

Routine Maintenance on Centre Lathes and Turret Milling Machines

1. Centre Lathes

Minor Service

- Oil change (3 Gearboxes)
- Slides adjust (Gibbs)
- Check handles and levers
- Tighten all bolts and nuts
- Clean machine
- Check V-belt tension
- Check general working of machine
- No stripping
- Cost: R3 000.00 Duration: ± 1 day

Medium Service

- Minor service plus following
- Strip apron and slides, clean, check, re-assemble
- Oiling system check
- Strip, clean and re-assemble tailstock
- Cost: R5 000.00 Duration: ± 2 days

Major Service

- Medium service plus following
- Clean sludge and debris from headstock and feedbox (flushing)
- Make test cuts and adjust taper cutting if necessary/possible
- Trouble shooting
- Adjust spindle bearings if necessary

- Check steady's
- Check tooling
- Check machine leveling
- Open and check feedbox
- Slide wipers
- Cost: R8 000.00 Duration: ± 3 days

Report findings and corrective action.

2. Turret Milling Machines

Minor Service

- Cleaning
- Lubrication
- Check handles and levers
- Tighten all bolts and nuts
- Check general working of machine
- Slides adjust – Gibbs
- No stripping
- Cost: R3 000.00 Duration: ± 1 Day

Medium Service

- Minor service plus following
- Strip, clean and re-assemble all slides
- Check leadscrews and nuts
- Check and upgrade lubricationsystem
- Cost: R6 000.00 Duration: ± 2 Days

In the event of:

- Main drive belt change Cost: R3 000.00 (Including belt)
- Secondary drive belt change Cost: R2 500.00 (Including belt)
- If both of the above together Cost: R3 900.00
- If top half bearings and bushes, is to be renewed (bearings and bushes included) Cost: R6 500.00
- Spindle bearings supply and fitment Cost: R3 500.00
- If bottom half is to be refurbished (spindle bearings included) Cost: R7 000.00

- **If a pre-existing problem exists then it is not covered by any one of the above quotes. It will be quoted on separately.**
- **Where applicable a deposit will be required.**
- **All payments are COD.**

Thank you.

Ivan