

PREVENTIVE MAINTENANCE

This is only a guide. Actual production conditions may require more or less preventive maintenance. A good maintenance program requires the cooperation of all. Preventive maintenance can save cost by reducing "down time", rejected parts, and other small problems.

Operators Care of the Machine:

- 1 - Check lube oil in sight glass at beginning of shift. Fill if necessary.
- 2 - Oil all oil fittings with oil gun every shift.
- 3 - At the beginning of each shift, check to be sure there is adequate coolant flow to all tooling cutting edges and coolant flow is directed away from the work spindles.
- 4 - Wipe the bars clean of dirt and grit before loading them into the machine. Wipe with oily rag to reduce noise and load on feeding mechanism.
- 5 - Be sure both ends of all bars are chamfered before loading them into the machine for easier entry into pushers and collets (chucks).
- 6 - At the end of each shift, turn power to the machine to "Jog Off". Wipe or brush all chips and grit away from slides, gibs, and tool holders. Do Not use an air hose. High pressure air is dangerous and drives grit into the slides, gibs and other mechanisms; which prevents proper operation.
- 7 - Do not operate machine with improperly adjusted clutches. Notify your supervisor.
- 8 - NEVER ATTEMPT TO FORCE THE MACHINE TO OPERATE. In case of hang up, twisted cam shaft, or any other malfunction, turn machine off and notify your supervisor.
- 9 - Check collet (chuck) adjustment when loading new bars and re-adjust if necessary.
- 10 - Check condition of cam rolls and pins each time cams are changed.
- 11 - Keep machine and floor area around the machine free from accumulated oil, dirt and debris.

Daily Maintenance

Check:

- 1 - Lubricating oil level in main reservoir.
- 2 - Coolant level in pan reservoir.
- 3 - Coolant intake pipe (or Pump) screen; clean if necessary.
- 4 - Condition and alignment of stock reel and stock reel support.
(This should be lagged to floor).
- 5 - Lubricating oil delivery to spindle bearings.
- 6 - Brake adjustment.

Bi-Weekly Maintenance

- 1 - Visually inspect and hand feel high speed and starting clutches.
- 2 - Check radial torque on threading clutch. (Use torque wrench).
See MB-226-SA, sheet #3. Also check for neutral approximately 1/4" of play.
- 3 - Check locking nuts on spindle change gear shafts.
- 4 - Check revolving head for end play and adjust thrust ring if necessary.