

PREVENTATIVE MAINTENANCE

FOR RTL-SERIES MACHINES

Preventative maintenance is based on a set of procedures and checks carried out on a regular basis. This program is based on current wear and tear of a machine used 8-10 hours per day 5 days a week.

DAILY ON POWER UP

Visually check air pressure at air gage, setting should be between 5.5bar-6.5 bar.

Visually Check way-lube oil level in oil tank.

Check hydraulic gage pressure for current operation before running the machine.

Check oil reservoir on coolant skimmer if fitted.

Check coolant level and fill as needed.

WEEKLY

Wipe down inside covers of machine blow off chips and spray with WD 40 to protect seals on sheet metal.

Wipe down roller guide for the door mechanism.

Wipe down machine sheet metal and clean controller face.

MONTHLY

Check and top up way lube oil tank with Mobil Vectra oil #2

Check cutting fluid level and check mixture of oil and water.

Check hydraulic fluid level, top up as needed.

Clean air conditioner filter.

Check tension on the encoder belt.

Check tension on the drive belt.

If a live spindle is used, check the carousel grippers for oil build up and clean any excess oil or chips.

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3 MONTHLY

Check the temperature on the electrical cabinet air conditioner.

Temperature setting should be 30^o-32^o C

(Set temperature to 29^o C fan should start to run) If Fan starts set temp back original temperature.

If a Y axis is fitted remove the slide cover and check for chip build up.

Add grease to the slide and using the grease nipple grease the linear slide block.

If a live spindle is used check the coolant tank and clean out the tank.

If a live spindle is used check the clamping mechanism.

Clean spindle motor fan cover. Check fan operation.

6 MONTHLY

Remove center panel and wipe down interior panels and check for chip build up.

Check servo drive motor connections on X-Z axes.

Check servo motor connections on the carousel if fitted.

Check that the X axis motor cables are secured to the casting correctly.

Check the lock sensor cable on the turret clamping system for oil contamination, clean as needed.

12 MONTHLY

Drain coolant from machine sump and remove all excess chips and oil.

Refill tank with coolant that has been checked for the correct mixture.

Check drive & encoder belts and if needed replace both at the same time.

48 MONTH

Drain the hydraulic coolant tank, refill with fresh oil