____
SERIAL #: _____	MODEL: _____

Complete form by placing a checkmark in the boxes as task are completed.

- 1** Update software when applicable. Verify error logging is turned on (code 319) for SMX, KMX and RMX.
- 2** Tram the head. Record values: **Side to side** **Front to back**
- 3** a) Check TRAK Sensors and M5 Bases. Replace wiper pads and chip scrapers. Check mounting of brackets.
b) Check Glass Scales and Reader Head mounting.
- 4** Lubricate head, add oil and grease. Fill lube pump and inspect lubrication system.
- 5** Check alignment of Z-axis (only 3-axis knee mill or retrofit)
- 6** Run spindle through the Low, Neutral, and High gear ranges. Note any issues below. (Excludes retrofit) Check functionality of spindle fan and brake resistor fans (RMX).
- 7** If programmable spindle control, inspect and adjust spindle belt.
- 8** Check spindle brakes. **Spindle stop?** Yes No
- 9** Check and adjust level of machine, unless retrofit.
- 10** Adjust all gibs (including knee)
- 11** Adjust and inspect axis servo motor belts and drive train assemblies. Use belt tension tool on RMX.
- 12** Run Service Codes 11, 12, 128, 100, 101, 102, 103. Make adjustments as needed.
- 13** Calibrate X, Y and Z (quill) axis. Calibrate ram and check backlash.
- 14** Record positioning accuracy : **X:** **Y:** **Z:**
- 15** Record uni-directional repeatability: **X:** **Y:** **Z:**
- 16** Record bi-directional repeatability: **X:** **Y:** **Z:**
- 17** Check all cables and cable connections. All cables should be neat and securely tied. Inspect cables inside electrical cabinet, tighten if needed for RMX.
- 18** Check if emergency stop button disables the control.
- 19** Check functionality of auxiliary functions when applicable.
- 20** Inspect X, Y, and Z limit switches. Set to full travel.
- 21** Jog the X, Y and Z-axis and listen for any unusual noises.
- 22** Inspect Electronic Handwheels. Clean friction pucks as needed.
- 23** Replace pendant fan filter (N/A on RMX).
- 24** Wipe machine down. Clean touchscreen on RMX.

List potential problems, observations, or recommendations:

TECHNICIAN

NEXT MAINTENANCE DATE