Lathe C-axis Inspection Report

Technician		**Cell#**	
Serial Number		**Date**	
Model			

Type	☐ Pneumatic ☐ Hydraulic

1. What alarm generated?	
2. When does the alarm/symptom occur?	
3. Is the Alarm resettable?	☐ Yes ☐ No

4. Other - Describe the issue:

Mandatory Troubleshooting

Control Pendant

5. Has an error report been generated and uploaded?	☐ Yes ☐ No
6. Has there been a video uploaded of the program running?	☐ Yes ☐ No
6a. Does the video include C axis load?	☐ Yes ☐ No
6b. Does the video show the chuck with the C axis in use?	☐ Yes ☐ No
6c. If applicable does the video show the noise or vibration coming from the C axis motor? (If N/A enter "No")	☐ Yes ☐ No
7. Can you handle jog the C axis?	☐ Yes ☐ No
8. Is there excessive vibration or noise coming from the spindle or C axis assembly?	☐ **Yes** ☐ **No**
8a. Does the C vibrate when in position to engage?	☐ **Yes** ☐ **No**
8b. Does the C axis vibrate when engaged?	☐ Yes ☐ No
8c. Does the C axis vibrate when machining or controlled with handle jog?	☐ Yes ☐ No
9. Check alarm history, have the crash indicating alarms below been triggered? **Alarm X.103** Axis servo error too large. **Alarm X.9920** position error too large. **Alarm X.9921** velocity error too large. **Alarm 994** amplifier overload	☐ **Yes** ☐ **No**
11a. If an alarm was triggered did the issues with the C axis begin after this? (If N/A enter "No")	☐ Yes ☐ No
9. What version is the Mocon? (1.16.S or higher)	☐ [1.16] ☐ [1.16.k] ☐ [1.16.S]
10. Is the latest version of software installed?	☐ Yes ☐ No
12. Do the issues persist after a clean software install and test without restoring the backup?	☐ Yes ☐ No

Check Parts

13. Does the motor and pion gear properly engage and disengage?	☐ Yes ☐ No
14. Have you inspected the C-axis gear and motor for damage?	☐ Yes ☐ No
14b. Have the gear teeth been damaged or worn down?	☐ Yes ☐ No
14c. If the teeth have been worn down are they still functional?	☐ Yes ☐ No
14d. Has the pinion been damaged or worn down?	☐ Yes ☐ No
14. Is there lubrication on the motor gear?	☐ Yes ☐ No
15. Check if there is any hydraulic fluid leaking from the motor assembly?	☐ **Yes** ☐ **No**
16. Check air and hydraulic tubes for kinks and leaks?	☐ **Yes** ☐ **No**
17. Check if the piston is leaking hydraulic fluid?	☐ Yes ☐ No
18. Has the brake been properly set?	☐ Yes ☐ No
19. If new machine install verify that the correct gear has been installed?	☐ **Yes** ☐ **No**
20. Has the encoder gapping, ring runout and axial distance been checked?	☐ **Yes** ☐ **No**
21. Do the C axis issues persist if amplifiers are checked and replaced?	☐ Yes ☐ No
22. Are all ferrites installed properly onto the power and encoder cables?	☐ Yes ☐ No

Tolerances

23. Has the C axis gear runout been checked?	☐ Yes ☐ No Runout:
24. Has the Spindle belt tension been checked?	☐ Yes ☐ No

Notes/Observations:

Attach this report, an error report, and any relevant documentation to a service notification in the Haas Service App.

Answer these questions in the notes section