

### Trouble Shooting for Milling Machine

| Trouble                                   | Analysis  | Solution                               |
|---|---|--|
| The workpiece milled is not flat          | The spindle bearing is loose                          | Adjust the spindle bearing gap         |
|   | The gibs of X、Y axis are loose                        | Adjust the gibs' gap                   |
|   | The processing amount is too much                     | Choose reasonable processing amount    |
|   | The tools are damaged                                 | Change the tools                       |
| The machine shakes when cutting workpiece | The machine is located unsteadily                     | Retighten the machine                  |
|   | The cutting condition is not good                     | Choose suitable cutting feed           |
| Handle feeling is heavy                   | the wedge is too tight                                | Adjust the wedge                       |
|   | The gap between lead screw and screw nut is not right | Adjust the gap                         |
|   | Oil line blocked                                      | Check the oil line and repair it       |
|   | No oil in oil pump                                    | Add oil                                |
|   | The oil pump does not work                            | check the oil pump and oil line        |
| The spindle sleeve is tight               | The spindle sleeve lacks of oil                       | Add oil                                |
|   | The spindle sleeve is dirty                           | Clean the spindle sleeve and repair it |
| No coolant liquid                         | The water pump does not work                          | Check the water pump                   |
|   | The water pump turns in reverse direction             | Change its rotation direction          |
| The spindle feed is not smooth            | The fixed bar of hi-lo sleeve is not loosened         | Loosen the fixed bar                   |
| The spindle brake does not work normally  | The brake circle is damaged                           | Change the brake circle                |
| The spindle does not rotate               | The switch has poor contact                           | Check the power switch                 |
|   | The belt is too tight                                 | Adjust it                              |
|   | Something with the motor                              | Repair it                              |
| Wrong rotation direction                  | The power switch turns to the wrong direction         | Change the switch indication position  |