

Autoflow Maintenance - Sawing Centre

Procedures for Daily, Weekly and Monthly Maintenance on Autoflow Sawing Centre Module

 Difficulty **Medium**

 Duration **2 hour(s)**

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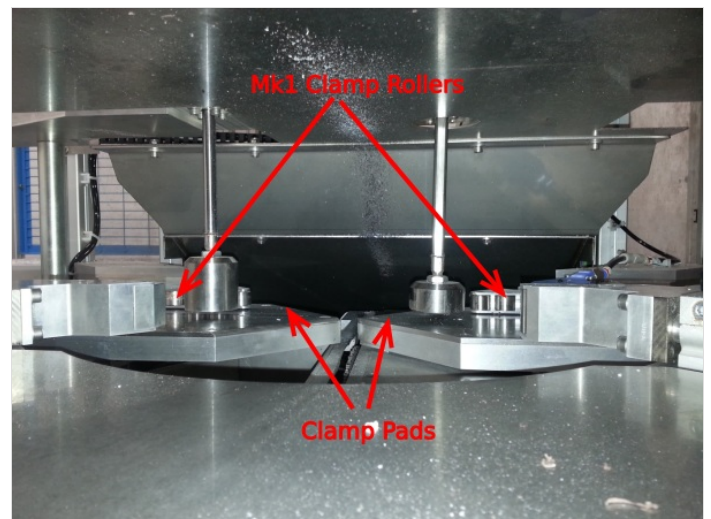
Comments

Introduction

The Machine has many moving parts, all which need regular maintenance. Below outlines what items need particular attention

Step 1 - Horizontal and Vertical clamps

- Remove any debris from clamp pads and rollers
- Visually check the rollers and clamp pads for damage or excessive wear, oil rollers with supplied oil, visually check cylinder rods for damage

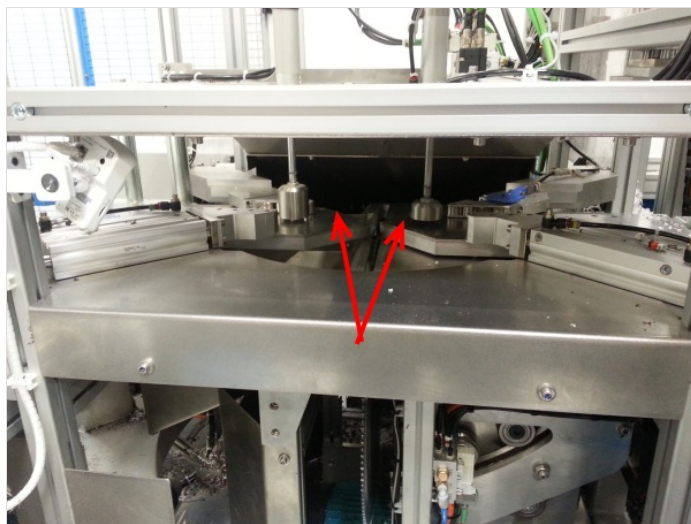


Step 2 - Check Rear Fence Alignment

Using the supplied straight-edge, check the backfence alignment through machine. Misalignment is the normal cause of inaccuracy issues

Step 3 - Stainless Steel Bed

Use a suitable foam cleaner for cleaning off the glue and tape residue left by the profile rolling along the beds



Step 4 - Saw Blade Area

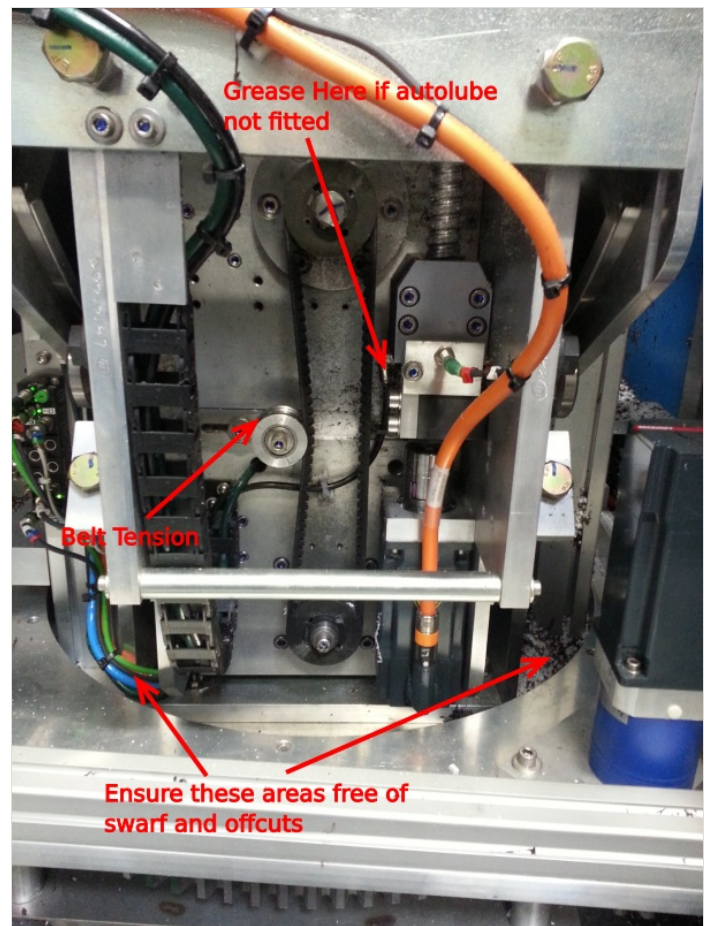
Check saw blade teeth for wear or damage, check saw blade for warping

⚠ ...When changing blade – ensure that the correct type and size saw blade is used, using the wrong type / size of blade can cause accuracy issues – Please refer to your Stuga manual for the correct specification of blade or contact Stuga Service for further assistance



Step 5 - SZ Axis Saw Up / Down Drive

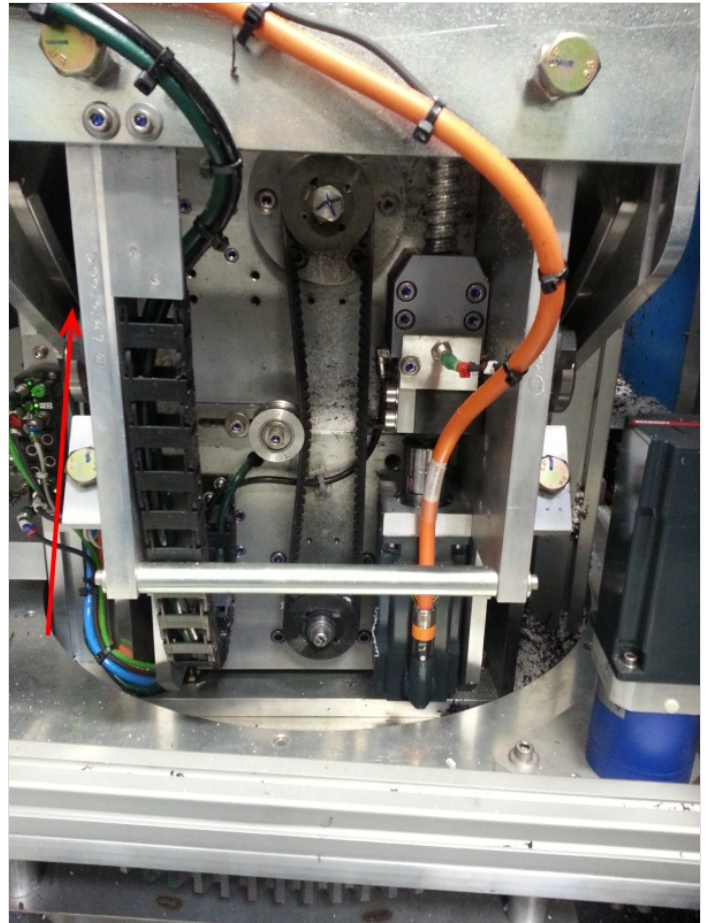
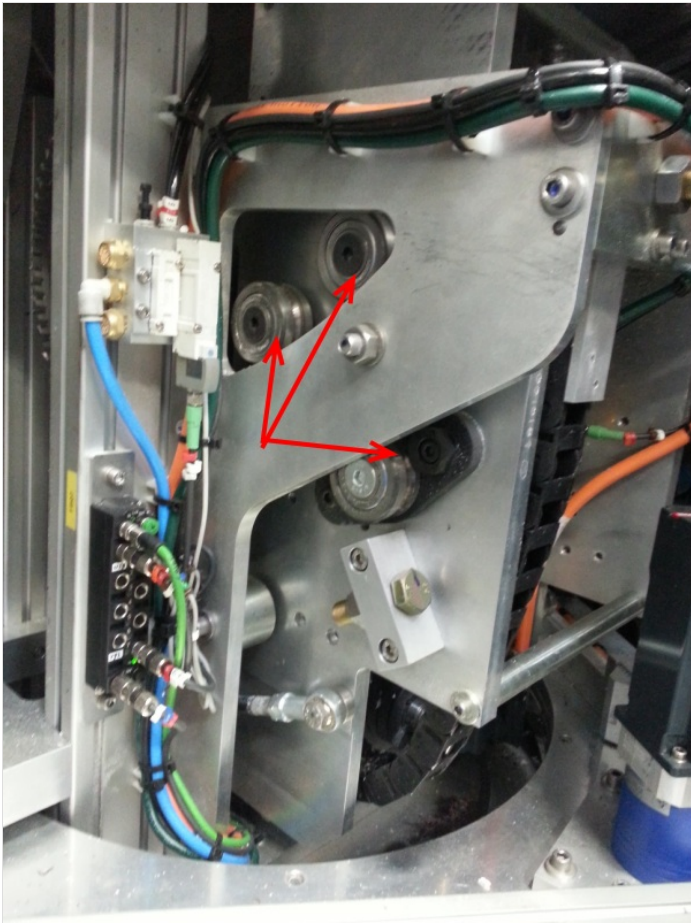
- Check that the drive belt is free from wear or any cuts / nicks along the circumference of the belt
- Ensure that the drive belt has sufficient tension via the tension roller
- Check the leadscrew for any wear or damage
- Grease with 1 Pump if lubricator not fitted



Step 6 - Saw Tilt Rollers

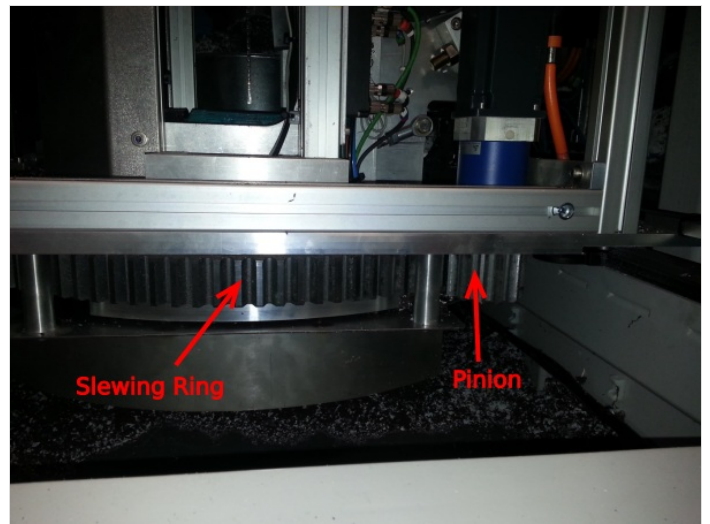
i ...Only used if compound VS cut machine option

- Check rollers and runner surface for damage or wear
- Lightly oil rollers and runner surface



Step 7 - SR Axis Slewing Ring and Pinion

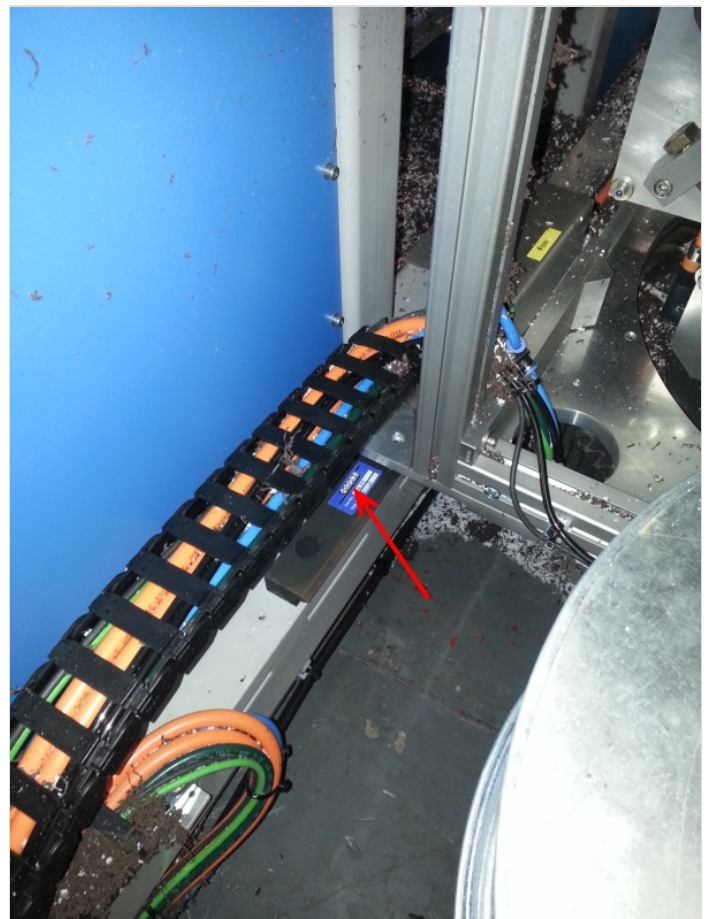
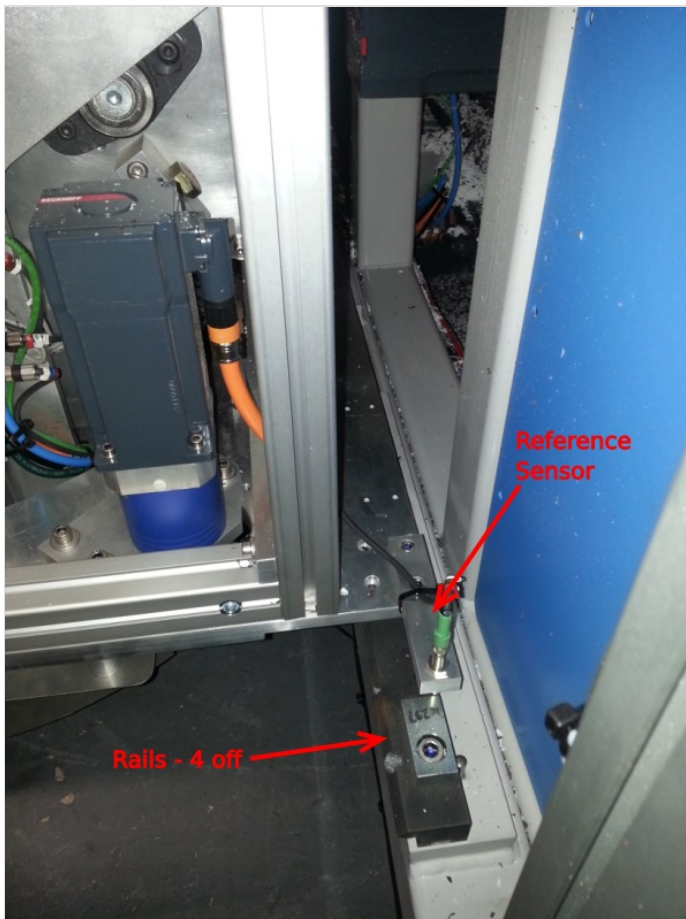
- Visually check pinion wheel and slewing ring for any damage, chips or cracks
- Remove any debris that may have become caught up in the teeth
- Turn assembly through full range of movement to check for any tight spots
- Grease ring on grease points. 1 Pump each



Step 8 - SY Axis Linear Rails


- Lightly oil rail surface with supplied oil
- Ensure reference sensor is not damaged

i ...There are 4 rails in total, 2 at front and 2 at rear



Step 9 - Extraction Separator

Ensure that the Hose and Chute are not blocked by large offcuts

 ...Side open the Extraction separator base to empty offcuts

Check Hose for damage / cuts – replace if necessary

