

***Mazak***

***QT 18N***

***Serial Number: 111583***

**MTSS**  
**Machine Technical Service Support**  
**The Machine Shop Solution**  
**MTSS Will Get There Quick!**

**Mazak**

**Machine Number Assigned:**

**Model: QT18N**

**Serial Number: 111583**

**Franklin Equipment Asset Number:**

**Date of Inspection: 02-08-10.....02-09-10**

**Inspector: Larry R. Green (MTSS)**

**Signature of Inspector:**



**Machine Features and Options:**

**Mazak T32B Mazatrol Cam Conversational Control**  
**Chip Conveyor**  
**8D Tool Turret**  
**Tool Pre- Setter (Tool Measuring Arm)**  
**EIA/ISO Programming Option**  
**DNC Function**  
**Second Miscellaneous Function**  
**Manual Measurement**  
**Amber CRT ( Certain options not available )**

**Manuals:**

**Mechanical Parts List**  
**Electrical Wiring Manual**  
**PLC Ladder Diagram Manual**  
**QT 18N Operating Manual**  
**Parameter/ Alarm Listing Manual**  
**T32B Operating Manual**  
**Parameter Hard Copy**

Conditions at Power Up:

1. Machine would not power up.
2. Re-installed Servo Drive Unit for the X axis.
3. Re-installed Spindle Control Power Supply
4. Re-installed Turret Clamp Cylinder and the Turret.
5. Re-initialize the Control .
6. Was able to power up machine.
7. Punched In Parameters
8. X axis Servo Drive Unit Needs Repairing.
9. The Spindle Control Power Supply needs to be replaced.
10. Hydraulic unit works correctly.
11. Chip Conveyor works correctly.
12. Not able to check control operations due to Servo Drive and Spindle Control Power Supply.

A. X Axis Servo Drive Unit Needs To Be Repaired    Estimated Cost \$1,200.00 Mitsubishi  
B Spindle Control Power Supply Needs To Be Repaired Estimated Cost \$1,500.00 Mitsubishi

Machine overall condition is Rated as Listed below:

Poor to Fair Condition

Note: The Machine Will Power Up!!!

The batteries on the Memory Boards do need to be replaced.

Prices varies around \$37.00 to \$65.00 thru Mazak or Mitsubishi. There are 2 sets in the Machine and they have not been replaced in the past 5 years.