

Monthly Maintenance

Remove the following items from the revolving head, clean thoroughly, inspect and replace:

- 1 - Collets (chucks)
- 2 - Inner Spindle
- 3 - Feed Fingers
- 4 - Feed Tubes

Inspect condition of:

- 1 - Outer spindle and clean internally with boiler brush
- 2 - Stop Screws
- 3 - Cross Slide and Gib Adjustment

Inspect wear and/or damage condition of:

- 1 - Stock Reel
- 2 - Stock Reel Stand
- 3 - Locating Lever (to assure it is locking correctly and roll is turning)
- 4 - Chuck Slide, Roll, and Pin

Check wear and/or damage of:

- 1 - Spanner Nuts
- 2 - Bearings
- 3 - Rollaway Clutch
- 4 - Gears (tooth wear and mounting)
- 5 - Shafts
- 6 - Chuck and Feed Cam Shaft

Check for:

- 1 - Twisted Front Cam Shaft (the locating lever must clear the locating blocks (724-1) on index and make contact on the angle side first when locking with approximately .012 push back.)

Quarterly Maintenance

- 1 - Remove coolant from the pan and thoroughly clean pan of sediment and fine chips. Add new coolant.
- 2 - On long runs, where the cams are seldom changed, remove cross slides and clean, then check cross slide gib adjustments.
- 3 - Plugs at the bottom of the worm housing should be removed and the housing flushed out with an OSHA approved solvent. Replace the plugs and fill with fresh oil.

Semi-Annual Maintenance

- 1 - Drain, clean, flush, and refill main lube oil reservoir. Check condition of filter.
- 2 - Check for excessive end play of revolving head.
- 3 - Check for excessive looseness of work spindles.
- 4 - Check for excessive looseness of tool spindles.
- 5 - Check for excessive end play of thrust bearings.
- 6 - Check condition of electrical controls: switches, solenoid valves, wiring, panel box, and motors. NOTE - ELECTRICAL MAINTENANCE SHOULD BE BY AUTHORIZED PERSONNEL ONLY.
- 7 - Check main drive belt tension.