

Maintenance protocol

Customer	SCEMAMA	Machine type	BS12CE-V
Customer machine name		Machine serial N°	5079
		Machine localization	
Date of control	13/04/2026	REP N°	
Customer special request	Maintenance préventive sans remplacement de pièces.		
Description of the problems and parts needed		Time in hour	Priority
Racleur peigne principale (3220-T020-0400)			
Roulements Contre-broche (à contrôler après rodage)			
Customer contact name		Tsugami Technician	SCHMITT
Customer Signature		Technician Signature	

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A. Parts to change for every preventive maintenance

1. Amplifier and CNC batteries

Battery	Item ref	Replaced quantity	Comments
Battery 1.5V LR20	PE-00625		

2. Electrical Relays

Relay type	Item ref	Replaced quantity	Comments

3. Oil and Air filters

Designation	Item ref	Replaced quantity	Comments

4. Others

Complete the table below with the other parts you have replaced

Designation	Item ref	Replaced quantity	Comments

B. Functional analysis

Machine

1. Software

Soft status

Customer wants an update [YES/NO]	Version PMC	Version Fanuc CNC	Comments
	40A0 20.0	G103 25.0	

2. Doors

Designation	Door safety device status [OK/KO]	Door locking status [OK/KO]	Comments
Machining door	OK	Portes déposées	
Main Spindle door			
Electrical cabinet door	OK		
Chip pan door			
Part catching door			

3. Pneumatic

General condition [OK/KO]	Audible air leak [OK/KO]	Pipe condition [OK/KO]	Comment
KO			Tuyaux pneumatique remplacé par le client Filtre du manomètre à remplacer

4. Axis lubrication system

General pipe status [OK/KO]	Oil level [OK/KO]	Comments
OK	OK	

5. Electrical cabinet

Measure the 24V between. If it's under 24V please adjust

General condition [OK/KO]	Oil in cabinet [OK/KO]	24V tension [Volt]	Comments
OK	OK	24.0VDC	

6. Fans and radiators

Fan	Running [OK/KO]	Comments
Radiator from electrical cabinet	Clean the radiator	
Amplifier	OK	

7. Part exhaust/ catcher

Designation	Status [OK/KO]	Comments
General aspect	OK	
Tubing	OK	
Bucket catcher		

8. Ejector

Designation	Status [OK/KO]	Comments
General aspect	OK	
Sensor	OK	
Function	OK	

9. Spindle and CrossDrill check

Designation	Noise [OK/KO]	Closing Opening Collet [OK/KO]	Bearing status (turn with hand) [OK/KO]	Comments
Main Spindle	OK	OK	OK	Remplacé
Sub Spindle	KO	OK	OK	Remplacé (à controller après rodage)
Guide Bush	OK		OK	Point dur (à controller après rodage)
Cross Drill	OK		OK	
Back Drill	OK		OK	
Off-center Drill	OK		OK	

10. Oil pump and tank

Designation	General condition [OK/KO]	Oil flow [OK/KO]	Comments
Coolant pump			Hors d'huile

11. Spindle cooler system

Check the spindle cooler system and clean the radiator with a brush and air.

Radiator cleaning done [Yes]	Coolant level [OK/KO]	Fan working [OK/KO]	Comments
			Hors d'huile

12. Backup

Complete Backup Done [OK/KO]	Comments
OK	Donné au client

Peripheral devices

1. Bar feeder

Designation	Status [OK/KO]	Comments
Model and type		IEMCA ELITE 112

2. Mist collector (Do not fill if not present)

Model and type	General condition [OK/KO]	Suction [OK/KO]	Anti-fire valve function [OK/KO]	Comments

3. Collecting device with tups (Do not fill if not present)

Model and type	General condition [OK/KO]	Visual Status [OK/KO]	Comment

4. HF Spindle & milling cutting device (Do not fill if not present)

Option not present

Designation	Status [OK/KO]	Comments
Model and type		
Spindle		
Converter		
Overpressure/lubrication		

5. Fire extinguisher system (Do not fill if not present)

Option not present

Model and type	General status [OK/KO]	Date of the next check	Pression in bar (if present)	Comments

6. High pressure pump (Do not fill if not present)

Option not present

Designation	Status [OK/KO]	Comments
General condition		
Oil flow		
Filter		
Valve check		

C. Geometric accuracy items

General axis check

1. Measurement tools

Please fill in the table below with the measurement tools you have used.

Designation	Article N°	Last quality check	Comments

2. Ballscrews and motor check

Move the axis to the soft limits and check if the ballscrew and motor are in good condition (vibration, position error)

Axis	Status [OK/KO]	Comments
X1	OK	Remplacé
A1	OK	
Z1	OK	Remplacé
X2	OK	
Y2	OK	
Z2	OK	

3. Backlash

Above 8µm backlash correction into the CNC, we highly recommend exchanging the ball screw

Axis	Value [0.001mm]		Comments
	CNC value initial	CNC value corrected	
X1	0	0	
A1	0	2	
Z1	0	0	
X2	0	0	
Y2	0	0	
Z2	0	0	

Geometrical protocol

No	Diagram	Item	Tolerance [mm]	Plant measured value[mm]	
1		Parallelism between main spindle centerline S1 and main spindle movement Z1	0.015 / 70	V	0.006
			0.015 / 70	H	0.002
2		Concentricity between centerlines of spindle and guidebush holder hole	Ø 0.010	C	0.006
3		Main spindle S1 run out, Axial & Radial	0.005	A	0.000
				R	0.002
4		Guide bushing run out on the cone (if Customer has a guidebush)	0.005	C	0.004
5		Counter spindle S21 run out, Axial & Radial	0.005	A	0.000
				R	0.005

No	Diagram	Item	Tolerance [mm]	Plant measured value[mm]	
6		Parallelism opposite spindle in relation to slide Z2	0.015 / 70	V	0.007
			0.015 / 70	H	0.003
7		Centering of opposite spindle in relation to guidebush holder face	0.010	V	0.005
			0.010	H	0.005

