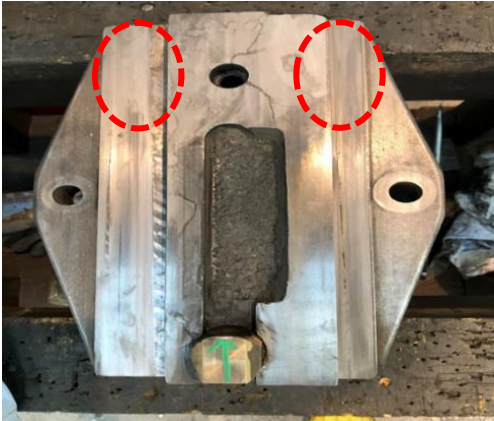


No.	004-24
job classification	Repairs & OH
target machine	Engine Lathe

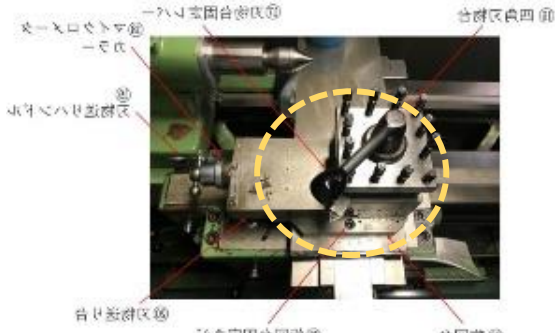
SHIOZAWA NEWS

Manufacturer	HAKUSAN KOUSAKUSYO
Model	
Task	Repair & overhaul of turret

【 Overview of repair machines 】



【 There is a 0.3 mm steps on the swivel of the swivel base of the turret section. 】



【 Overall view of turret section 】

【 Key points of the exchange operation : If the wear is so excessive that it cannot be corrected by the kisage (Scraping) process, a grind process can be performed. 】



【 Correction of steps by grinding 】



【 Wear condition of the tool post feed table section 】



【 Scraping of the feed table slide section 】

【 Implementation details and approximate man-hours 】

- ◆ Additional machining (grinding) is also available.
- ◆ The overall accuracy is checked, and the surface is scraped to ensure that it is in a state of accuracy.

Man-hours for grinding process and repair when parts are available. ;



【 Overview of maintenance works 】

Preliminary inspection and preparation

- ◆ Replacement of parts such as feed screws requires confirmation of the supply system on the part of the manufacturer
- ◆ Gibs can be manufactured in-house, but delivery time depends on the availability of drawings.

works

- ◆ Grinding process can be done in 0.5 days if the schedule can be arranged.
- ◆ If the grinding process can be done in 0.5 days, 2 days are required, including the grinding process.

Factors causing additional items

- ◆ If turcite is affixed to the gib, a separate delivery date is required. An additional 3 days is required to make a turcite-attached gib.
- ◆ If there are no drawings of the gib, delivery time will be required to measure and create the gib from the actual one.