

DIVINE TOOLINGS

Daily Maintenance Checklist for machine

FORM NO:

Machine ID:

Month :

Checking Parameters	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	
1. Clean the machine thoroughly																																
2. Wipe the toggles with clean cloth till it is free of the accumulated grease & dust.																																
3. Check the nozzle area for melt accumulation & clean it (if necessary).																																
4. Check level of oil in tank.																																
5. Check the piping of grease lubricating system for loose connections.																																
6. Check whether the feed throat temperature is maintained during running. If, found rising even with the water supply 'ON', check & clean the cooling ring.																																
SIGN AFTER VARIFICATION																																

APPROVED BY _____

PREPARED BY: _____

DIVINE TOOLINGS

Weekly Maintenance Checklist for machine

FORM NO:

Machine ID:

Month :

Checking Parameters

1. Check the grease pump for sufficient amount of grease

2. Check safety devices

3. Clean filters on control cabinet front door

4. Clean venting filter on oil tank

5. Check oil level in bearing housing of screw drives.

6. Check idle pump pressure - it should be around 22 bar for machines with variable displacement pumps

7. Clean the filter mesh inside the grease filling block

8. Check & clean the oil suction filter.

9. Check for tightness of pipe & hose connections

10. Check for tightness of piston rods of hydraulic cylinders

11. Check for tightness of Hydromotors

12. Check for tightness of valves & valve blocks

13. Check for tightness of water battery

14. Check for tightness of water connection to the oil cooler

Sign After Varification

APPROVED BY

PERPARED BY:

DIVINE TOOLINGS

Half Yearly Maintenance Checklist for machine

<u>Machine ID:</u>	FORM NO:	
<i>Checking Parameters</i>	<i>Jan</i>	<i>July</i>
1. Check leveling of machine		
2. Check nozzle centering		
3. Check guide bars & strips (below the moving platen) for pressure marks.		
4. Fill grease through the nipples provided for the roller bearing support of the moving platen		
5. Check the platen surface & apply a thin film of oil.		
6. Check for the tightness of connectors on Ibed, PLC, wiring terminals on the control cabinet, Linear Potentiometer plugs & solenoid plugs.		
7. Check the condition of hydraulic oil.		
8. Check oil cooler & clean.		
9. Ensure the thread engagement of atleast 2 to 2.5 times the diameter of the bolts used for clamping the mould		
10. Replace the oil filter after every eight months or if damaged		
Sign After Verification		
APPROVED BY	PERPARED BY:	