

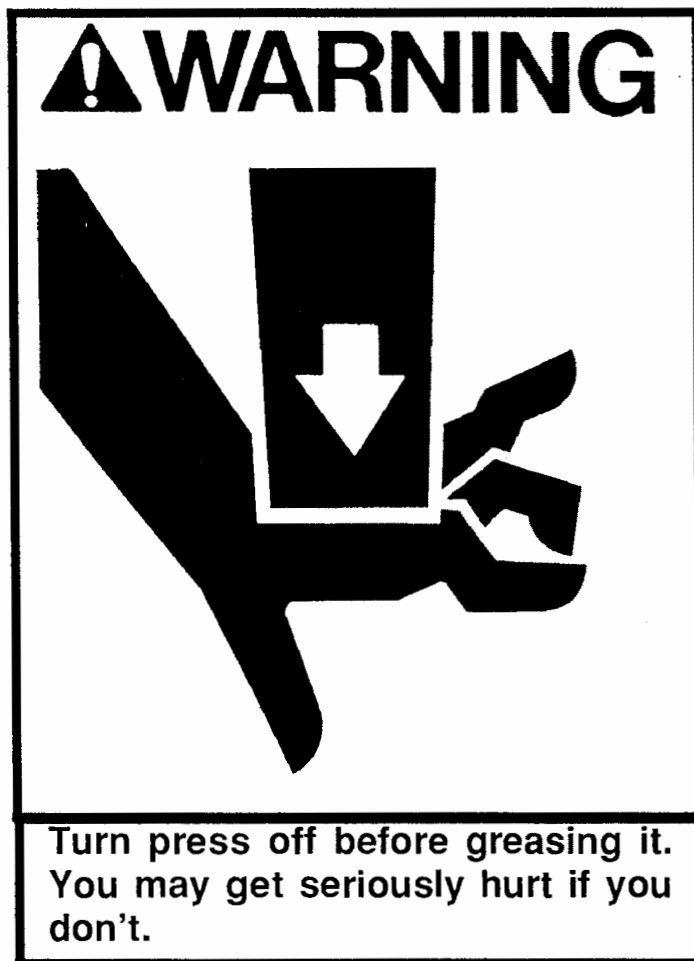
CHAPTER 7 PERIODIC MAINTENANCE

7.1 PERIODIC MAINTENANCE CHART

Use Table 7.1 A as a guide on when to service the press.

What To Do-	When To Do It-	Refer to Section:
Grease Press	Every 80 Hours Of Use (Every 70,000 Punches)	7.2
Lubricate Hold-Down Arms	Every 80 Hours Of Use (Every 70,000 Punches)	7.3
Empty Slug Bin	As Needed	7.4
Clean Sensing Head Lenses	As Needed	7.5
Clean Air Filter	Every 6 Months Or As Needed	7.6

Table 7.1 A



7.2 GREASING THE PRESS

The press should be greased once for every 80 hours of use or after every 70,000 Punches. Grease the press as follows:

Tools Needed:

- > 3/16" hex wrench (Allen wrench)
- > grease gun & good-quality grease
- > needle-nose pliers
- > medium flat-tip screwdriver

1. Press "OFF" button on control panel.
2. Unscrew ram guard screws with screwdriver and remove ram guard. See Figure 7.2 A.
3. Unscrew crank guard screws with hex wrench and flip hinged crank guard up. The crank guard screws are hidden behind the brackets that the ram guard screws screw into. See Figure 7.2 A.

7.2 GREASING THE PRESS

4. Pull up crankshaft cover button with needle-nose pliers and let crankshaft cover flip into up position. See Figure 7.2 A.

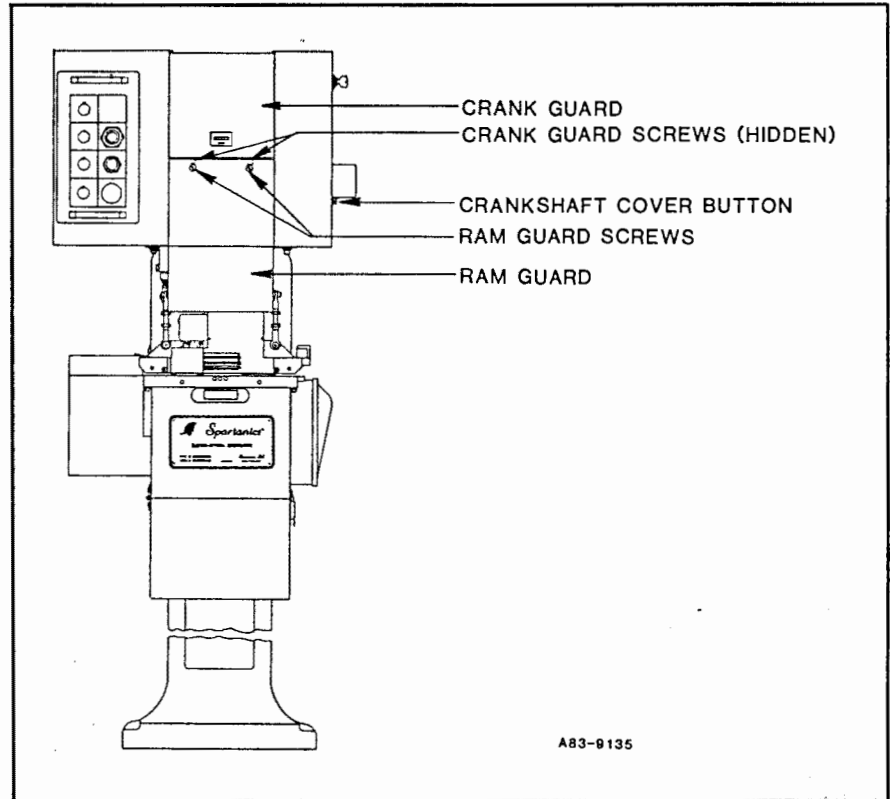


Figure 7.2 A

CAUTION
Do not over grease fittings #1 and #4 (see Figure 7.2 B). The brake and clutch will be damaged if these fittings are over greased.

5. Apply grease to the seven grease fittings shown in Figure 7.2 B. Wipe up any spilled or excess grease with rag.
6. Reassemble press.

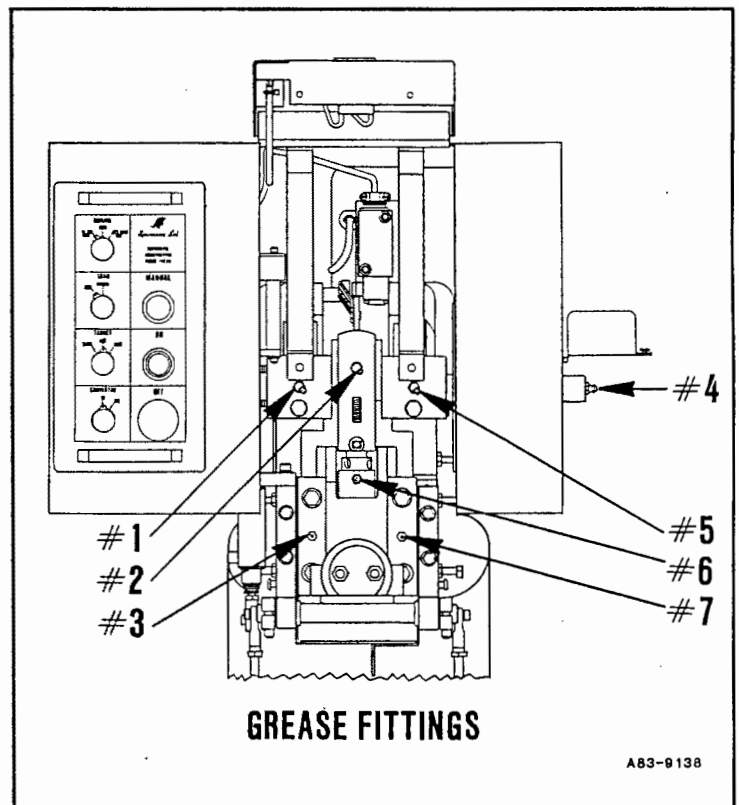


Figure 7.2 B

7.3 LUBRICATING HOLD-DOWN ARMS

Lubricate the hold-down arms as follows:

Tools Needed:

- pump-type oil can with light-machine oil
1. Apply a light coat of machine oil to the ends of the hold-down arms. See Figure 7.3 A.

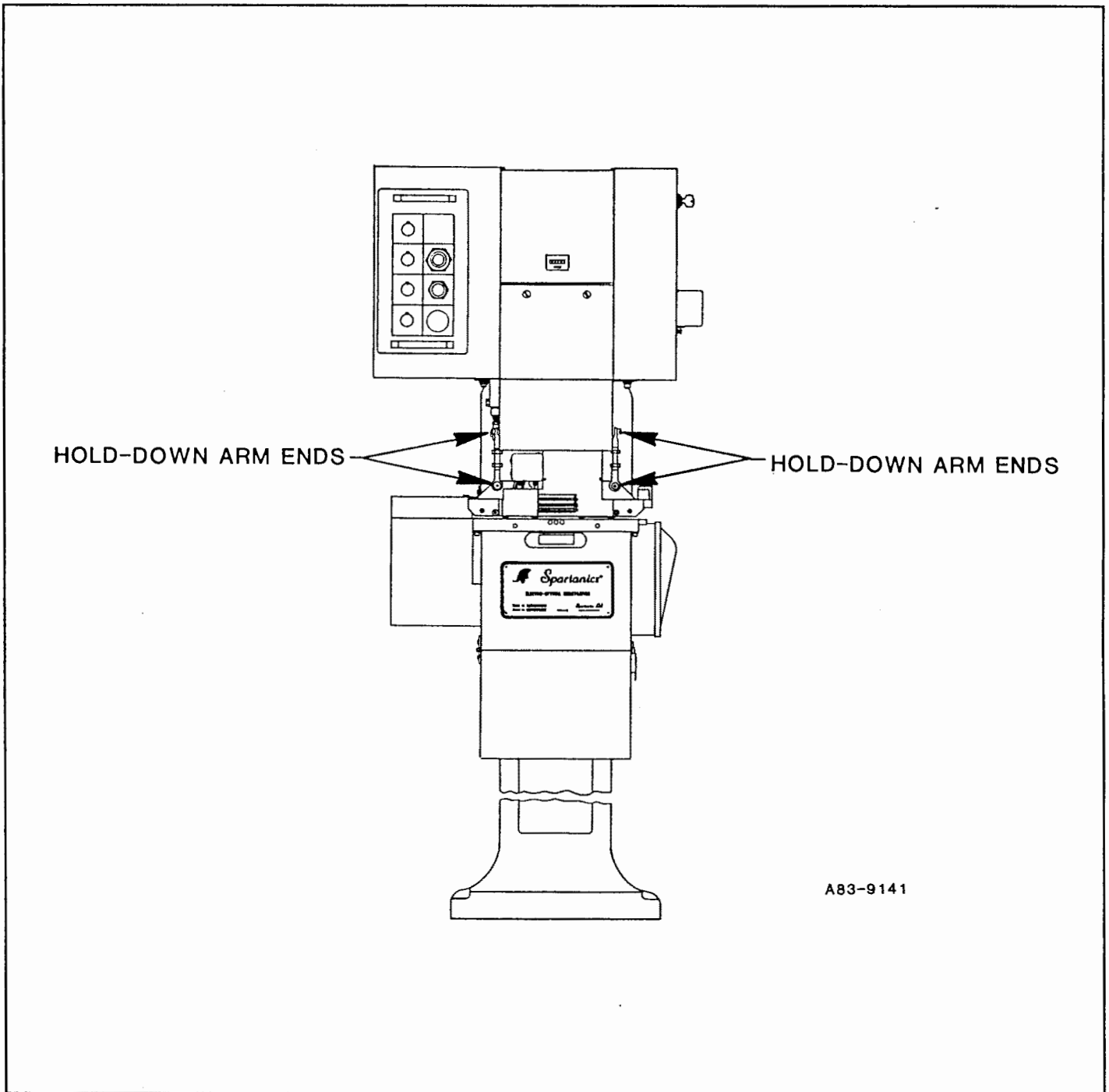


Figure 7.3 A

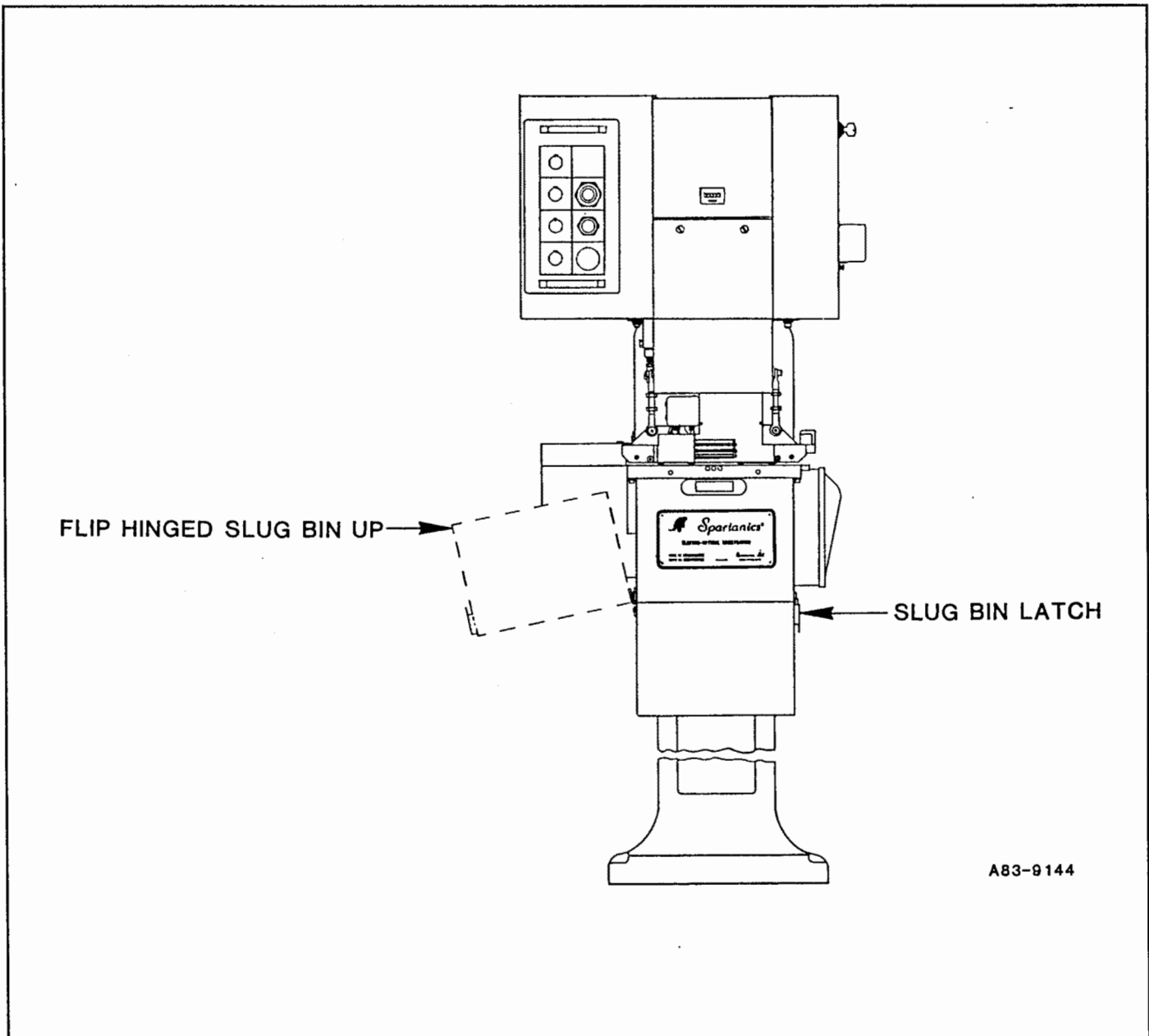
7.4 EMPTYING THE SLUG BIN

Empty the slug bin as follows:

Tools Needed:

- waste basket

1. Unhook the slug bin latch. See Figure 7.4 A.
2. Flip hinged slug bin up and empty slugs into waste basket. See Figure 7.4 A.
3. Hook slug bin latch back up.



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Figure 7.4 A

7.5 CLEANING THE SENSING HEADS' LENSES

Clean the sensing heads' lenses as follows:

Tools Needed:

- > cotton swab

Material Needed:

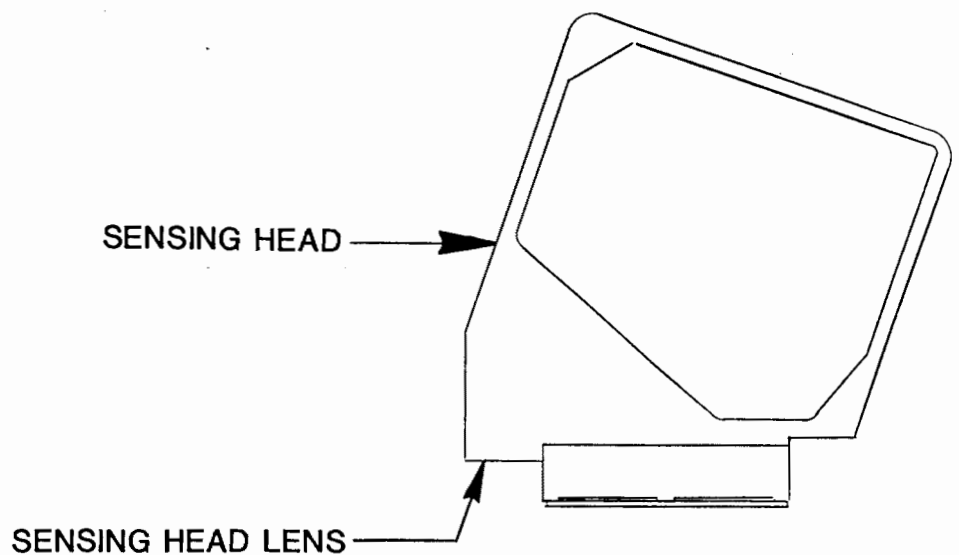
- > acetone or window cleaning solution

1. Remove the sensing heads from the press according to Section 8.9.3.
2. Apply window cleaner or acetone to swab and wipe lenses off. See Figure 7.5 A.
3. Reinstall heads according to Section 8.9.3.

CAUTION

Do not use any type of cleaner other than window cleaning solvent or acetone on the sensing heads' lenses. The sensing heads' lenses can be damaged by some types of cleaners.

Do not apply too much cleaner to sensing heads' lenses. Too much cleaner can damage the lenses.



NOTE: RIGHT-LEFT SENSING HEAD HAS TWO SIDE-BY-SIDE LENSES

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Figure 7.5 A