

ATC Maintenance Schedule

One Time Maintenance

- Motor Temperature: After the machine is turned on for a few hours, check every motor for the correct temperature between 140 - 160 degrees Fahrenheit.

Daily Maintenance

- Air Pressure
 - Ensure that the air drier or chiller on the air compressor is functioning and provides clean air.
 - Check CNC machine air regulators for water, if any, drain.
 - Tip: If moisture is accumulating inside the regulators, your air drier or chiller may not be functioning correctly.
- Saw Dust
 - Clean Machine of dust and debris
- Spindle (Air & Liquid Cooled)
 - Spindle Warm-Up Routine
 - (Liquid Cooled Only) Coolant is Flowing: Tip - Use a Flow Meter
- ISO30 Tool Holder:
 - Clean off the cone of the tool holder.
- HSK63F Tool Holder:
 - Clean off the cone and inside the top of the tool holder.
- Cutters
 - Remove pitch buildup: Tip - Use Diamond Wet Stone on straight carbide edges.
 - Spray with Dyna Glide: Tip - Spray cutters with Dyna Glide before use to extend cutter life.

Weekly Maintenance

- ISO30 Tool Holder:
 - Ensure that the pin on the top of the tool holder is tight.
- Clean Bearing Rods along X, Y, and Z-axis (Round Profile Machines Only)
 - Remove Rust & Contamination: Tip - Use Scotch Brite
 - Spray with Dyna Glide to prevent rust & contamination build-up: Tip - Adjust frequency of bearing rod cleaning based on humidity levels.
- Grease Profile Bearings (Profile Bearing Machines Only)
 - Pump grease into profile bearings through Zerk fittings using NGLI2 grease.
 - Note: Do not overfill!
- Clean Rack along X & Y axis
 - Spray with Dyna Glide to prevent rust & contamination build-up: Tip - Adjust frequency of bearing rod cleaning based on humidity levels.
- Z-Axis Screw
 - Lubricate with White Lithium Grease: Tip - Wipe on with rag to prevent overspray.

Monthly Maintenance

- Check Coolant for Liquid Cooled Spindles

- Note: either purchased premix green antifreeze or mix the concentrate with distilled water.
- Open Coolant Reservoir to check the coolant level, color, concentration, smell and for any debris.
- Keep coolant between 1"-5" from the top rim of the reservoir
- Check for Backlash
 - Check for vibration noises along the X & Y axis to locate any rack alignment issues.
 - Check machined surfaces for chatter marks.
 - Push & Pull Test every 10" along the X & Y axis to locate backlash.
 - Remove backlash or Over engagement by adjusting rack bracket to the pinion.

Storage Tips

- Short Term Storage 1-3 days
 - It's OK to leave the cutter, collet & collet nut in the Spindle.
- Mid Term Storage 4-30 days
 - Remove cutter and collet from the spindle.
 - It's OK to leave the collet nut in the Spindle.
- Long Term Storage - 1 month or longer
 - Remove cutter and collet from the spindle.
 - It's OK to leave the collet nut in the Spindle.
 - Spray "White Lithium Grease" along each bearing rod on the X, Y, and Z-axis.

When Changing Tools in a Tool Holder

- Collet & Collet Nut
 - Clean out Collet & Collet Nut
 - Remove Rust & Contamination
 - Spray with Dyna Glide
 - The Shake Test: when the collet is seated properly into the Collet Nut, Shake collet nut upside down. If the collet falls out, replace collet.
- ISO30 Tool Holder:
 - Take apart the entire tool holder and clean inside and outside thoroughly.
 - Ensure that the pin on the top of the tool holder is tight.
- HSK63F Tool Holder:
 - Take apart the entire tool holder and clean inside and outside thoroughly.