Rotary Inspection Report

Technician/Customer		**Cell#**	
Serial Number		**Date**	
Model		**P Code**	

Single or Dual Axis	☐ Single ☐ Dual
Rotary Control	☐ CHC Machine ☐ NGC Machine ☐ Control box ☐ Software Version:
Brush or Brushless	☐ Brush (1 cable per axis) ☐ Brushless (2 cables per axis)

1. What Alarm is being generated	
2. When does the issue occur?	☐ Start up ☐ Commanded to Move ☐ While cutting ☐ Other (specify below)
3. Is the Alarm resettable?	☐ Yes ☐ No

4. Other - Describe the issue:

Mandatory Troubleshooting	
5. Has a crash occurred?	☐ Yes ☐ No
6. If the Rotary has two axis which axis is having the problem.	☐ ROT ☐ TILT ☐ BOTH
7. Was the reported issue troubleshot by a certified technician or the customer?	☐ Technician ☐ Customer
8. Has any of the rotary cables been connected or disconnected while the power is ON?	☐ Yes ☐ No
9a. Can the Rotary be zero returned?	☐ Yes ☐ No
9b. If you cannot zero return the rotary unit, can you create motion by hand-jogging the rotary using the "Without Zero Return" feature? Do not rotate more than a few degrees.	☐ Yes ☐ No
10. Attach an error report **(NGC)** or Machine backup **(CHC)** from the machine. Take the report while the alarm is active.	☐ Attached ☐ No Alarm
11. Was the rotary installed by the customer or Haas Certified Service Engineer?	☐ Technician ☐ Customer
12. Was the 4th and/or 5th axis interface installed by a Haas Certified Service Engineer, or at the factory?	☐ Technician ☐ Factory
13. Is the unit compatible with the software version in your machine or control box?	☐ Yes ☐ No ☐ Unknown
14. Are the correct parameters being used for the particular unit and P code of the unit?	☐ Yes ☐ No ☐ Unknown
15. Were the configuration files updated (NGC) or Checked with the parameter checker(CHC) by a Haas Certified Service Engineer?	☐ Yes ☐ No
16. Do you have pictures or videos of the issue?	☐ Yes ☐ N/a
Air Leak	
17. What is the air pressure going to the rotary?	PSI
18a. Is there a brake booster connected to the rotary unit?.	☐ Yes ☐ No
18b. Does air still leak if the air is directly connected to the Rotary instead of the booster?	☐ Yes ☐ No
19. Is the air turned off at night when the machine is not used?	☐ Yes ☐ No
20. Have you tested the unit without turning off the air supply over night?	☐ Yes ☐ No
21. In single axis rotaries. Is the air leaking from under the platter, from the brake plate, or from the enclosure.?	☐ Platter ☐ Break ☐ Enclosure
22. On dual axes rotaries. Is the air leaking from under the platter, from the brake plate, from the enclosure, or from the junction where the tilt axis meets the rotary axis?	☐ Platter ☐ Break ☐ Enclosure ☐ Junction
Oil Leak	
23. In single axis rotaries. Is the oil leaking from under the platter, from the brake plate, or from the enclosure.?	☐ Platter ☐ Break ☐ Enclosure
24. On dual axes rotaries. Is the oil leaking from under the platter, from the brake plate, from the enclosure, or from the junction where the tilt axis meets the rotary axis?	☐ Platter ☐ Break ☐ Enclosure ☐ Junction
Accuracy and positioning	
25. Is the reported issue related to accuracy or repeatability? If so, provide measurement details in the notes section.	☐ Yes ☐ No
26a. Was the machine's level and geometry verified?	☐ Yes ☐ No
26b. If you answered yes to 26a. Do you have an inspection report?	☐ Yes ☐ No
27. Is the rotary positioning to the correctly on the axis with the issue?	☐ Yes ☐ No ☐ Unknown
28. If the rotary has two axis, what axis has the problem?	☐ ROT ☐ TILT ☐ BOTH
29. How much error are you experiencing?	
30. Is the error in the positioning in both the positive and negative directions?	☐ Positive ☐ Negative
31. Does the position improve if you rotate the rotary axis in one direction only?	☐ Yes ☐ No
Back Lash	
32. Are you measuring backlash using an indicator or using the machine control?	☐ Indicator ☐ Machine control
33. What is the issue that makes you question the backlash?	☐ Add to Notes ☐ N/a
34. If backlash is found, mark the platter to casting (single axis) or Tilt to Rot casting (dual axis) where backlash is found.	☐ Yes ☐ No
35. How much is the backlash?	

Notes/Observations:

Attach this report, an error report, and any relevant documentation to the Rotary RA form.