



# Autoflow Mk1-Mk3 Daily Maintenance

Autoflow Mk1 - 3 Daily Maintenance Procedures to be carried out by Operators

 Difficulty Easy

 Duration 15 minute(s)

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Comments


## Introduction


The following areas should be attended to daily  
This routine should take no more than 15 minutes

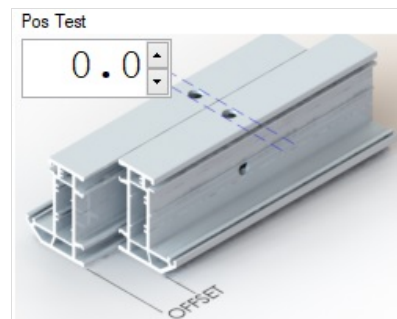
## Step 1 - Daily Tests

To check the machine is ready for production, a couple of simple tests can be run

1. Datum Test
2. Pos Test

 ...Do not attempt to make any adjustments to the machine on the basis of one test. If there is an error, run the test again twice more. !! Adjustments are only effective if the error is repeatable !!

 ...The machine tolerance is +/-0.5mm, so there is no need to adjust if an inaccuracy is less than this tolerance (1mm back to back)



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## Step 2 - Infeed Table

- Thorough blow down of the infeed module
  - Blow down of the gripper carriage
  - Wipe the offcut measurement sensors
  - Remove swarf from grip finger teeth
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## Step 3 - Machining Centre Module

- Thorough blow down of the Machining Centre Module
  - Visually check tooling for damage or swarf buildup
  - Check the V notch blades are not buckled
  - Check M/C rollers for tape build up
  - Empty M/C waste boxes if required
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## Step 4 - Saw Module Cabinet

- Thorough blow down of the saw module
  - Remove any loose waste pieces in the saw
  - Check the the rear rollers and saw beds for profile tape buildup
  - Check saw blade pulley belts (tension/replaced as required)
  - Empty saw waste box if required
  - Empty extraction waste pieces from cyclone / hopper box
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## Step 5 - Saw Outfeed

- Thorough blow down of the saw outfeed
  - Thorough shake of the extraction top cloth bags
  - Change lower extraction bags as required
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