

# Maintenance Instructions

**TNL12.2**

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## Preface

## General notes

The maintenance activities described in this document essentially pertain only to the machine. Maintenance activities of auxiliary units (e.g., bar loading magazines, extraction systems) are described in the documentation of the specific manufacturer.

The maintenance and servicing activities must absolutely be observed. Failure to conduct maintenance and servicing in accordance with these instructions (especially not at the respective intervals) rules out any claims for damages. This does not apply if it is proved that the non-compliance with the maintenance and servicing activities is unrelated to the defect. Normal wear and tear, especially of components such as bearings and seals, is not a defect. These components are therefore excluded from the warranty. It is recommended to keep a written log of all maintenance activities carried out.

**Maintenance intervals**

The maintenance intervals are given based on the operating hours counter / "Hydraulic system On" operating condition.

**Maintenance intervals displayed on the controller (XPanel)**

Depending on the respective machine type and the different controller types, a corresponding message is issued on the controller when a maintenance interval is reached. The maintenance instructions stored on the respective controller provide information (maintenance log) explaining the service and maintenance activities to be performed.

**Cleaning of the machine****Do not clean the machine with compressed air**

- Raised dirt particles may cause breathing difficulty or injury (especially of the sensory organs). Furthermore, raised dirt particles or chips may reach spots where they cause technical problems.

**Do not use cotton waste for cleaning**

- When cleaning with cotton waste, fibers or thread can get loose causing safety problems.

**Solvents**

- Do not use highly volatile solvents such as petroleum spirit, trichloroethylene or similar cleaning agents. These cleaners may damage the seals, which can lead to safety problems.

**Pressure washers**

- Do not clean the machine with a pressure washer. Cleaning with a pressure washer results in strong corrosion. Furthermore, bearings may be degreased and seals may become leaking, which can lead to safety problems.



### **Cleaning of tool mountings**

A suitable cleaning tool must be used to clean the hole in the tool mounting.



### **Ordering spare parts**

Always specify the machine type and machine number when ordering spare parts. This and other information about the machine are located on the nameplate under the main switch of the control cabinet.



### **Operating material**

For all work in connection with operating media, observe the information in the data sheets from the respective manufacturers and the information in the document Notes on Operating Materials.



### **Pressure accumulators $\leq 1$ L**

Pressure accumulators with a volume of  $\leq 1$  L are **not** subject to testing and labeling according to the current issue of the pressure equipment directive. The guidelines and regulations applicable in the country of use must be followed.

## Safety Instructions



### **Safety Instructions and Technical Details**

The user documentation and, in particular, the document “**Safety Instructions and Technical Details**” must be observed.



## **Carrying out maintenance work**

### **Authorized and trained personnel**

- Maintenance is to be performed only by authorized and trained personnel. This applies particularly to work on motors (spindle motors) or other electrical assemblies. The instructions in the respective manufacturer documentation must be followed for such work.

### **Allow the machine to cool down**

- Prior to working on the machine, it must be allowed to cool down, as hot parts may be located under the covers.

### **Maintenance work on machine being switched off**

- In general, maintenance is to be carried out with the machine switched off. The main switch must be locked out. Even when the main switch is switched off, parts of the machine (e.g., the control cabinet light) may still carry electricity. These parts are labeled. In a few cases, maintenance work needs to be performed with the machine turned on (e.g., replacement of backup batteries). These maintenance activities must be carried out with special care.

### **Required tools**

- For removing machine parts, suitable lifting gears and a variety of tools must be used. Removed machine parts must be placed in a safe position and secured against falling over.
- All maintenance work on the machine must be carried out with utmost care. Fasteners must be loosened carefully and parts must be secured against falling down. When elastic items (springs) are removed/replaced, appropriate devices must be used. Any (non-horizontal) axes that pose a risk of falling down must be moved to their end positions or secured against falling down. Pedal switches must be put aside to avoid inadvertent actuation.

### **Performing maintenance, repair or service work**

- The currently valid safety regulations, as well as the specific manufacturer's information for the intended use must be observed for these activities.

### **Use of climbing aids (ladders or steps)**

- In addition, appropriate climbing aids may be required to carry out these activities. When working on climbing aids at great heights, e.g., on the control cabinet, these must always be secured or fastened (depending on the machine, eyelets are also provided for this purpose).



### Procurement/use of spare parts

We recommend the use of original spare parts and accessories. For damages caused by the use of parts from third-party providers, liability and warranty are excluded. The use of such products may change the structural characteristics of the machine and negatively affect the active or passive safety.



### Cellular and cordless phones

When the control cabinet is open or the machine covers are open or removed, no cellular or cordless phones may be used within a <math><2\text{ m}</math> radius.



### Handling hydraulic and hose lines

Damaged hydraulic hose lines must be replaced immediately. Typical types of damage include chafing, kinks, cracks, deformations, or visible leaks.

Flexible, pressurized hydraulic hose lines of **INDEX** equipment are generally designed as thermoplastics or metallic hydraulic hose lines.

The machine operator/owner is responsible for compliance with the laws and regulations of the country of use with regard to the use of hydraulic hoses.

We recommend inspection and documentation of the hydraulic hose lines installed inside the machine and not directly visible every 12 months. For hydraulic hose lines visible in the work area or mounted outside the machine and connecting components to the machine, we recommend inspection and documentation every 6 months.

For the flexible, pressurized hydraulic hose lines used by **INDEX**, empirical values are available for very different periods of use, some of which exceed 10 years.



### Maintenance work on fluid systems (hydraulic, lubrication, and pneumatic systems)

When carrying out maintenance work on fluid systems (hydraulic, lubrication, and pneumatic systems), make sure **before** starting the work that the respective system has been **depressurized** (accumulator drain valve / manual slide valve).



### Dry run or functional test

After all maintenance work and work on electrical assemblies, a dry run or functional test must be performed.



## **Service Interval - Care activities**

## Maintenance Summary - Care activities



It is recommended to document the maintenance activities carried out by using the appropriate maintenance log. The maintenance log has the document number DTE073EN - 23.03.2023.



The maintenance interval is highly dependent on the production and environmental conditions of the machine. The determination of the appropriate interval must be made by the operator.

**The maintenance interval should be between once per shift and once a week!**

- AL012** - Check the work area door and window pane
- AL013** - Clean the guide rail/gutter at the work area door
- AL047** - Check pneumatic unit (visual inspection)
- AL051** - Check the filter mat of the main and counter spindle cooling, clean if necessary
- AL076** - Check fill levels of the fluid tanks
- AL095** - Visual inspection of all fluid lines and electrical cables
- AL122** - Check cooling lubricant (visual inspection)
- AL137** - Check the fan in the control cabinet, clean if necessary
- AL149** - Check work area light (visual inspection)
- AL164** - Clean and check all telescopic covers and telescopes of the tool carrier units
- AL168** - Pneumatic clamping device, clamping without collet
- AL169** - Clean and lubricate clamping device
- AL170** - Check pneumatic hollow clamping device (spring tension) on main and counter spindles
- AL171** - Clean covers and wipers
- AL180** - Clean the work area
- AL241** - Clean the chip pan
- AL250** - Clean the strainer baskets (twin strainer basket) of the cooling lubricant unit
- AL264** - Clean the chip conveyor
- AL312** - Lubricate all linear axes by moving the axes.

## AL012 - Check the work area door and window pane

## Orientation



The work area door consists of the basic door with a glued-in viewing pane made of polycarbonate (work area side) and the attached design pane made of PMMA (operator side).

Inspection and maintenance of the work area door includes several steps:

- Inspection of the window pane and design pane for damage.
- Check the protective film and the circumferential overlapping bond on the window pane for damage.
- Check the safety label on the window pane (replacement interval 12 years).
- Check/adjust or replace, if necessary, the wipers.
- Check the work area door for smooth opening/closing.
- Automatic work area door (optional). Hydraulic valves and motor, control panel, rack and spur gear. (for hydraulic door drive)
- Automatic work area door (optional - electric door drive - **follow the manufacturer's documentation** ).

The window pane is subject to natural aging and must be replaced at regular intervals. There is a safety label on the window pane indicating the part no., year of manufacture, and manufacturer. The first replacement of the window pane (basic door with glued-in window pane) must be carried out 12 years after the manufacture of the machine (see type plate).



If the window pane is damaged, it must be replaced. This is necessary regardless of the extent of damage. Even with minimal damage, the impact resistance of the pane can no longer be guaranteed.



The protective film and the all-round overlapping bond must be checked for damage at regular intervals. If there is any damage to the bond or protective film, the window pane must be replaced immediately.

Heavily soiled or damaged wipers may cause damage to the inner pane. Moreover, it may be possible that the work area door can be moved only with considerable effort due to heavy soiling or chip deposits in the wipers.

Check the guide rails of the work area door. The guide bars must be checked and cleaned regularly so that the work area door can be moved without much effort.

## Procedure

1. Check the window pane and design pane for damage.

2.



The window pane (work area side) is scratch-resistant. Any commercial cleaning agent can be used here.

Clean the window pane.

3.



Use a soft cloth or sponge and glass cleaner or soapy water to clean the design pane (operator side). Do not use abrasive or alkaline cleaners (e.g., benzene, acetone or carbon tetrachloride) and no sharp tools or sharp objects (such as razor blades or screwdrivers).

Clean the design pane.

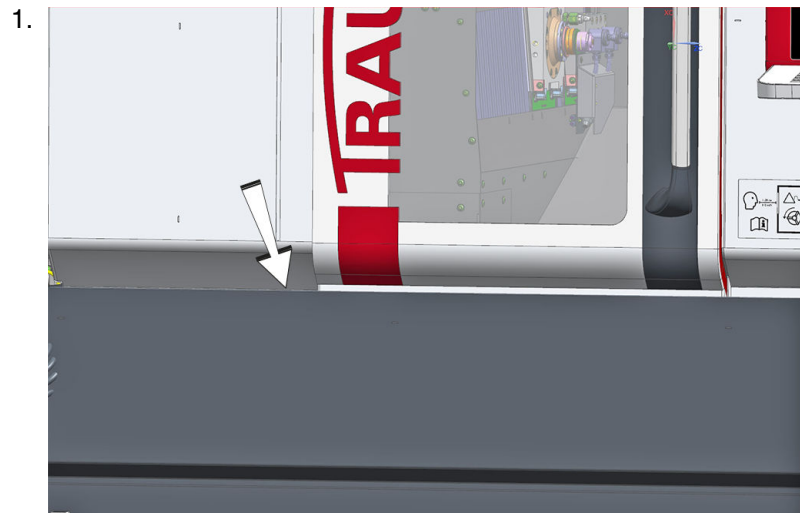
4. Check wipers. Remove and clean the wipers. If the wipers are severely deformed or damaged, they must be replaced. To clean the door panels evenly, be sure to reinstall the wipers after their removal aligned in parallel and ensure that they snugly contact the work area door.
5. Check the work area door for ease of movement. To do so, open and close the work area door. If the work area door can be moved only with effort, determine the cause. Possible causes include – depending on the work area door – defective or improperly adjusted wipers. Chips on the guide bar or between the door and wiper, or in the guide rollers of work area door.

**AL013** - Clean the guide rail/gutter at the work area door

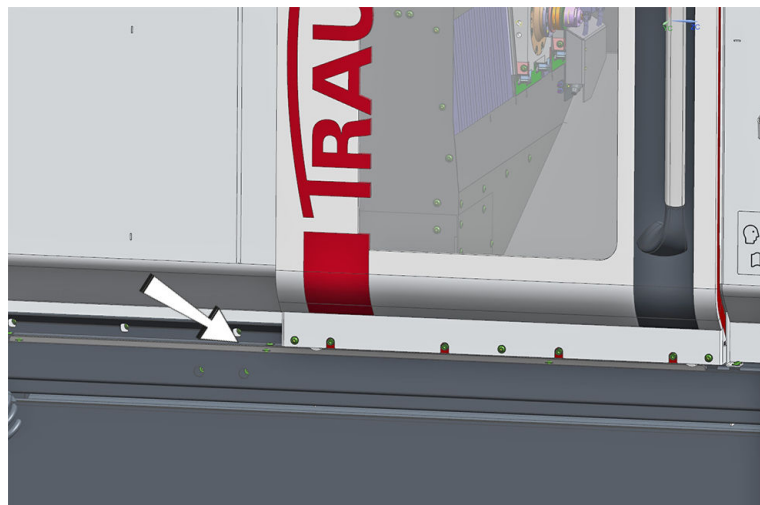
## Orientation

The guide rail/gutter located at the underside must be cleaned regularly around the work area door.

## Procedure



TNL12.2 guide rail/gutter 1



TNL12.2 guide rail/gutter 2

Remove the front cover from the work area door. Clean guide rail/gutter at the work area door.

2. Reinstall the front cover.

## AL047 - Check pneumatic unit (visual inspection)

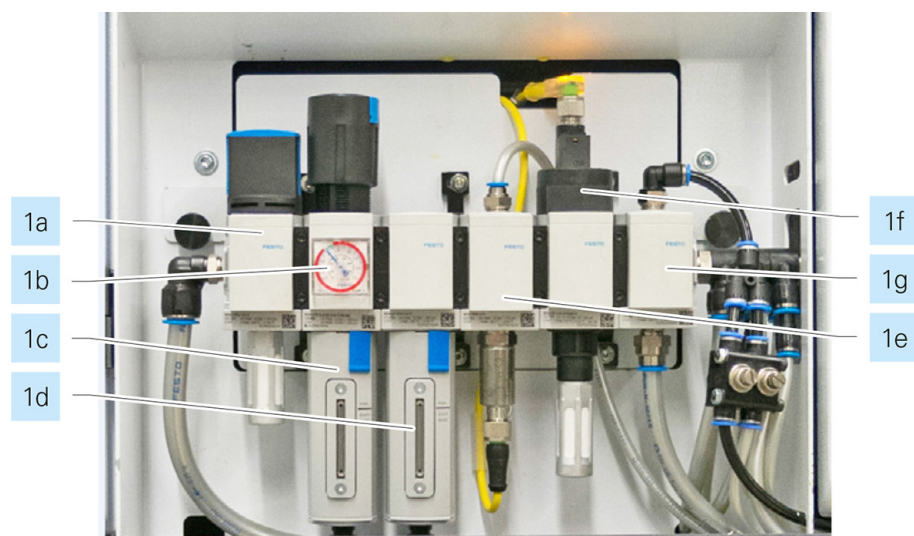
### Orientation

The pneumatic unit is composed of system parts 1a–1h. To ensure trouble-free operation, periodic checks (visual inspection) of the pneumatic unit are necessary.

- Check system pressure and sealing air settings.
- Check fluid lines.
- Drain condensate (not applicable to auto-drain).



Due to different requirements and/or specifications of the respective manufacturers, be sure to review the respective manufacturer's documentation!



**Example: Pneumatic unit TNL12.2**

- 1a** Manual switch-on valve
- 1b** Filter regulating valve / system pressure gauge 6 bar
- 1c** Filter insert 40 µm
- 1d** Filter insert 5 µm
- 1e** Branch module with system pressure sensor
- 1f** Electrical turn-off valve
- 1g** Branch module for functions

### Procedure

1. Check the pressure setting on system pressure gauge and adjust if necessary. An operating pressure of 6 bar has been set at the factory.
2. Check the pressure setting on the sealing air pressure gauge and adjust if necessary. A pressure of 1 bar has been set at the factory.
3. Check fluid lines (damage and leakage). Fluid lines must be checked for damage. Pre-damage such as kinks or abrasions should be logged and replacement should be initiated.
4. Drain condensate (not applicable to auto-drain).

**AL051** - Check the filter mat of the main and counter spindle cooling, clean if necessary

## Orientation

The filter must be cleaned regularly depending on the environmental conditions.

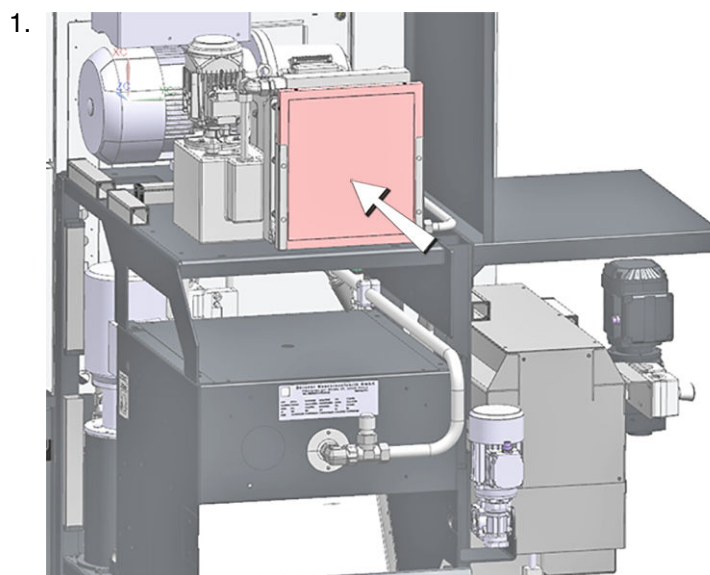


Use only the original filters according to the spare or wear parts list! Otherwise the machine is at risk of sustaining serious damage due to overheating.

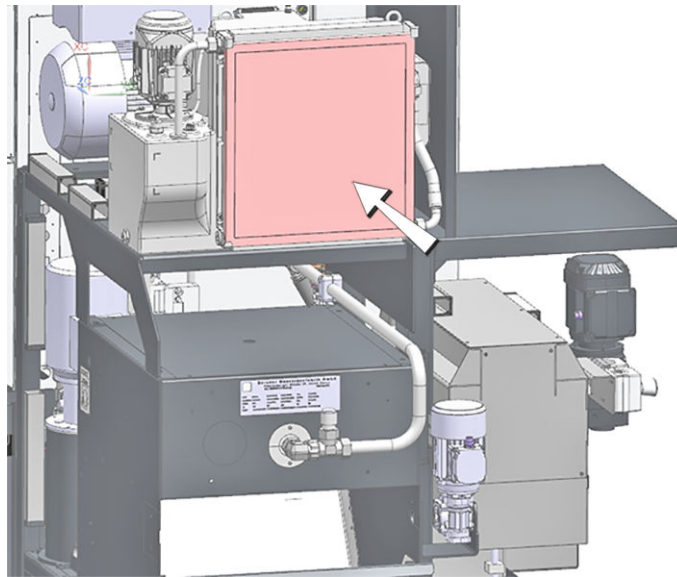


Follow the corresponding manufacturer's documentation.

## Procedure



TNL12.2\_Filter mat\_FLKS-1 (example shown)



TNL12.2\_Filter mat\_FLKS-2 (example shown)

2. If necessary, clean the filter mat according to the manufacturer's instructions. (size FLKS-1 or FLKS-2).



## AL076 - Check fill levels of the fluid tanks

### Orientation

To ensure the operational safety of the machine, the fill levels of all fluid tanks must be regularly checked, and topped off if necessary.

Operating fluids such as cooling lubricants, lubricating greases/oils are also subject to degradation or aging like the components involved in this process, and must therefore be serviced, refilled or changed at regular intervals. Do not use cotton waste and highly volatile solvents such as petroleum spirit, trichloroethylene or similar cleaning agents. The machine must not be cleaned with compressed air. To ensure trouble-free operation, periodic checks of the oil level are necessary.

The interval for this maintenance activity is strongly dependent on the operating profile of the machine. If the machine is used in three-shift operation, this maintenance activity must be carried out much more frequently.

### Requirement



For all work in connection with operating materials, the information in the data sheets of the respective manufacturers and the information in the document **Notes on Operating Materials** must be observed.



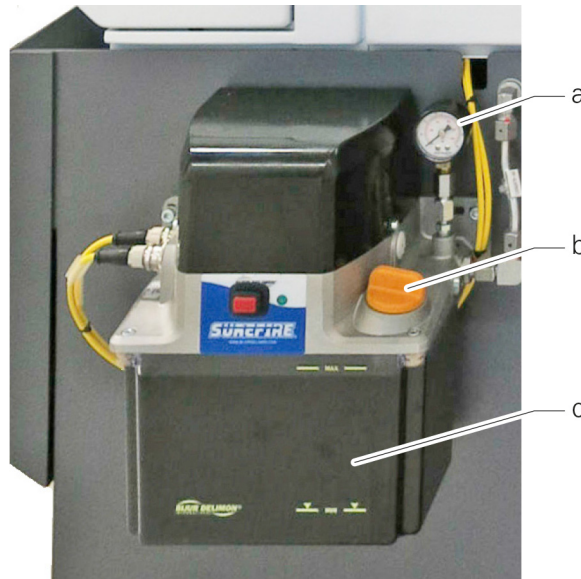
Due to different requirements and/or specifications of the respective manufacturers, be sure to review the respective manufacturer's documentation!

### Procedure

1.



Only oil of viscosity class ISO VG 220 must be used to lubricate the TNL12.2.



Central lubrication unit\_TNL12.2

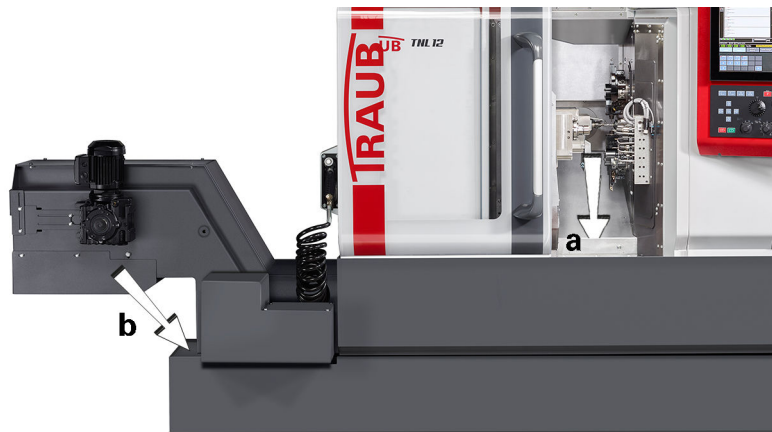
- a System pressure gauge
- b Lubricating oil filler neck.
- c Lubricating oil level indicator

Check fill level of the central lubrication unit, refill if necessary.

2.



The cooling lubricant must be checked or refilled with the machine switched on so that the cooling lubricant lifting pump of the chip conveyor / chip pan is active.



TNL12.2 Example shown

Open the fill level indicator for the cooling lubricant at the control unit and check the fill level; refill if necessary. **a) Up to machine no. 12520006** With the work area door open, refill the cooling lubricant directly into the chip conveyor/chip pan near the work area. **b) Machine no. 12520007** and higher Refill the cooling lubricant in the cooling lubricant tank.

## AL095 - Visual inspection of all fluid lines and electrical cables

### Orientation

Depending on the duration of use, usage profile of the machine and different ambient conditions, it is absolutely necessary to subject all fluid lines and electrical cables to regular visual inspections. This allows that any faults or problems can be detected and eliminated early on.



Damaged fluid lines may cause leakage of fluids under high pressure. Be sure to use personal protective equipment during visual inspection.

### Requirement

Should defective points be found on fluid lines or electrical cables during the visual inspection, the machine must be switched off and the damaged lines or cables must be promptly replaced.



Replaced fluid lines must be tightened to the torque specified by the manufacturer.

### Procedure

1. Visual inspection of all fluid lines.
2. Visual inspection of all electrical cables.

## AL122 - Check cooling lubricant (visual inspection)

### Orientation



Follow the user documentation **Notes on Operating Materials** and the documentation of the cooling lubricant manufacturer.



For all work in connection with operating materials, the information in the data sheets of the respective manufacturers and the information in the document **Notes on Operating Materials** must be observed.

The cooling lubricant is subject to wear depending on the material and the generated temperature. Regular inspection is therefore essential.

In case of strong formation of odor, fungus or mold, the cooling lubricant emulsion must be changed at once. The principle of open lubrication may cause a slight commixture between cooling lubricant and hydraulic fluid. If the surface of the cooling lubricant tank is covered with a layer of oil, the cooling lubricant must be replaced. Furthermore, determine the cause of the oil ingress.



Synthetic cooling lubricants or cooling lubricant based on esters are not admissible.

If the type of cooling lubricant or the manufacturer is changed, make sure that the cooling lubricant meets the required specifications.

See the manufacturer's documentation for the fill quantities.



Regularly checking the cooling lubricant is necessary in particular if cooling lubricant emulsions containing mineral oil are used, so that the required properties are ensured.

### Requirement

A refractometer is required to determine the concentration.

### Procedure

1.



Caution

**Biological and chemical changes in the cooling lubricant.  
Skin irritation or respiratory and circulatory problems.**

Wear personal protective equipment (e.g., safety gloves and safety goggles).

Remove a cover (e.g., at the filter basket) on the chip pan or the chip conveyor.

2. Visual and olfactory inspection of the cooling lubricant.

3. Check cooling lubricant emulsion. See document **Notes on Operating Materials**

4. Check fluid lines. Fluid lines must be checked for damage. Pre-damage such as kinks or abrasions should be logged and replacement should be initiated.

## AL137 - Check the fan in the control cabinet, clean if necessary



Carrying out the maintenance activities described below requires special knowledge. For this reason, these maintenance activities must only be carried out by staff that has received adequate training by the machine manufacturer!

### Procedure

1.



Caution

**Electrical equipment or parts thereof are under dangerous voltage.**

**Electric shock.**

Switch off the machine and lock it out.



Fan in control cabinet TNL12.2

Check the fan in the control cabinet, clean if necessary.

## AL149 - Check work area light (visual inspection)

### Orientation

To ensure even illumination of the working areas in the machine, work area lights are installed in the work area.

They enable safe working and should therefore be checked regularly. **Damaged lighting fixtures must be replaced immediately.**

### Procedure

1. Check all lamps (visual inspection).
- 2.



Example: Work area light TNL20

Check lamp protective glass for damage. If cooling lubricant has already penetrated into the lamp protective glass of the work area light, the lamp must be repaired.

## AL164 - Clean and check all telescopic covers and telescopes of the tool carrier units

### Orientation

Depending on the material used and the machining process, the telescopic covers and telescopes must be cleaned and checked regularly. In particular, before any prolonged shutdown of the machine (e.g., during weekends).



After cleaning, the telescopic covers and wipers must be coated with low-viscosity oil.

The oil must not resinify and sediments must not form when exposed to other fluids or machining residues (e.g., metallic dust). Otherwise, the service life of the wipers would be considerably impaired.

### Requirement

To clean the telescopic covers and the telescopes of the upper/lower tool carriers, counter spindle, front working attachment, and back working attachment, the respective tool carrier units must be moved to suitable positions.

### Procedure

1. Clean telescopic covers and telescopes.
2. Flush plates with cooling lubricant.
3. Check the plates for visible damages (e.g., dents or flaws). Have damaged plates repaired or replaced immediately by the machine manufacturer's service personnel.
4. Apply thin oil to telescopic plates by spraying or rubbing.
5. Carefully move tool carrier units back and forth, if necessary, spray or rub with oil.



## AL168 - Pneumatic clamping device, clamping without collet

### Orientation

To ensure lubrication of the pneumatic clamping device across the entire clamping area, some clamping operations should be made over the entire stroke without a collet when changing the collet.



Follow the corresponding manufacturer's documentation.

### Procedure

1. Perform no-load clamping according to the manufacturer's instructions.

## AL169 - Clean and lubricate clamping device

### Orientation

To ensure reliability and accuracy of the machine, clamping devices must be subjected to periodic maintenance.

The interval of this maintenance is strongly influenced by the type of material and daily production time. Especially for short chipping materials (e.g., brass or cast iron), these maintenance activities must be performed much more frequently.

Compression collets and guide bushings must be removed for cleaning.

Remove the compression collet from the main spindle in the work area, independent of fixed or sliding headstock operation.



Due to different requirements and/or specifications of the respective manufacturers, be sure to review the respective manufacturer's documentation!



Depending on the materials to be machined (e.g.: brass, cast iron) and the number of shifts per day, more frequent cleaning of the clamping device is necessary.

For this, the clamping device must be removed and completely cleaned.

### Requirement



Example: Collet and chuck.



**Do not use cotton waste for cleaning.**

When cleaning with cotton waste, fibers or thread can get loose causing safety problems.

### Procedure

1.



Caution

**Sharp contours on the clamping device**

**Cuts**

Use personal protective equipment (e.g., protective gloves)



The **removal/installation of the compression collet and guide bush** is described in the document "Layout and function of the machine TNL12.2".

Clean clamping devices

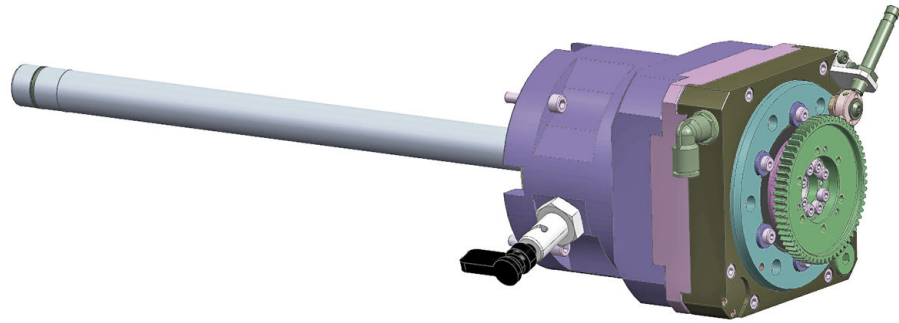
2. Lubricate clamping devices according to manufacturer's instructions.

## AL170 - Check pneumatic hollow clamping device (spring tension) on main and counter spindles

### Orientation



Due to different requirements and/or specifications of the respective manufacturers, be sure to review the respective manufacturer's documentation!



Pneumatic clamping device TNL12.2

### Procedure

1. Check clamping stroke of the pneumatic hollow clamping device (spring tension) by empty clamping
2. Perform clamping force measurement with suitable clamping force measuring device.

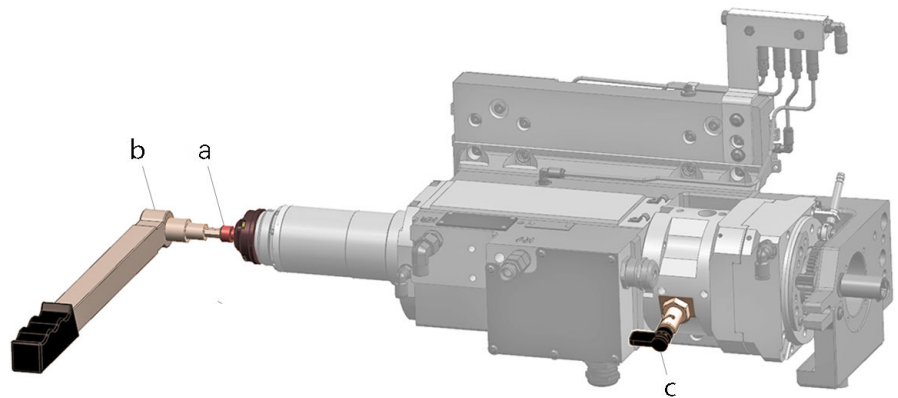
#### **Alternatively, the following procedure can be used!**

Alternatively, the clamping force can be measured with a torque wrench and a screw turned down (see from point 3).

3.

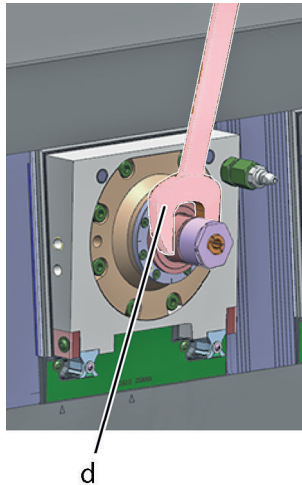


The main and counter spindles must be secured against rotation for torque measurement. **Main spindle** by locking with the latching pin. Hold the **counter spindle** with the a/f32 wrench included in the accessories; the electromagnetic locking unit must not be actuated. For the **clamping force adjustment**, see Document "Structure and Features of the Machine", Chapter "Work fixture".



Example shown: TNL12.2 Torque measurement on main spindle

- a Screw (adapted to required dia.)
- b Torque wrench
- c Latching pin on main spindle



Example shown: TNL12.2 Counter spindle counterhold

- d 32mm wrench for counter spindle

4. For torque measurement using a torque wrench, turn a screw (e.g., M10) smoothly to the desired diameter.
5. Clamp the stripped screw into the spindle to be checked.
6. Set the torque wrench to the desired torque.
- 7.



Secure the **main spindle** with the latching pin (c) during measurement. Hold the **counter spindle** with the a/f32mm wrench (d) during measurement.

Measure the clamping force with the torque wrench. If necessary, adjust the respective clamping force.

## AL171 - Clean covers and wipers

### Orientation

Depending on the material used and the machining process, the covers and wipers must be cleaned and checked regularly. In particular, for dry machining and before any prolonged shutdown of the machine (e.g., during weekends).

Dirty covers and wipers affect the accuracy of the machine and its service life.

Contamination of the covers and wipers results in increased friction (stiffness) of the plates. This may damage the covers and wipers so that contaminants can get into the area behind the cover. This in turn may cause damage to other machine parts, requiring expensive repair. In the event of damage, determine the cause of the damage and immediately notify the machine manufacturer or its representative company.



After cleaning, the cover must be coated with low-viscosity oil.

The oil must not resinify and sediments must not form when exposed to other fluids or machining residues (e.g., metallic dust). Otherwise, the service life of the wipers would be considerably impaired.

### Requirement

Before starting the cleaning, move the tool slides to positions that are more convenient for the cleaning process.



Power off the machine and secure it against power on.

### Procedure

1. Clean cover panels. Remove chips with a suitable chip hook or hand-held broom. Afterwards rub with a cloth.
2. Check covers and wipers for damage. Look for deep scoring or abrasion.
3. Oil covers.
4. Switch the machine on and move the tool slides until an even film of oil is visible over the whole traversing range of the covers. If relubrication is required, first stop the travel movement and set feed rate override to “zero” position.

## AL180 - Clean the work area

### Orientation

To ensure consistent quality, high availability and value retention, the machine must be regularly cleaned, depending on the operating conditions.

Of course, this is influenced by various factors. The use of emulsion as a cooling lubricant requires a more frequent and intensive cleaning.

Compared to machining producing long chips, machining producing short chips requires a considerably higher maintenance effort. Short chips, such as in the machining of brass or cast iron, form chip accumulations or become deposited in small cracks and corners. These positions must be cleaned regularly to avoid damage to the respective components.

Areas such as telescopic covers, rubber seals, sealing lips or wipers are particularly affected points. Frequent cleaning of these areas is particularly important.

### Requirement



Only the agents described in the documentation may be used for the cleaning and after-treatment of the machine.

Always use the proper tool to remove chips.

The following tools are required for cleaning:

- chip hooks,
- chip brushes,
- spray bottles of cleaners or cooling lubricant,
- a sufficient quantity of rags,
- the used medium, cooling lubricant to apply to the telescopic plates and all other bare parts by spraying or by brushes.

### Procedure

1.



**Chips and projecting tools in the work area.**

**Cuts.**

Use of personal protective equipment such as safety goggles and gloves, and appropriate tools.

Remove chips from the work area.

2. Chip accumulation particularly in the area of the tool carriers and the work area door.
3. Flush work area with cooling lubricant.
4. Wipe clean with rags.
5. Apply an oil film to bare metal plates and telescopic covers.
6. Examine any visible damage, and repair or replace, if necessary.

## AL241 - Clean the chip pan

### Orientation



Avoid skin contact with cooling lubricant! Use appropriate skin protection agents!...



For all work in connection with operating materials, the information in the data sheets of the respective manufacturers and the information in the document **Notes on Operating Materials** must be observed.

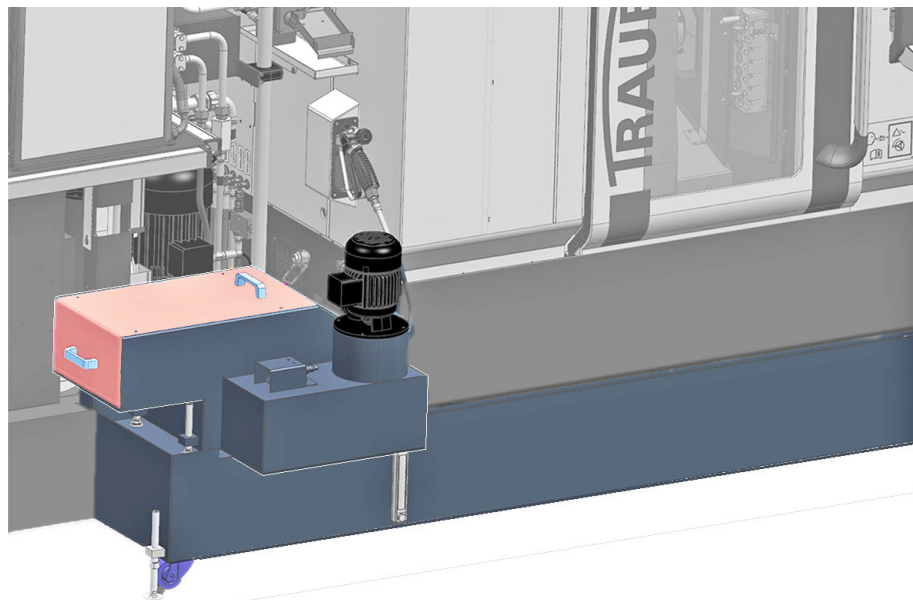


Follow the corresponding manufacturer's documentation.



Removing the chips is allowed only when the machine is switched off or in setup mode.

To ensure a smooth production process, the chip pan should be cleaned and serviced regularly. The cleaning interval depends on the utilization of the machine. The chip pan is used for collection of chips from the work area and is also a reservoir for the cooling lubricant. In particular, make sure that the area around the cooling lubricant pump(s) is always free of chips or dirt.



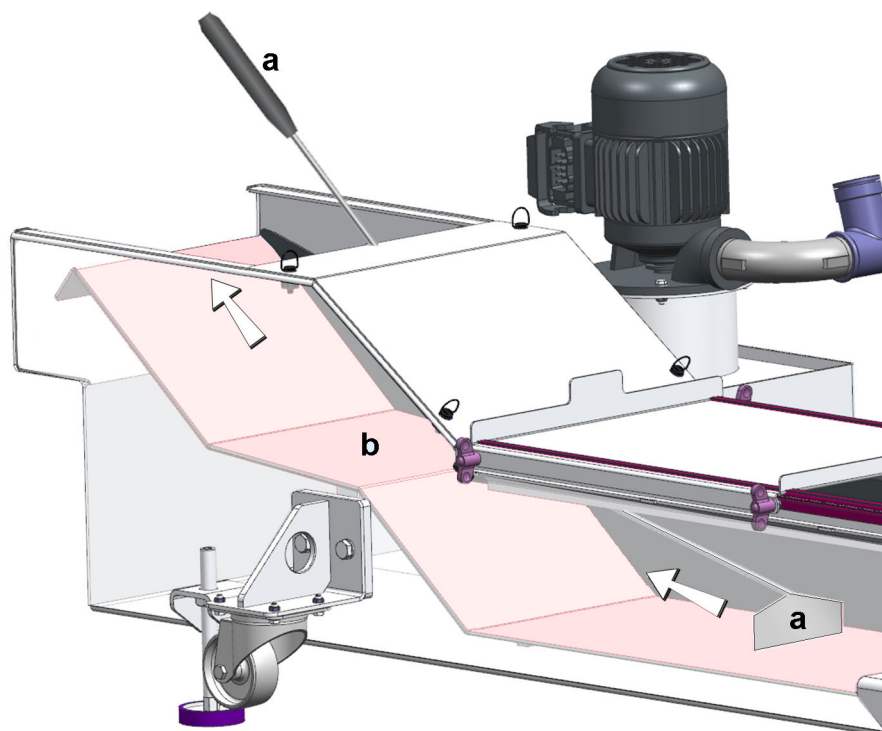
TNL12.2 Chip tray (example shown)

### Procedure

1. Open the screws/releases on the cover. Lift the cover at the upper handle and take it off using the second handle.
2. If necessary, push the chips from the machine area to the chip pusher (a).



3.



Example shown

Use the chip pusher (a) to push the chips to the storage/drip position (b) and allow the cooling lubricant to drain.

4. Then deliver the chips into a suitable container using the chip pusher.
5. Replace the cover and fasten it with the 2 quick releases.

## AL250 - Clean the strainer baskets (twin strainer basket) of the cooling lubricant unit

### Orientation



Avoid skin contact with cooling lubricant! Use appropriate skin protection agents!...

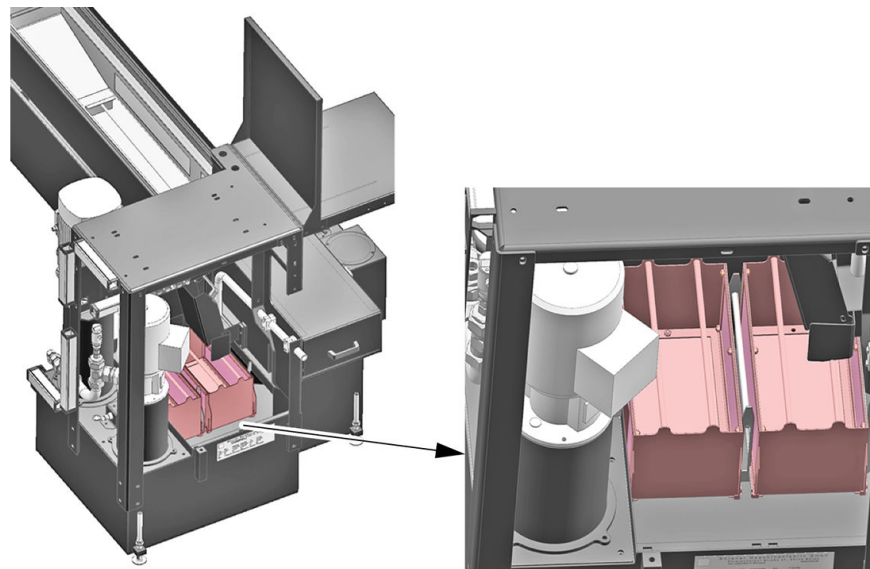


For all work in connection with operating materials, the information in the data sheets of the respective manufacturers and the information in the document **Notes on Operating Materials** must be observed.



Follow the corresponding manufacturer's documentation.

The cooling lubricant unit can be equipped with 2 strainer baskets (twin strainer basket) for filtering fine chips from the cooling lubricant of the chip tray / chip conveyor. To ensure a smooth production process, the strainer baskets should be cleaned regularly. The cleaning interval depends on the utilization of the machine. One strainer basket is always in use, while the other strainer basket can be emptied and cleaned.



TNL12.2 Cooling lubricant unit with twin screen basket (example shown)

### Procedure

1. Perform service and maintenance activities on the strainer baskets according to the manufacturer's instructions.

## AL264 - Clean the chip conveyor

### Orientation



Service and maintenance are to be carried out according to the manufacturer's specifications.



For all work in connection with operating materials, the information in the data sheets of the respective manufacturers and the information in the document **Notes on Operating Materials** must be observed.

### Requirement

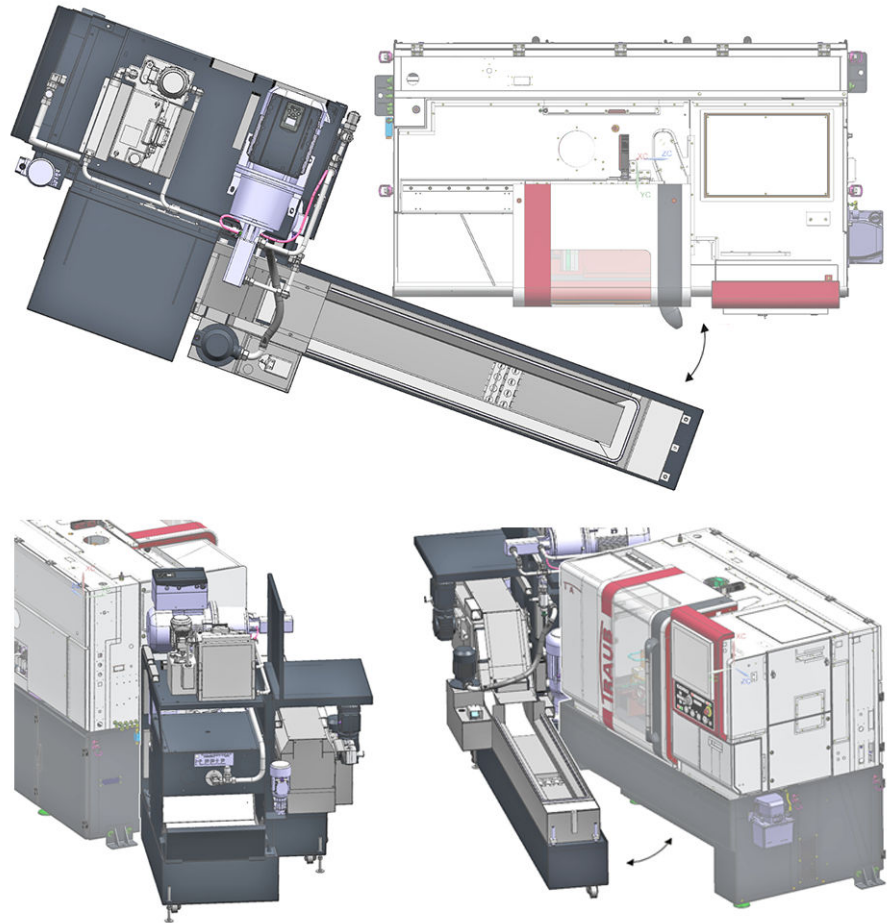
To ensure a smooth production process, the chip conveyor should be cleaned and serviced regularly. With regular cleaning, any defects can be detected and corrected early. The chip conveyor is used for removing the produced chips from the work area. The cooling lubricant is filtered in the chip conveyor. For this purpose, various filters and filter plates are built into the chip conveyor. These filters must be cleaned regularly.



Be sure to interrupt the motion of the conveyor belt by switching off the chip conveyor before commencing cleaning work around the discharge chute!

## Procedure

1.



Cooling lubricant unit with chip conveyor (example shown)

For cleaning and maintenance work, the cooling lubricant unit with chip conveyor can be swung away from the machine as indicated in the figures. If necessary, close the hose connection to a central cooling system (e.g., water-water cooling of the spindle cooling) by means of a shut-off valve or separate it by means of a quick coupling.


2. Perform service and maintenance activities on the chip conveyor according to the manufacturer's instructions

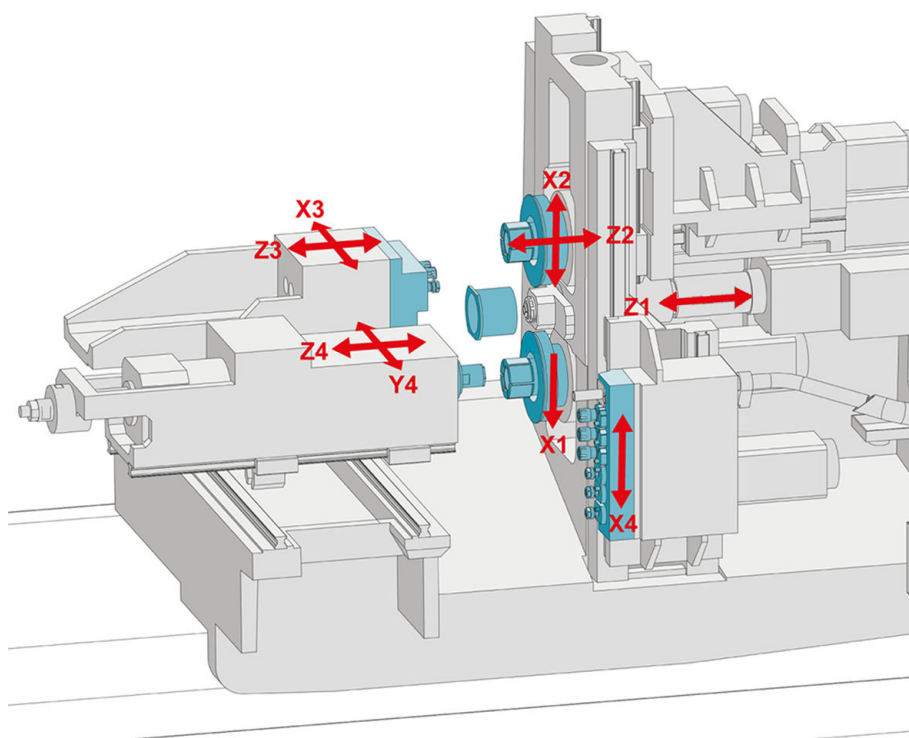
**AL312** - Lubricate all linear axes by moving the axes.

## Orientation

Move all linear axes through the maximum travel stroke to ensure uniform lubrication of the linear guides.

## Procedure

-  When moving the axes, be sure to pay attention to the collision zones with other spindles, tool carriers and tools.



TNL12.2 linear axes

Lubricate all linear axes by moving the axes.



**Service Interval - 2.000 Operating hours**

## Maintenance Summary - 2.000 Operating hours



It is recommended to document the maintenance activities carried out by using the appropriate maintenance log. The maintenance log has the document number DTE073EN - 23.03.2023.

- CL010** - Check maintenance logs of servicing activities
- CL020** - Clean and check wipers and guide rails of the work area door
- CL120** - Replace post-filter for cutting oil mist
- CL500** - Perform data backup
- CL520** - Check control cabinet



## CL010 - Check maintenance logs of servicing activities

### Orientation

The maintenance logs on the performed maintenance activities allow you to review the maintenance activities carried out between two maintenance intervals. The logs may contain important indications as to work that may be necessary beyond the maintenance activities. Similarly, the logs can be used for determining the cause of malfunctions due to incorrect or inadequate maintenance activities carried out.

### Procedure

1. Check maintenance or inspection logs.

## CL020 - Clean and check wipers and guide rails of the work area door

### Orientation



Regular inspection of the wipers prevents damage to the wipers themselves and to the work area door.

If the work area door can be opened and/or closed only with increased effort, it can be expected that the wipers are already destroyed by accumulation of chips and swarf compaction.

### Requirement



Example: Chip hook and chip brush

Use appropriate tools to remove coarse chips, chip nests and other debris.

### Procedure



Example: 1 Removing chip nest using appropriate tools (e.g., chip hooks)

Remove large chips on the inside of the work area door from top to bottom. Use a chip hook for this purpose.



Example: 2 Sweep small chips and other debris from top to bottom using chip brooms or brushes.

Remove small chips and chip accumulations on the inside of the work area door from top to bottom. Use a chip brush for this purpose.




Example: 3 upper wipers, G300

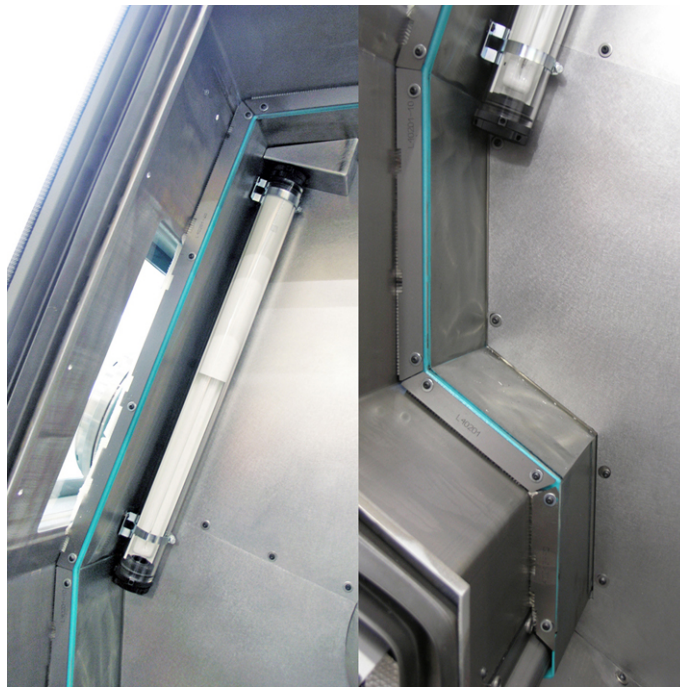
Clean wipers.

**Alternatively, the following procedure can be used!**

In case of heavy soiling or adhesion of chips to the wipers, the wipers and associated cover panels should at any rate be completely removed and cleaned. **In this case, also clean the area behind the wipers.**

- 4.
- 

Make sure that the wipers evenly contact the work area door before tightening the screws.



Example: 4 wipers on the sides and bottom, G300

Check the wipers for proper seating. After the work area door has been cleaned, it should open and close again without much effort as usual

5.



If cleaning or replacement of the wipers has not resulted in tangible improvement, the soiled rollers and the guide rail of the work area door must also be cleaned.

Clean rollers and guide rail of the work area door.

**CL120** - Replace post-filter for cutting oil mist

## Orientation



Post-filter for cutting oil mist

The post-filter must be replaced regularly depending on the environmental conditions.



Follow the corresponding manufacturer's documentation.



Only original filters must be used!



After a deflagration in the machine, the post-filter may have to be replaced, depending on the degree of discoloration. After max. 3 deflagrations, the post-filter must be replaced without fail.



Post-filter for cutting oil mist: left new – right used

## Procedure

1. Replace post-filter for cutting oil mist according to manufacturer's instructions

## CL500 - Perform data backup

### Orientation

Using a current data backup, the machine can be restored to the original state before the failure after a defect of the internal storage device/NC control.

The file name of the data backup includes the machine type, machine number, and date/time of the backup.

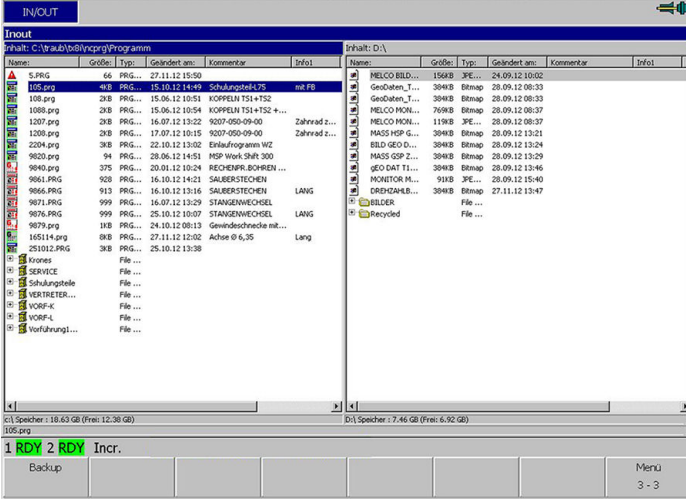


Network settings and the customer's NC programs are not included in the backup.

Backup additionally to an external data carrier for access in case of a defect of the internal storage medium.

### Procedure

1. Connect USB device to USB port

2. 

Example shown

Open **IN/OUT** screen and use **TAB** to activate the right part of the screen

3. Press **Softkey Select** (F3) (select appropriate target, e.g., USB)
4. Press **Softkey Menu** (F8) twice. Softkey text "Menu 3-3" appears

5. Note that the backup includes no customer NC programs! Include them in a separate backup, if necessary

Press **Softkey Backup** (F1) and press **Softkey OK** (F1) to acknowledge the informational message

All relevant parameters and data for the backup are compiled


6. Press **Softkey OK** (F1) to confirm the transfer of the data to the desired storage location

## CL520 - Check control cabinet

### Orientation


To avoid problems and prevent any resulting system failures, simplified control cabinet checks must be carried out at regular intervals on the cabinet and associated components. Additional built-in air conditioning units (option) ensure a constant temperature in the control cabinet. These air conditioners cannot work efficiently if filters are dirty or doors are not tight.

### Procedure

1.  **Electric shock**  
Power off the machine and wait approx. 30 minutes. Check with a meter if there is still voltage applied to the intermediate circuit.

Check settings of the fuses. For this purpose, review the information in the wiring diagram.

2. Check the screws of drives, terminals, control modules, connectors, bus, device bus and intermediate circuit bus for tightness.

3.  Due to different requirements and/or specifications of the respective manufacturers, be sure to review the respective manufacturer's documentation!

If necessary, check settings on the air conditioning unit(s).

4. Clean suction port(s).
5. Check condensate drain.
6. Check door seals.





**Service Interval - 4.000 Operating hours**

## Maintenance Summary - 4.000 Operating hours



It is recommended to document the maintenance activities carried out by using the appropriate maintenance log. The maintenance log has the document number DTE073EN - 23.03.2023.

- DL010** - Cleaning of the machine
- DL031** - Check coolant
- DL052** - Check central lubrication unit
- DL056** - Check pneumatic unit
- DL072** - Check pneumatic hollow clamping device (spring tension) on main and counter spindles
- DL076** - Check the cycloidal gear on the upper and lower turrets
- DL160** - Determine axis ball screw backlash
- DL170** - Axes
- DL180** - Check fire protection system (visual inspection)
- DL227** - Replace belts and check belt tension
- DL485** - Replace the wiper and telescopic plates
- DL493** - Replace wiper in guide sleeve for fixed headstock operation
- DL510** - Perform data backup
- DL520** - Check control cabinet and cable assemblies (visual inspection)
- DL590** - Check inspection/replacement date of the backup batteries in the control cabinet (NC)
- DL636** - Check the replacement interval of the servo backup batteries at the axis servos.
- DL640** - Check the check valve of the workpiece pickup/gripper unit

## DL010 - Cleaning of the machine

### Orientation

To ensure consistent quality, high availability and value retention, the machine must be regularly cleaned, depending on the operating conditions.

Of course, this is influenced by various factors. The use of emulsion as a cooling lubricant requires a more frequent and intensive cleaning.

Compared to machining producing long chips, machining producing short chips requires a considerably higher maintenance effort. Short chips, such as in the machining of brass or cast iron, form chip accumulations or become deposited in small cracks and corners. These positions must be cleaned regularly to avoid damage to the respective components.

Areas such as telescopic covers, rubber seals, sealing lips or wipers are particularly affected points. Frequent cleaning of these areas is particularly important.

### Requirement



Only the agents described in the documentation may be used for the cleaning and after-treatment of the machine.

Always use the proper tool to remove chips.

The following tools are required for cleaning:

- chip hooks,
- chip brushes,
- spray bottles of cleaners or cooling lubricant,
- a sufficient quantity of rags,
- oil to apply to the telescopic plates and all other bare parts by spraying or by brushes.

### Procedure

1.



**Chips and projecting tools in the work area.**

**Cuts.**

Use of personal protective equipment such as safety goggles and gloves, and appropriate tools.

Remove chips from the work area.

2. Chip accumulation particularly in the area of the tool carriers and the work area door.
3. Flush work area with cooling lubricant.
4. Wipe clean with rags.
5. Apply an oil film to bare metal plates and telescopic covers.
6. Check plates for damage, repair or replace if necessary.

7.



When cleaning the drive area, make sure that the dirt does not penetrate directly into the path measuring systems and the ballscrews. The cleaning process must not aggravate the contamination of the components.

Clean drive area. Spray cooling lubricant onto the drive area around the supports of the guide bars and then sweep off the rough dirt down into the drag of the machine with a hand brush. Afterwards rub with rags.

8.



When cleaning the spindle carriers, make sure that the dirt does not penetrate directly into the spindle encoders. The cleaning process must not aggravate the contamination of the components. Follow the manufacturer's documentation.

Cleaning of the spindle carriers of the main and counter spindles. Remove machine covers in the area of the spindles. Then remove and clean the spindle covers.

9. Clean the machine base. Remove accumulations of chips, especially in the area of the counter spindle. For this purpose, move the counter spindle towards the main spindle and flush the area with cooling lubricant in the direction of the chip conveyor. Sweep the dirt arising from the cleaning of the drive area also in the direction of the chip conveyor and then flush with cooling lubricant. Afterwards rub with rags.

10. Clean and reinstall machine covers.

11. Clean the collecting tray under the workpiece handling unit.

## DL031 - Check coolant

## Orientation

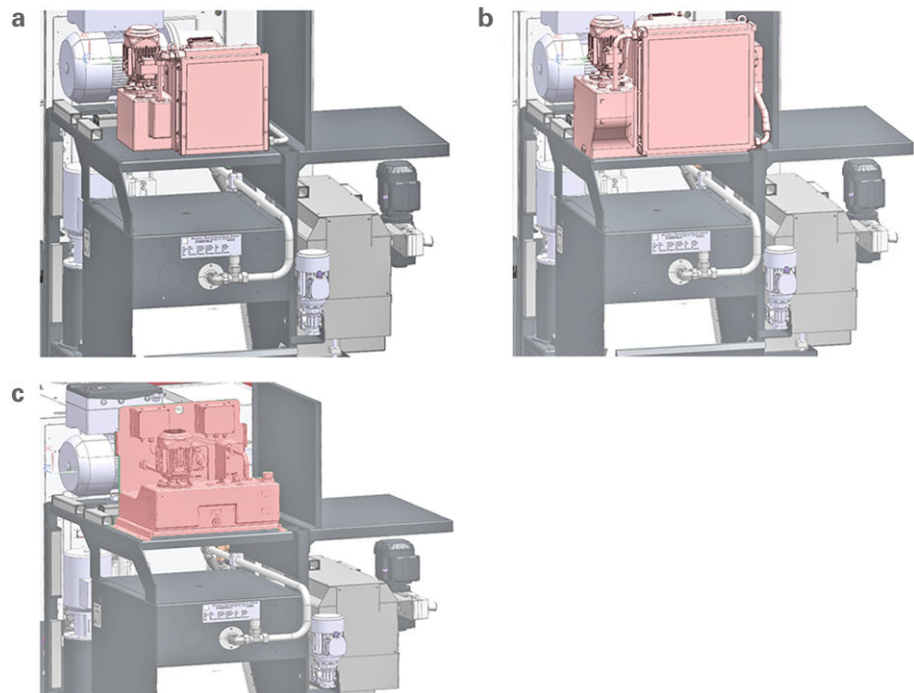
For add-on equipment that cannot be cooled conventionally with cooling lubricants or hydraulic fluid due to high temperature development, separate cooling is provided in an independent cooling circuit. The coolant used here should be checked continuously for its condition.



Due to different requirements and/or specifications of the respective manufacturers, be sure to review the respective manufacturer's documentation!



For all work in connection with operating materials, the information in the data sheets of the respective manufacturers and the information in the document **Notes on Operating Materials** must be observed.



TNL12.2 Cooling unit for spindle cooling (example shown)

- a Cooling unit FLKS-1
- b Cooling unit FLKS-2
- c Cooling unit FWKS

## Requirement



Replenish only with coolant of the same manufacturer having the same specification. Mixing different coolants may lead to corrosion of the cooling system and degradation of the coolant.



When switching the coolant to another product or changing the manufacturer, the cooling system must be completely flushed and cleaned with this coolant. Only then the machine may be put back into operation.

## Procedure

1. Check coolant. Test criteria for this visual inspection are the clarity and purity of the coolant.

If necessary, replace the coolant according to the manufacturer's requirements

2. Check fill level

**DL052** - Check central lubrication unit

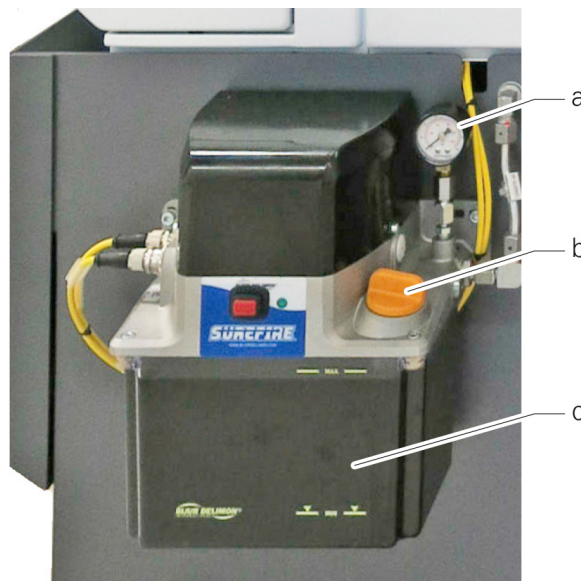
## Orientation



Due to different requirements and/or specifications of the respective manufacturers, be sure to review the respective manufacturer's documentation!



Only oil of viscosity class ISO VG 220 must be used to lubricate the TNL12.2.



Central lubrication\_TNL12.2

- a System pressure gauge
- b Lubricating oil filler neck
- c Lubricating oil level indicator

**Lubrication points of central lubrication unit**

- X/Z axis upper turret → trolley, screw drive (option)
- Tool drive in lower/upper turret → drip lubrication, gear (option)
- Z axis main spindle → trolley, screw drive
- Y/Z axis counter spindle → guide, ballscrew drive
- X/Z axis front working attachment → guide, ballscrew drive (option)
- Front working attachment tool drive → Drip lubrication, gear (option)
- X axis lower turret → trolley, screw drive
- X axis back working attachment → trolley, screw drive
- Back working attachment tool drive → Drip lubrication, gear (option)

## Requirement

The maintenance of the central lubrication unit system requires the following auxiliary or working equipment:

- Use an ample supply of cleaning rags.
- A sufficient amount of lubricating oil for refilling/changing.

- Replacement filters for lubricating oil tank if necessary.

## Procedure

1. Check fill level of the central lubrication unit; refill if necessary.
2. Approx. 10 x apply lubrication pulse in the control.
3. Monitor the area around the lubricating oil distributor for leakage



## DL056 - Check pneumatic unit

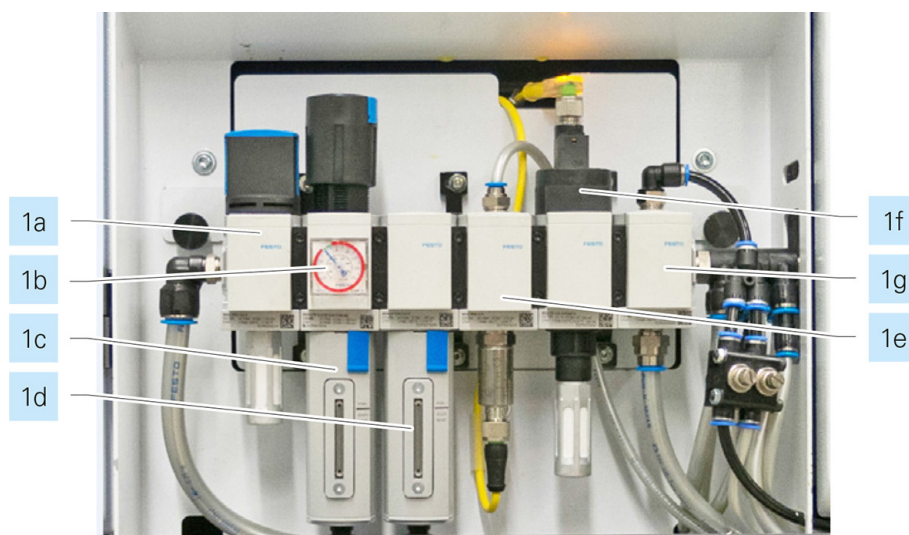
## Orientation

The pneumatic unit is composed of system parts 1a–1h. To ensure trouble-free operation, periodic checks of the pneumatic unit are necessary.

- Check oil level at oiler.
- Check system pressure and sealing air settings.
- Check fluid lines.
- Drain condensate (not applicable to auto-drain).
- Check pressure setting on the pressure differential monitoring pressure gauge.



Due to different requirements and/or specifications of the respective manufacturers, be sure to review the respective manufacturer's documentation!



**Example: Pneumatic unit TNL12.2**

- 1a** Manual switch-on valve
- 1b** Filter regulating valve / system pressure gauge 6 bar
- 1c** Filter insert 40 µm
- 1d** Filter insert 5 µm
- 1e** Branch module with system pressure sensor
- 1f** Electrical turn-off valve
- 1g** Branch module for functions

## Procedure

1.



Power off the machine to depressurize the pneumatic unit and secure against accidental switching on.

Check oil level at oiler

2. Check fluid lines (damage and leakage). Fluid lines must be checked for damage. Pre-damage such as kinks or abrasions should be logged and replacement should be initiated.

3.



Dirty filter cartridges must never be cleaned but always replaced. Filter cartridges are hazardous waste and must be disposed of according to local regulations.

Only filters with a filter fineness described in the fluid plans must be used.

Replace filter.

4.



Condensate is extremely harmful to the environment due to its high pollution impact. Condensate must be collected in a container specifically marked for this purpose and properly disposed of.

Drain condensate (not applicable to auto-drain).

5. Switch on the machine.

6. Check the pressure setting on system pressure gauge and adjust if necessary. A pressure of 6 bar has been set at the factory.

7.



Dirty measuring systems or lack of sealing air can cause damage to the machine.

Check sealing air supply. To protect measuring systems or other components from the ingress of liquids or dirt, they are pressurized (1.0 bar). In this case, a low hiss is noticeable. To ensure trouble-free operation, periodic checks of the sealing air supply are necessary.

8. Check all fluid lines of the sealing air supply for damage.

9. Check the pressure setting on the sealing air pressure gauge and adjust if necessary. A pressure of 1 bar has been set at the factory.

10. Check sealing air supply on the components. A reliable method is the use of a suitable pressure gauge. The pressure gauge is attached to the line that is screwed off to monitor the existing pressure. The pressure should be in the range of the preset pressure of the sealing air supply. If this is not the case, the cause must be determined and the fault must be fixed.

**Alternatively, the following procedure can be used!**

Disconnect the fluid line in the area of the components and cover the opening of the fluid line with your finger. A slight counter pressure should be felt. Then connect the fluid line again.

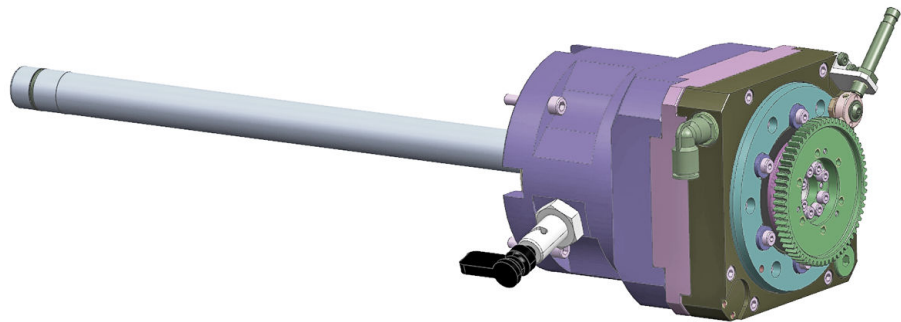
11. Check the pressure settings on the differential pressure sensor for glass scales and adjust if necessary. An operating pressure of 1.0 bar has been set at the factory.

**DL072** - Check pneumatic hollow clamping device (spring tension) on main and counter spindles

## Orientation



Due to different requirements and/or specifications of the respective manufacturers, be sure to review the respective manufacturer's documentation!



Pneumatic clamping device TNL12.2

## Procedure

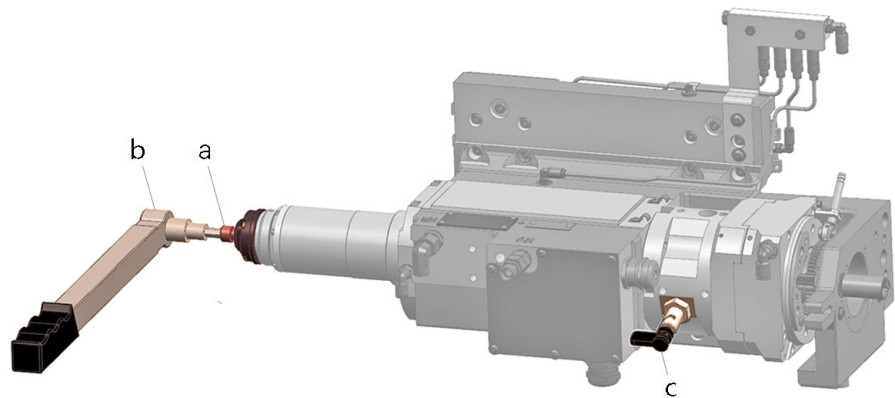
1. Check clamping stroke of the pneumatic hollow clamping device (spring tension) by empty clamping
2. Perform clamping force measurement with suitable clamping force measuring device.

**Alternatively, the following procedure can be used!**

Alternatively, the clamping force can be measured with a torque wrench and a screw turned down (see from point 3).

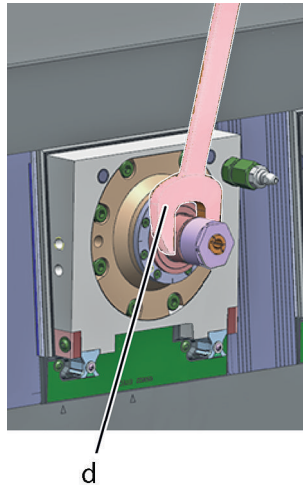
3.
 

The main and counter spindles must be secured against rotation for torque measurement. **Main spindle** by locking with the latching pin. Hold the **counter spindle** with the a/f32 wrench included in the accessories; the electromagnetic locking unit must not be actuated. For the **clamping force adjustment**, see Document "Structure and Features of the Machine", Chapter "Work fixture".



**Example shown: TNL12.2 Torque measurement on main spindle**


- a** Screw (adapted to required dia.)
- b** Torque wrench
- c** Latching pin on main spindle



**Example shown: TNL12.2 Counter spindle counterhold**

- d** 32mm wrench for counter spindle

4. For torque measurement using a torque wrench, turn a screw (e.g., M10) smoothly to the desired diameter.
5. Clamp the stripped screw into the spindle to be checked.
6. Set the torque wrench to the desired torque.
- 7.



Secure the **main spindle** with the latching pin (c) during measurement. Hold the **counter spindle** with the a/f32mm wrench (d) during measurement.

Measure the clamping force with the torque wrench. If necessary, adjust the respective clamping force.

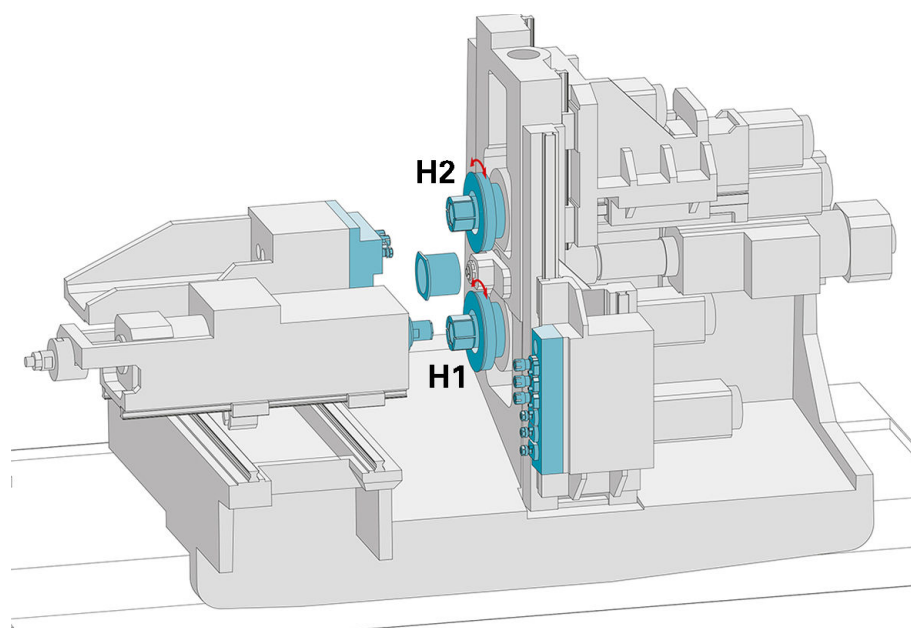
**DL076** - Check the cycloidal gear on the upper and lower turrets

Carrying out the maintenance activities described below requires special knowledge. For this reason, these maintenance activities must be carried out only by authorized personnel of the manufacturer!

**Orientation**

The cycloidal gear must be checked on the upper and lower turrets by measuring the axial runout and the repeatability of the H axis.

- Upper/lower turrets
- H axes 360 degrees



H axes TNL12.2

**Procedure**

1. Check the cycloidal gear on the turrets by measuring the axial runout and the repeatability of the H axes.

## DL160 - Determine axis ball screw backlash



Carrying out the maintenance activities described below requires special knowledge. For this reason, these maintenance activities must only be carried out by staff that has received adequate training by the machine manufacturer!

### Orientation



The Z axis should be adjusted around the machining position, as the backlash is not constant across the entire Z axis!

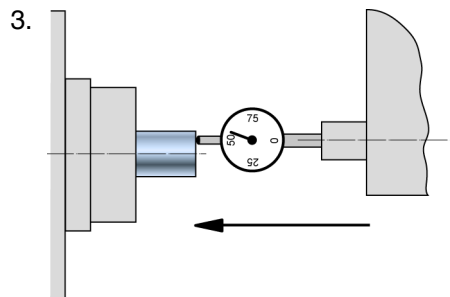
### Requirement

For backlash checking, the machine must have run warm for at least 3 h (traverse all axes).

For measuring the backlash, the machine must only be traversed by a CNC program, not with the handwheel.

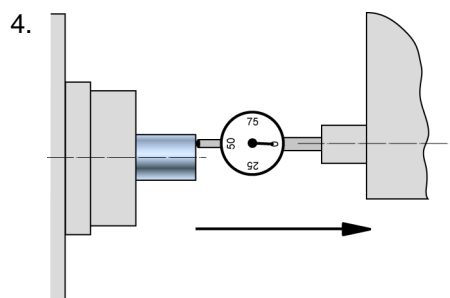
### Procedure

1. Clamp a face-cut round part in the collet.
2. Attach dial gauge (accuracy 1/1000) to the tool carrier.



Move dial gauge into position

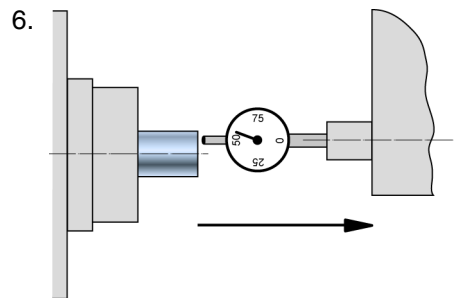
Move to the clamped turned part until the dial gauge probe is short of the hard stop (feed rate  $f = 200$  mm/min).



Back off the dial gauge by 1/2 measuring range

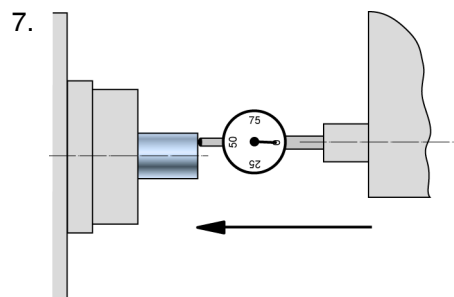
Back off the slide until the pointer of the dial gauge is within the indicating range (f = 150 mm/min).

5. Set the dial gauge pointer to "0".



Back off the dial gauge by 3 mm

Back off the slide by 3 mm (dial gauge is free) (f = 150 mm/min).



Advance the dial gauge by 3 mm

Advance the slide by 3 mm to the zero point (f = 150 mm/min).

8. Repeat the measurement five times and calculate the average.

Double this value and enter the result as backlash compensation into the control.

9. Remeasure for confirmation.

Should the backlash values for the X, Y and Z axes exceed 0.01 mm, they must be corrected by the machine manufacturer's service personnel.

## DL170 - Axes



Carrying out the maintenance activities described below requires special knowledge. For this reason, these maintenance activities must be carried out only by authorized personnel of the manufacturer!

### Orientation

Check the grid point spacing and the reference points of all axes, and correct if necessary.

### Requirement

### Procedure

1. Have the grid point spacing of all axes checked by the machine manufacturer's service personnel.
2. Have the reference points of all axes checked by the machine manufacturer's service personnel.



## DL180 - Check fire protection system (visual inspection)

## Orientation



An examination of a fire protection system may only be conducted directly by the manufacturer or a person with written authorization by the manufacturer.

Be sure to read the operating instructions of the manufacturer!

## Procedure

1. 

**Kraft & Bauer Kleinlöschanlage** DIN 14497  
 Kohlendioxid CO<sub>2</sub> Brandklasse B  
 18 kg Löschmittel Funktionsbereich 0°C - 35°C

Vorsicht bei Verwendung in engen, schlecht belüfteten Räumen (gesundheitsschädliche Gase). Die Auslösung der Feuerlöschanlage erfolgt automatisch - oder durch Handauslösung Drucktaster.

Bei Feueralarm Raum sofort verlassen oder Sicherheitsabstand von mindestens 5 Metern einhalten.

**ACHTUNG: Gesundheitsgefahr!**  
 Hinweis: CO<sub>2</sub> fließt in tieferliegende Räume ab. Unbedingt belüften!  
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## Example: Kraft and Bauer stickers

Check sticker for manufacturing date.

2. Check sticker for inspection date.

3. Check sticker for battery replacement.

## DL227 - Replace belts and check belt tension



Carrying out the maintenance activities described below requires special knowledge. For this reason, these maintenance activities must be carried out only by authorized personnel of the manufacturer!

### Orientation



Use only the original belts according to the spare or wear parts list.

### Requirement



After replacing a drive belt, be sure to observe the values (Hz) specified in the table below for the belt tension of the respective axis. **A frequency meter is required for testing.**

Also the reference point may need to be checked or adjusted.

### Procedure

1.



Caution

**Uncontrolled movements of axes or machine components.  
Severe cut and crush injuries.**

Secure all axes or components against uncontrolled movements during maintenance or repair work.

Move the tool slides to a suitable position.

2. Replace X1 belt.
3. Measure belt tension (frequency meter) and adjust belt.
4. Replace H1 belt.
5. Measure belt tension (frequency meter) and adjust belt.
6. Replace X2 belt.
7. Measure belt tension (frequency meter) and adjust belt.
8. Replace H2 belt.
9. Measure belt tension (frequency meter) and adjust belt.
10. Replace X4 belt.
11. Measure belt tension (frequency meter) and adjust belt.
12. Replace Y4 belt.
13. Measure belt tension (frequency meter) and adjust belt.

14. Replace X3 belt.
15. Measure belt tension (frequency meter) and adjust belt.

## DL485 - Replace the wiper and telescopic plates

### Orientation



Regular inspection of the wipers prevents damage to the wipers themselves and to the work area door.

If the work area door can be opened and/or closed only with increased effort, it can be expected that the wipers are already destroyed by accumulation of chips and swarf compaction.

### Requirement



Example: Chip hook and chip brush

Use appropriate tools to remove coarse chips, chip nests and other debris.

### Procedure



Example: 1 Removing chip nest using appropriate tools (e.g., chip hooks)

Remove large chips on the inside of the work area door from top to bottom. Use a chip hook for this purpose.

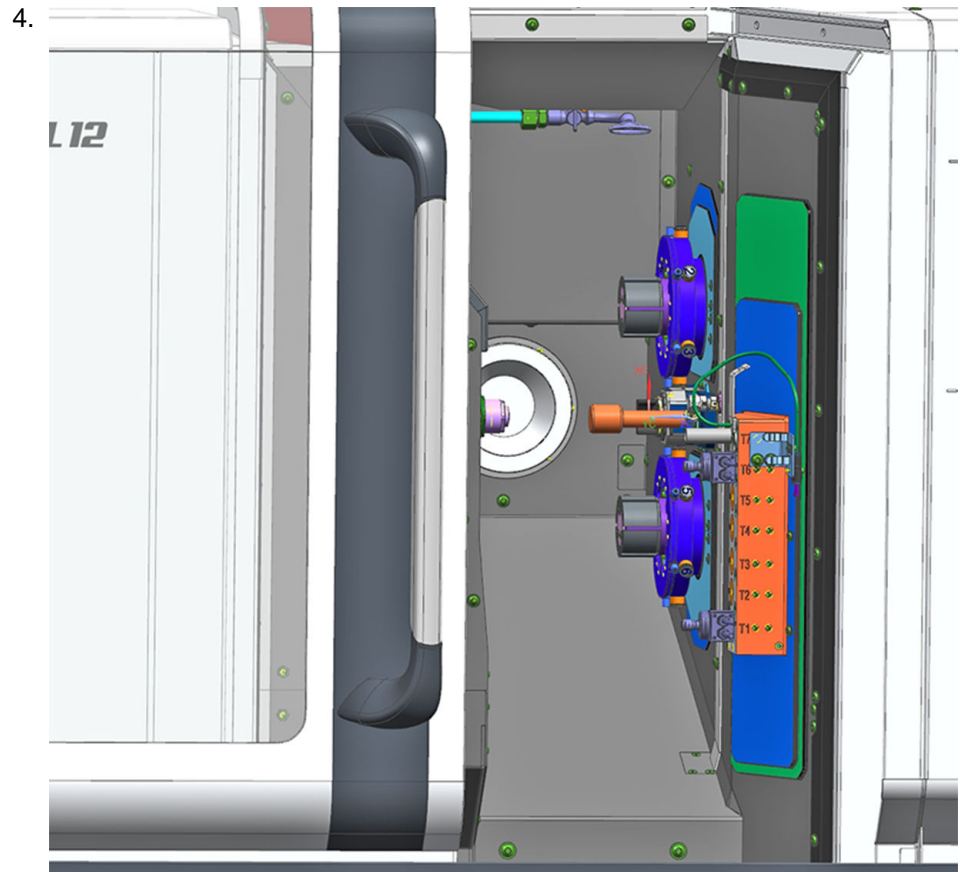
2.



Example: 2 Sweep small chips and other debris from top to bottom using chip brooms or brushes.


Remove small chips and chip accumulations on the inside of the work area door from top to bottom. Use a chip brush for this purpose.

3. Clean the area behind the wipers.




**Wipers work area TNL12.2**

Replace wipers.

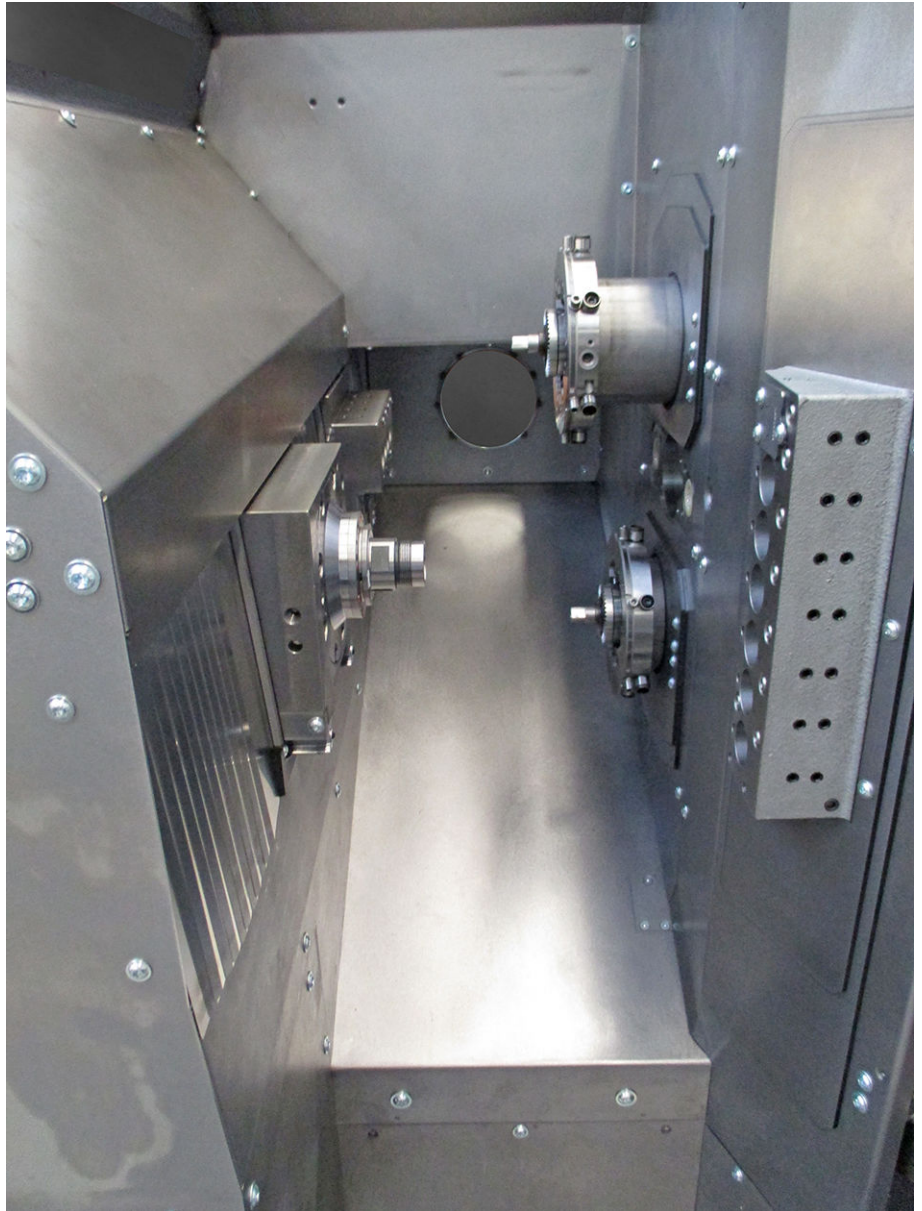
5.  Make sure that the wipers evenly contact the work area door before tightening the screws.

Check the wipers for proper seating. After the wipers have been replaced, the work area door should open and close again without much effort as usual

6.  If replacement of the wipers has not resulted in tangible improvement, the soiled trolley and the guide rail of the work area door must also be cleaned.

Clean trolley and guide rail of the work area door.

7.



**Example: Detailed view of work area TNL12.2**

Replace telescopic plates in the work area

## DL493 - Replace wiper in guide sleeve for fixed headstock operation



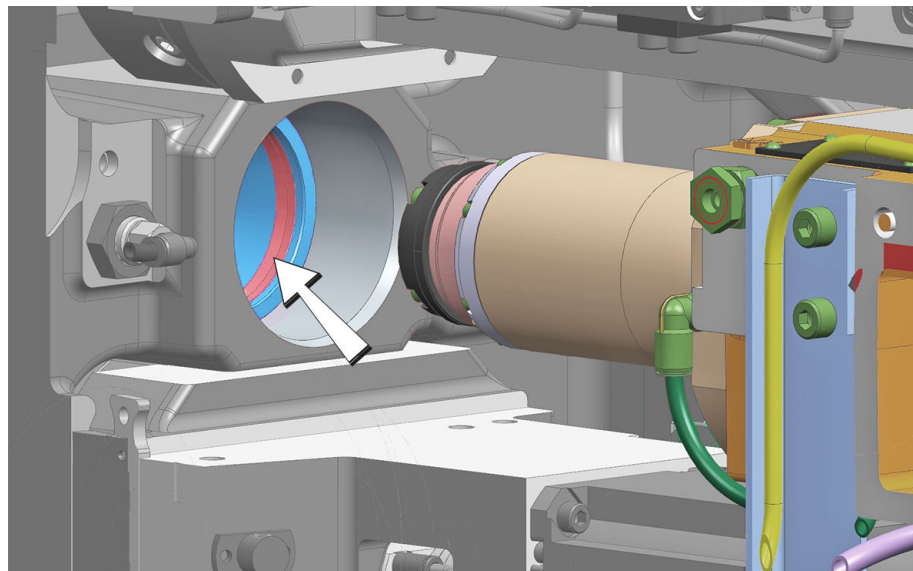
Carrying out the maintenance activities described below requires special knowledge. For this reason, these maintenance activities must be carried out only by authorized personnel of the manufacturer!

### Orientation



The part numbers can be found in the spare parts catalog.

For fixed headstock operation, a wiper is located in the guide sleeve. This seals the spindle area (main spindle/sleeve) between the work area and the drive area during fixed headstock operation.



TNL12.2 wiper, guide sleeve, fixed headstock operation

- a Sleeve
- b Wiper

### Requirement

Move the main spindle by means of the Z axis to the rear end position. Remove guide sleeve and replace the wiper. Then reinstall the guide sleeve.

### Procedure

1. Replacing wipers



## DL510 - Perform data backup

## Orientation

Using a current data backup, the machine can be restored to the original state before the failure after a defect of the internal storage device/NC control.

The file name of the data backup includes the machine type, machine number, and date/time of the backup.



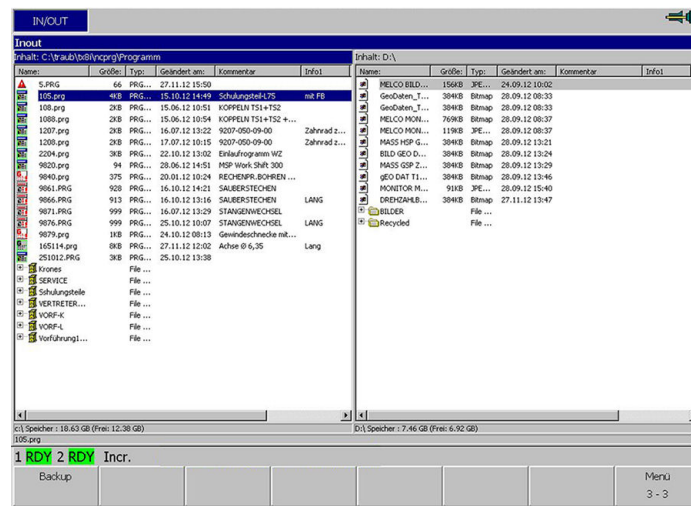
Network settings and the customer's NC programs are not included in the backup.

Backup additionally to an external data carrier for access in case of a defect of the internal storage medium.

## Procedure

1. Connect USB device to USB port

2.



Example shown

Open **IN/OUT** screen and use **TAB** to activate the right part of the screen

3. Press **Softkey Select** (F3) (select appropriate target, e.g., USB)

4. Press **Softkey Menu** (F8) twice. Softkey text "Menu 3-3" appears

5.



Note that the backup includes no customer NC programs! Include them in a separate backup, if necessary

Press **Softkey Backup** (F1) and press **Softkey OK** (F1) to acknowledge the informational message

All relevant parameters and data for the backup are compiled

6. Press **Softkey OK** (F1) to confirm the transfer of the data to the desired storage location

## DL520 - Check control cabinet and cable assemblies (visual inspection)



Carrying out the maintenance activities described below requires special knowledge. For this reason, these maintenance activities must only be carried out by staff that has received adequate training by the machine manufacturer!

### Orientation

To avoid problems and prevent any resulting system failures, simplified control cabinet checks must be carried out at regular intervals on the cabinet and associated components. This include a visual inspection of the wire harnesses of the individual modules and the grounding cable. Additional built-in air conditioning units (option) ensure a constant temperature in the control cabinet. These air conditioners cannot work efficiently if filters are dirty or doors are not tight.



Use only the original filters according to the spare or wear parts list!

Filters are hazardous waste and must be disposed of in accordance with environmental guidelines and regulations of the country of operation.

When working in or on the control cabinet, switch off the machine and secure it against power on.

### Requirement



Even with the machine powered off, some devices or components in the control cabinet are still energized.



Observe the specific electrical diagrams for this machine.

### Procedure

1. Switch off the machine.
2. Have the electrical diagrams for the corresponding machine ready.
3. Replace all filters on the control cabinet and cabinet components.
4. Check that the cabinet doors can be properly closed. If the cabinet doors can not be closed properly, determine the cause and eliminate it. Possible causes could be faulty seals, hinges, or even a damaged cabinet door.
5. Check all cabinet seals. They should be free of oil and condensation.
6. Clean the control cabinet. Use a suitable vacuum cleaner for this purpose.
7. Check the cabinet lighting (optional).

8. Check grounding cable. Grounding cables are located, e.g., between the control cabinet and cabinet doors and between the base and the machine bed.
9. Check all connections in the control cabinet, tighten loose connections

10.

**Danger from electricity**

The charge lamp should be off (must not illuminate).  
Measure the voltage at the power rails to ensure they are de-energized.

Remove the covers from the power rails of the amplifiers and retighten all connections. Then reinstall the covers.

11. Check cable assemblies for damage, replace if necessary.

## DL590 - Check inspection/replacement date of the backup batteries in the control cabinet (NC)



Carrying out the maintenance activities described below requires special knowledge. For this reason, these maintenance activities must only be carried out by staff that has received adequate training by the machine manufacturer!

### Orientation

To ensure that no important machine data is lost in the event of a power failure, backup batteries or rechargeable batteries are installed at various points of the machine, which must be regularly tested and/or replaced. The backup batteries described here have a lifespan of 4 years after which they must be replaced promptly.



Due to different requirements and/or specifications of the respective manufacturers, be sure to review the respective manufacturer's documentation!

### Requirement

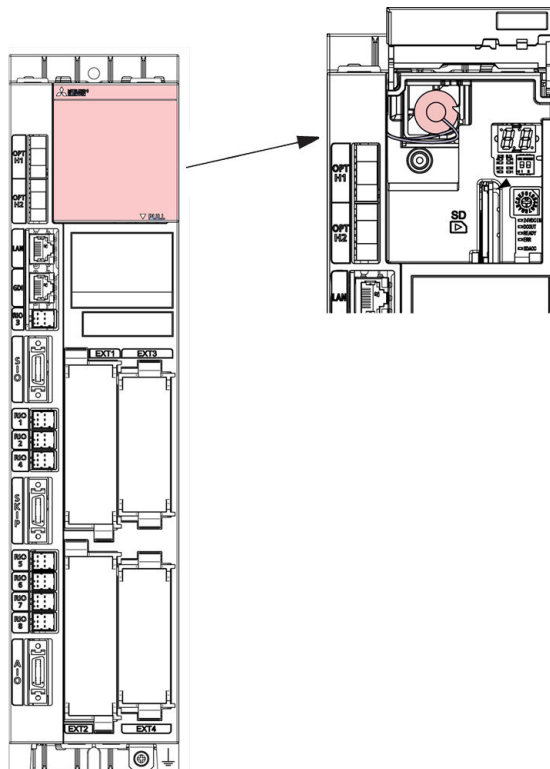
Prior to this maintenance activity, make sure that you have a sufficient number of batteries or rechargeable batteries available.

The required number of backup batteries varies depending on the configuration of the machine. The number of required backup batteries can be found in the electrical diagrams of the machine or obtained from the customer service of the machine manufacturer.

### Procedure

1. Switch off drives.
2. Press the emergency stop button.

3.

**NC backup battery in the control cabinet**

Open the battery compartment cover.

4. Remove the battery including connectors.
5. Insert a new battery and plug in the connectors.

6.



Example of the data to be logged in a maintenance schedule.

- approved/replaced on:
- Name:
- Signature:

Record testing or replacement date in a maintenance schedule.

7. Record testing or replacement date of NC backup battery in the control cabinet.
8. Close covers.

## DL636 - Check the replacement interval of the servo backup batteries at the axis servos.



Carrying out the maintenance activities described below requires special knowledge. For this reason, these maintenance activities must only be carried out by staff that has received adequate training by the machine manufacturer!

### Orientation

To ensure that no important machine data is lost in the event of a power failure, backup batteries or rechargeable batteries are installed at various points of the machine, which must be regularly tested and/or replaced. The axis servo backup batteries described here have a lifespan of 4 years after which they must be replaced promptly.



Due to different requirements and/or specifications of the respective manufacturers, be sure to review the respective manufacturer's documentation!

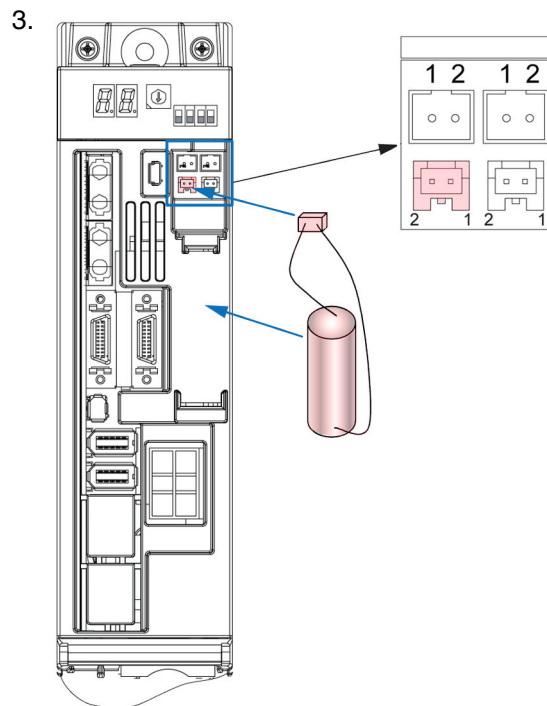
### Requirement

Prior to this maintenance activity, make sure that you have a sufficient number of batteries or rechargeable batteries available.

The number of axis servos and thus the required number of backup batteries vary depending on the configuration of the machine. The number of required backup batteries can be found in the electrical diagrams of the machine or obtained from the customer service of the machine manufacturer.

### Procedure

1. Switch on the NC.
2. Press the emergency stop button.



**Servo backup battery in the control cabinet**

Disconnect and remove the servo backup battery.

4. Connect a new servo backup battery and insert it into the axis servo.

5.



Example of the data to be logged in a maintenance schedule.

- Axis servo:
- approved/replaced on:
- Name:
- Signature:

Record testing or replacement date in a maintenance schedule.

## DL640 - Check the check valve of the workpiece pickup/gripper unit

### Orientation

The function of the check valve for the swiveling workpiece removal/gripper unit must be checked at the workpiece removal to the left. The position of the workpiece pickup/gripper unit must be maintained even after the machine has been at a standstill for a longer period of time. The check should be carried out when the machine is at a standstill for a longer period of time (e.g., when the machine is at a standstill overnight).

### Procedure

1. Move the workpiece removal unit to the left in the Z direction into the work area (the workpiece removal/gripper unit is in the upper position). Switch off the machine and let it stand for a longer period of time if possible (e.g., overnight). The position of the workpiece pickup/gripper unit must be maintained. If necessary, the check valve of the workpiece pickup/gripper unit must be replaced.



**Service Interval - 8.000 Operating hours**

## Maintenance Summary - 8.000 Operating hours



It is recommended to document the maintenance activities carried out by using the appropriate maintenance log. The maintenance log has the document number DTE073EN - 23.03.2023.

**EL021** - Check pneumatic hollow clamping device (spring tension) on main and counter spindles, replace if necessary

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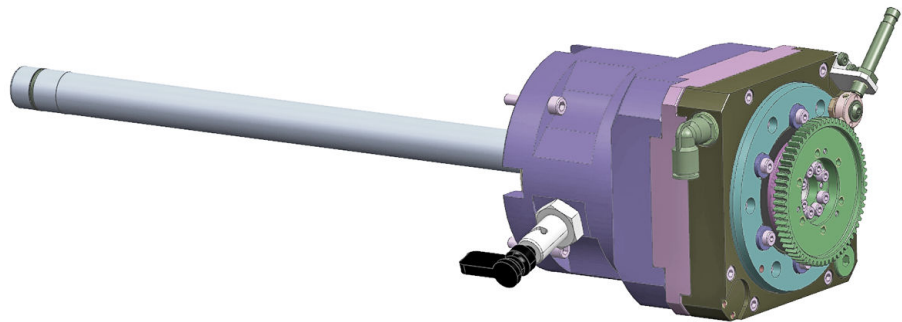


Carrying out the maintenance activities described below requires special knowledge. For this reason, these maintenance activities must be carried out only by authorized personnel of the manufacturer!

## Orientation



Due to different requirements and/or specifications of the respective manufacturers, be sure to review the respective manufacturer's documentation!



**Pneumatic clamping device TNL12.2**

## Procedure

1. Check pneumatic hollow clamping device (spring tension) according to manufacturer's specifications, replace if necessary.



## **Service Interval - 5 Years**

## Maintenance Summary - 5 Years



It is recommended to document the maintenance activities carried out by using the appropriate maintenance log. The maintenance log has the document number DTE073EN - 23.03.2023.

**IL010** - Replacing the pneumatically pilot- controlled cooling lubricant valves

## IL010 - Replacing the pneumatically pilot- controlled cooling lubricant valves

### Orientation

In the course of the machine's operating time, internal wear of the pneumatically pilot-controlled cooling lubricant valves may occur, with the result that cooling lubricant may penetrate the pneumatic control lines. To avoid consequential damage, **INDEX** recommends replacing these valves after 5 years.

### Requirement



Due to different requirements and/or specifications of the respective manufacturers, be sure to review the respective manufacturer's documentation!



Power off the machine to depressurize the pneumatic system and secure against accidental switching on.

### Procedure

1. Renew valves.





## **Service Interval - 12 Years**

## Maintenance Summary - 12 Years



It is recommended to document the maintenance activities carried out by using the appropriate maintenance log. The maintenance log has the document number DTE073EN - 23.03.2023.

**KL006** - Replace the window pane of the work area door

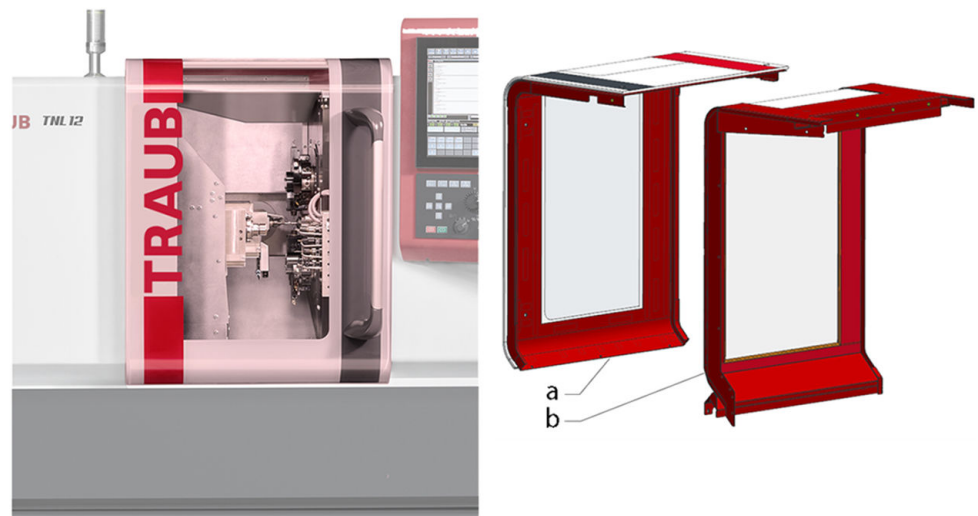
## KL006 - Replace the window pane of the work area door



Carrying out the maintenance activities described below requires special knowledge. For this reason, these maintenance activities must only be carried out by staff that has received adequate training by the machine manufacturer!

### Orientation

The work area door consists of the basic door (b) with a glued-in window pane made of polycarbonate (workspace side) and the attached design pane (a) made of PMMA (operator side).



TNL12.2 Work area door

- a) Design pane made of PMMA (operator side)
- b) Basic door with glued-in polycarbonate window pane (work area side)

The window pane is subject to natural aging and must be replaced at regular intervals.

There is a safety label on the window pane indicating the part no., year of manufacture, and manufacturer. The first replacement of the window pane (basic door b with glued-in window pane) must be carried out 12 years after manufacture of the machine (see type plate).



If the window pane is damaged, it must be replaced. This is necessary regardless of the extent of damage. Even with minimal damage, the impact resistance of the pane can no longer be guaranteed.



The protective film and the all-round overlapping bond must be checked for damage at regular intervals. If there is any damage to the bond or protective film, the window pane must be replaced immediately.



For safety reasons, it is recommended to obtain the window pane directly from the machine manufacturer or its country representative.



When disassembling and assembling the work area door, INDEX recommends using suitable suction lifters to secure it. To ensure safe handling, both the suction surfaces of the suction lifters used and the corresponding areas of the work area door must be carefully cleaned beforehand. Personal protective equipment -> Use gloves with rubberized palm/inside. Determine and prepare the storage location for the work area door. To prevent scratching of the design pane, cover the surface at the storage location with suitable tarpaulins, foils, felt mats or similar.



**Cleaning the window pane.** The window pane (work area side) is scratch-resistant. Any commercial cleaning agent can be used here. **Cleaning the design pane.** The design pane (operator side) is sensitive to scratches! Use a soft cloth or sponge and glass cleaner or soapy water to clean the design pane. Use no abrasive or alkaline cleaning agents and no sharp-edged items.



If you have questions, be sure to contact the INDEX service department or an INDEX representative.

## Requirement

Suitable suction lifters can be used to replace the window pane.

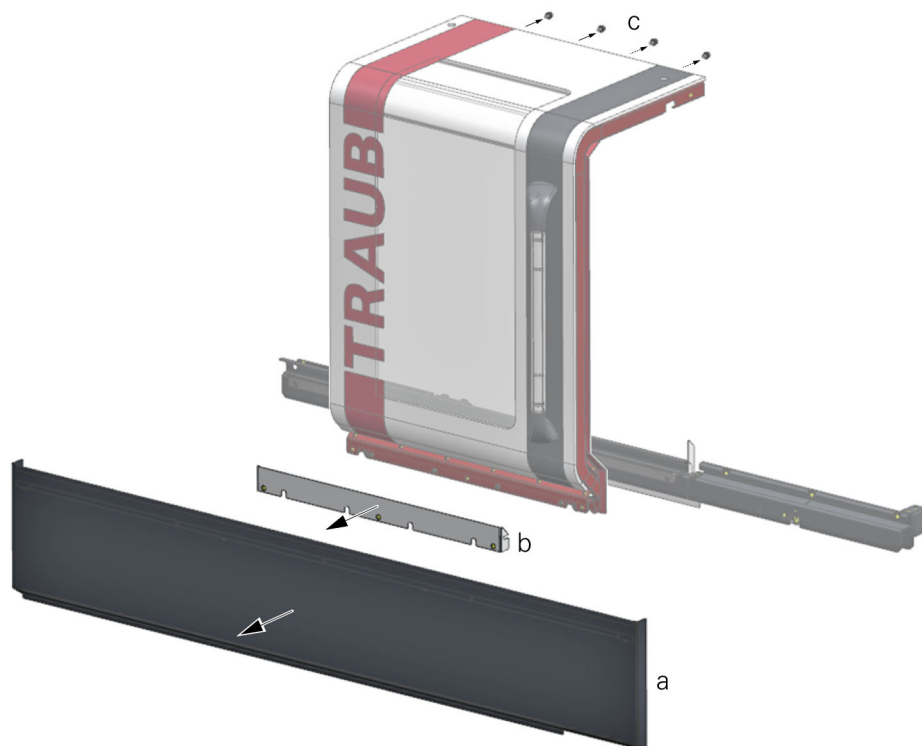


60kg

Example: Bohle suction lifter 60 kg

## Procedure

1.

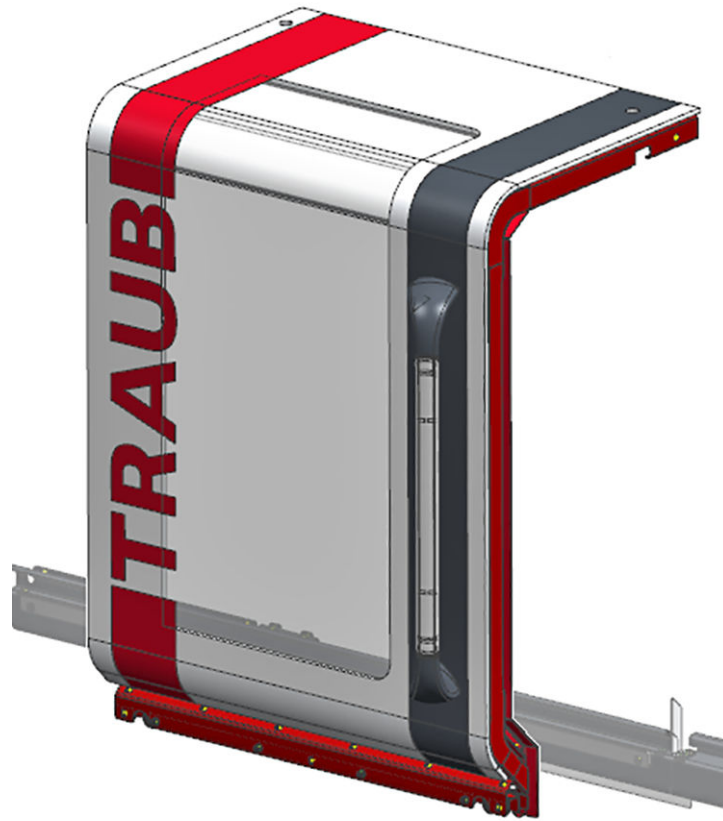
**TNL12.2 Work area door attachment parts**

- a** Trim carrier
- b** Attachment part, trim
- c** Cylinder head screws, upper guide of the work area door

Remove the trim (a) from the bottom of the carrier

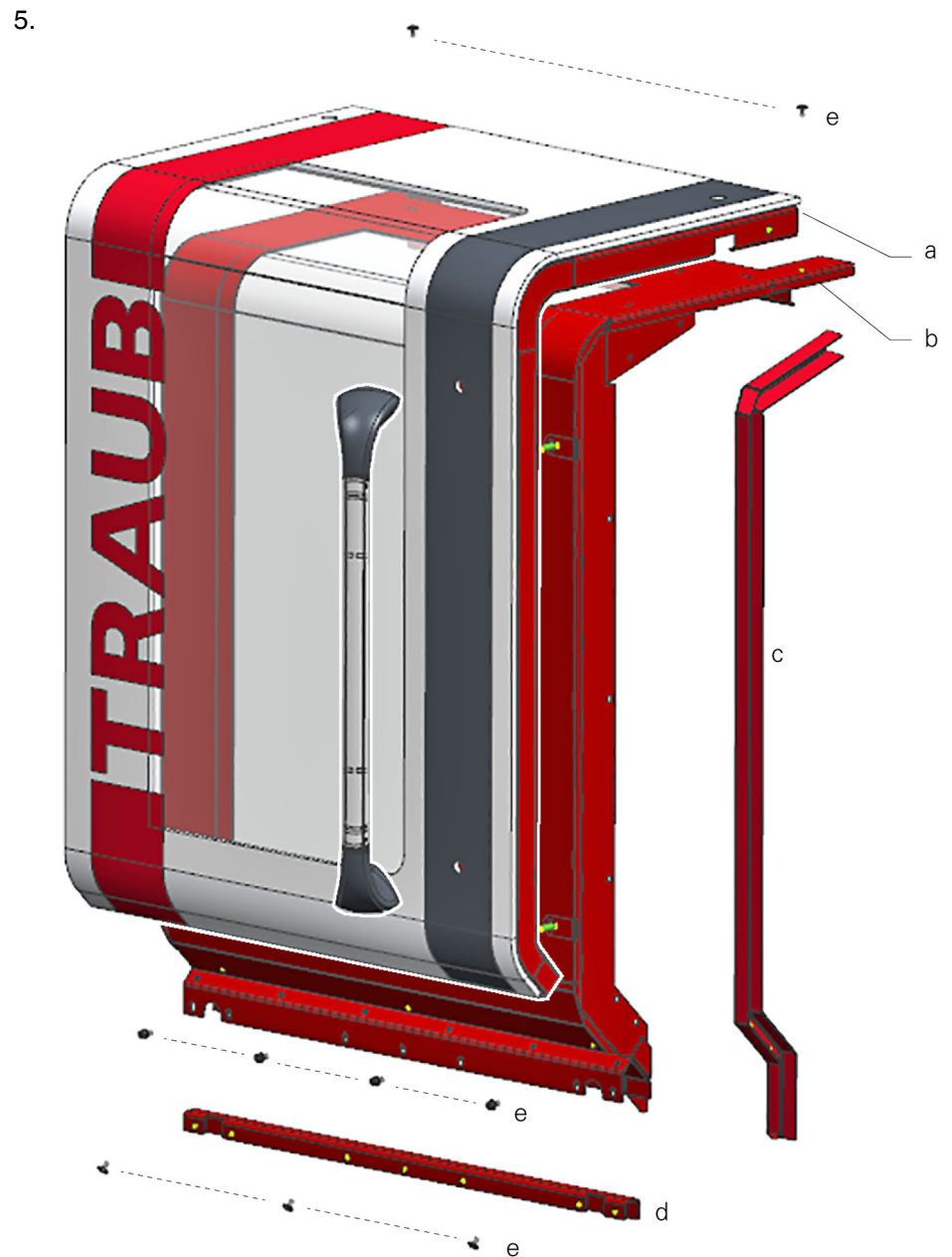
2. Remove the trim attachment part (b) from the lower guide of the work area door.
3. Loosen and remove the 4 cylinder head screws (c) from the upper guide of the work area door.

4.



**TNL12.2 Work area door**

Lift the complete work area door out of the guides (use suction lifters if necessary) and carefully set it down at the prepared storage location.



#### TNL12.2 Disassembly of work area door

- a PMMA design pane
- b Basic door with glued-in polycarbonate window pane
- c Labyrinth sheet
- d Frame attachment
- e Filister flange head screws

6. Remove the handle of the work area door
7. Loosen the filister flange head screws (e) from the top and bottom of the design element connection
8. Remove the labyrinth sheet (c) and frame attachment (d).
9. Detach the design element (a) from the basic door (b).
10. Replace the basic door (b) with a new basic door with a glued-in window pane.

11. For assembly, follow the steps in reverse order. Ensure proper cleanliness during the installation.





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