

## Cast 4 Aluminium Pvt Ltd

DOC NO-F/PRD/34 REV No/ DATE.-01 11.10.2023

## Firm Std for JH (Cleaning, Lubrication, Inspection, Retightening)

	Shop- Mach		Machine:- CNC Turning								Machine No							Month-																									
	Breakd	4	<b>▲</b> Defect •							Accident						)																											
Sr.No	Sub assembly ( Front side)	Part Name	Action		RT	- Check For	Fre	Required condition (Standard)	Tools/Metho	d Leads T	o Resp	Action (If Not Ok)	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	Dates	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31
1	Lubrication Level	Lubrication Tank		+	-	Oil level	D	As mark Level		<b>A</b>	OPF	Adjust it in mark																															
2	System Pressure	System Pressure gauge		+		30 to 40 Kg/Cm2	W	/ As mark Level	(C)	•	OPF	Adjust it in mark																															
3	Clamping Pressure	Pressure gauge		+		6 to 10 Kg/Cm2	D	As mark Level		•	OPF	Adjust it in mark	:																														
4	Hydrolic oil level	Hydrolic tank		+		Oil level	D	As mark Level		<b>A</b> •	OPF	Adjust it in mark	:																														
5	Motor spindle	Spindle motor body	+	+		Noise	D	Noise free	@	<b>A</b> •	OPF	Inform to PM																															
6	Coolant Level	Coolent tank		+		Coolent leve	1 0	As mark Level		•	OPF	Adjust it in mark level																															
7	Turret assembly	Mounting bolt/ Turret body	+		+	Tightning/Cle aning	e c	No dirt/No loose	No.	<b>A</b> •	OPF	Clean it																															
8	Free from burr	Machine area/body	+			Cleaning	D	Free from burr	N.	•	OPF	Clean it																															
9	Belt tightning	V belt/ Timining Belt		+		Tightning	W	/ No loose	A Sulp	<b>A</b> •	OPF	Inform to PM																															
10	Leakages	Piston leakages		+		Free from leakage	D	No leakage		•	OPF	Inform to PM																															
11	Pannel Working	Switches	+			Working	W	/ Push	Sy	•	OPF	Inform to PM																															
12	Communication signals	Limit Switches			+	Tightning	D	No loose/ Push operate	5	<b>A</b> •	OPF	Inform to PM																															
13	Chuck/Fixture	Chuck /fixture	+-			Tightning/Cle aning	e c	Greesing/ Free from dirt	- M	<b>^•</b>	OPF	Clean it																															
14	Insert Tightness	Tool			+	Tightning	D	No loose inert	- M	•	OPF	Tighten it.																															
15	Jaw Thickness	Vernier		+		Wear	D	2.5 mm Min	- Nh	<b>A</b> •	SUP	Replace it																															
Operator Sign													-						_	_	_						_	_							<u> </u>		Ш		$\sqcup$	$\vdash$	Щ		╀
Superwiser Sign																																			<u>L</u>								<u> </u>