


Autoflow Maintenance - Gripper

Weekly and Monthly Maintenance Procedures for Autoflow Gripper

 Difficulty Easy

 Duration 30 minute(s)

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Comments

Introduction

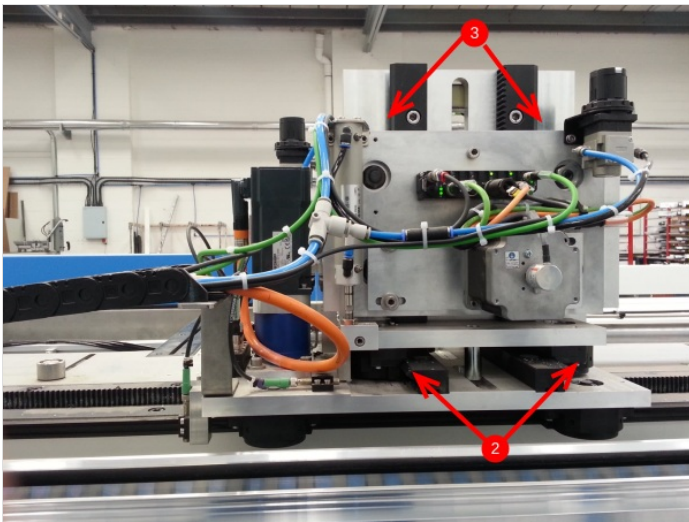
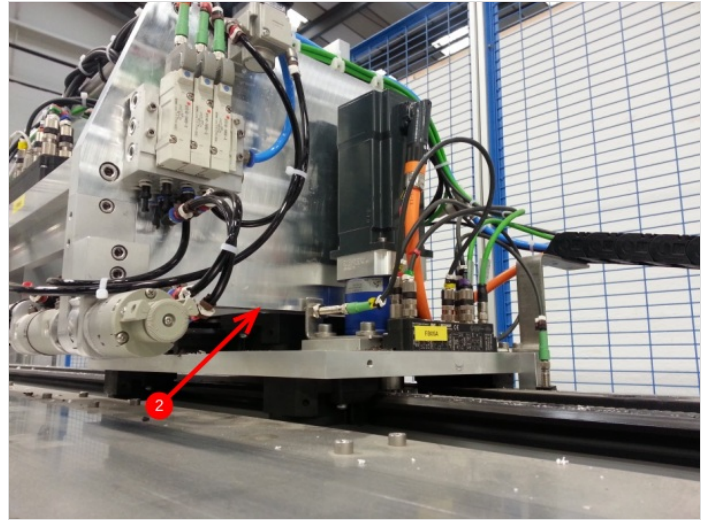
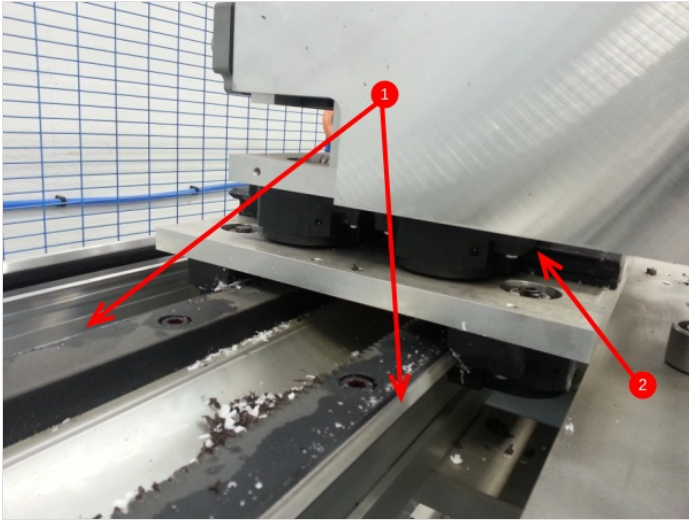
The following preventative maintenance tasks should be carried out regularly on the machine. The frequency depends on the machine use, but as a guide:

2-3 Shifts	Weekly
40 Hrs/Week	Bi-Weekly
20 Hrs/Week	Monthly

Step 1 - Linear Slide Rails

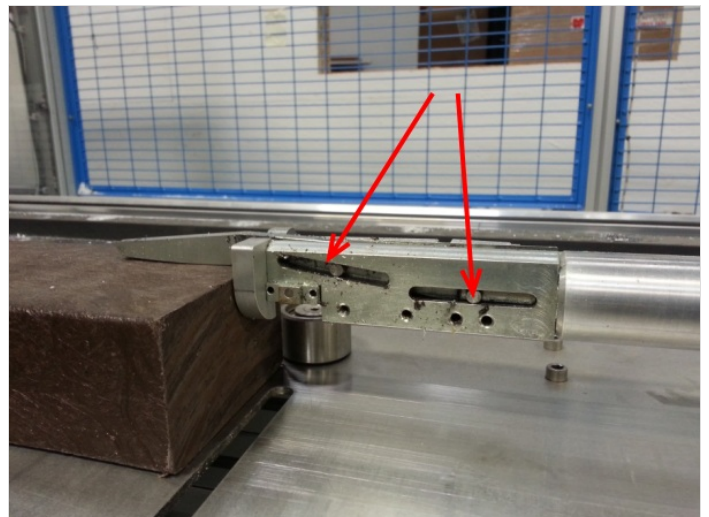
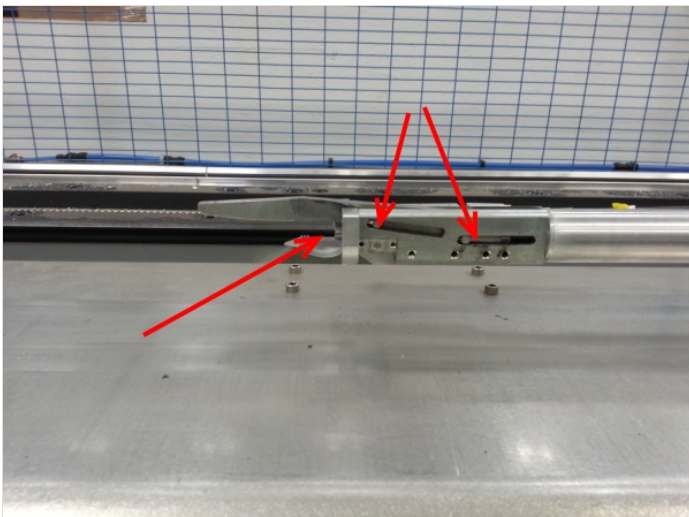
Wipe away any excess oil, dirt or swarf. Apply oil lubricant and wipe of excess

1. Main X axis slideways
2. GY Gripper Y axis Slideway
3. GZ Gripper Z axis slideway



Step 2 - Gripper finger

- clean away any swarf or excess oil from the mechanism; inspect gripper finger teeth for damage, wear or play
- visually check gripper finger teeth and shear pin for damage / wear
- clean away any excess swarf or oil, lightly oil pins for the movement mechanism with supplied oil
- Activate the gripper from the Service screen, ensure the gripper closes securely to 0.5mm-1mm



Step 3 - Pinion Wheel and Rack

- Clean area of swarf
- visually check rack and pinion wheel for any damage, chips or cracks, remove any debris that may have become caught up in the teeth



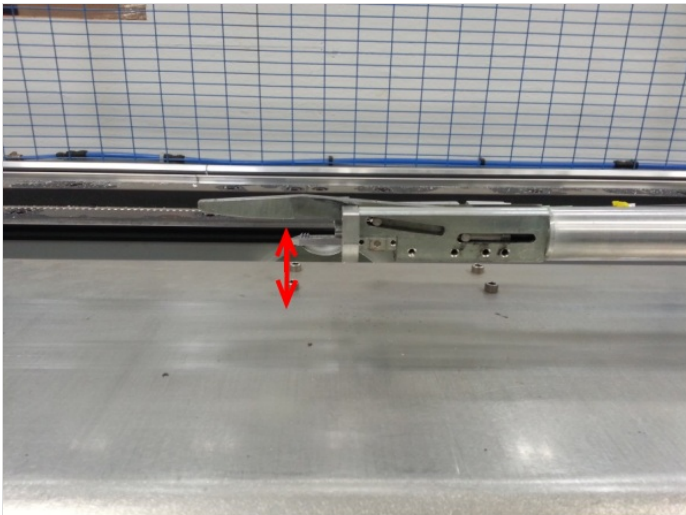
Step 4 - Check Gripper Datum Position

The gripper GY and GZ position can become misaligned if there has been an impact with a stray offcut.

1. Datum the machine
2. Check the height of the centreline of the gripper teeth is within a millimetre of the GZ "Move" position in the parameter settings
3. Check the same on GY

If these positions are very different, the gripper may not align with the openings on the profile. The gripper can be gently but firmly manhandled back into its correct position

! ...It is not good practice to change the software settings to suit the gripper position, as this will affect the minimum and maximum axis positions, leading to axis overrun.



Machine Settings															
Datum Tests	Accuracy	Parameters	Axes	Tooling	IO Map	Clamps	X-Holds	Alarms	Profile	Colours	Notching	Fine Adjustment	Rack Offset		
GA	27807.98	2000	2000	5000	7057.6	2310	200	20	10	0	0	0	-1070	7239	10000
GY	45.96	100	100	200	8	35	20	5	20	0	0	0	-32	73	10000
GZ	45.96	100	100	100	61.5	45	10	5	20	0	0	0	31	125	10000
Y	104857.6	250	350	350	4.7	5	50	5	2	0	0	0	-95	127	10000
Z	104857.6	500	700	700	-30.6	0	50	5	25	0	0	0	-126	110	10000
R	149062.8	250	1000	1000	-0.1	0	20	5	10	0	0	0	-1	361	15000
SY	409.6	30	100	100	42.6	30	10	10	75	0	0	0	14	64	40000
SZ	104857.6	300	800	800	-12.5	-28	10	5	10	0	0	0	-31	150	10000
SR	296125.4	250	250	250	50.7	90	6	5	5	0	0	0	-100	271	10000

