



MRT-1017 Maintenance Schedule

These are basic guidelines and maintenance intervals may vary based on machine usage. The below usage is based off of five 8-hour shifts per week.

"A clean machine is a happy machine"

Daily housekeeping (every 8hr shift): is approx. 15 min per shift

AM:

-Lift the split lid and de-dross the solder pot. Scrape sides of tank and riser on pump to free any dross or particles. Scoop out particles and dross from tank with spatula (P/N S0014) or similar device.

-Also, take the time to clean around the boss on the nozzle riser. (See **Fig. 1**)

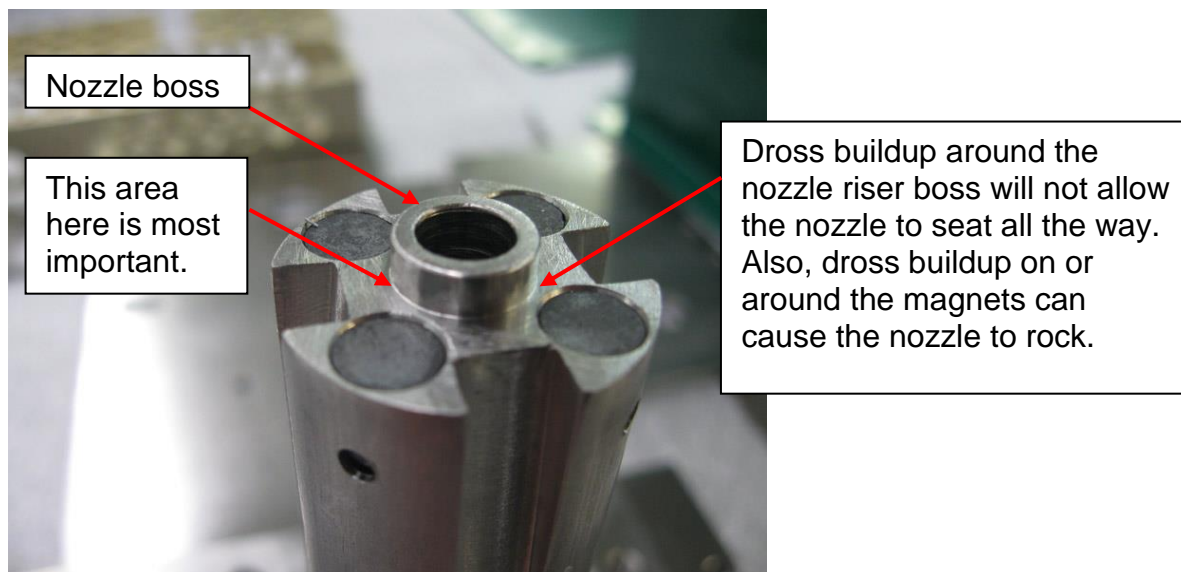


Fig. 1

-Remove any solder from pump lid. Scrape off any solder debris off nozzle caps and N2 chimney.
-With alcohol and or using scotch brite clean flux cover, nozzle caps, and N2 chimney of flux residue as solder can bond to the stainless steel, especially the Superior #75 (P/N S0006) flux residue.

-Test fire fluxer(s) for accurate operation before running boards. Put glass plate on rails and verify that the equipped fluxer(s) are operating normally.

-Note: If you cleaned the X and Y linear rails then lube with a light layer of Super Lube (6150448).

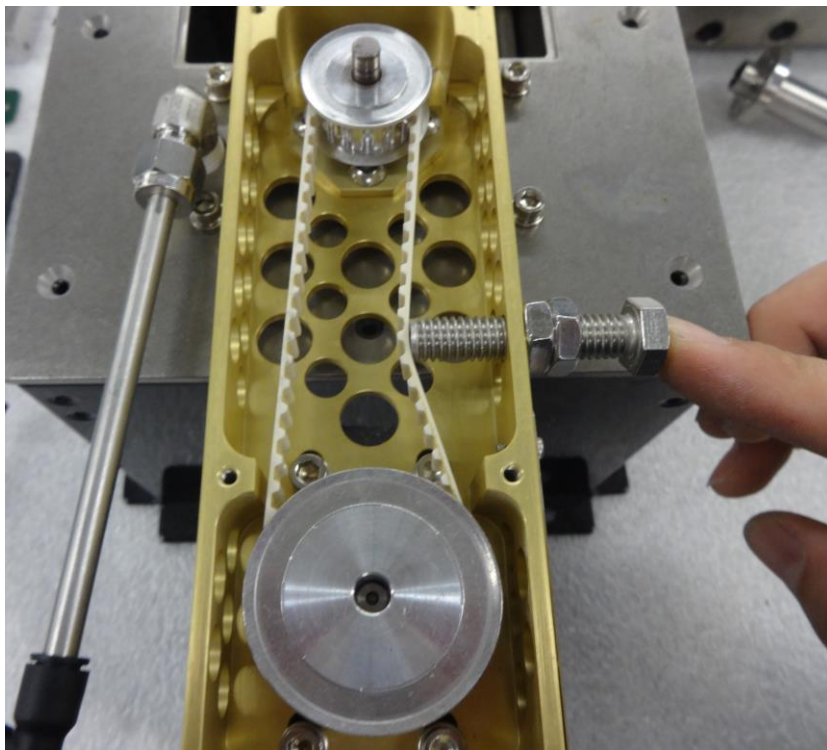
PM:

- Clean flux residue from machine, special focus on PCB rails (top and bottom side) using alcohol wipes or similar cleaners.
- Wipe off flux heads with alcohol wipes or other suitable cleaning device.
- Clean all external surfaces of machine with alcohol or Windex equivalent.
- Close off fluid valve to drop jet if equipped.
- Clean stainless-steel drip tray in the bottom of the machine with a suitable stainless-steel cleaner / polish.

Weekly or 32 to 40 hours of operation: is approx. 20-25 min. maintenance time.

- De-dross pot and pump. Remove pump from pot and remove dross from pump assembly. Scrape inside of pot around heaters and thermocouple tube to free up dross dust and particles from tank. Scoop out dross and particles from pot.
- Clean machine, remove splattered solder and flux residue from inside machine. -Visually inspect rails, z posts, screw drives, linear rails, (for 104's, check conveyor and conveyor belts) for build-up of flux or dirt and clean with alcohol or equivalent. If rails are cleaned they must be re-lubed using Super Lube (P/N 6150448), apply a light coating on linear rails. If screw drives need to be cleaned, wipe clean and test function. If X and Y linear screws have been lubricated (this is not recommended by Nordson SELECT) then they will need to be cleaned and re-lubricated with a light bead of Super Lube. Width adjust screws and slide rails should be free of dirt and debris, lube with a light coating of Super Lube (P/N 6150448).

- Verify belt tension. This should be done when the pump is at operating temperature.
(See **Fig. 3**)



The belt deflection should look the same once the motor is tight. So, note the shape of the chain with pressure on the right side.

Note:

The tool being used for belt deflection is just a 3/8-16 hex head bolt set at 0.860" from the jam nut to the end of the bolt and it is not necessary. It is a reference used here at Ace for a new pump. The idea of the first picture in this step is the shape of the chain when you put pressure on it. If the chain is too loose it can cause cavitation's in your solder dome. If the chain is too tight it will wear out the graphite sleeve and bronze bushing prematurely.

Fig. 3

-Clean and lube the linear X and Y rails. Clean with alcohol and a cloth or similar device and re-lube with a light layer of Super Lube. Make sure lube is spread around evenly on unpainted surface to ensure all bearings receive lube in pillow blocks.

Bi-Weekly PM: is approx. 5-10 min.

-Inspect Z posts and Z drive train, if needed clean and lube the Z linear shafts with a light layer of Super Lube. Also, leave a light film of the Super Lube to the top of the shaft to protect it. If needed clean the teeth and gear on the Z power train and re-lube Z drive train with white lithium grease (P/N FS - Lithium Grease 1 1/2oz. bottle) on gears and teeth.

Monthly PM: is approx. 5-10 min

-Backup SWAK-OS 4.0 software database, see MRT-1109 SWAK-OS 4.0 Database Backup and Restore.

-Backup project files. Files can be found here, "<C:\Users\Users\Documents\Nordson SWAK-OS>".

Every 3 to 6 months PM: is approx. 1 hr.

-Perform deep cleaning on pump assembly. Clean out pump serpentine and remove dross from pump. Clean all dross from tank scraping along heaters and thermocouple tube, scoop out dross from tank.

-Blow dust and debris out of PC and PC fans.

-Blow out fans on machine. GenI Machines: There is 1 fan in the back of the machine. GenII Machines: There are 2 fans are on the right side of the machine

As needed maintenance:

-Filters in back of machine (if equipped)

-Filters in front doors of PC

-Clean mouse trackball with alcohol, remove from mouse and wipe clean.

-Blow out keyboard with compressed air.

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