JH Checksheet for CNC Machine

M/C NO		F/MTN/01
		Rev. 04
		Rev.Date 02.06.24

Sr. No.	Part	Standard	Method		Responsibilty	Ferq.	Month :-June -24																														
							1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31
Cleaning																																					
1	**Machine cleaning**	No Scale/Dust		Visual	Operator	D																															
2	**Oil & Coolant leakege**	No Leakage		Visual	Operator	D																															
3	**Machine Area cleaning**	Burr oil & other		Visual	Operator	D																															
Lubrication																																					
1	**Hy. Oil Level**	Arbian 68		By Oil Cane	Superviser	W																															
2	**Lubrication oil level**	as per mark		Visual	Operator	D																															
3	**Turret Oil level**	as per mark		Visual	Superviser	M																															
4	**Cutting oil level**	3% to 5%	microscop	Visual	Superviser	D																															
Inspection																																					
1	**All Hoses pipe condition**	No Leakage		Visual	Superviser	D																															
2	**All Inserts & Mounting Bolts**	No Damage & Brakage		Visual	Superviser	D																															
2	**All Inserts Clamping nut to be change every after 10 Nos.**	No Damage & Brakage		Visual	Superviser	D																															
3	**Hy. Pressure**	28 to 30 Bar		Visual	Superviser	D																															
4	**Lubrication pressure**	Green mark		Visual	Operator	D																															
5	**clamping. Pressure**	16 to 20 Bar		Visual	Superviser	D																															
6	**Coolant Flow**	Maximum		Visual	Operator	D																															
6	**CNC Stopper Condition Monitering**	Maximum		Visual	Superviser	M																															
Tighting																																					
1	**Collet Housing Condition/ stopper bolt**	Should be Tight		Allen Key (5 mm)	Superviser	D																															
2	**Door Sensor**	Should be Tight		Allen Key (4 mm)	Superviser	D																															
3	**All Sefety Guards**	Should be Tight		Allen Key (4,5 & 6 mm)	Superviser	D																															
4	**Chek Bes jow condition**	Should be Tight		Allen Key (4,5 & 6 mm)	Superviser	D																															
5	**All Electrical part condition**	Should be Tight		Allen Key (4,5 & 6 mm)	Superviser	W																															
6	**foot swich condition**	Should be Tight		Allen Key (2.5.T10 & 4 mm)	Operator	D																															
7	**All fillter cleaning**	Should be Clean		Visual	Superviser	M																															
8	**Insert tightening nut**	Should be Tight		Allen Key (T15 & 5, 6 mm)	Superviser	10																															
10	**Chek cleaning & gresing**	Smooth	Disel & gresing	Visual	Superviser	M																															
Approved by																																					

D- Daily Once, W – Weekly , M – Monthly

Done - **Not Done -**

Special Observation if any :-

#After : Check Point Added for the CNC Stopper Condition Monitering

Accrete electromech Pvt Ltd	ONE POINT LESSON			Sr. NO: 04
PILLAR: EDUCATION & TRAINING				
TITLE: CNC stooper wear out			DATE: 08.06.2024	Area: CNC
BASIC KNOWLEDGE	IMPROVEMENT CASE	TROUBLE CASE	PREPARED BY: Mr. Dethe Shashikant s	APPROVED BY: Mr. Bharat D

BEFORE

Before: CNC stopper in wear out Conditon

AFTER

After : Stopper Replacement done with New one