

BE-07

MAINTENANCE MECHANIC TRAINING

SKILL CHECK GUIDE

Duty BE: Ways and Gibs
BE-07: Set and Adjust Gibs

Issued 06/01/98

Rationale

This Skill Development Guide provides the knowledge a Learner needs to set and adjust the gibs on a vertical lathe. The Learner must be able to set and adjust the gibs on a vertical lathe.

Skill Check Set-Up

Designate a G & L lathe for the practice activity. Set up a situation where the gibs require an adjustment. Ask the Learner to perform the steps for setting the gibs to specifications. Before the Learner replaces the way wipers, check the torque adjustments to ensure that they are within specifications.

Provide the tools, materials, and resources needed to demonstrate the task.

What The Learner Will Need

This section contains the safety information, tools, and resources you will need before setting and adjusting gibs on a vertical lathe.

SAFETY FIRST

DON'T TAKE
CHANCES

- Follow all Caterpillar facility safety standards when performing this task.
- The floor surface inside the machine may be slippery due to coolant.
- You will be working in a confined space; watch your head clearance.
- Feedrate for the machine must be set to MIN. to avoid unexpected movement of the machine head.



- Giddings & Lewis VTL
- shop cleaning rags
- torque wrench (in/lb)
- Allen wrenches



- machine's maintenance service manual



Skill Check

Given a vertical lathe with a semi-yearly PM scheduled or a piece part with dimensions exceeding the allowable tolerance, set and adjust the gibs on the vertical lathe.

Needs
Mastered Practice

Safe Work Practices

- | | | |
|-------|-------|---|
| _____ | _____ | 1. Follow all Caterpillar facility safety standards when performing this task. |
| _____ | _____ | 2. The floor surface inside the machine may be slippery due to coolant. |
| _____ | _____ | 3. You will be working in a confined space; watch your head clearance. |
| _____ | _____ | 4. Feedrate for the machine must be set to MIN. to avoid unexpected movement of the machine head. |

Task Standards

- | | | |
|-------|-------|--|
| _____ | _____ | 1. Gibs are adjusted to within 25-30 in/lbs. |
| _____ | _____ | 2. Piece part is machined within specifications. |



Evaluator's Sign-Off

The Learner has demonstrated safe work practices and competent performance of the task.

Evaluator: _____ Date: _____

Learner: _____ Clock No: _____

