

Milling unit maintenance for scheduled down-time periods

Before down-time period

Cleaning procedures

- 1 Clean the milling chamber, workpiece holder, tool holders and length measuring probe.
- 2 Empty and clean the cooling liquid tank. Fill the cooling liquid tank with **hot water only**. If the milling unit is not used for wet milling, skip to Collet maintenance.
- 3 Start circulating the hot water by clicking the **Cooling liquid on/off** icon. Circulate the hot water 2-3 minutes. Stop the pump by clicking the same icon. Empty and clean the tank and the milling chamber.



Collet maintenance

- 1 Start collet maintenance by clicking the **Service position** icon. Clean and grease the collet.
- 2 Leave the milling chamber lid open and the tank out for drying.
- 3 Shut down the milling unit, the extraction unit and the control laptop (PlanMill 50).



After down-time period

- 1 Turn on the milling unit, the extraction unit and the control laptop (PlanMill 50).
- 2 Perform collet maintenance.
- 3 Perform a spindle warm-up. Download the *warm-up-spindle.iso* file from the following link: <http://download.planmecagroup.com/planmeca/CADCAM/CADCAM-Lab/warm-up-spindle.zip>
- 4 Make sure tool T11 is available and start the *warm-up-spindle.iso* milling program.
- 5 Perform zero point and b-axis calibration.
- 6 Start milling.

For detailed instructions, please see the user's manual. Copyright Planmeca. Rights for changes reserved.