



PRESS MAINTENANCE - BEST PRACTICES

EVERY DAY

- 1. PRIOR TO STARTING PRESS, DO A COMPLETE WALK AROUND INSPECTION**
- 2. NO OBSTRUCTIONS IN DIE AREA**
- 3. AREA AROUND PRESS IS CLEAN**
- 4. GUARDS IN PLACE WITH PROPER FUNCTION**
- 5. ALL ELECTRICAL PANELS ARE CLOSED / LOCKED**
- 6. NO AIR LEAKS**
- 7. NO OIL LEAKS**
- 8. NO UNUSUAL ELECTRICAL NOISES**
- 9. AUTO GREASE TANK LEVEL IS CORRECT**
- 10. ACB OIL TANK IS FULL**
- 11. ACB PRESSURE SET FOR UPPER DIE WEIGHT**
- 12. TURN SPEED TO MINIMUM BEFORE STARTING MAIN MOTOR**
- 13. PRESS START UP AND CONTROL TEST**
 - INCH MODE**
 - SINGLE STROKE MODE**
 - CONTINUOUS MODE**
 - RAM STOP**
 - TOP STOP**
 - EMERGENCY STOP**
- 14. MAKE SURE SLIDE STOPS AT OR NEAR TDC IN INCH AND SINGLE STROKE MODE**




PRESS MAINTENANCE - BEST PRACTICES

EVERY WEEK

1. CHECK ALL 'EVERY DAY' LINE ITEMS
2. INSPECT AIR LINE LUBRICATOR NEAR DSV VALVE AND CLUTCH AND FILL AS NEEDED
3. DRAIN AIR TANKS OF ANY MOISTURE AND EMPTY COLLECTION TRAY
4. CHECK IN LINE AIR FILTER AND DRAIN AS NEEDED
5. RELEASE HOP / HYDRAULIC OVERLOAD AND REPRESSURIZE

EVERY MONTH

1. CHECK ALL 'EVERY DAY' LINE ITEMS
2. CHECK ALL 'EVERY WEEK' LINE ITEMS
3. RUN SLIDE ADJUST TO UPPER AND LOWER LIMITS AND BE SURE LIMIT SWITCHES PREVENT OVER TRAVEL AS STAMPED ON INDICATOR.
 **DO NOT RUN SLIDE ADJUST MOTOR WHEN DIES ARE COMPRESSED** AS THIS WILL DAMAGE THE SLIDE ADJUST SYSTEM AND TRIP THE THERMAL OVERLOAD FOR SLIDE ADJUST MOTOR.
4. CHECK ALL AIR HOSES TO CLUTCH & BRAKE AND COUNTER BALANCE CYLINDERS
5. CHECK UPPER LUBRICATION DISTRIBUTOR BLOCKS ARE CLEAN AND IN NO LEAK CONDITION
6. PERFORM A COMPLETE ELECTRICAL FUNCTION TEST AND CONFIRM ALL SYSTEMS FUNCTION



PRESS MAINTENANCE - BEST PRACTICES

EVERY 6 MONTHS

- 1. CHECK AND TIGHTEN INTERNAL SLIDE BOLTS**
- 2. CHECK AND TIGHTEN CON ROD CAP BOLTS**
- 3. ADD OIL TO CONNECTING ROD THREAD THRU WEEP HOLE IN FRONT OF CASTING (SAME OIL AS MAIN TANK)**
- 4. CLEAN OUT INTERIOR OF SLIDE**
- 5. CHECK SLIDE GIB & CRANK BUSHING DISTRIBUTOR BLOCK BEHIND SLIDE AND MAKE SURE IN NO LEAK CONDITION**

EVERY 12 MONTHS

- 1. CHECK PARALLELISM OF SLIDE TO BOLSTER AT 90-180-270 DEGREES**
- 2. CHECK SLIDE GIBS FOR CLEARANCE AND ANY SIGN OF WEAR**
- 3. FULL COUNTERBALANCE AIR PRESSURE TO BE COMPARED TO JIS 1ST CLASS INSPECTION DOCUMENT FROM WHEN PRESS WAS NEW**
- 4. CHECK FLYWHEEL BEST TENSION**
- 5. CONFIRM ENCODER MOUNT IS SECURE**
- 6. CONFIRM OVERRUN SENSOR AND MECHANICAL CAM IN ENCODER HOUSING IS SECURE**
- 7. CONFIRM ENCODER BELT, PULLIES AND KEYWAYS ARE SECURE.**
- 8. LUBRICATE FLYWHEEL BEARING (SEE LUBE INSTR)**
- 9. CLEAN PRESS INSIDE AND OUT**
- 10. CHECK ALL BOLTS AND CAP SCREWS AND MAKE SURE EVERYTHING IS SECURE**