

Mill Spindle Inspection Report

Technician:		Cell:	
Serial Number:	Model:	Date:	

Spindle Type

Inline		Spindle Taper	Max RPM
Belted		20	
Belted-Gearbox		30	
		40	
		50	

Why Is The Spindle Being Replaced?

Seized		Surface Finish	
Noise		Drops Tool	
Vibration		Tools Sticking	

Other - Describe The Issue:

Mandatory Troubleshooting, Check the Following:

Lubrication

Pump primed		Bijur Style Pump	
Leaks around sight glass		If yes, rebuild and add a sight glass	

Spindle Condition

Inline	Belted
Verify motor to spindle alignment	Drive sprocket/belt condition
Float in spindle motor	Encoder sprocket/belt in good condition
Non-Contact Encoder Condition/Gap	Verify belt tension

Inline & Belted

TSC union or coolant collector making noise	Motor only vibration test
Spindle taper condition	Balanced Spindle
Run a vibration test	Spindle to toolchanger alignment

If Issue is Drawbar Related Check the Following:

Drawbar clamp force	Drawbar shaft runout
If belted: drawbar carbide face runout	Condition of ball bearings and drawbar cup

Tool Holders

Pull studs torqued to spec.	Balanced tool holders
Correct pull studs being used	Pull stud condition

Troubleshooting Details and Customer Application: