

ภาคผนวก จ-5 : เอกสารตรวจสอบและซ่อมบำรุงเครื่องจักร

<DCM No.>

No.1:① No.5:⑤ No.9:⑨
 No.2:② No.6:⑥
 No.3:③ No.7:⑦
 No.4:④ No.8:⑧

	Revised Detail	Day/Month	Approval	Creating
1				
2				
3				
4				

Preparation Date

Classification No.

Machine (Injection)

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark	
1	Stroke injection Linear sensor Check and Cleaning ストロークニアセンサ確認・掃除 (UBE Check Gap STD 0.35mm)(Toshiba 0.20mm) 30min/1person	1Time/ 3Month			①	⑥					①	⑥		①	⑥	
					②	⑦					②	⑦		②	⑦	
					③	⑧					③	⑧		③	⑧	
					④	⑨					④	⑨		④	⑨	
					⑤						⑤			⑤		
2	Change Line Filler ラインフィルター交換 30min/1person	1Time/ 6Month			①						①					
					②						②					
					③						③					
					④						④					
3	ฉีดจารบี couplings Injection グリースアップ 10min/1person	1Time/ 1Month	①	①	①	①	①	①	①	①	①	①	①	①		
			②	②	②	②	②	②	②	②	②	②	②	②	②	
			③	③	③	③	③	③	③	③	③	③	③	③	③	
			④	④	④	④	④	④	④	④	④	④	④	④	④	
			⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	
			⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	
			⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	
			⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	
			⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	
4	check Gap Coupling injection カプリング隙間確認 40min/2person	1Time/ 3Month		①			①			①			①			
				②			②			②			②			
				③			③			③			③			
				④			④			④			④			
				⑤			⑤			⑤			⑤			
				⑥			⑥			⑥			⑥			
				⑦			⑦			⑦			⑦			
				⑧			⑧			⑧			⑧			
				⑨			⑨			⑨			⑨			
5	ฉีดจารบี Inten valve 10min/1person	1Time/ 6Month		①						①						
				②						②						
				③						③						
				④						④						
				⑤						⑤						
				⑥						⑥						
				⑦						⑦						
				⑧						⑧						
				⑨						⑨						

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Equipment (Mold Clamping)

2/14

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	Check of corbel liner slide liner (เปลี่ยนเบ้า) Toshiba สลัก 21.2 mm. และ UBE 21.8mm.) コーベルライナーสไลด์ ไทร์เช็ค 10min/1	1Time/ 3 Month	① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			Toshiba 1.90mm UBE 2.50mm
2	Die Clamp Force Tie Bar Balance (±5%) 型締力タイバーバランス (±5%) 2hr/3 person	1Time/ 1 Year					① ②	③ ④	⑤ ⑥	⑦ ⑧	⑨				Holiday plan
3	Cylinder die close/open are tighten the nut lock end rod 5min/1 person	1Time/ 3 Month			① ② ③ ④			① ② ③ ④			① ② ③ ④			① ② ③ ④	
4	Check gap Bush tie bar 2hr/2 person	1Time/ 6 Month					① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤						① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤		Holiday plan

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Machine (Mold Change Equipment)

3/14

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	C Plate dimension measurement C板寸法測定 20min/ person	1Time/ 6Month		① ②	③ ④	⑤ ⑥	⑦ ⑧	⑨		① ②	③ ④	⑤ ⑥	⑦ ⑧	⑨	
2	Check การตรวจ Nut ยึดC Plate 20min/2 person C板固定ナット緩み点検	1Time/ 6Month		① ②	③ ④	⑤ ⑥	⑦ ⑧	⑨		① ②	③ ④	⑤ ⑥	⑦ ⑧	⑨	
3	Check การตรวจของ bracket 押出ブラケット割れ点検 10min/ 1 person	1Time/ 6Month		① ②	③ ④	⑤ ⑥	⑦ ⑧	⑨		① ②	③ ④	⑤ ⑥	⑦ ⑧	⑨	

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Machine (Hydrolic Unit)

4/14

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	Triple R Change トリプルR交換 40min/2person	1Time/ year					① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤								DCM1.2 เปลี่ยน เสร็จวันที่ 11/03/20 22
2	Cleaning Suction Filter Triple R トリプルR交換 40min/2person	1Time/ 6Month					① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤						① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤		
3	Cleaning Oil cooler オイルクーラー清掃 4hr/2person	1Time/ 1Year						① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤							holiday
4	Cleaning suction Filter Hyd.Pump サクションフィルター 清 掃 60min/2person	1Time/ 3Month		① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤		
5	Check N2 PRESSURE AT ACC TANK ACCの窒素ガス確認 30min/2person	1Time/ 3Month	① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			
6	CLEANING FILTER OIL LUBRICANT TOGGLE トグルのオイルフィルタ ーの掃除 30min/1person	1Time/ 1Year						① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤							
7	Check Metering valve Lub. For all machine 各マシンのMOバルブ確認 4hr/2person	1Time/ Year			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	⑤ ⑥ ⑦ ⑧	⑨								holiday
8	Cleaning Motor Hydraulic and Fan Motor 油圧モーター・ファンモ ーターの掃除 30min/1person	2Time/ 1Year			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤					① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤					
9	Pump Die clamp lock are change oil and cleaning tank	1Time/ Year	① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤												holiday
10	Hydraulic motor are change rubber of coupling 60min/2 person	1Time/ Year				⑥ ⑦ ⑧ ⑨									
11	Check magnetic contactor of hydraulic motor 20min/2 person	1Time/ 6Month						① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤							

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SCRAP CONVEYOR

5/14

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	Conveyor and chain check tension and Trough limit visual checkコンベア・チェン のテンション確認とトルク リミット目視確認	1Time/ month	① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	
2	Rammer ตรวจเช็คแผ่น suspension ถ้าชำรุดให้ เปลี่ยน サスペンションのゴム確認	1Time/ 3month			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	
3	เช็คแกน Rammer 打ち棒確認	1Time/ 3month			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	

สัญลักษณ์ (Symbol) :

○ แผน (Plan)

● ทำได้ตามแผน (On Plan)

○ เลื่อนแผน (Postponed)

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Control panel

6/14

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	Backup PLC Die cast シーケンサー回路採取 10min/person	1time/6 Month						① ⑥						① ⑥	
								② ⑦						② ⑦	
								③ ⑧						③ ⑧	
								④ ⑨						④ ⑨	
								⑤						⑤	
2	Backup OF PLC, GOT CUTTING TAKE OUT, SPRAY ROBOT シーケンサー回路採取 10min/person	1time/6 Month						① ⑥						① ⑥	
								② ⑦						② ⑦	
								③ ⑧						③ ⑧	
								④ ⑨						④ ⑨	
								⑤						⑤	
3	Backup OF PLC, GOT LADLE ROBOT シーケンサー回路採取 10min/person	1time/6 Month						① ⑥						① ⑥	
								② ⑦						② ⑦	
								③ ⑧						③ ⑧	
								④ ⑨						④ ⑨	
								⑤						⑤	
4	Backup OF PLC CONVEYOR シーケンサー回路採取 10min/person	1time/6 Month						① ⑥						① ⑥	
								② ⑦						② ⑦	
								③ ⑧						③ ⑧	
								④ ⑨						④ ⑨	
								⑤						⑤	
5	Backup OF PLC Holding Furnace 保持炉 シーケンサー回路採取 10min/person	1time/6 Month						① ⑥						① ⑥	
								② ⑦						② ⑦	
								③ ⑧						③ ⑧	
								④ ⑨						④ ⑨	
								⑤						⑤	

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Machine (Control panel)

7/14

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	Backup Program Laser marker読取機 シーケンサー回路採取 10min/person	1time/6 Month						① ⑥						① ⑥	
								② ⑦						② ⑦	
								③ ⑧						③ ⑧	
								④ ⑨						④ ⑨	
								⑤						⑤	
2	Backup OF PLC, GOT Reversing machine シーケンサー回路採取 10min/person	1time/6 Month						①						①	
								②						②	
								③						③	
								④						④	

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Machine (Control panel)

8/14

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	Battery change OF PLC, GOT die casting machine 鋳造シーケンサー回路採取 10min/person	1Time/ 1Year											① ⑥		
													② ⑦		
													③ ⑧		
													④ ⑨		
													⑤		
2	Battery change OF PLC, GOT Ladle robot ラドルロボット電池交換 10min/person	1Time/ 1Year											① ⑥		
													② ⑦		
													③ ⑧		
													④ ⑨		
													⑤		
3	Battery change OF PLC, GOT CUTTING TAKE OUT, SPRAY ROBOT 電池交換 10min/person	1Time/ 1Year											① ⑥		
													② ⑦		
													③ ⑧		
													④ ⑨		
													⑤		
4	Battery change OF GOT Reverse M/C 反転機電池交換 10min/person	1Time/ 1Year											①		
													②		
													③		
													④		

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Machine (Other)

9/14

9/14

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	ตรวจสลับTiming Belt ของเครื่องตัด 切断機タイミングベルト ト張り確認 20min/1person	1Time/6Month		① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤						① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤					
2	เปลี่ยนTiming Belt ของเครื่องตัด 60 min/2 person	1Time/ 1Year										① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤			
3	Cleaning Sensor Vacuum Move-Fix Die-Inlet filter vacuum Tank 固定・可動の真空セ ンサーと真空タンク のインレットフィルタ ー掃除	1time/1Month	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨		
4	Grease up for Nipper unit Use to Grease NO.1 ニッパークリースアッ プ (No1) 15min/1person	1time/2 Month	① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤		① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤		① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤		① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤		① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤		① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤		
5	Cleaning filter Air laser Marking 搬送コンベアの扇風 機と刻印機のフィルタ ー掃除 10min/1person	1time/1 Month	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨	① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨		
6	Cleaning Solenoid Valve Vacuum 60min/1person	1time/1 Month	⑧ ⑨	⑧ ⑨	⑧ ⑨	⑧ ⑨	⑧ ⑨	⑧ ⑨	⑧ ⑨	⑧ ⑨	⑧ ⑨	⑧ ⑨	⑧ ⑨	⑧ ⑨	

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Spray robot

10/14

10 / 14

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark			
1	Check Head Spray And Motor robot スプレーヘッドとロボットモーター確認 30min/2person	1time/1 Month	①	①	①	①	①	①	①	①	①	①	①	①				
			②	②	②	②	②	②	②	②	②	②	②	②	②			
			③	③	③	③	③	③	③	③	③	③	③	③	③	③		
			④	④	④	④	④	④	④	④	④	④	④	④	④	④		
			⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤		
			⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	
			⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	
			⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	
			⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	
2	Change Grease แคลล joint 各軸グリス交換 240min/ person	1Time/1Year											① ⑥	② ⑦		การปั๊ม 49 ลิตร		
													③ ⑧	④ ⑨				
													⑤					
3	Change Battery of Robot and control panel robot & 制御盤 電池交換 40min/2person	1Time/1Year											① ⑥	② ⑦				
													③ ⑧	④ ⑨				
													⑤					
4	Change Nozzle DCLP Head Fix & Move 固定・可動のDCLPノズル交換 15min/1person	1Time/Month	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤			
			⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥		
			⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	
			⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	
			⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	
5	Cleaning nozzle spray robot 150 min/1person	1Time/6Month				①						①						
						②						②						
						③						③						
						④						④						

<DCM No.>

No.1:①

No.5:⑤

No.9:⑨

No.2:②

No.6:⑥

No.3:③

No.7:⑦

No.4:④

No.8:⑧

Take out Robot

11/14

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	Handhack .LM check by Cutter chuck ハンドチャック ガタ付き確認 30min/2person	1time/1 Month	①	①	①	①	①	①	①	①	①	①	①	①	
			②	②	②	②	②	②	②	②	②	②	②	②	
			③	③	③	③	③	③	③	③	③	③	③	③	
			④	④	④	④	④	④	④	④	④	④	④	④	
			⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	
			⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	
			⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	
			⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	
			⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	
2	Change grease all zone 各軸グリス交換 240min/2person	1Time/ 1Year											① ⑥		การบิไซ 19 ถึง
													② ⑦		
													③ ⑧		
													④ ⑨		
													⑤		
3	Change Battery of Robot and control panel ロボット制御盤 電池交換 40min/person	1Time/ 1Year											① ⑥		
													② ⑦		
													③ ⑧		
													④ ⑨		
													⑤		

<DCM No.>

No.1:①

No.5:⑤

No.9:⑨

No.2:②

No.6:⑥

No.3:③

No.7:⑦

No.4:④

No.8:⑧

Cutting Robot

12/14

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	Handhack .LM check by Cutter chuck ハンドチャック ガタ付き確認 30min/2person	1time/1 Month	①	①	①	①	①	①	①	①	①	①	①	①	
			②	②	②	②	②	②	②	②	②	②	②	②	
			③	③	③	③	③	③	③	③	③	③	③	③	
			④	④	④	④	④	④	④	④	④	④	④	④	
			⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	
			⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	
			⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	
			⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	
			⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	
2	Change grease all zone 各軸グリス交換 240min/2person	1Time/ 1Year											① ⑥		
													② ⑦		
													③ ⑧		
													④ ⑨		
													⑤		
3	Change Battery of Robot and control panel ロボット制御盤 電池交換	1Time/ 1Year											① ⑥		
													② ⑦		
													③ ⑧		
													④ ⑨		
													⑤		

<DCM No.>

No.1:①

No.5:⑤

No.9:⑨

No.2:②

No.6:⑥

No.3:③

No.7:⑦

No.4:④

No.8:⑧

Ladle Robot

13/14

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	Change Grease 各軸グリス交換 Joint 240min/2person	1Time/ 1Year											① ⑥		holiday
													② ⑦		
													③ ⑧		
													④ ⑨		
													⑤		
2	Change Battery of Robot and control panel ロボット制御盤 電池交換 40min/person	1Time/ 1Year											① ⑥		holiday
													② ⑦		
													③ ⑧		
													④ ⑨		
													⑤		
3	LADLE SPIN GEAR ラトル回転ギア グリスアップ 10min/1person	1Time/ 3month	① ⑥			① ⑥			① ⑥			① ⑥			
			② ⑦			② ⑦			② ⑦			② ⑦			
			③ ⑧			③ ⑧			③ ⑧			③ ⑧			
			④ ⑨			④ ⑨			④ ⑨			④ ⑨			
			⑤			⑤			⑤ ⑨			⑤			
4	LADLE SPIN BEARING ラトル回転ベリング グリスアップ 10min/1person	1Time/ 3month	① ⑥			① ⑥			① ⑥			① ⑥			
			② ⑦			② ⑦			② ⑦			② ⑦			
			③ ⑧			③ ⑧			③ ⑧			③ ⑧			
			④ ⑨			④ ⑨			④ ⑨			④ ⑨			
			⑤			⑤			⑤			⑤			
5	THE GREASE LADLE SPIN BEARING ラトル回転 減速機グリスアップ 20min/1person	1Time/ 3month	① ⑥			① ⑥			① ⑥			① ⑥			
			② ⑦			② ⑦			② ⑦			② ⑦			
			③ ⑧			③ ⑧			③ ⑧			③ ⑧			
			④ ⑨			④ ⑨			④ ⑨			④ ⑨			
			⑤			⑤			⑤			⑤			

<DCM No.>

No.1:①

No.5:⑤

No.9:⑨

No.2:②

No.6:⑥

No.3:③

No.7:⑦

No.4:④

No.8:⑧

Secondary Cooling

14/14

14 / 17															
NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	Cleaning of heat exchanger plates 熱交換器プレートの洗浄 180min / 2person	1Time/ 6Month					① ⑥						① ⑥		holiday
							② ⑦						② ⑦		
							③ ⑧						③ ⑧		
							④ ⑨						④ ⑨		
							⑤						⑤		
2	Replacement O-N separator セパレータのO-Nの交換	1Time/ 2Year						⑥							next time 2024
							② ⑦								
							③ ⑧								
							④ ⑨								
							⑤								
3	Replacement of regulator element レギュレータの元素トの交換	1Time/ 2Year						⑥							next time 2024
							② ⑦								
							③ ⑧								
							④ ⑨								
							⑤								
4	Replacement of regulator micro mist separator レギュレータ・マイクロミストセパレータの交換	1Time/ 2Year						② ⑦							next time 2024
							③ ⑧								
							④ ⑨								
							⑤								
5	Cleaning auto drain of regulator レギュレータのオートドレインの掃除	1Time/ 6Month				① ⑥						① ⑥			
						② ⑦						② ⑦			
						③ ⑧						③ ⑧			
						④ ⑨						④ ⑨			
						⑤						⑤			
6	Replacement of membrane module in dryer ドライヤの膜モジュールセットの交換	1Time/ 4Year						①							next time 2024
							②								
							③								
							④								
							⑤								
7	Replacement Cleaning and Change water タンク清掃と水槽冷却水の入れ替え 120min / 2person	1Time/ 3Month		① ⑥			① ⑥			① ⑥			① ⑥		
				② ⑦			② ⑦			② ⑦		② ⑦			
				③ ⑧			③ ⑧			③ ⑧		③ ⑧			
				④ ⑨			④ ⑨			④ ⑨		④ ⑨			
				⑤			⑤			⑤		⑤			
8	Exchange of Filter filtration device change 濾過装置のフィルターの交換	1Time/ 1Month	①	①	①	①	①	①	①	①	①	①	①	①	
			②	②	②	②	②	②	②	②	②	②	②	②	
			③	③	③	③	③	③	③	③	③	③	③	③	
			④	④	④	④	④	④	④	④	④	④	④	④	
			⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	⑤	
			⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	⑥	
			⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	⑦	
			⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	⑧	
			⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	⑨	
9	RO Filter change ROのフィルター交換 40min / 1person	1Time/ 6Month				① ⑥						① ⑥			
						② ⑦						② ⑦			
						③ ⑧						③ ⑧			
						④ ⑨						④ ⑨			
						⑤						⑤			
10	Cleaning Inlet Outlet Y-stainer インレットYストレーナー掃除 40min / 2person	3Time/ 1Year	① ⑥				① ⑥				① ⑥				
			② ⑦				② ⑦				② ⑦				
			③ ⑧				③ ⑧				③ ⑧				
			④ ⑨				④ ⑨				④ ⑨				
			⑤				⑤				⑤				
11	Cleaning Sensor Cooling water return 戻り側の冷却のセンサー掃除 20min / 1person	1Time/ 2Month	①		①		①		①		①		①		
			②		②		②		②		②				
			③		③		③		③		③				
			④		④		④		④		④				
12	Cleaning Flow Check Water Return Fix Move 固定型・可動型のリターン冷却水の流量計の掃除 90min / 1person	1Time/ 6Month			① ⑥						① ⑥				
					② ⑦						② ⑦				
					③ ⑧						③ ⑧				
					④ ⑨						④ ⑨				
					⑤						⑤				
13	Cleaning electrode level Tank レベルタンクの電極の掃除 30min / 1person	1Time/ 6Month				① ⑥						① ⑥			
						② ⑦					② ⑦				
						③ ⑧					③ ⑧				
						④ ⑨					④ ⑨				
						⑤					⑤				

สัญลักษณ์ (Symbol) :

○ แผน (Plan)

● ทำได้ตามแผน (On Plan)

● เลื่อนแผน (Postponed)

< Finishing No. >

No.1:① No.5:⑤

No.2:② No.6:⑥

No.3:③ No.7:⑦

No.4:④ No.8:⑧

No.9:⑨ Heat treatment:H

	Revised Detail	Day/Month	Approval	Creating
△				
△				
△				
△				

Classification No.	Approval	Check	Making

Control Panel

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	PLC・タッチパネルのバックアップ Backup PLC and touch panel 60min/1 person	1Time/6Month						① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤						① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	
2	AGVのPLCのバックアップ Backup OF PLC AGV 10min/1 person	1Time/6Month						① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤						① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤	
3	制御盤の掃除 Cleaning Control panel 30min/1 person	1Time/6Month					① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤						① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤		
4	PLC・CNC・タッチパネルのバッテリー交換 Battery change OF PLC,CNC ,touch panel 30 min/1 person	1Time/Year											① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤		

< Finishing No. >

No.1:① No.5:⑤

No.2:② No.6:⑥

No.3:③ No.7:⑦

No.4:④ No.8:⑧

No.9:⑨

Robot

パネル・ロボット panel and robot

2/12

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	ロボットグリースアップ Change grease of robot 90min/1 person	1Time/Year											① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤		
2	ロボットのバッテリー交換 Battery change OF Robot 20min/1 person	1Time/Year											① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤		
3	Clamp/unclamp cylinder check bolt M2.5 at piston and cleaning	1Time/Year		① ⑥ ② ⑦ ③ ⑧ ④ ⑨ ⑤											

< Finishing No. >

No.5:

No.6:

No.7:

No.8:

Shot Blast

エレベーター Elevator

3/12

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	バケツのベルトのテンション確認 Bucket Belt Tension check 30min/1 person	1Time/2Month		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧	
2	目視でバケツの磨耗確認 Bucket check abrasion visual inspection 10min/1 person	1Time/2Month		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧	
3	プーリーの下側と上側のベアリング交換 Change bearing pulley low side and Upper side 360min/2 person	1Time/2Year			⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧								Next time 2024
4	チェーンのテンションの確認と調整 chain Tension check and adjust 30min/2 person	1Time/2Month		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧	
5	目視でモーター確認とベアリングの音確認 Motor visual check and Sound check for bearing motor 10min/1 person	1Time/2Month		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧	

< Finishing No. >

No.5:

No.6:

No.7:

No.8:

Shot Blast

ローター Rotor

4/12

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	目視でインペーターとブレードの磨耗確認 Impeller and Blade visual check of abrasion 10min/1 person	1Time/2Month		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧	
2	目視でモーター確認とベアリングの音確認 Motor visual check and Sound check for bearing motor 10min/1 person	1Time/2Month		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧	
3	ベルトのテンションの確認と調整 Belt Tension check and adjust 30min/2 person	1Time/2Month		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧		⑤ ⑥ ⑦ ⑧	

<Finishing No.>

No.5:

No.6:

No.7:

No.8:

Shot Blast

Orbital system

5/12

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	目視でモーター確認とベアリングの音確認 Motor visual check and Sound check for bearing motor 10min/1 person	1time/2Month		⑤		⑤		⑤		⑤		⑤		⑤	
				⑥		⑥		⑥		⑥		⑥		⑥	
				⑦		⑦		⑦		⑦		⑦		⑦	
				⑧		⑧		⑧		⑧		⑧		⑧	
2	ベルト・チェーンのテンションの確認と調整 Belt and chain Tension check and adjust 20min/2 person	1time/2Month		⑤		⑤		⑤		⑤		⑤		⑤	
				⑥		⑥		⑥		⑥		⑥		⑥	
				⑦		⑦		⑦		⑦		⑦		⑦	
				⑧		⑧		⑧		⑧		⑧		⑧	

<Finishing No.>

No.5:

No.6:

No.7:

No.8:

Shot Blast

ネジ Screw

6/12

1	目視でモーター確認とベアリングの音確認 Motor visual check and Sound check for bearing motor 10min/1 person	1time/2Month		⑤		⑤		⑤		⑤		⑤		⑤	
				⑥		⑥		⑥		⑥		⑥		⑥	
				⑦		⑦		⑦		⑦		⑦		⑦	
				⑧		⑧		⑧		⑧		⑧		⑧	
2	チェーンのテンションの確認と調整 chain Tension check and adjust 20min/1 person	1time/2Month		⑤		⑤		⑤		⑤		⑤		⑤	
				⑥		⑥		⑥		⑥		⑥		⑥	
				⑦		⑦		⑦		⑦		⑦		⑦	
				⑧		⑧		⑧		⑧		⑧		⑧	

<Finishing No.>

No.5:

No.6:

No.7:

No.8:

Shot Blast

Entrance and blasting rotation

7/12

1	目視でモーター確認とベアリングの音確認 Motor visual check and Sound check for bearing motor 10min/1 person	1time/2Month		⑤		⑤		⑤		⑤		⑤		⑤	
				⑥		⑥		⑥		⑥		⑥		⑥	
				⑦		⑦		⑦		⑦		⑦		⑦	
				⑧		⑧		⑧		⑧		⑧		⑧	
2	目視でリングプーリーの磨耗確認 Lining Pulley visual check of abrasion 10min/1 person	1time/2Month		⑤		⑤		⑤		⑤		⑤		⑤	
				⑥		⑥		⑥		⑥		⑥		⑥	
				⑦		⑦		⑦		⑦		⑦		⑦	
				⑧		⑧		⑧		⑧		⑧		⑧	

<Finishing No.>

Heat treatment:H

Heat treatment furnace

Control Panel

8/12

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	PLC・タッチパネルのバックアップ Backup PLC and touch panel 60min/1 person	1time/6Month													
								H						H	
2	制御盤の掃除 Cleaning Control panel 30min/1 person	1time/6Month													
3	PLC・タッチパネルのバッテリー交換 Battery change OF PLC touch panel 30 min/1 person	1Time/Year													

<Finishing No.>

Heat treatment:H

Heat treatment robot

パネル・ロボット panel and robot

9/12

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	ロボットグリースアップ Change grease of robot 90min/1 person	1Time/Year													
2	ロボットのバッテリー交換 Battery change OF Robot 20min/1 person	1Time/Year													
3	PLC・タッチパネルのバックアップ Backup PLC and touch panel 60min/1 person	1time/6Month													

<Finishing No.>

Heat treatment:H

Heat treatment furnace

Burner

10/12

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	リンケージ緩み linkage looseness 10min/1 person	1time/3Month													
2	ジョイントでガス漏れ確認 Check gas leakage from the piping joint 20min/1 person	1time/3Month													

<Finishing No.>
Heat treatment:H

Heat treatment furnace

Main Body

11/12

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	炉中の製品置きバーの変形確認 Check the damage and deformation for the rack flat bar 180min/2 person	1time/6M onth						H						H	
2	ボルトの緩み確認 Check the bolt looseness 180min/2 person	1time/6M onth						H						H	
3	ダンパー確認 check by the external handle Damper Direction 10min/1 person	1time/3M onth			H			H			H			H	
4	炉の底の破れ・破損確認 Inside plate of the furnace Torn out or worn-out 60min/1 person	1time/6M onth						H						H	
5	炉内にあるアルミバリ確認 Aluminum burr inside the furnace 60min/1 person	1time/6M onth						H						H	
6	炉のシーリング確認 Check the furnace seal packing worn-out? 30min/1 person	1time/3M onth			H			H			H			H	
7	開閉のリミットスイッチ確認 Detection of limit switch for open-close 30min/1 person	1time/3M onth			H			H			H			H	
8	扉開閉条件(スピードコントロール) Door open/Close condition (Speed control) 60min/2 person	1time/3M onth			H			H			H			H	
9	クッションの状態確認 Cushion shock absorber condition at open-end 60min/1 person	1time/3M onth			H			H			H			H	
10	扉のシーリング確認 Is the Door seal packing worn-out 15min/1 person	1time/3M onth			H			H			H			H	
11	ベアリングのノイズ確認 Bearing sound Check 15min/1 person	1time/3M onth			H			H			H			H	
12	チェーンの磨耗・切れ確認 Drive Chain Worn-out and cut-off 60min/2 person	1time/3M onth			H			H			H			H	
13	スプロケットの磨耗確認 Sprocket Worn-out 30min/1 person	1time/3M onth			H			H			H			H	

<Finishing No.>
Heat treatment:H

Heat treatment furnace

Circulation fan

12/12

NO	ITEM	Period	January	February	March	April	May	June	July	August	September	October	November	December	Remark
1	ベルトの磨耗確認 Worn-out of V-belt 30min/1 person	1time/3M onth			H			H			H			H	
2	ベルトのテンション確認 Tension of V-belt 20min/1 person	1time/3M onth			H			H			H			H	
3	ベアリングのノイズ確認 Strange sound from the bearing 15min/1 person	1time/3M onth			H			H			H			H	
4	稼働中のモーターの電流確認 Current value at running 15min/1 person	1time/3M onth			H			H			H			H	
5	溶接ビードの確認 main body check crack of the welding surface 20min/1 person	1time/6M onth						H						H	

สัญลักษณ์ (Symbol) :



แผน (Plan)



ทำตามแผน (On Plan)



เลื่อนแผน (Postponed)