

SIMMS

MACHINERY, INC.

"Experts in Door Casing Assembly"

Preventive Maintenance Schedule for VN4 MP-MC/U500-U600 Machines

DAILY

- ✓ Blow dust off and under the machine.
- ✓ Listen for air leaks and correct as needed.

WEEKLY

- ✓ Inspect lubricator for proper adjustment and fluid level.
- ✓ Inspect and clean drive area-inspect for worn parts.
- ✓ Clean the 2 carriage rods under the machine(must be dry as not to attract dirt and dust)
- ✓ Inspect and adjust Pressure Regulators (110 psi incoming on side of machine, 50-80 psi top pressure regulator, and 30 psi (MP only) for feed pressure regulator under the machine.)
- ✓ Inspect electric cables and cord to keypad for nicks and wipe clean.

Monthly (200 working hours)

- ✓ Remove Vnails from machine. (use the magnetic pick up tool)
- ✓ On the side of the machine, locate the block where the air is connected. On top of the block you will find a silver disk. Remove this disk with a hex wrench. Put 10 to 15 drops of the light-weight ATC (Air Tool Cleaner) into the hole where the disk was removed then replace disk.
- ✓ On the top of the air block, you will find a plastic nipple with a set screw located inside. Loosen this set screw a $\frac{1}{4}$ of a turn. Place a casing profile into the machine (a left and a right side of two heads will work for this) cycle or "dry fire" the machine 10 to 20 times. This will work the lubricant through the machine, cleaning the pneumatic parts, as well as lubricating them. Re-tighten the set screw inside the nipple.
- ✓ Drain air tanks (2) in lower floor stand and moisture trap on the side of the machine. With the air still connected, open the valves at the base of the machine. Allow the air to flow through the valves for about a minute to purge any water from the tanks.

Every 6 Months

- ✓ Remove lower 2 panels of the floor stand, remove Vnails and clean out area with low pressure air with electric turned off of machine.
- ✓ Clean and grease driver, and hold down cylinders. (6 months-1 year)

For Service, Parts or Questions call 1-800-527-4667