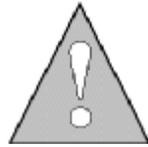


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# SECTION G4: PREVENTATIVE MAINTENANCE SCHEDULE



## **CAUTION!**

***Regular inspection of all guards, protective devices, point of operation safeguarding systems and mechanically loaded components is recommended. Component devices or guarding which show signs of wear, fatigue (cracks, distortion), or damage of any type should be replaced immediately.***

Injected Metal Assembly system maintenance includes specific routines that should be performed at regular intervals as shown on the following schedule. System downtime can be significantly reduced through routine preventive maintenance.

Whenever the tooling is removed, it should be carefully examined for signs of wear or damage, particularly the cavity and the nozzle seat.

### Daily

1. Skim the dross from the top of the melt pot at least once per shift.
2. Check for any sign of alloy escaping between the nozzle seat and the nozzle tip. Correct the nozzle alignment and locking pressure adjustment, if necessary.
3. Check the condition of the nozzle tip. Replace the nozzle if there is any sign of damage, wear or erosion.
4. Check the operation of the Cable-In-Place (Part-In-Place) switch and the Cable Processor Module Closed switch.

### Weekly

1. Lubricate the pivot points on the machine's moving mechanism as well as all moving slides on the Cable Processor Module and tool with a good quality mineral oil.
2. Check the timer and pressure settings and adjust, if necessary.

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3. Check the fluid level in the pneumatic lubricator and refill as required with the proper lubricant.
  4. Check the speed of all pneumatic cylinders. Adjust the flow controls, if necessary, to provide for rapid motion with no excessive slamming at the end of the stroke.
  5. Observe the operation of the injection unit plunger. If there is evidence of a longer than normal plunger stroke, or if there is evidence of leakage between the plunger and sleeve, replace the injection unit gooseneck and plunger with a new or reconditioned set.
  6. Check the condition of all moving parts on the system. Replace or repair as required.
  7. Check all pneumatic lines for signs of wear or abrasion. Replace if necessary.
  8. Check the pneumatic valve exhaust mufflers to ensure that they are free of obstructions. Remove any obstructions that are detected to allow free flow of exhaust air.
  9. Clean the pneumatic filter bowl and the accumulator tanks.

## Monthly

1. Check the accuracy of the temperature controller by measuring the pot temperature with a separate device.
2. Remove a small sample of alloy from the melt pot and have it tested to ensure that it meets specification.
3. Check the operation of all machine functions in set up mode.