



Preventive Maintenance (PM) Schedule for B-1500/50

The PM procedure is to maintain a fully functional operational machine. These steps should be done on quarterly (every 3 months) year schedule and should be done by a fully trained PM technician or an Allteq Field Service Engineer. This to prevent unnecessary adjustment or inadequate PM problems. If any parts need to be removed or/and cleaned, refer to your Maintenance & Diagnostics section of your machine manual. This will insure that the steps needed to remove and installed parts are properly taking care during the PM procedure and all necessary machine adjustment is done properly. If any problems arise, please contact your nearest Allteq representative to assist you in any problems do to improper PM procedure.

1. Elevator and XYZ leadscrews should be cleaned with alcohol or equivalent solvent using a clean lint free cloth. Next, lubricate with light machine oil. Remove any covers/plates needed to do this step. **NOTE: "DO NOT USE ANY TYPES OF GREASES ON THE LEADSCREWS THIS WILL CAUSE YOU TO POSSIBLE HAVE INDEXING PROBLEMS"**
2. Wipe off Elevator shafts with lint free cloth, no lubricant needed.
3. Remove/clean any debris that might be inside the machine such as excessive die coating materials, cotton tips, finger cots, pens, pencils, etc. The PCB Sensor 30001016-430 mounted to the Conveyor may need to be removed and check for die coating material that may have fallen onto it.
4. Check for any obstruction in or on the Wheel Guides grooves of the XYZ stage and the Z-Head. For example, die coating material. This can cause stiffness during the die coating process.
5. The Bias Solenoid Cylinder Boat Biasing may need to be clean. Die Coating material may have fallen on it and may cause the shaft to incorrectly operate. Use alcohol to clean the shaft.
6. Inspect and clean the Vacuum Chuck Assembly if needed. Die Coating materials may have fallen/dripped inside where the Vacuum Chuck Block is located.
7. Remove any debris on the Front and Rear Rail slots, such as die coating materials. This can cause boat indexing problem, boat jamming and improper belt/o-ring wear. **NOTE: If the Conveyor or Rail Assembly needs to be remove and cleaned refer to your manual or a qualified Allteq Service Engineer to ensure proper installation and/or setups, alignments and adjustments. If this is not done more problems could arise do to lack of knowledge of Special Adjustments need to maintain proper machine operation.**
8. Clean/vacuum exhaust fans located inside for machine. After a period of time these collect dust and if not properly maintained can cause fans to function improperly.
9. Clean outside of machine with only soaps and water type of cleaning agents. Inspect outside unit for any broken/damaged items that may have occurred over a period of time. Repair as needed.
10. Check/clean air filter on back of machine.

This concludes the PM Schedule Operation for the L-1500/50 units. Refer to you machine manual for any other information needed.