

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)		
1. What Alarm is being generated			
2. When does the issue occur?			
	Start up Commanded to Move While cutting Other (specify below)		
3. Is the Alarm resettable?			
	Yes No		
4. Other - Describe the issue:			
Mandatory Troubleshooting			
5. Can the Rotary be Zero Returned?			Yes No
5. Has a crash occurred?			Yes No
6. If the Rotary has two axis which axis is having the problem.			ROT TILT BOTH
8. Has any of the rotary cables been connected or disconnected while the power is ON?			Yes No
9. If you cannot zero return the rotary unit, can you create motion by hand-jogging the rotary using the "Without Zero Return" feature? Do not rotate more than a few degrees.			Yes No
10. Attach an error report (NGC) or Machine backup (CHC) to a work order under the rotary's serial number. Take the report while the alarm is active.			Attached
13. Is the unit compatible with the software version in your machine or control box?			Yes No Unknown
14. Are the correct parameters being used for the particular model and P code of the rotary?			Yes No Unknown
15. Were the configuration files updated (NGC) or Checked against the parater list on the Haas Service Guide (CHC) by a Haas Certified Service Engineer?			Yes No
16. Do you have pictures or videos of the issue? If yes attach to a work order.			Yes N/a
Back Lash			
32. Are you measuring backlash using an indicator or the machine control? An indicator is recommended. See the rotary service manual for instructions on how to ensure backlash.			Indicator Machine control
33. What is the issue that makes you question the backlash?			Added 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 at various locations?			
0/360	45	90	135
180	225	270	315
Accuracy and positioning			
25. Is the issue with the rotary related to accuracy or repeatability? If so, provide measurement details in the notes section.			Added to Notes N/a
26a. Was the machine's level and geometry verified?			Yes No
26b. If you answered yes to 26a. Attach to a work order.			Attached N/a
28. If the rotary has two axis, what axis has the problem?			ROT TILT BOTH
31. Does the positioning improve if you rotate the rotary axis in one direction only? If yes see the backlash section.			Yes No
Air/Oil 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?			Yes No
19. Is the air turned off at night when the machine is not used? Turning air off at night can cause oil leaks under the plater when air is turned back on.			Yes No
20. Have you tested the unit for air/oil leaks without turning off the air supply over night?			Yes No
21. In single axis rotaries. Where is the air leaking from? Check all that apply.			Platter Break Enclosure
22. On dual axes rotaries. Where is the air leaking from? Check all that apply.			Platter Break Enclosure Junction
23. In single axis rotaries. Where is the oil leaking from? Check all that apply.			Platter Break Enclosure
24. On dual axes rotaries. IWhere is the oil leaking from? Check all that apply.			Platter Break Enclosure Junction
Notes/Observations:			
Attach this report, an error report, and any relevant documentation to the Rotary RA form.			