Spindle Motor Inspection Report

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

Type of Spindle Motor

1. What is the spindle taper?	20 ☐ 30 ☐ 40 ☐ 50 ☐ HSK ☐
2. What is the spindle motor RPM?	4k ☐ 6k ☐ 7.5k ☐ 8.1k ☐ 10k ☐ 12k ☐ 15k ☐ 18k ☐ 20k ☐ 30k ☐ 50k ☐
3. Is the spindle motor inline or belt driven?	Inline ☐ Belt ☐
4. What is the machine's software version?	

Why is the Spindle Motor being replaced?

5. What alarms are generated?	
6. When does the alarm/symptom occur?	
7. Is the alarm resettable?	Yes ☐ No ☐
8. Is the spindle motor physically damaged?	Yes ☐ No ☐

9. Other - Describe the issue:

Spindle Motor Troubleshooting

10. Does the spindle motor run?	Yes ☐ No ☐
10b. If so, does the issue occus while the spindle motor is running?	Yes ☐ No ☐
10c. Is there excessive noise while the spindle motor is running?	Yes ☐ No ☐
10d. For Inline motors only: Is there a poor finish on parts?	Yes ☐ No ☐
11. Is the program too aggressive for the spindle motor?	Yes ☐ No ☐
12. For TSC machines only: Has the TSC union been inspected for leaks?	Yes ☐ No ☐
12b. If the inline motor has been replaced, has the union been upgraded to the compensating?	Yes ☐ No ☐
13. Has there been a vibrational analysis test?	Yes ☐ No ☐

Electrical Troubleshooting

14a. Has the J-Box been inspected?	Yes ☐ No ☐
14b. Does the temperature sensor work?	Yes ☐ No ☐
14c. Are all the connections secure?	Yes ☐ No ☐
15. Have you tested the following:	
15a. Secure cable connections?	Yes ☐ No ☐
15b. Spindle fan?	Yes ☐ No ☐
15c. Vector drive?	Yes ☐ No ☐
15d. Regen?	Yes ☐ No ☐
15e. Wye/Delta?	Yes ☐ No ☐
16a. Has the encoder system been checked for wear or damage?	Yes ☐ No ☐
16b. Has the encoder feedback been checked for accuracy?	Yes ☐ No ☐
16c. For GB with belted encoder: Has the encoder pulley/belt been inspected?	Yes ☐ No ☐
16d. Has runout and play been checked for within the encoder?	Yes ☐ No ☐

Motor Ohm Out Test

17. Measure between motor leads or terminals and enter the value in ohms:

T1 & T4: _____	T2 & T5: _____	T3 & T6: _____
T2 & T4: _____	T3 & T4: _____	T1 & T5: _____
T3 & T5: _____	T1 & T6: _____	T2 & T6: _____

18. Measure between each individual motor lead or terminal and the motor's armature:

T1 & Motor Chassis: _____	T2 & Motor Chassis: _____	T3 & Motor Chassis: _____
T4 & Motor Chassis: _____	T5 & Motor Chassis: _____	T6 & Motor Chassis: _____

Notes/ Observations:

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