

Maintenance schedule

ARBURG

Machine number

248049

Machine model

370 A

Year of construction

2019

Person responsible

List of contents

Header data	1
Introduction	3
Maintenance schedule	
Months Turnus 1 von 1	4
Operating hours in automatic 2) 1000h ... 1 von 3	5
Operating hours in automatic 2) 1000h ... 2 von 3	6
Operating hours in automatic 2) 1000h ... 3 von 3	7
Operating hours in automatic 2) 33000h ... 1 von 3	8
Operating hours in automatic 2) 33000h ... 2 von 3	9
Operating hours in automatic 2) 33000h ... 3 von 3	10
Maintenance jobs	
29=Clamping unit: fill oil container of central lubrication system	11
93=Clamping unit: lubricate mould height adjustment system	12
92=Clamping unit: lubricate mould height adjustment system	13
36=Clamping unit: move mould height adjustment system	14
38=Clamping unit: visual inspection of central lubrication system	15
1=Electrics: inspect control cabinet cooler for any leakages	16
5=Hydraulics: hydraulic oil: laboratory test (chemical analysis)	17
54=Hydraulics: hydraulic oil: particle measurement ISO 4406	18
6=Hydraulics: replace filter insert in oil filter	19
11=Hydraulics: replace hoses	20
9=Hydraulics: replace toothed ring in drive coupling	21
3=Hydraulics: visual inspection for any leakages	22
48=Injection unit: change gear oil	23
49=Injection unit: clean and lubricate tie-bars	24
46=Injection unit: lubricate gear housing	25
44=Injection unit: lubricate running surfaces, rollers, guides	27
45=Injection unit: replace filter insert	28
55=Injection unit: visual inspection of cylinder module	29
15=Machine base: change hydraulic oil	30
56=Machine base: change temperature-control medium	31
18=Machine base: decalcify secondary circuit of temperature control device	32
19=Machine base: drain off condensation in pneumatics	33
14=Machine base: readjust alignment	35
17=Machine base: replace filter element	36
40=Safety devices: clean and lubricate guides	37
41=Safety devices: inspect	38

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.

#248049

Months

Turnus 1 von 1

										a	Date	Signature
Commissioning												
11=Hydraulics: replace hoses										25.01.20		
										25.01.21		
										25.01.22		
										25.01.23		
										25.01.24		
										25.01.25		
										25.01.26		
										25.01.27		
										25.01.28		
										25.01.29		
										25.01.30		
										25.01.31		
										25.01.32		
										25.01.33		
										25.01.34		
										25.01.35		
										25.01.36		
										25.01.37		
										25.01.38		
										25.01.39		
										25.01.40		
										25.01.41		
										25.01.42		
										25.01.43		
										25.01.44		
										25.01.45		
										25.01.46		
										25.01.47		
										25.01.48		
										25.01.49		

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		h	Date	Signature
Commissioning				
1=	Safety devices: inspect	1000		
		2000		
		3000		
		4000		
		5000		
		6000		
		7000		
		8000		
		9000		
		10000		
		11000		
		12000		
		13000		
		14000		
		15000		
		16000		
		17000		
		18000		
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		20000		
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		24000		
		25000		
		26000		
		27000		
		28000		
		29000		
		30000		
		31000		
		32000		
6=	Injection unit: lubricate gear housing			
54=	Hydraulics: hydraulic oil: particle measurement ISO 4406			
6=	Hydraulics: replace filter insert in oil filter			
3=	Hydraulics: visual inspection for any leakages			
18=	Machine base: decalcify secondary circuit of temperature control device			
14=	Machine base: readjust alignment			
38=	Clamping unit: visual inspection of central lubrication system			
5=	Injection unit: replace filter insert			

	h	Date	Signature
29=Clamping unit: fill oil container of central lubrication system	33000		
	34000		
	35000		
	36000		
	37000		
	38000		
	39000		
	40000		
	41000		
	42000		
	43000		
	44000		
	45000		
	46000		
	47000		
	36=Clamping unit: move mould height adjustment system	48000	
49000			
50000			
51000			
52000			
53000			
54000			
55000			
56000			
57000			
58000			
59000			
60000			
61000			
62000			
63000			
64000			
40=Safety devices: clean and lubricate guides			
49=Injection unit: clean and lubricate tie-bars			
44=Injection unit: lubricate running surfaces, rollers, guides			
55=Injection unit: visual inspection of cylinder module			
19=Machine base: drain off condensation in pneumatics			
17=Machine base: replace filter element			
92=Clamping unit: lubricate mould height adjustment system			

	h	Date	Signature
5=Hydraulics: hydraulic oil: laboratory test (chemical analysis)	33000		
	34000		
	35000		
	36000		
	37000		
	38000		
	39000		
	40000		
	41000		
	42000		
	43000		
	44000		
	45000		
	46000		
	47000		
	48000		
	49000		
1=Electrics: inspect control cabinet cooler for any leakages	50000		
	51000		
	52000		
	53000		
	54000		
	55000		
	56000		
	57000		
	58000		
	59000		
	60000		
	61000		
	62000		
	63000		
	64000		
15=Machine base: change hydraulic oil			
56=Machine base: change temperature-control medium			
93=Clamping unit: lubricate mould height adjustment system			
48=Injection unit: change gear oil			
9=Hydraulics: replace toothed ring in drive coupling			

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

Maintenance
location:
Effect:
Interval:

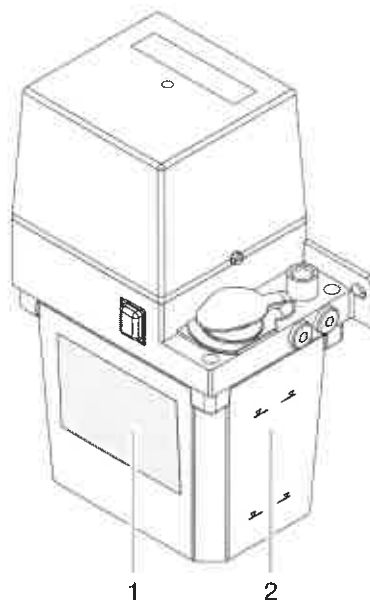
Clamping unit

Note

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.



- 1: Label with lubricant information
2: Lubricant container

W2B2

93=Clamping unit: lubricate mould height adjustment system

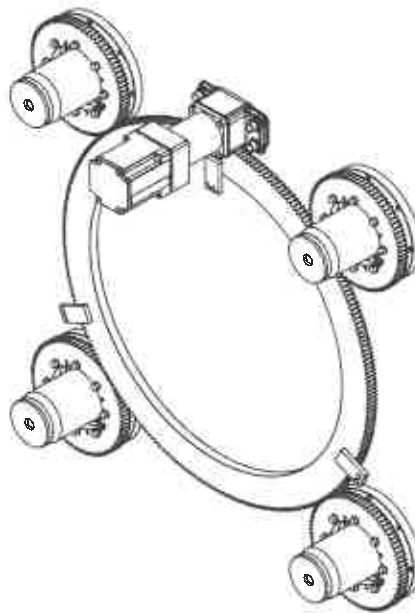
Maintenance location:
Effect:
Interval:

Clamping unit

Warning
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
location:
Effect:
Interval:

Clamping unit

Warning
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
location:
Effect:
Interval:

Clamping unit
Warning
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.

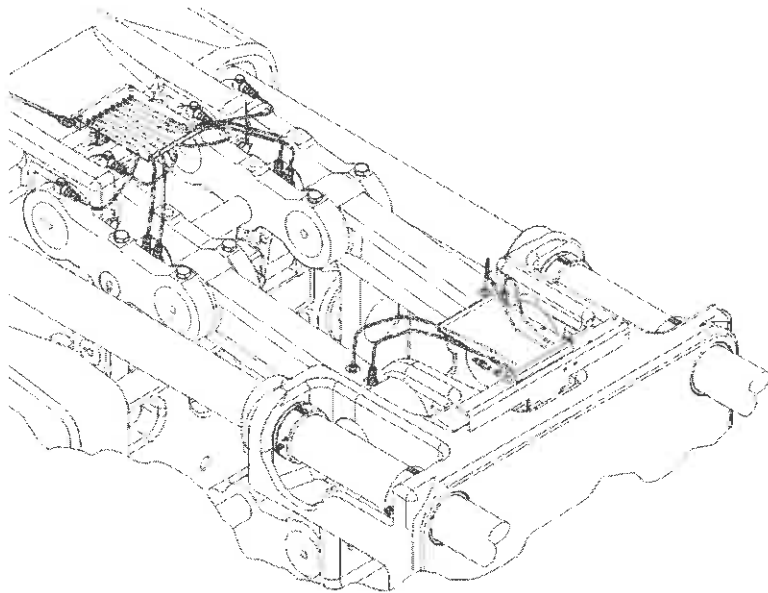
38=Clamping unit: visual inspection of central lubrication system

Maintenance location:
Effect:
Interval:

Clamping unit
Warning
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
location:
Effect:
Interval:

Electric system

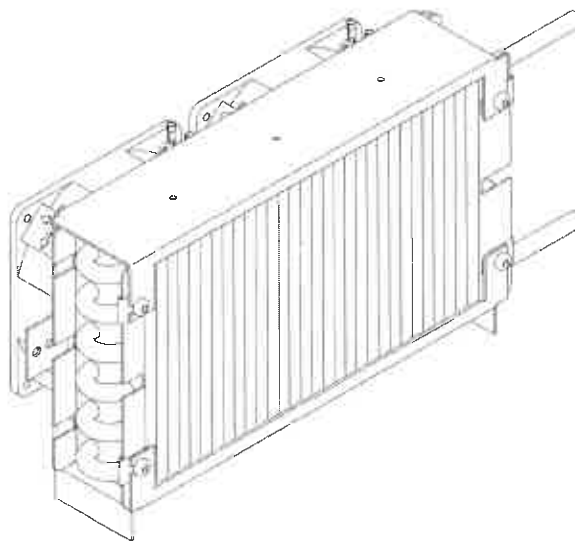
Note

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
location:
Effect:
Interval:

Hydraulic systems
Warning
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
location:
Effect:
Interval:

Hydraulic systems

Warning
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
location:
Effect:
Interval:

Hydraulic systems

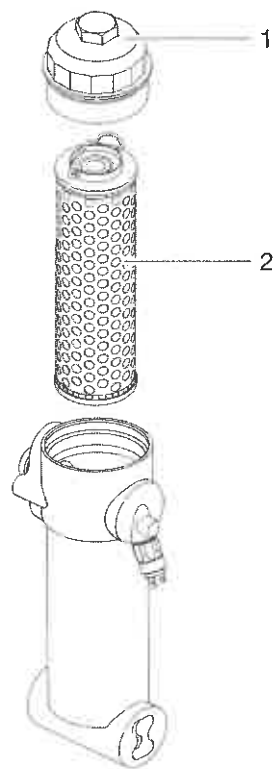
Alarm

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

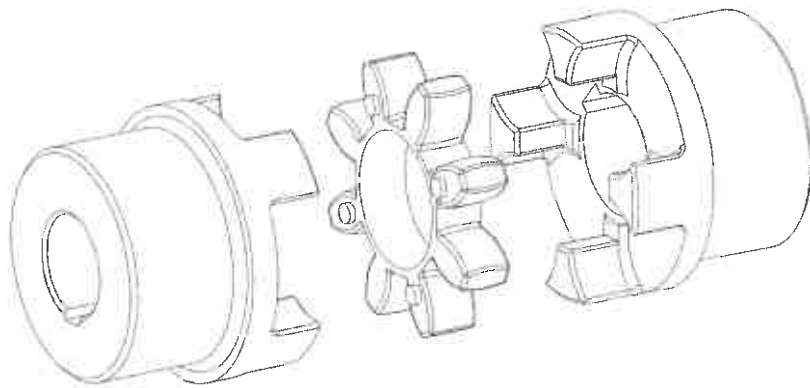
Maintenance
location:
Effect:
Interval:

Hydraulic systems
Alarm
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
location:
Effect:
Interval:

Hydraulic systems

Note

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
location:
Effect:
Interval:

Injection unit

Alarm
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

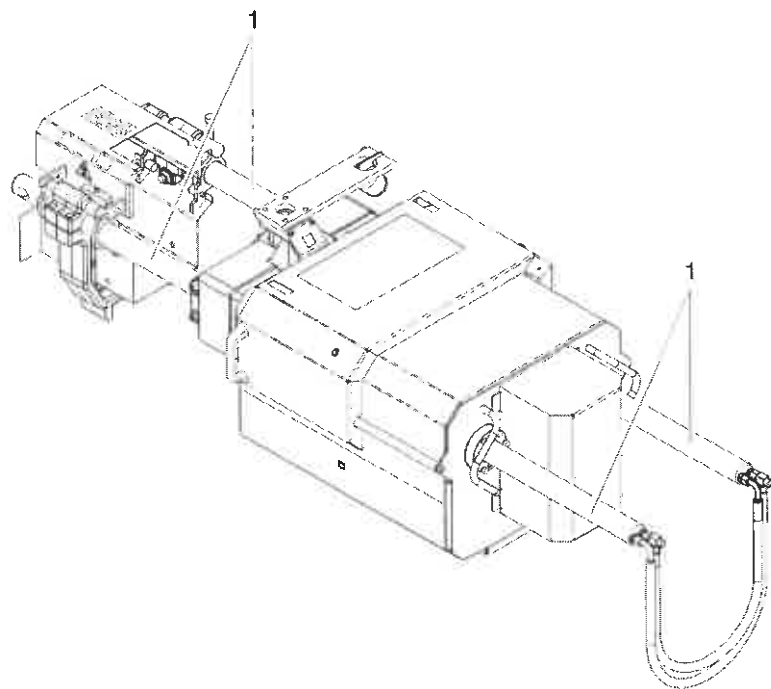
Maintenance
location:
Effect:
Interval:

Injection unit
Warning
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

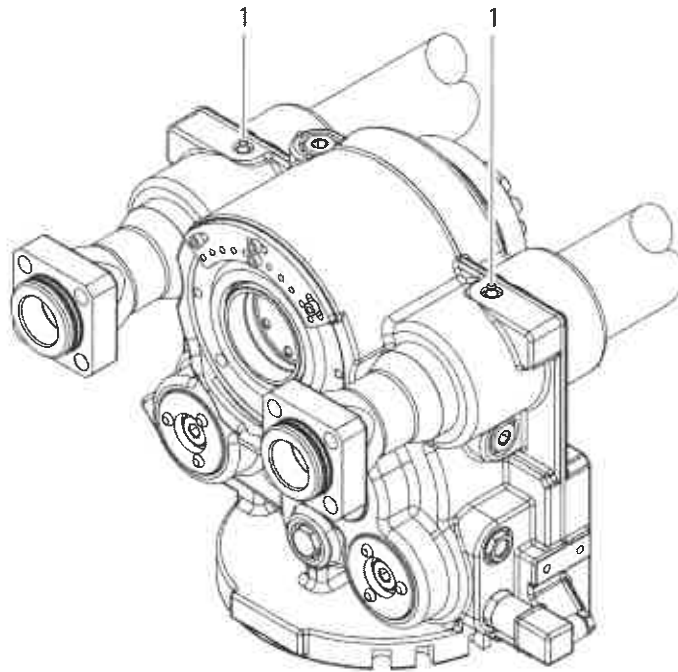
46=Injection unit: lubricate gear housing

Maintenance location:
Effect:
Interval:

Injection unit
Warning
5000 Operating hours in automatic

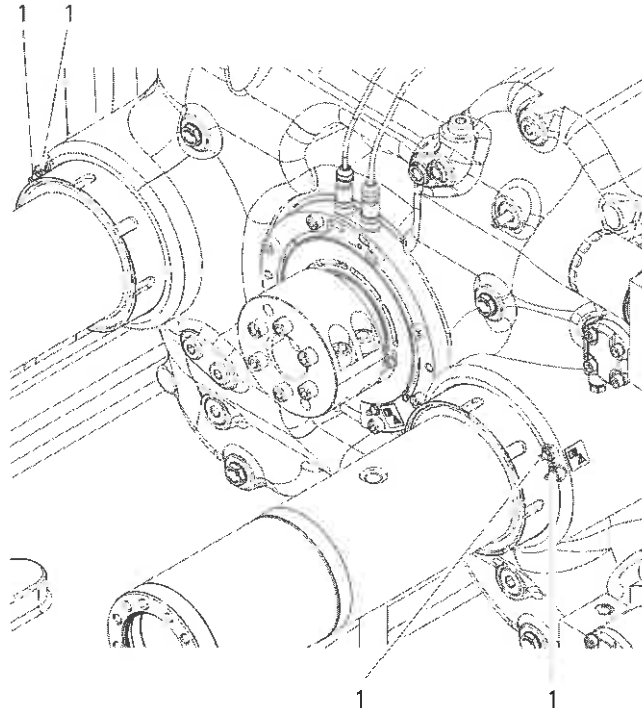
Work to be carried out:

- Lubricate gear housing of injection unit.



W4B10

1: Lubrication points



W4B34

1: Lubricating nipple

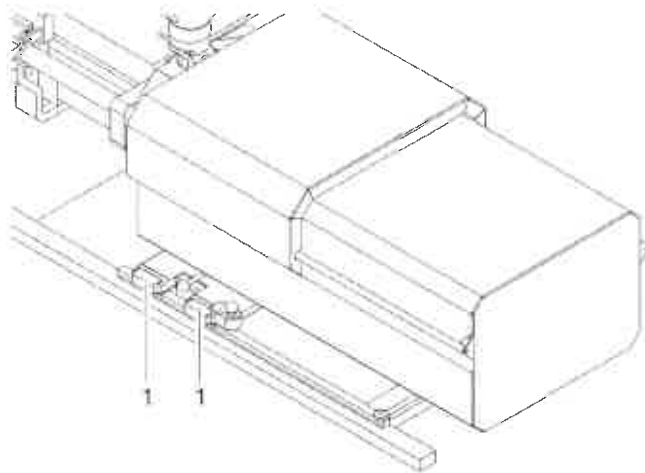
44=Injection unit: lubricate running surfaces, rollers, guides

Maintenance location:
Effect:
Interval:

Injection unit
Warning
1000 Operating hours in automatic

Work to be carried out:

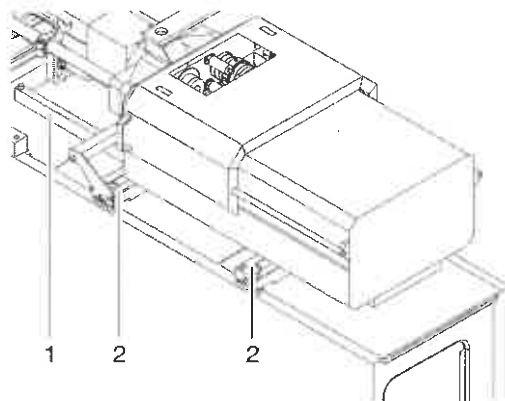
- Clean the guide rails.
- Lubricate the runner blocks of the injection units.



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 location:	Machine base
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.

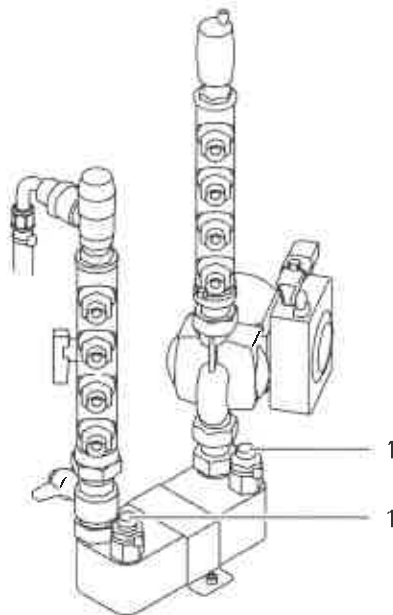
56=Machine base: change temperature-control medium

Maintenance location:
Effect:
Interval:

Machine base
Warning
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
location:
Effect:
Interval:

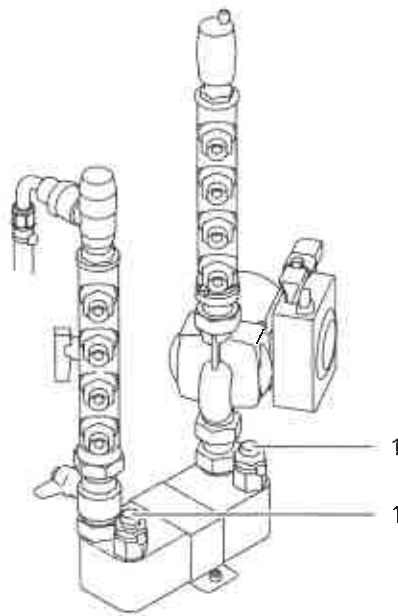
Machine base

Note

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
location:
Effect:
Interval:

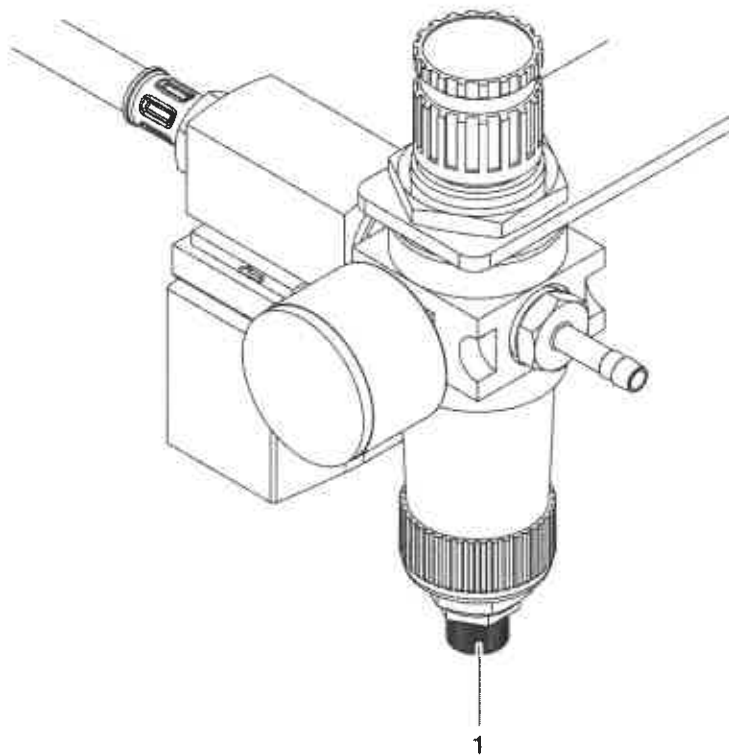
Machine base

Note

5000 Operating hours in automatic

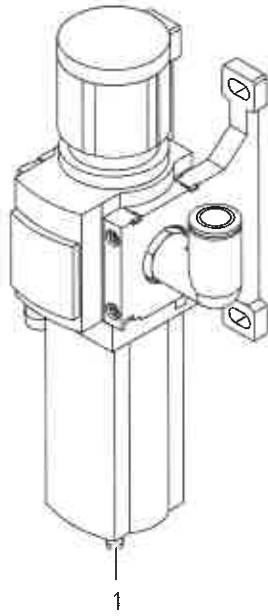
Work to be carried out:

- 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 location:
Effect:
Interval:

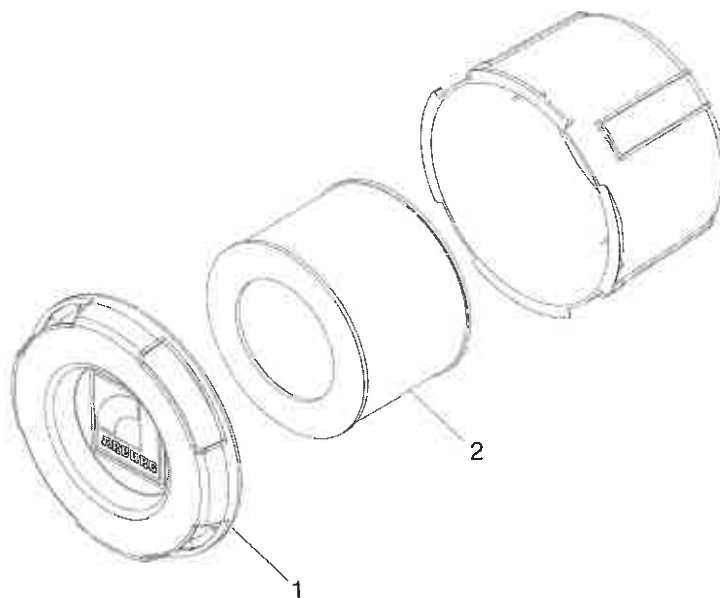
Machine base
Alarm
5000 Operating hours in automatic

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.



1: Cover
2: Filter insert

W1B8

40=Safety devices: clean and lubricate guides

Maintenance
location:
Effect:
Interval:

Safety devices

Warning

1000 Operating hours in automatic

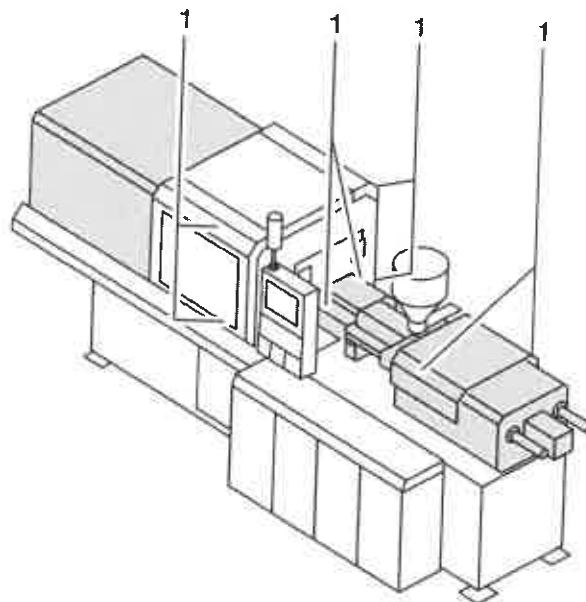
Work to be carried out:

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.



1: Guides

W3B4

41=Safety devices: inspect

Maintenance location:	Safety devices
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.