

**PREVENTATIVE MAINTENANCE
 TRAK 20P 23-POINT INSPECTION**

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

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

- 1** Clean beneath way covers; X, Y, and Z axes. Check home switches.
- 2** Clean around ATC and inspect sensors. Ensure sensors that tell the control if the ATC is in or out are tightened.
- 3** Check ATC cylinder in-and-out time and check door to ensure it's functioning properly
- 4** Clean the fine filter coolant screen.
- 5** Update software when applicable.
- 6** Verify that error log is turned on, service code 319.
- 7** Check tram and adjust as required.
- 8** Check servo motor axis belt tensions and adjust as necessary. Inspect belts.
- 9** Inspect the lubrication system and fill, if necessary. Lubricate grease fittings on the ATC linear guides
- 10** Ensure rolling torque on X & Y axis is < 8 in-lbs. Check torque in 3 places along ballscrew to ensure alignment is ok
- 11** Double check all motor index angles in service code 505 (Index angles must be checked in the positive direction)
- 12** Check ball lock location and reset as necessary using code 500.
Record previous values and new values: _____
- 13** Check tool change height using service code 520 and check ATC locations and alignment.
- 14** Check calibration and adjust backlash as necessary.
- 15** Record positional accuracy: X _____ Y: _____ Z: _____
- 16** Record uni-directional repeatability: X _____ Y: _____ Z: _____
- 17** Record bi-directional repeatability: X _____ Y: _____ Z: _____
- 18** Check oil level cup on the tool clamp cylinder.
- 19** Spindle head test:
 1) Run spindle at 1000 RPM for 5 minutes.
 2) Run spindle at 6000 RPM for 5 minutes. Make sure the spindle brakes properly from 6000 RPM. It should stop in 6 seconds or less.
 3) Run spindle at 500 RPM increments for a few seconds per increment. Note any head noise, excessive heat on spindle, vibration, or spindle fan noise.
- 20** Replace filters on the electrical cabinet and servo cabinet.
- 21** Inspect wires in the electrical cabinet and tighten as needed.
- 22** Check that emergency stop button disables the spindle and control.
- 23** Verify the door opens and closes with a minimal amount of force and moves smoothly. Make sure the door fully closes under its own weight and that hardware that holds door rollers is tight.

List potential problems, observations, or recommendations:

TECHNICIAN

NEXT MAINTENANCE DATE