

DMG MORI Inspection .

Firma	[REDACTED]	NC Software:	G113/43.0
Location:	[REDACTED]	PLC Software:	6L8115141C
Engineer:		Installation date:	07/12/2009
Machine type:	NT3200 DCG/1000S	Machine hours:	129418
Machine Sr. No:	7038NT320II0134J	Spindle hours:	66743

Legend	Status	- Check done (x) or not possible/inspection point not relevant ()
	Repair	- Recommend component exchange or adjustments for quote
	Result	- Measured value
		- Okay (Ok.)
		- Not okay (N.Ok.)

	Status	Repair	Measured value	Ok.	N.Ok.
Media supply					
pneumatics					
Filter elements - Check supply unit	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Filter elements - Check main drive/motor spindle	not possible	N/A		<input type="checkbox"/>	<input type="checkbox"/>
Filter elements - Check measuring systems / Air purge system	not possible	N/A		<input type="checkbox"/>	<input type="checkbox"/>
Filter elements - Check other filter elements	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check consumers	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check pipes and lines for leakage	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check automatic water separator	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Hydraulics					
Check hydraulic pressure	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Change hydraulic filter	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check pipes and lines for leakage	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Change hydraulic oil	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check filling level	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check pressure settings system pressure hydraulics unit	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Cooling and venting					
Check state of cooling unit (remove casing)	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check filling level	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Mixing ratio in accordance with manufacturer requirements	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Cooling medium in accordance with manufacturer requirements	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Change filter mat/clean filter mat	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check pipes and lines for leakage	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check consumers	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check pumps	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>
Slideway lubrication					
Check tank / filling level	checked			<input checked="" type="checkbox"/>	<input type="checkbox"/>

Check pipes and lines for leakage	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Change lubrication filters	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Grease nipple functions / guide rails Check (tightness, grease leak)	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Lubrication medium in accordance with manufacturer requirements	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>

Slideway covers

Covers condition

Check blinds / pushover plate	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check wipers	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>

Axis drives

Ball screw drive / Linear actuator / Rotary axes drive

Visual inspection rotary axes / Linear actuators	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Visual inspection linear guidance	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check for abnormal noises/vibration from each axis	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>

Tool spindle

Tool spindle / ISM

Check tool fitting strength	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Visual inspection spindle cone	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check concentricity at spindle nose	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check concentricity at 300mm	checked	200mm	<input checked="" type="checkbox"/>
Check for abnormal noise/vibration	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check function oil/oil mist lubrication	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check Air purge system function	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Clean/change filter mat for ventilation (only for cooles ISM)	not possible	<input type="checkbox"/>	<input type="checkbox"/>
Leakage check	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Visual inspection collet	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check collet adjustment measure	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Clamping force measurement for Turning	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>

Tool

Tool changer

Visual inspection general changer functions	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
State of tool gripper	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check sensor settings	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>

Tool magazine

Check tool change position	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check opening and locking mechanism	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check tool magazine location designation	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Quiver and tool clamps / holders	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Visual inspection chain/disc	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check sensor settings and clean sensors	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>

Tool turret

Check sealing plug	not possible	<input type="checkbox"/>	<input type="checkbox"/>
Check tool location designation	not possible	<input type="checkbox"/>	<input type="checkbox"/>
Check air purge system	not possible	<input type="checkbox"/>	<input type="checkbox"/>

Coolant Tank and coolant

Check Coolant's degree of contamination	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Visual inspection high pressure pumps	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Filling level monitoring	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check monitoring unit rolling paper belt filter	not possible	<input type="checkbox"/>	<input type="checkbox"/>

Check switch over filter (for internal coolant supply)	not possible		<input type="checkbox"/>	<input type="checkbox"/>
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Machining area and electrical cabinet

Machining area

Visual inspection windows	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Functional check door switch incl. secondary doors	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Functional check emergency stop switch	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>

Electrical cabinet

Check sealing around cabinet	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check function of electrical cabinet's cooling filter/vent	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check vent and filter / external steller warming / running noises	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check filter mat condition	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check all cables inside electrical cabinet are tight	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>

Machining area

Visual inspection interior (wipers, gaiter, light, door, axle)	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check inspection glass for damages	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check rotating inspection glass for damages	not possible		<input type="checkbox"/>	<input type="checkbox"/>
Check door guides / stops	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Functional check safety devices and locking	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>

Control

Visual inspection control panel	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Visual inspection monitor	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check function emergency shut off	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>

Linear guide rails X, Y, Z and belt

Visual inspection guides	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check for noises / vibration	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check wipers	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check belt	not possible	No belts	<input type="checkbox"/>	<input type="checkbox"/>

Check chip conveyor

Visual inspection of links	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check chain tension	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Check filters	checked		<input checked="" type="checkbox"/>	<input type="checkbox"/>

Ultrasonic unit (Only for Ultrasonic)

Visual inspection actuator	not possible	N/A	<input type="checkbox"/>	<input type="checkbox"/>
Functional check ultrasonic	not possible		<input type="checkbox"/>	<input type="checkbox"/>
Check air gap and mounting position	not possible		<input type="checkbox"/>	<input type="checkbox"/>
Visual inspection ultrasonic tools (actuator)	not possible		<input type="checkbox"/>	<input type="checkbox"/>

Laser / Laser machining head / Scanner (Only for Lasertec)

Check laser resonator optic	not possible	N/A	<input type="checkbox"/>	<input type="checkbox"/>
Check beam guidance optic	not possible		<input type="checkbox"/>	<input type="checkbox"/>
Check laser safety window optic	not possible		<input type="checkbox"/>	<input type="checkbox"/>
Laser performance measurement	not possible		<input type="checkbox"/>	<input type="checkbox"/>
Check offset camera, measuring probe, laser beam	not possible		<input type="checkbox"/>	<input type="checkbox"/>
Cooler: Conductivity value measurement cooling water	not possible		<input type="checkbox"/>	<input type="checkbox"/>

Options

Visual inspection work piece handling systems	not possible	N/A	<input type="checkbox"/>	<input type="checkbox"/>
Visual inspection work piece measuring unit / measuring probes	not possible	N/A	<input type="checkbox"/>	<input type="checkbox"/>
Visual inspection tool measuring devices	not possible	N/A	<input type="checkbox"/>	<input type="checkbox"/>
Visual inspection oil mist pump	not possible	N/A	<input type="checkbox"/>	<input type="checkbox"/>
<i>Further options:</i>			<input type="checkbox"/>	<input type="checkbox"/>
			<input type="checkbox"/>	<input type="checkbox"/>
			<input type="checkbox"/>	<input type="checkbox"/>
			<input type="checkbox"/>	<input type="checkbox"/>

Inspection display

Reset Inspection display	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Explanation inspection results	checked	<input checked="" type="checkbox"/>	<input type="checkbox"/>

Please mind the following: The purpose of the inspection is only to determine the machine state at the time of the inspection. The repair of any machine errors which are found or service issues as well as the delivery of wear, replacement or other parts is not included within the scope of the inspection (Exception: when executing Inspection Plus as well as maintenance, selected wear parts are included). Based upon the inspection's results you will receive an offer with measures, which we recommend to re-establish your machine's target values.

Please file this inspection list with your documents. Additionally we recommend you undertake the necessary maintenance and exchange duties according to the manufacturer requirements in your machine's manual.

23/04/2025

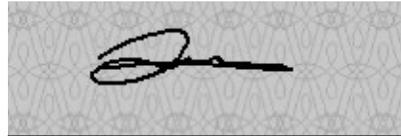
Date



Signature engineer

23/04/2025

Date



Signature customer