

Guidelines to Re-start the machine after lockdown

1. Please use safety gear like masks, goggles, hand gloves and safety shoes.
2. Before starting the machine, sanitize the machine and surroundings.
3. Never use bare hands to touch the machine elements and ensure electrical parts are isolated for human safety.
4. Do a visual inspection of machine surrounding, machine bed inside areas to ensure that the cables and hoses are intact and not damaged visually. All areas to be cleaned thoroughly.
5. All protection guards to be removed and checked for rust free environment
6. In case of LM guide ways, Ball screw, gears etc, it should be lubricated afresh if not done before lock down after thorough cleaning.
7. Check the air, fixtures, hydraulic and coolant pipe conditions (if applicable) and fix it if required
8. Check the hydraulic and lubrication oil Viscosity & replace if necessary and arrest any leakages if present.
9. Check the level and cleanliness of hydraulic, lubrication, coolant oil and filters.
10. Check and verify the pneumatic air pressure and leakage and make sure that it is free from mist.
11. Open the machine cabinet and MOP door, visually inspect and ensure all the cables and wires are intact, if it has suffered any physical damage due to external causes. Fix it before Power On.
12. Before powering up the machine, measure proper electrical supply, earthing and battery voltage/ups
13. Make the functional test of safety devices such as ESTOP, Push button, safety door switches, light curtain and two hand push button.
14. After powering up the machine make sure that proper program parameter is restored.
15. Check the electrical interface for sparks and/or burning smell. If yes do not panic but immediately turn off the main breaker. Find the root cause or contact us with your findings to avail further support to avoid any damage to the machine.
16. After safe power on, please check for any unintended alarm Screen on the control panel. If you cannot resolve, contact us for further plan of action to start the machine.
17. Keep the machine ON and hydraulic ON condition and check the leakage and ensure lubrication reaches to the required areas.
18. After successful Power on and archive data restoration, please ensure no alarm on the screen
19. Switch on hydraulic functions, check for any oil leakage in the hydraulic power pack and various parts of the machine and correct if there is any. To be repeated for lubrication also.
20. Check whether the axis reference position and end limits are functioning properly
21. Move the axis slides in manual mode for some time or until there is smoothness in movement.
22. Check all the manual individual operations like chucking, clamping etc after ensuring the basic steps are adhered.
23. Physically rotate the spindle by hand and ensure smooth, careful rotation. Be aware of the sharp edges since they may damage your hands.

24. Run the spindle in inching mode after ensuring the basic steps are adhered. If no abnormality, please run continuously up to 1 min with a dwell of 1min with 25rpm.
25. Run the spindle for min and max speed with the same sequence as explained above.
26. After powering up the machine make sure that proper program parameter is restored.
27. Before starting the production, run the machine in dry run mode two or three times.

For assistance contact**Primary Support : Girish - +91 91080 01995****Secondary Support : Abhijit - +91 91080 01993****Email id : support@etatechnology.net****Escalation****Shivakumar - +91 98867 14471****Email id : Sales@etatehnology.in****Disclaimer:**

This document is recommendary and more generic in nature. For specific machine related details, we recommend you refer to the Machine Operations manual. You may contact the support team for any specific clarification