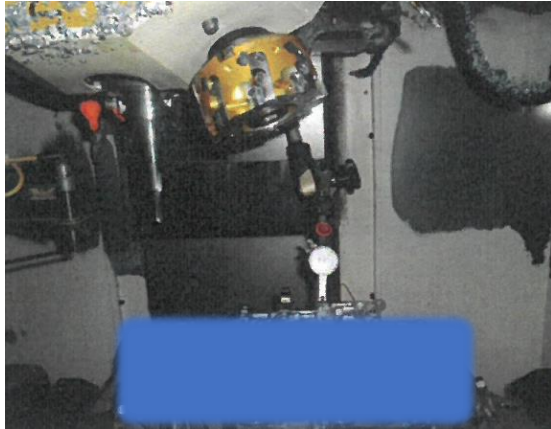


No.	0010-24
job classification	periodic inspection
target machine	Tapping machine

SHIOZAWA NEWS

Manufacturer	FANUC
Model	Robo-Drill
Task	Accuracy Inspection and Preventive Maintenance

【 Overview of repair machines 】



【Check the fixture of the tapping center】

Inspection report for Robo-drill		Line		Process		Factory name		Serial No.	

LM-guide & brock layout drawing

No.	Inspection point	Inspection item	Procedure/Device	Criterion	Result	Comments	Probable cause
1	X-axis in general	cutting chips	Visual observation	No chips	○	Invasion of cutting chips	Chips getting in clearance on side
2	X-axis LM rail	Recovery surface	Visual/Palpator	No removing, No steps	○		
3	X-axis LM rail	Gap	Visual/Palpator	No removing, No steps	○		
4	X-axis LM block	Lubrication	Visual/Palpator	Lubricating	○		
5	X-axis LM block	Condition of Block	Visual	No heat of shelling, No swelling	○		
6	X-axis ball screw	Backlash	1p-dial gauge	Less than 5μ	1μ ○		
7	X-axis ball screw	Noise	Auscultation	No noise	○		
8	X-axis side cover	Damage, Deformation	Visual	No heat of shelling, No swelling	○		
9	X-axis in general	cutting chips	Visual observation	No chips	○	Invasion of cutting chips	Chips getting in clearance on side
10	Y-axis LM rail	Recovery surface	Visual/Palpator	No removing, No steps	○	Rust on sideways, Scratch on the face	
11	Y-axis LM rail	Gap	Visual/Palpator	No removing, No steps	○		
12	X-axis LM block	Lubrication	Visual/Palpator	Lubricating	○		
13	X-axis LM block	Condition of Block	Visual	No heat of shelling, No swelling	○		
14	X-axis ball screw	Backlash	1p-dial gauge	Less than 5μ	3μ ○		
15	X-axis ball screw	Noise	Auscultation	No noise	○		
16	X-axis side cover	Damage, Deformation	Visual	No heat of shelling, No swelling	○		

【Preparation of inspection report】

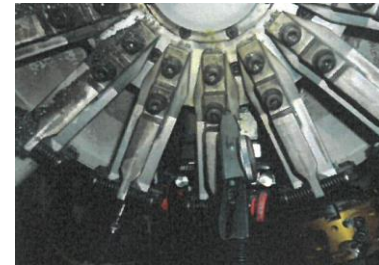
【 Key points of the exchange operation : Inspects the accuracy of each axis, spindle, and ATC jig. 】



【Check Z-axis backlash】



【Thrust and radial runout of spindle】



【Check for play of magazine】

【 Implementation details and approximate man-hours 】

- ◆ Runout and wear of the spindle, ATC, jigs, etc. are also checked.
- ◆ After the inspection, we summarize the results in an inspection report and report the results to the customer.
- ◆ If the customer has the necessary replacement parts in stock, we will immediately perform the work. If not, we will wait for the customer to receive the parts and perform the replacement work.

If it is a line facility and only periodic inspections are required ;

works: 3 units/ day

【 Overview of periodic inspection works 】

01

In the case of preventive maintenance, multiple units are checked at the same time by a group because of the line.

02

Normally, machine diagnostics proceed at a rate of 3 machines/day.

3 units/day

03

Possibly add a check for clamping force (clamp measuring device needed)

04

If a B-axis is installed, repair of the B-axis is left to the manufacturer in principle.