

Service Report

DMG MORI Houston
8420 N. Sam Houston Pkwy. W.
Texas 77064

Customer: Harris Machine Tools Inc, United States, Houston	Customer No: AC0597815	Machine Model: NT6600DCG/6000B	Control: FS-31iA5
Street: 24 Greenway Plaza Ste 624	Serial Number: NT660120401	Work Order: 22-641-220590-001	
City: Houston	State: Texas	Machine Hours: 49,625	Technician: Harrison, Michael
ZIP/Postal Code: 77046	Country: United States	Spindle Hours: 4,798	Officer in Charge:
Contact Person: Harris Jr., Jean	Email:	Area Sales Manager Houston 37	Purchase Order: 19681
Phone: +1 713-4625800	Fax: +1 (713) 462-8222	Installation Date: 08/02/2012	

Problem Description:

Machine decommission at Baker Hughes, 2001 Rankin

Work Performed:

3/10/2022 MH

- Arrived at customer and got checked in with security
- Arrived at machine and began work
- Completed machine back up
- Changed the servo and NC batteries
- Attempted a tool change and found it stopped mid cycle
- Manually recovered the tool changer unit
- Completed multiple tool changes
- Moved steady rest in Z and attempted to move in X
- Only steady 2 would move in X but not steady 1
- Attempted moved the tailstock and found the clamp switch stuck
- Removed all covers and freed the switch up with lubricant
- Installed most of the covers and moved the tailstock back to a clamp position
- Will return with camera man to get video of the machine moving

3/11/2022 MH

- Completed program testing in single block and made adjustments for clearances
- Ran program with camera man until he was satisfied
- Deleted all customer programs from the control
- Cleaned area and will return when decommission starts

3/14/2022 MH

- Arrived at customer and began decommission
- Removed and labeled all chip shooters for the coolant tank
- Removed all coolant tank connections electrical and hoses
- Had Baker Hughes assist with the coolant tank removal
- Spoke with Jean on crating and packing needs
- Disassembled the rear wall on the machine and staged for crating
- Manually moved the tool changer to get an idea on what needs to be done for removal
- Cleaned the area and will return in the morning to continue

3/15/2022 MH

- Arrived on site and continued machine disassembly
- Removed all sheet metal for the magazine and staged for crating
- Removed sheet metal for the ATC and staged for crating
- Disconnected high pressure units and prepped for shipping
- Assisted with sheet metal staging
- Prepped magazine and ATC for removal
- Will need shipping brackets before we can continue

3/16/2022 MH

- Arrived on site and continued on machine decommission
- Removed sheet metal from steady rest and tailstock to make room for shipping brackets
- Customer arrived with shipping brackets for Y, X and Z
- Completed the Y axis bracket by drilling the needed holes
- Installed the Z axis bolts for shipping
- Positioned X and found the provided bolts were too long to use requested customer supply correct bolts or washers
- Removed sheet metal on control and prepped for final power down and removal
- Secured the chuck pressure regulator in the headstock area

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-Need the remaining brackets to install and power machine down and continue final disassembly
3/17/2022 MH
-Arrived on site and waited for shipping brackets
-Brackets arrived at 8:45
-Installed both steady rest brackets
-Steve finalized the tailstock bracket and installed
-Powered machine down for final disassembly
-Removed all power and air lines to the ATC
-Removed electrical and hydraulic connections from the hydraulic unit
-Removed air, electrical, hydraulic and power cables from the magazine
-Removed the ATC from the machine and prepped for transit
-Machine is ready to have the magazine lifted from the machine and main electrical removed from the machine

3/18/2022 MH
-Arrived on site and finalized machine decommission
-Removed cable track for ATC for clearance purposes
-Removed machine anchor nuts from jack bolts
-Customer had electrical removed
-Secured the doors and Z axis covers
-Machine is ready for rigging company and magazine removal

Remarks:

Work Hours

Start Time	End Time	Duration
03/10/2022 08:00	03/10/2022 14:30	6.50
03/11/2022 06:45	03/11/2022 10:00	3.25
03/14/2022 06:30	03/14/2022 15:30	9.00
03/15/2022 07:15	03/15/2022 14:00	6.75
03/16/2022 06:30	03/16/2022 14:30	8.00
03/17/2022 07:15	03/17/2022 14:15	7.00
03/18/2022 08:30	03/18/2022 13:00	4.50
TOTAL WORK TIME:		45.00

Status at visit:	Operational	after visit:	Operational	Follow-up service:	No
Follow-up notes:					

Please confirm all working hours performed in execution of authorized work. The costs and conditions are subject to the rates prevailing at the time work took place.

3/22/2022

Date

No contact on site

Harrison, Michael