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USSR ELECTRIC REGISTER FOR RECORDING MACHINE TOOL OPERATING TIME

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Production equipment in the USSR is repaired according to a PPR (preventive maintenance) system. The basic principle of all existing PPR systems is a specified length of periods between repairs and of repair cycles and a specified order of rotation for various types of repair. In the majority of existing PPR systems, the lengths of periods between repairs and of repair cycles are calculated in calendar months or, at a number of plants, in hours that each machine tool has actually worked.

It has been found that recording the operating time is the best way to determine the actual wear of machine tool mechanisms.

A special electric register can be used to record the time that each machine tool has been in operation. There are several designs of such time registers. An electric time register [see Item 1 of graphics material] is being used at one plant and consists of two basic parts: an SD-2 synchronous electric motor and a registering mechanism.

The mechanism of the register is enclosed in a box with a window for reading the register [see Item 2 of graphics material].

The electric motor of the register is connected to the circuit and is switched on or off simultaneously with the electric motor of the machine-tool or spindle drive. In the spindle drive, a terminal switch is used.

The register is mounted on the headstock of a machine tool, on the bed, or on any other suitable place.

The register shows the total of machine tool operating time in minutes (up to 10,000 minutes). The reading of the register must be taken every week or 10 days.

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The number of hours that a machine tool has operated each month is entered on a repair card.

The readings of the time register on the repair card give a graphic picture of the actual work load of each machine tool.