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***STARTURN PC***

***MAINTENANCE***



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## MAINTENANCE SCHEDULE

ROUTINE INSPECTION AND MAINTENANCE SHOULD BE CARRIED OUT TO THE FOLLOWING SCHEDULE:-

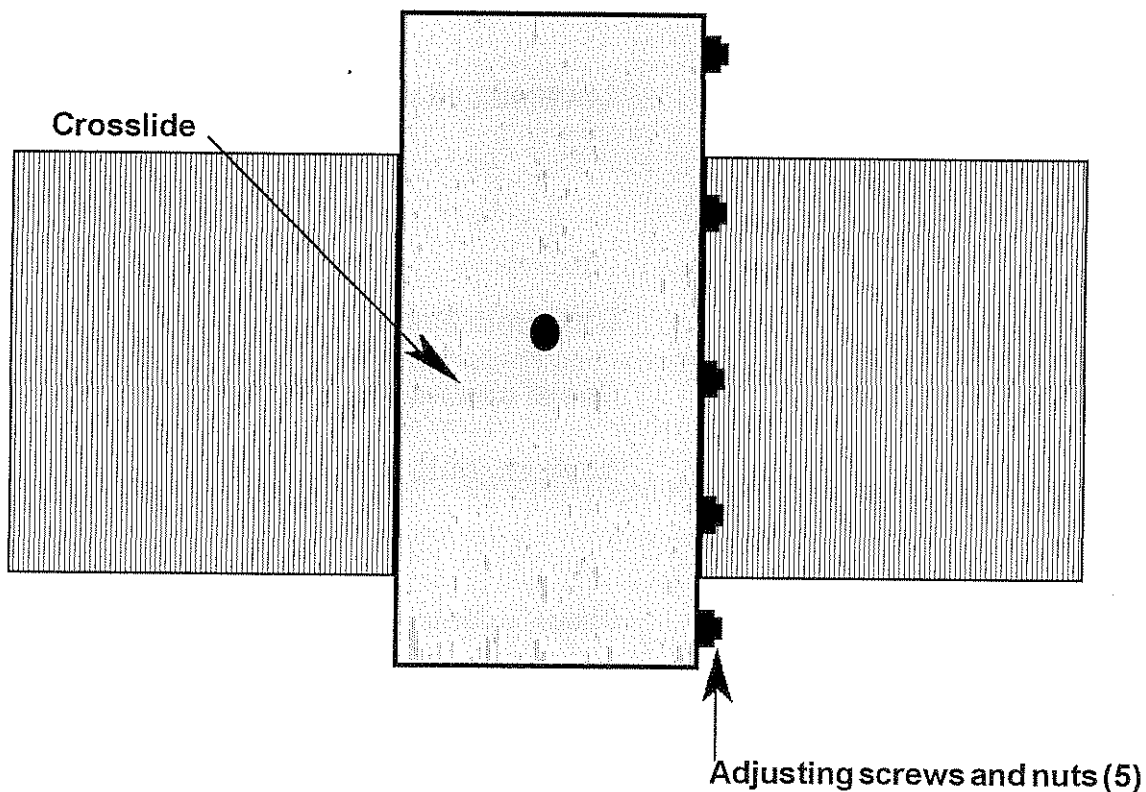
<u>PERIOD</u>	<u>MAINTENANCE REQUIRED</u>
Daily	Lubricate oil nipples
Weekly	Clean machine thoroughly Check screws and nuts for tightness lubricate both ballscrews
Bi-Annually	Check and clean machine thoroughly Check screws and nuts for tightness Lubricate both ballscrews
Annually	Check machine alignments and accuracy

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## SLIDE ADJUSTMENT

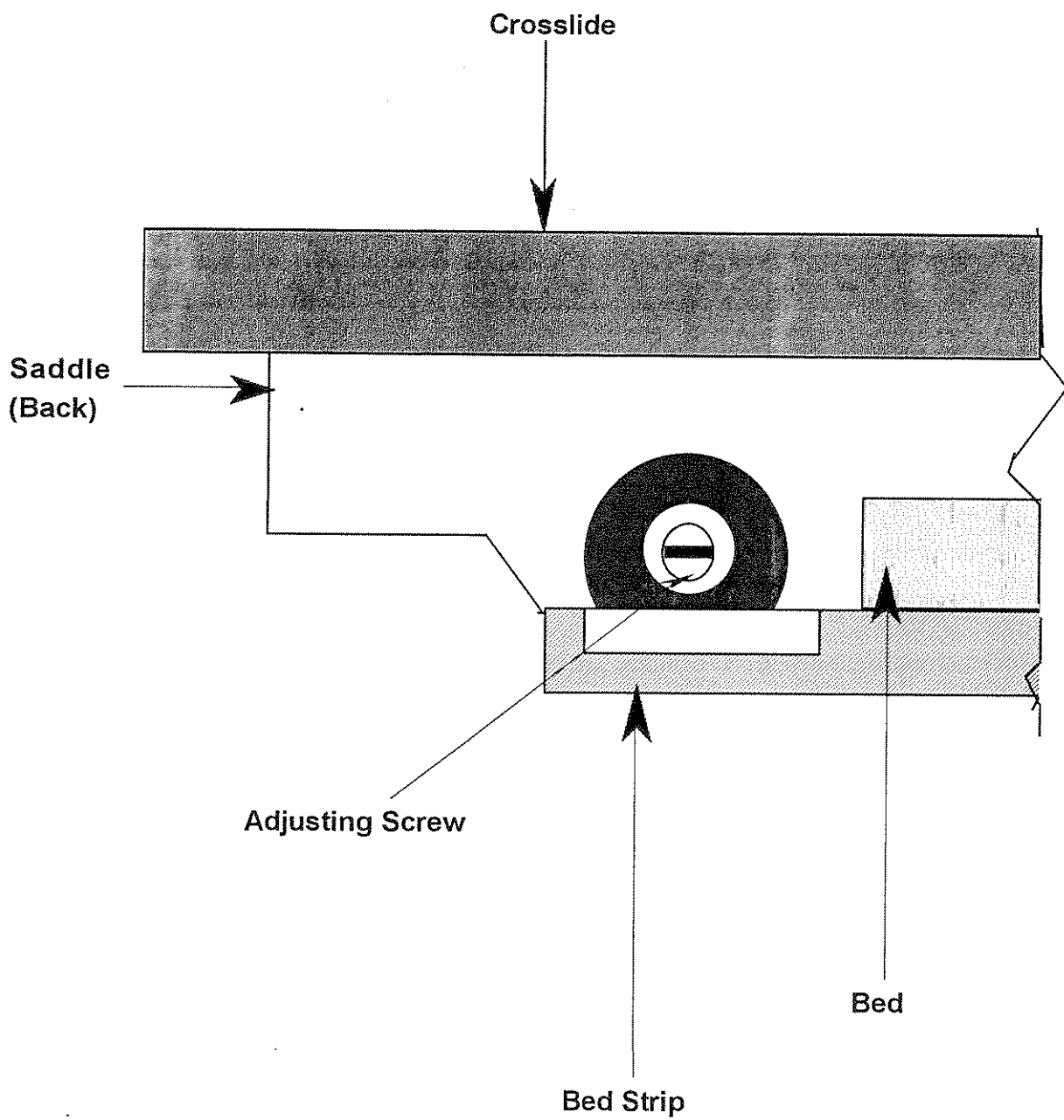
### CROSSLIDE STRIP ADJUSTMENT

To take up wear on the top slide gib strip, loosen the five locknuts on the RH side of the slide and adjust all five screws evenly to give a slight drag on the slide movement, then retighten the locknuts whilst holding the adjusting screw with the allen key.



### SADDLE STRIP ADJUSTMENT

To take up the wear on the saddle gib strip, loosen the lockscrew on the LH Side (rear) of the slide and loosen the screw say one half turn. Tighten the screw on the RH Side of the slide say on half turn, continue to do this until any slack has been eliminated and a slight drag is experienced when the saddle is traversing.



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## LUBRICATION

All oiling and greasing points have been fitted prior to despatch. Before running the machine initially, oil the ballscrews and the slides.

Carry out routine maintenance and lubrication according to schedule.

The recommended lubricants are as follows:-

	SHELL	CASTROL
OIL	VITREA 60	PERFECTO NN
GREASE	ALVANIA No.3	SPHEEROL AP3

### CROSSLIDE BALL SCREW LUBRICATION

Remove the plastic grommet from the centre of the crossslide, this will reveal a screw which has a lubrication hole through the centre. Pump oil through the hole whilst traversing the crossslide.

### SADDLE BALL SCREW AND BED LUBRICATION

Lift the concertina bed cover to reveal the saddle ball screw, with a pump action oil can pump oil on to the screw and traverse the saddle.

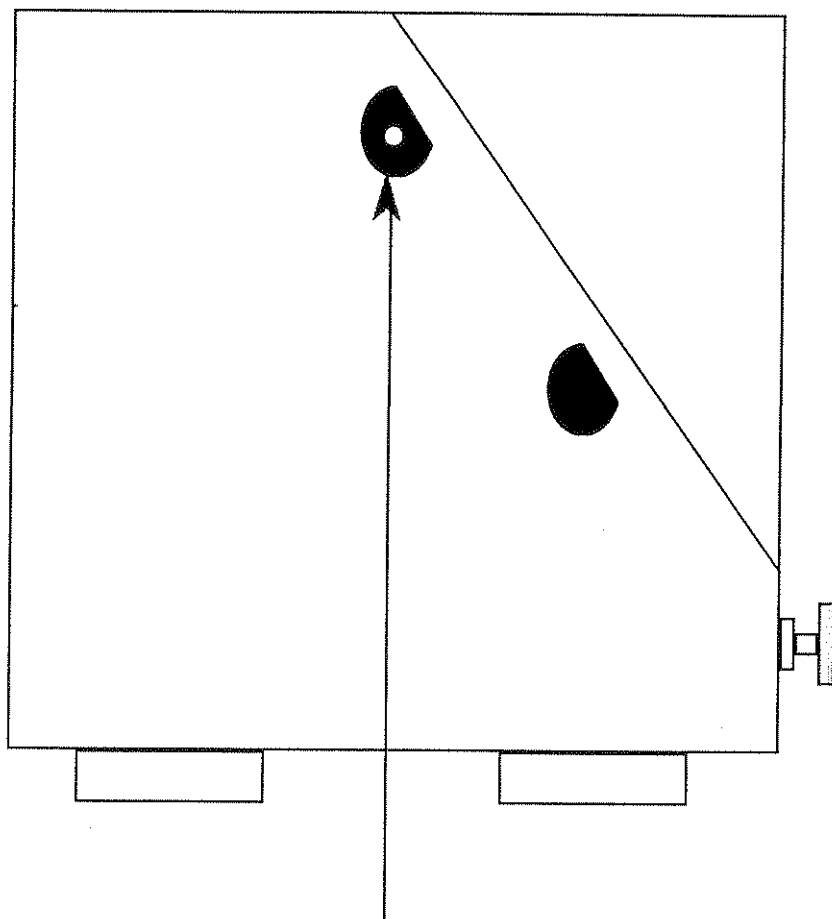
Whilst the cover is lifted pump oil on to the top and bottom of the bed ways.

### CROSSLIDE SLIDEWAY LUBRICATION

With the crossslide in the datum position pump oil beneath the slideway cover at the front of the machine and traverse the crossslide to spread the oil.

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## LUBRICATION OF CANTILEVER GUARD



Oiling point on either side

