### ARBURG

# Maintenance schedule

	Unic.
Machine model Year of construction	

Person responsible

248049	370 A	2019



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### Introduction

Maintenance overview

The check lists on the following pages are to be used for your regular inspections and serve as confirmation that this work has been carried out.

Carry out the respective maintenance work at the scheduled times and confirm with your signature and the date that it has been carried out completely and correctly.

Observe the dates specified here. This will save you unnecessary malfunctions and repairs and prolong the service life of your machine. The lubricant data are to be found in chapter 9.9 of the operating manual of the machine or in chapter 7.1 of the operating manual of the MULTILIFT.

Maintenance work for additional and non-standard equipment.

Depending on the configuration of your machine, additional and non-standard equipment may be installed. In this case, the required maintenance work is described in the respective chapters of the operating manual or in the enclosed documentation of the manufacturer.

The maintenance intervals of the additional and non-standard equipment are not included in the maintenance forewarning system of the SELOGICA controller. If these maintenance intervals are also to be managed via the SELOGICA controller, the respective data must be entered manually (see chapter 9.11 of the operating manual of the machine).

Maintenance locations

The maintenance locations specified here correspond to the respective chapters in the spare parts list.

Safety instructions

The safety devices must be inspected at regular intervals:

- after each mould change,
- at the start of each work shift,
- once a week in continual operation.

Cleaning agents

The powder enamel coating of the machine must not be treated with cleaning agents containing ketones, e.g. acetone, methanol, ethanol, glycol, PER, trichloroethane.

No plastic parts on the machine, including the viewing panels on the safety devices, must be cleaned with cleaning agents containing alcohol or solvents.

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Operating hours in automatic

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## Operating hours in automatic

92=Clamping unit: lubricate mould height adjustment system	17=Machine base: replace filter element	19=Machine base: drain off condensation in pneumatics		44=Injection unit: lubricate running surfaces, rollers, guides	Ш	9=Injection unit: clean and lubricate tie-bars		40=Safety devices: clean and lubricate guides		36=Clamping unit: move mould height adjustment system		29=Clamping unit: fill oil container of central lubrication system	33000 34000 35000 36000 37000 38000 39000 41000 42000 43000 44000 45000 46000 47000 50000 51000 52000 53000 54000 55000 55000 55000 56000 57000 58000 59000 60000 61000 62000 63000		Signature
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Operating hours in automatic

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29=Clamping unit: fill oil container of central lubrication system

Maintenance

Clamping unit

location:

Effect:

Note

Interval: 1000 Operating hours in automatic

### Work to be carried out:

- Check oil level of central lubrication system.
- Top up oil if level drops too low.
- See chapter 9.8.5 for procedure.
- · For lubricant see chapter 9.9.4.



W2B2

- 1: Label with lubricant information
- 2: Lubricant container



93=Clamping unit: lubricate mould height adjustment system

Maintenance

Clamping unit

location: Effect:

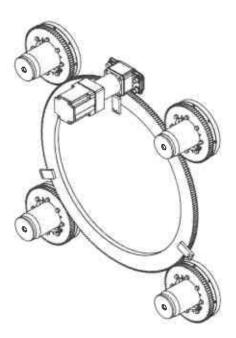
Warning

Interval:

20000 Operating hours in automatic

### Work to be carried out:

- Move mould height adjustment system to front position
- · Remove old grease from the threads.



W2B62



92=Clamping unit: lubricate mould height adjustment system

Maintenance

Clamping unit

location:

Effect:

Warning

Interval:

5000 Operating hours in automatic

### Work to be carried out:

### After 20000 hours:

- First remove the old grease from the threads
- Carry out after 20000 hours, see chapter 9.8.14.

### After 5000 hours:

- Fill nuts of mould height adjustment system via lubrication nipples.
- See chapter 9.8.14 for procedure.



36=Clamping unit: move mould height adjustment system

Maintenance

Clamping unit

location:

effect:

Warning

Interval:

1000 Operating hours in automatic

### Work to be carried out:

- Move mould height adjustment system in both directions
- Move forwards from the starting position by at least 70 mm
- Move backwards from the starting position by at least 70 mm

### Proceed as follows:

- · Set operating mode to "manual"
- Open the clamping unit
- Ensure that any connection cables between the mould halves are sufficiently long.
- Close the mould height adjustment system at least 70 mm
- Open the mould height adjustment system at least 70 mm

### Adjust mould height according to instructions in operating manual:

- Allrounder A see chapter 7.1.3.
- Allrounder E see chapter 7.1.3.
- Allrounder H see chapter 7.1.3.
- Allrounder S see chapter 7.1.7.
- Allrounder V see chapter 7.1.7.



38=Clamping unit: visual inspection of central lubrication system

Maintenance

Clamping unit

location:

Effect:

Warning

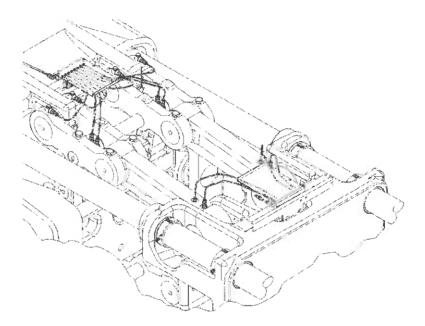
Interval:

10000 Operating hours in automatic

### Work to be carried out:

Visual inspection of central lubrication system of clamping unit.

· Check for damage or leaks in the hoses.



W2B9



1=Electrics: inspect control cabinet

cooler for any leakages

Maintenance

Electric system

location:

Interval:

Effect:

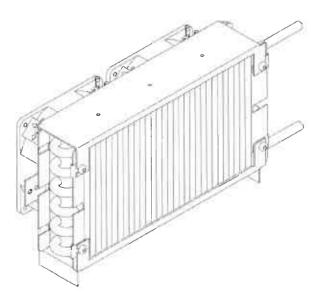
Note

10000 Operating hours in automatic

### Work to be carried out:

### Water cooler in control cabinet

- Clean cooler surface (vacuum clean)
- Test for leaks.
- · Test water flow.
- If flow impaired, clean nozzle in supply line (if necessary also decalcify).



W10B1





5=Hydraulics: hydraulic oil:

laboratory test (chemical analysis)

Maintenance

Hydraulic systems

location: Effect:

Warning

Interval:

10000 Operating hours in automatic

### Work to be carried out:

- Have hydraulic oil tested in laboratory for specified chemical characteristics (see chapter 9.9) and for usability.
- Test set for oil sample, material no. 525.156.





54=Hydraulics: hydraulic oil: particle measurement ISO 4406

Maintenance

Hydraulic systems

location:

Effect:

Warning

Interval:

5000 Operating hours in automatic

### Work to be carried out:

- Inspection of hydraulic oil for fine-particle soiling in accordance with ISO 4406, see chapter 9.9.
- To be carried out by ARBURG or external laboratory.



6=Hydraulics: replace filter insert in

oil filter

Maintenance

Hydraulic systems

location:

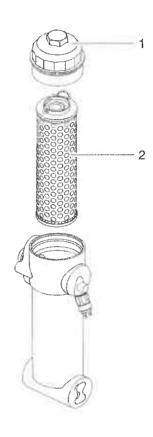
Effect: Alarm

Interval: 5000 Operating hours in automatic with S921

### Work to be carried out:

· Replace filter insert for hydraulic oil.

See chapter 9.8.3 for procedure.



W6B5

1: Cover

2: Filter insert





11=Hydraulics: replace hoses

Maintenance

Hydraulic systems

location:

Effect:

Warning

Interval: 72 Months

Work to be carried out:

· Replace all hydraulic hose assemblies.

See chapter 1.2.5 for procedure.



9=Hydraulics: replace toothed ring

in drive coupling

Maintenance

Hydraulic systems

location:

Effect:

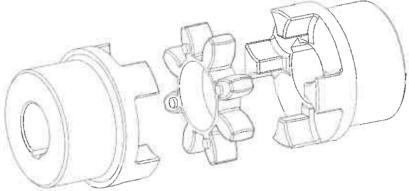
Alarm

Interval: 20000 Operating hours in automatic

### Work to be carried out:

· Replace toothed ring in drive coupling with each oil change.

See chapter 9.8.2 for procedure.



W6B4





3=Hydraulics: visual inspection for

any leakages

Maintenance

Hydraulic systems

location:

Effect:

Note

Interval:

5000 Operating hours in automatic

Work to be carried out:

· Inspection of hoses and (complete) hydraulic system

See chapter 1.2.5 for procedure.





48=Injection unit: change gear oil

Maintenance

Injection unit

location:

Effect:

Alarm

Interval:

20000 Operating hours in automatic

Work to be carried out:

Change gear oil.

See chapter 9.8.7 for procedure.



49=Injection unit: clean and lubricate tie-bars

Maintenance

Injection unit

location:

Effect:

Warning

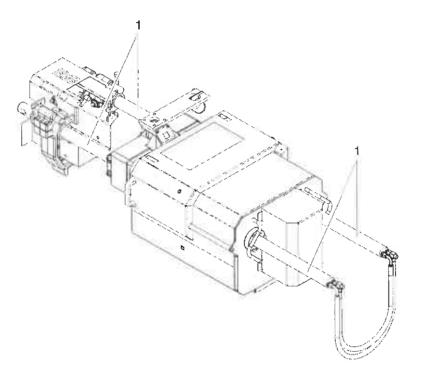
Interval:

1000 Operating hours in automatic

### Work to be carried out:

 Clean injection unit tie-bars and apply a light coating of oil (only in those areas in which no movements take place).

### Carry out more frequently if heavily soiled



W4B8

1: Tie-bars of injection unit



46=Injection unit: lubricate gear

housing

Maintenance

Injection unit

location:

Effect:

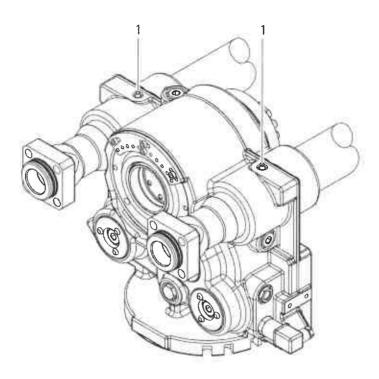
Warning

Interval:

5000 Operating hours in automatic

### Work to be carried out:

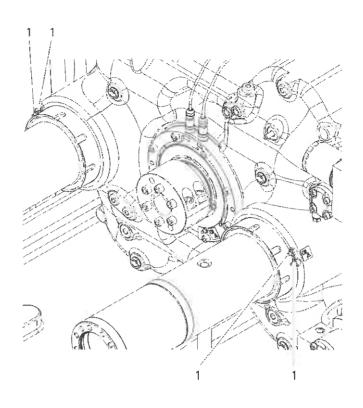
Lubricate gear housing of injection unit.



W4B10

1: Lubrication points





W4B34

1: Lubricating nipple



44=Injection unit: lubricate running surfaces, rollers, guides

Maintenance

Injection unit

location:

Effect:

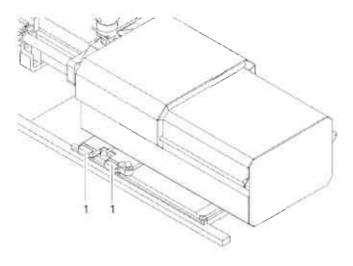
Warning

Interval:

1000 Operating hours in automatic

### Work to be carried out:

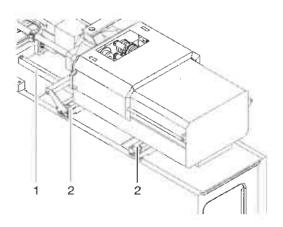
- Clean the guide rails.
- · Lubricate the runner blocks of the injection units.



W4B7

### 1: Runner blocks (4 pieces)

- Clean running surfaces of the support rails.
- Lubricate running surfaces lightly.
- Lubricate rollers



W4B2

1: Support rails 2: Rollers



45=Injection unit: replace filter

insert

Maintenance

Injection unit

location:

Effect:

Alarm

Interval:

10000 Operating hours in automatic with S971

### Work to be carried out:

· Replace filter element.

· Check filling level of gear oil.

Top up gear oil if required.

See chapter 9.8.7 for procedure.





55=Injection unit: visual inspection of cylinder module

Maintenance

Injection unit

location:

Effect:

Warning

Interval:

1000 Operating hours in automatic

### Work to be carried out:

- Visual inspection of cylinder module.
- Check the nozzle area and cylinder / screw coupling for damaged, loose or soiled components.
- Remove soiling in the area of the nozzle heater band.
- Check the nozzle and nozzle heater band for secure mounting. See chapter 9.1.4.
- Check the cylinder and screw coupling for secure mounting. See chapter 9.4.1.





15=Machine base: change

hydraulic oil

Maintenance

Machine base

location: Effect:

Alarm

Interval:

20000 Operating hours in automatic

### Work to be carried out:

- Change hydraulic oil.
- Clean oil container
- Top up oil immediately when the machine issues the following warning: "S925 oil level under nominal value" (S925 nominal value).

See chapter 9.8.2 and 9.8.4 for procedure.



56=Machine base: change temperature-control medium

Maintenance

Machine base

location:

Effect:

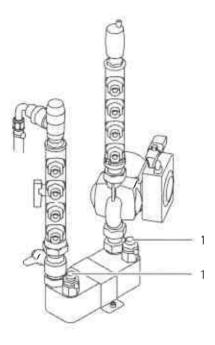
Warning

Interval:

20000 Operating hours in automatic

### Work to be carried out:

- Change temperature-control medium
- See chapter 9.8.8 for procedure.



W1B19

1: Connections for secondary circuit



18=Machine base: decalcify secondary circuit of temperature control device

Maintenance

Machine base

location:

Effect:

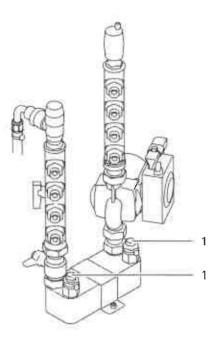
Note

Interval:

10000 Operating hours in automatic

### Work to be carried out:

 Clean and decalcify the secondary circuit of the heat exchanger on the temperature control device



W1B19

1: Connections for secondary circuit



19=Machine base: drain off condensation in pneumatics

Maintenance Machine base

location:

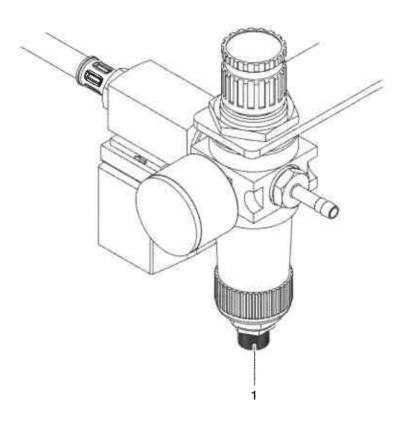
Effect: Note

Interval: 5000 Operating hours in automatic

### Work to be carried out:

Check condensation level in the pneumatic system.

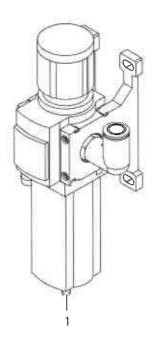
· Drain off condensation if necessary.



W1B3

1: Discharge valve for condensation





W1B18

1: Discharge valve for condensation



14=Machine base: readjust

alignment

Maintenance

Machine base

location:

Effect: Warning

Interval: 10000 Operating hours in automatic

Work to be carried out:

Check machine installation.

If necessary completely realign machine.

See chapter 1.1.5 for procedure.



17=Machine base: replace filter element

Maintenance

Machine base

location:

Effect:

Alarm

Interval:

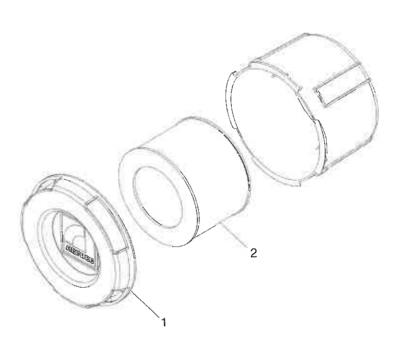
5000 Operating hours in automatic

### Work to be carried out:

Replace filter insert in air filter in oil container.

### Proceed as follows:

- Unscrew cover.
- Unscrew black sleeve.
- Change filter insert.
- Screw in sleeve.
- Replace cover.



W1B8

- 1: Cover
- 2: Filter insert



40=Safety devices: clean and

lubricate guides

Maintenance

Safety devices

location: Effect:

Warning

Interval:

1000 Operating hours in automatic

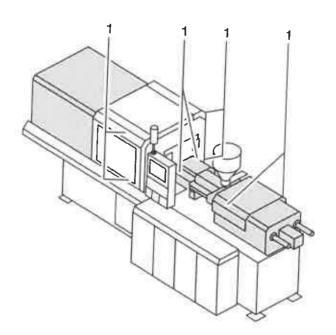
Work to be carried out:

Safety devices of clamping unit.

- Clean guides of safety gates.
- Apply a light coating of oil to the guides.

Safety devices of injection unit.

- Clean guides of safety gates.
- Apply a light coating of oil to the guides.



W3B4

1: Guides



41=Safety devices: inspect

Maintenance

Safety devices

location:

Effect:

Warning

Interval:

5000 Operating hours in automatic

Work to be carried out:

Check safety devices and mechanical end limits.

See chapter 1.2 for procedure.