

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	47-2psi	Pressure gauge	Measured pressure at 4.5k Mpa	<input checked="" type="checkbox"/> Complete
Check hydraulic fluid levels	D	To optimum level mark	between max and min 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 max and min 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	Remove machine's rear from chips and swarf	no chips or swarf	Brush, vacuum system, compressed air gun	Machine totally cleaned out	<input checked="" type="checkbox"/> Complete
Clean filter on coolant tank	M	Clean with compressed air and clean water	no dirt inside filter	Brush, vacuum system, compressed air gun	Checked and cleaned coolant filter - filter clean (NOTE, may need changing in 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	W	Brush, clean, check	Brush, clean, check, refill	hvac fan 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	W	No damage or play in pins or chain	Max 0.002" total play	Cleaning materials, compressed air, oil	No damage or loose pins or pins. Total float or movement was less than 0.002"	<input checked="" type="checkbox"/> Complete

# Example Of Preventive Maintenance Program

**J Rink**



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web fig 14 a piano makers bow drill the bow without the drill would be difficult to identify wear marks if a tool shows signs of wear marks either from the material being worked or from the hands using the tool this is another aid in showing how a tool was used and therefore another clue to what it is fig 15 a file cutter s hammer

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