

Machine / Device		CNC Machine (Asset #256-05)				
Task	Frequency	Description of maintenance task			Estimated Time (Minutes):-	
Process	Key	Standard	Specification	Tools / Materials	Note Condition / Corrective Action	Complete
Check the hydraulic pressure	D	4,500Psi	4" ±2%	Pressure gauge	Measured pressure at 4.54 Mpa	<input checked="" type="checkbox"/> Complete
Check hydraulic fluid levels	D	To optimum level mark	between min and max levels	Visual	Checked all hydraulic fluid levels and all OK	<input checked="" type="checkbox"/> Complete
Make sure cool fluid levels are at the correct levels	D	To optimum level mark	between min and max levels	Visual	Cooling fluid level was low, added more fluid topping up to correct levels	<input checked="" type="checkbox"/> Complete
Clean out all chips and swarf	D	Ensure machine is clear from chips and swarf	no chips or swarf	Brush, vacuum system, compressed air gun	Machine totally cleared out	<input checked="" type="checkbox"/> Complete
Clean filters on coolant tank	M	Clean with compressed air and clean water	No dirt or/oil filter	Brush, vacuum system, compressed air gun	Checked and cleaned coolant filter - Filter clean (NOTE, may need changing on next schedule)	<input checked="" type="checkbox"/> Complete
Check and add grease to chip conveyor chain	M	Apply grease to chain	Machine specified grease	Grease gun	Checked, cleaned and applied new grease to chain	<input checked="" type="checkbox"/> Complete
Clean coolant tank of sludge, chips, and oil	1h	Brush, clean, check	Brush, clean, check, refill	Jetifier pump, cleaning materials	Tank completely drained and cleaned, checked for damage and leak points, all OK, refilled to correct level	<input checked="" type="checkbox"/> Complete
Remove chain pins, clean, check for damage	1h	No damage or play on pins or chain	Max 0.002" total play	Cleaning materials, compressed air, oil	No damage or loose pins on pins. Total float or movement was less than 0.002"	<input checked="" type="checkbox"/> Complete

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DHEW Publication ,1979 **Maintenance Engineering Techniques** United States. Army Materiel Command,1975

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