

BE-07

MAINTENANCE MECHANIC TRAINING

TRAINER'S GUIDE

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

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Instructions To The Trainer

1. The Learner will contact you when ready to practice setting and adjust the gibs on a vertical lathe.
2. Be prepared to demonstrate the steps for this task.
3. Ask the Learner to contact the Evaluator when ready for the Skill Check.



Skill Objective

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.

Task Standards

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

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.



- 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



Practice Set-Up

The Learner may perform the following practice to help prepare for the Skill Check. Set up the practice for the Learner. Assist the Learner during the practice, if necessary; answer any questions concerning the task; and be prepared to demonstrate the task to the Learner. Make sure the Learner follows safe work practices while practicing the task.

Practice

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 adjustment readings to ensure that they are within specifications.

Practice Objective

The Learner must demonstrate emptying the ram and the four-star in both the manual and program modes. All safe practices must be demonstrated during task performance.

Next Step

Allow the Learner to continue practicing and developing skills needed to demonstrate the task. The Learner should ask the Evaluator to schedule a Skill Check when ready to demonstrate the task unaided and meet all the task standards and safe work practices.

