

CHARMILLES TECHNOLOGIES

ROBOFORM PREVENTIVE MAINTENANCE LOG

WEEKLY MAINTENANCE																																																				SURFACE FINISH				AUXILIARY FUNCTIONS			
Dielectric Filters - Replace at 200 hours intervals or as necessary. - ALL MACHINES																																																				Cross Reference Chart							
Lubricate tooling chuck - ALL MACHINES																																																				Charmilles	Micrometer	Microinch	RMS				
Lubrication - Pull lever then release, repeat 10 times with a 2 second interval in between - FO20/FO30 ONLY																																																				-2	0.08	3.14	3.485	13	C axis lock		
Lubricate the Z axis screw and slidways using the manually operated pump - MANUAL MACHINES																																																				-1	0.09	3.54	3.929	14	C axis release		
MONTHLY MAINTENANCE																																																				0	0.1	3.94	4.373	22	Filling the work tank		
Check the level and temperature of the dielectric fluid, and water level in chiller - ALL MACHINES																																																				1	0.11	4.33	4.806	23	Draining the work tank EXCEPT FO22		
Clean fans and replace air filters - ALL MACHINES except FO810																																																				2	0.12	4.72	5.239	24	Machining protection suspended for 30 seconds		
Check that the disk drive(s) is working properly, clean if necessary with a self cleaning disk. - ALL CNC MACHINES																																																				3	0.14	5.51	6.116	25	Machining protection suspended for 2 minutes		
Lubricate both sides of the table locking system with molybdenum disulfide grease. - MANUAL MACH ONLY																																																				4	0.16	6.29	6.982	26	Machining protection suspended for 8 minutes		
MAINTENANCE EVERY 6 MONTHS																																																				5	0.18	7.09	7.87	27	Normal machining protection		
ALL MACHINES																																																				6	0.2	7.87	8.736	28	VPULS default speed EXCEPT FO22		
Drain water from pneumatic reservoir																																																				7	0.22	8.66	9.613	29	VPULS program speed EXCEPT FO22		
Fill pneumatic oil reservoir																																																				8	0.25	9.84	10.92	50	Slow retraction in case of short circuit		
Check central lube reservoir level																																																				9	0.28	11.02	12.23	51	Rapid retraction in case of short circuit		
Check Z axis drive belt																																																				10	0.32	12.6	13.99	53	Stop on difficult machining		
CNC Machines																																																				11	0.35	13.78	15.3	55	Circulation pump off		
Run Auto Diagnostic																																																				12	0.4	15.6	17.32	59	No stop - Max. machining protection		
Check flushing flow rates																																																				13	0.45	17.6	19.54	60	No optimization, No stop		
YEARLY MAINTENANCE																																																				14	0.5	19.6	21.76	75	Retract linear tool changer rack		
ALL MACHINES																																																				15	0.56	21.6	23.98	76	Extend linear tool changer rack		
Replace dielectric																																																				16	0.64	25	27.75	95	Resets and stops machining counter		
Check belt tension and condition																																																				17	0.72	28.1	31.19	96	Machining time counter output		
CNC MACHINES																																																				18	0.8	31.2	34.63	97	Machining time counter and setting number output		
Check the Z axis brake																																																				19	0.91	35.5	39.41	ROBOFORM 35/54/55/810/84/X0X0 ONLY 32 Attack protection 61 SPAC on 63 SPAC off NOTES:			
Check the C axis brake																																																				20	1.01	39.4	43.73				
Check movement of all axis																																																				21	1.12	43.7	48.51				
MANUAL MACHINES																																																				22	1.28	49.9	55.39				
																																																				23	1.44	56.2	62.38				
																																																				24	1.6	62.4	69.26				
																																																				25	1.81	70.6	78.37				
																																																				26	2.03	79.1	87.8				
																																																				27	2.24	87.4	97.01				
																																																				28	2.54	99.1	110				
																																																				29	2.84	110.8	123				
																																																				30	3.15	122.9	136.4				
																																																				31	3.6	140.4	155.8				
																																																				32	4.05	158	175.4				
																																																				33	4.5	175.5	194.8				
																																																				34	5.1	198.9	220.8				
																																																				35	5.7	222.3	246.8				
																																																				36	6.3	245.7	272.7				
																																																				37	7.2	280.8	311.7				
																																																				38	8.1	315.9	350.6				

* For specific information please consult your machine maintenance manual

* For applications questions call 1-800-CTC-1-EDM ext. 870