ID-0023 Rev A

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)	
 What Alarm is being generated When does the issue occur? 	Start up Commanded to Mayo While sutting Other (aposity below)	
3. Is the Alarm resettable?	Start up Commanded to Move While cutting Other (specify below) 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		Yes No
Return" feature? Do not rotate more than a few degrees.		
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? 12. Was the 4th and/or 5th axis interface installed by a Haas Certified Service Engineer. or at the factor/2 		Technician Customer
12. Was the 4th and/or 5th axis interface installed by a Haas Certified Service Engineer, or at the factory?13. Is the unit compatible with the software version in your machine or control box?		Technician Factory Yes No Unknown
13. Is the unit compatible with the software version in your machine of control box?14. Are the correct parameters being used for the particular unit and P code of the unit?		Yes No Unknown
14. Are 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?19 Is the air turned off at night when the machine is not used?		Yes No
19. Is the air turned off at night when the machine is not used?20. Have you tested the unit without turning off the air supply over pight?		Yes No Yes No
20. Have you tested the unit without turning off the air supply over night?21. In single axis rotaries. Is the air leaking from under the platter, from the brake plate, or from the enclosure.?		Platter Break Enclosure
		Platter Break
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?		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		Platter Break
junction where the tilt axis meets the rotary axis?		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?29. How much error are you experiencing?		ROT TILT BOTH
29. How much error are you experiencing		Positive Negative
30. Is the error in the positioning in both the positive and negative directions?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.		