

GLS maintenance Manual

(IECHO-YF1808-D020)

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1. Equipment daily maintenance schedule

Cutter maintenance schedule		
period	Maintenance project	instruction
Every day	Check main inlet value and each module of cylinder air pressure value	Whether the air pressure is within the normal range (suggested air pressure provided outside the equipment is set at 0.6mpa)
	check air filter	Outlet water from oil-water separator: turn off air supply, Loosen the air filter seal screw to drain automatically
	clean receiving and marking platform sundries.	Use duster or air gun clean the platform.
	Clean working platform fragment	Feeding the fragments concentrate upon brush place, using air gun or brush clean.
	Clean dust and sundries of pressing plate, cutting tool, guide pulley	Use air gun clean(attention: Do not clean air gun with water in the air pipe)
	Check set screws tightness of cutting tool	Using wrench try tight
	Check cutting head cover tightness	Using wrench try tight head cover fixed screw and check the tightness of cutting head cover.
	Check emergency and stop button.	At least check once time emergency and stop button timeliness.
	Check cutting tools and grinding structure working condition	Starting up check the cutting tools and grinding structure working regular, can start and off normally.
	Check each punching tools tightness(if it has punching tool)	Using wrench try tight screws of punching tools
Every week	Clean cutting tools sliding block dirt oil	Pick up cutting tool, clean dirt oil using ethyl alcohol or duster, change the specific lube oil.
	Clean cutting head module and all direction guide rail	After cleaning guide rail, using clean duster rub the guide rail gently with the special lube oil.
	Clean the guide rail on the cutting head beam	After cleaning guide rail, using clean duster rub the guide rail gently with the special lube oil.
	Grinding wheel checking	Take out grinding wheel using duster clean the blot, confirm the grinding wheel need

	Check the rotating core of the connect roller	Check the tool and rotating core of connection roller sliding block moving smoothly.
Every month	working platform bristle brick check	Check bristle brick tight enough, push hard checking
	Checking feeding chain tight enough	Check feeding chain loose or not, using hand press chain tightness
	vacuum chamber checking	Cleaning filter box and net, prevent fragment blocking the filter net.

※ Note:

1, using air gun or brush cleaning X-axis, Y-axis rack frequently, make sure no fragments on the rack.

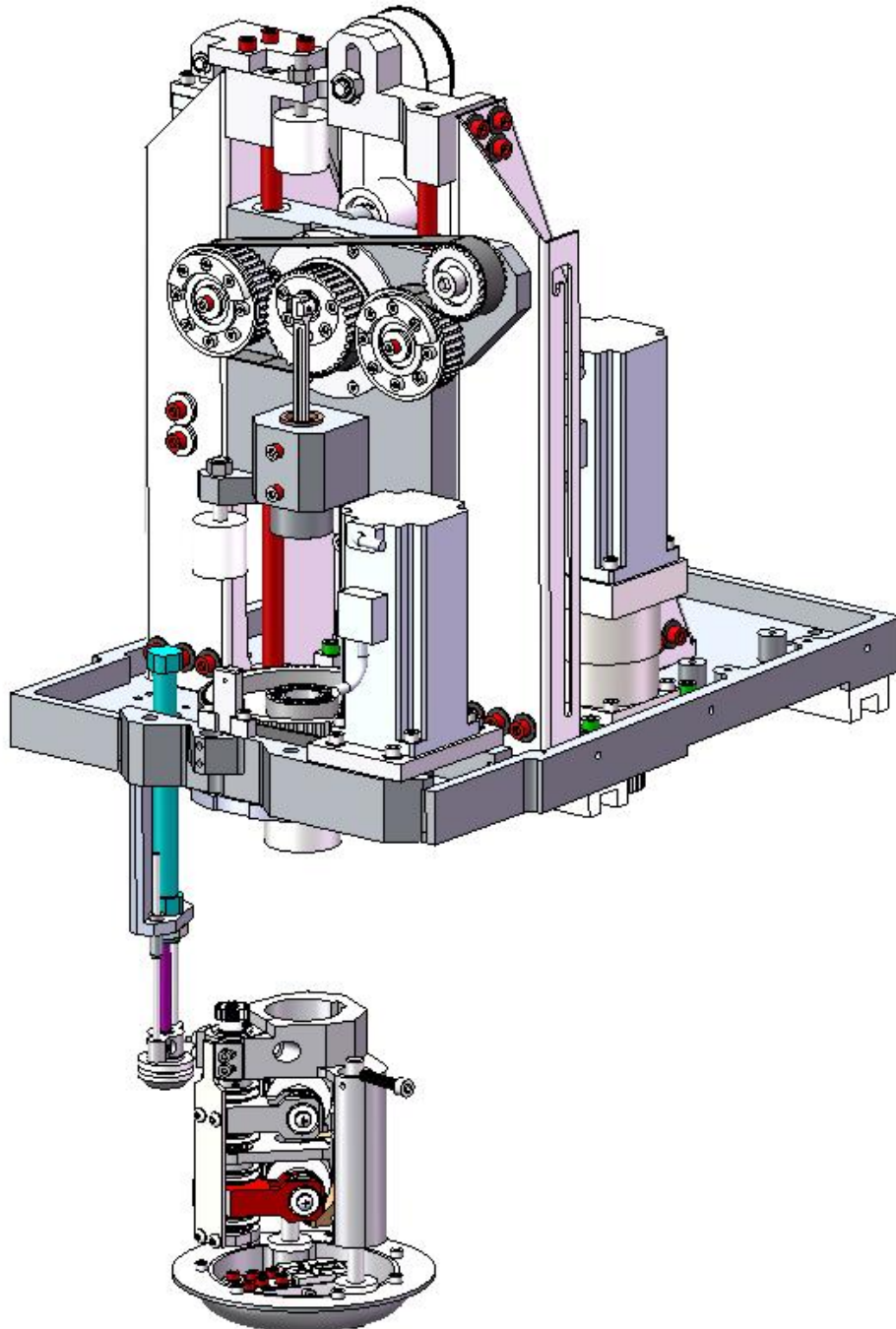
2, When software reminder blade point undersize, which means the cutting edge has used up, need change a new blade.

3, When the capacity of absorption decline, materials is easily moving when cutting, need excrete and clean bristle brick and cleaning the fragments in the bristle brick.

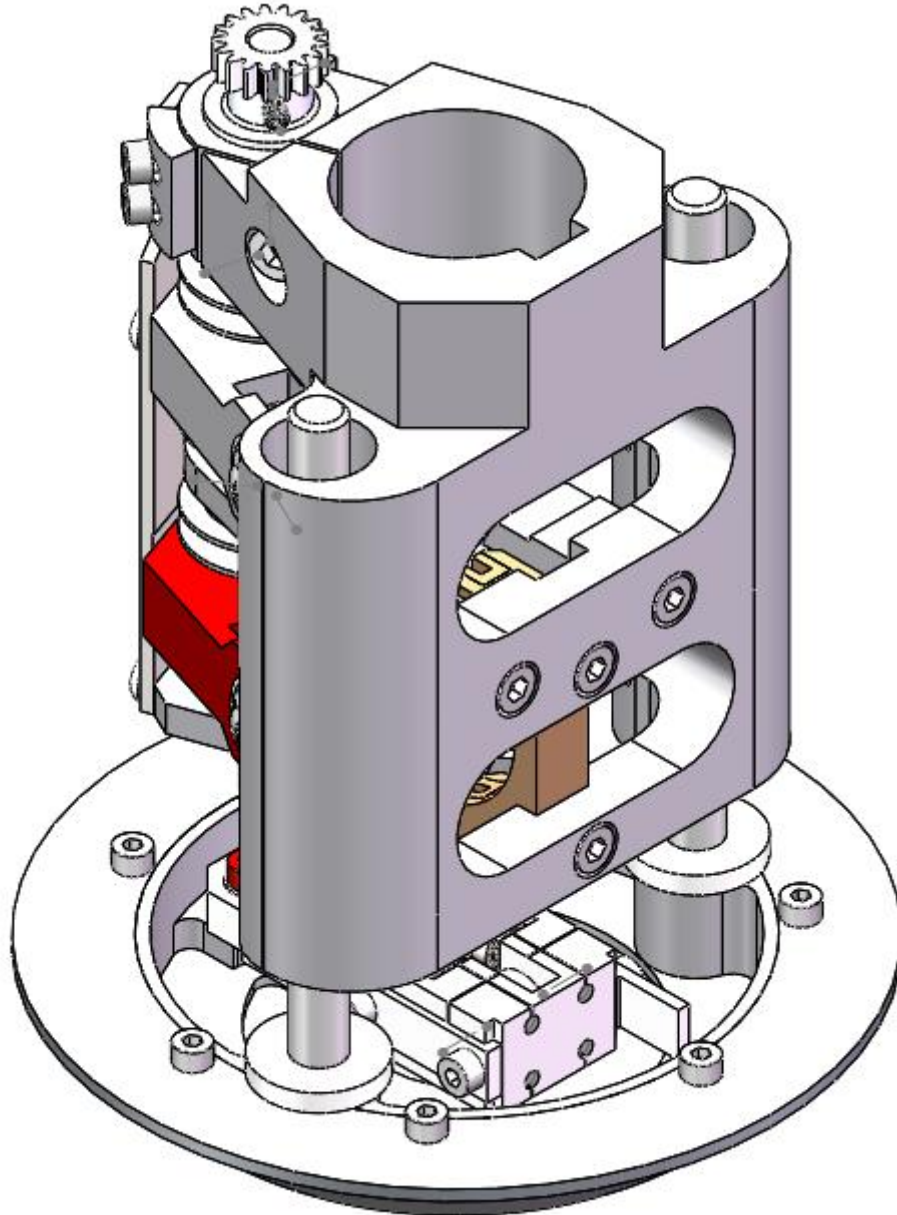
4, Lube oil, suggest using 'Mobil No.1 5W-30' , grease oil, suggest using 'Mobil grease MP' .

2 Diagram of key parts of equipment

2.1 diagram of cutting head pressing plate



(2.1.1 cutting head assembly image)



(2.1.2 pressing plate image)

3 Instruction For The Maintenance

3.1 X, Y direction rail guide lubricant oil adding

Clean dust on X and Y rail guide with air blow gun daily before turning on the machine, and add lubricant oil included in the machine.



3.2 Slider part lubricant grease adding

Every time changing blade, need to smear uniformly lubricant grease on round surface on the slider part.



3.3 Pressing plate' s up/down rail lubricant oil adding

Every week need to clean dust on pressing plate' s up/down rail with air blow gun and add lubricant oil included in the machine.



3.4 Pressing plate cylinder lubricant oil adding

Two cylinder on the pressing plate need to be maintained regularly, clean dust, add lubricant oil every day before turning on the machine to avoid up/down stuck and breaking blade.



3.5 Oscillating blade main axis lubricant oil adding

Every 3 months, unscrew M8 bolt on top of the oscillating box, add 1ml of lubricant oil included in the machine (Around 2 beans size). Once finished remember to screw back M8 bolt. (This operation is suited for some model)



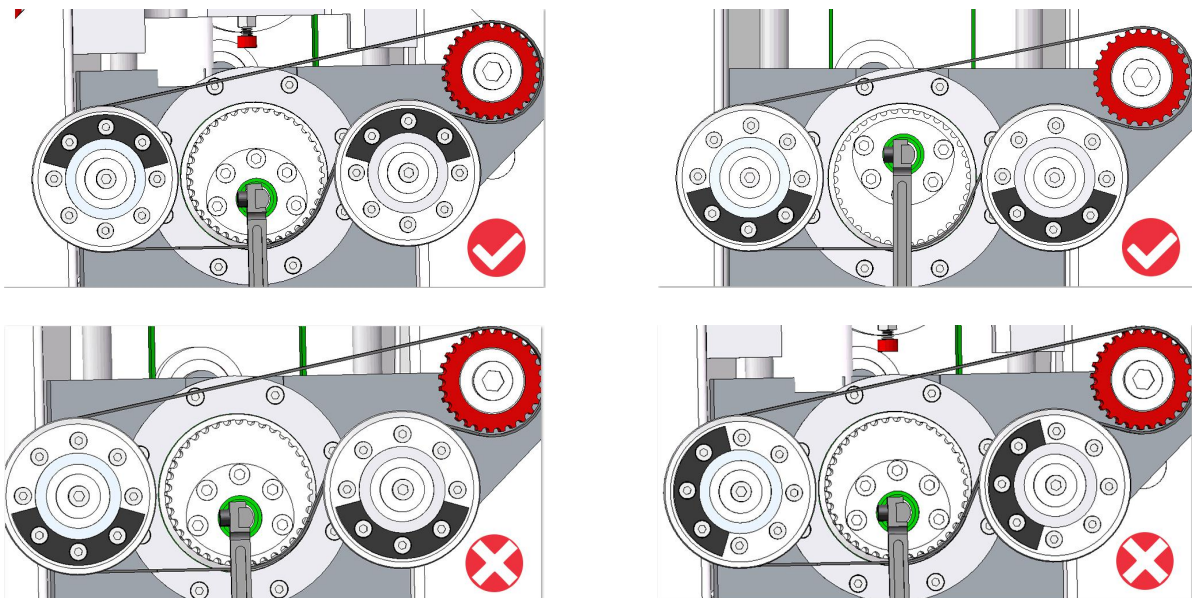
3.6 Grinding wheel cleaning

Need to clean regularly 4 grinding wheel with detergent included in the machine as shown in the picture, cleaning period around 1-7days, depends by the material worked. (After worked for some time, grinding wheel could be stuck by scraps, affecting knife sharpening, then affect cutting accuracy, in severe case could stick material and cause blade break.)



3.7 Balance wheel changing

Changing balance wheel need to pay attention to relative position between balance block and eccentric axis, misplacing would lead to cutting head shaking, affecting machine performance. Correct position and misplaced position are shown in below pictures.



3.8 Belt changing

When changing belt, look from backside of the cutting head, winding method is shown in the picture. After tightening belt, it should be fit in place, don't keep it on edge of the wheel otherwise it would deviate after tightening.

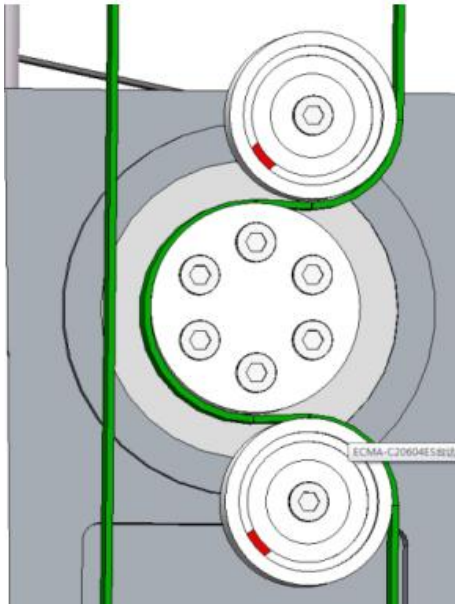


Image 1

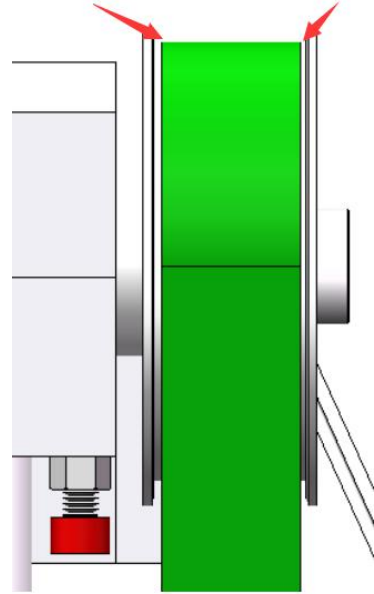
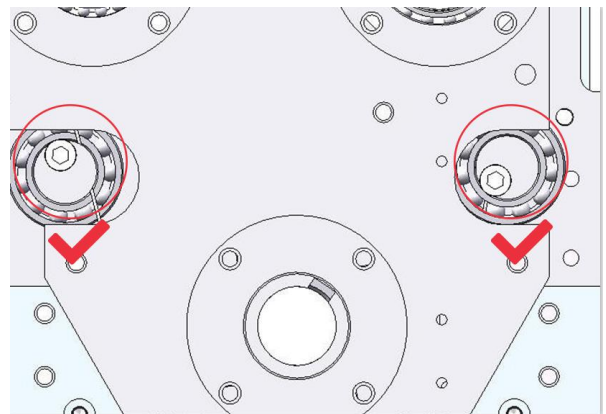
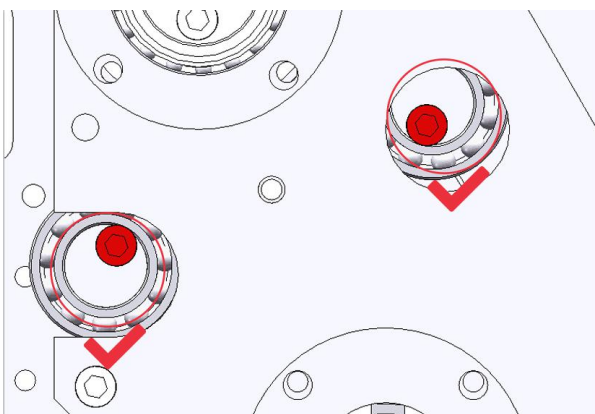
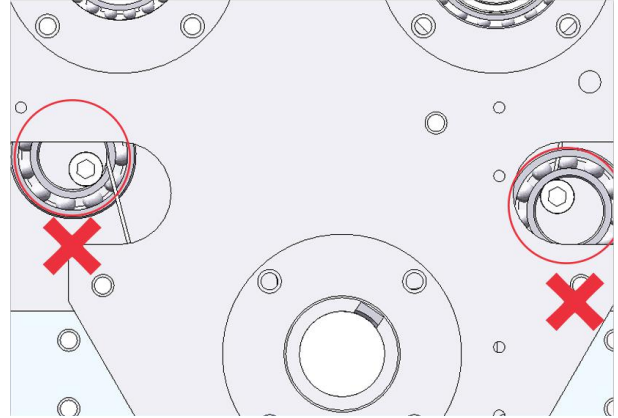
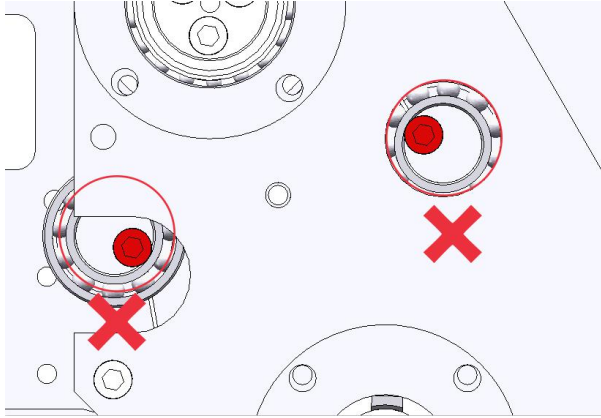


Image 2

3.9 Belt tensioner changing

When changing belt tensioner of two side of the beam, should pay attention axis should tightening in anti-clockwise, if tightening clockwise would be loosed. Correct and incorrect position are shown in pictures below.





4 Easy to wear spare parts replacement cycle

NO.	Spare parts code	Name	Specification	Qty.	Lifetime	Notes	Photo
1	1.10.01.0004335	GLS blade slot	GLS.05-030A	1	500h	The cutting accuracy of the sample becomes worse after abrasion	
2	1.10.03.0001496	GLS Slide block	Module	1 set	500h	Vibrating knife running noise becomes louder after wearing	
3	1.10.03.0002073	GLS Guiding wheel	Module	1 set	600h	Bearing failure, poor cutting accuracy, frequent tool breaks	
4	1.20.05.0000155	Deep groove ball bearing	624zz	1	600h	After the failure, the cutting accuracy gets worse, and frequent knife breaks etc.	
5	1.20.05.0000345	Deep groove ball bearing	623zz	4	600h	After the failure, the cutting accuracy gets worse, and frequent knife breaks etc.	
6	1.10.01.0004320	GLS Slip sleeve	GLS.05-014B	1	1000h	Vibrating knife running noise becomes louder after wearing	
7	1.20.06.0000160	Flat belt	910-2.0-20	1	1000h	Vibration knife lags or stops after failure	
8	1.10.03.0001164	GLS Grinding wheel driven sharpening parts	Module	1 set	1000h	Jumping, uneven sharpening, poor cutting accuracy, etc.*return to manufacturer for maintenance	
	1.10.03.0002109	GLSA Material pressing plate	Module	1 set			

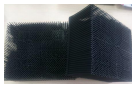




9	1.10.03.0001508	Sharpening circle belt		2	1000h	Grinding wheel stops or slips after failure	
10	1.10.01.0004309	Pressing plate spring	GLS.05-097	2	2000h		
11	1.20.04.0000254	Compact cylinder	ACP S-25*125-B	1	1000h	The lift knife function will fail.	
12	1.10.01.0004838	GLS driven sharpening blade holder	GLS.12-402	1	1000h		
13	1.20.01.0000840	Rubber cushion	D30*H30 M8	2	2000h	Vibrating knife running noise becomes larger after aging	
14	1.10.03.0002352	GLS Material Press cylinder	Module	1 set	2000h		
15	1.10.03.0002152	Pressing wheel	Module	1 set	2000h	the pressure tray lifting function will be invalid after broken	
16		GLS EOT eccentric wheel shaft	Module	1 set	2000h	Bearing failure makes loud noise * Return to company for maintenance	
17	1.10.03.0002235	GLSA EOT eccentric wheel shaft	Module	1 set	2000h	Bearing failure makes loud noise * Return to company for maintenance	
18	1.10.01.0004355	GLS Cutting head gear	GLS.05-048	1	3000h	The cutting accuracy of the sample becomes worse after abrasion	
19	1.10.03.0002236	GLS Head sharpening tool lock assembly	Module	1 set	3000h	Sharpening function fails in severe wear	
20	1.10.01.0004435	GLS Beam gear	GLS.04-014A	2	3000h	The cutting accuracy of the sample becomes worse after	

						abrasion	
21	1.20.06.0000155	5M Double-sided timing belt	550-5M-16	1	3000h		
22	1.20.04.0000255	Stainless steel mini cylinder	MI-12*100-S-U	1	3000h	if broken, the pressure tray lifting function is invalid	
23	1.20.02.0000147	Black felt brick		pcs	4000h		
24	1.20.06.0000148	5M Timing belt	450-5M-20	1	5000h		
25	1.10.03.0002237	Balance wheel	Module	2 set	5000h		
26	1.10.03.0002238	Double-sided belt tensioner	Module	1 set	5000h		
27	1.10.03.0002239	Small flat wheel	Module	1 set	5000h		
28	1.10.03.0002240	Flat belt tensioner	Module	2 set	5000h		
29	1.10.03.0002369	GLS Oscillating Motor	Module	1 set	5000h		
30	1.10.03.0002370	GLS Rotary motor	Module	1 set	5000h		
31	1.10.03.0004487	X direction reducer	Module	1 set	5000h		
32	1.20.14.0000096	Slider (beam)	HGH15CAZOC	4	1000~6000h	Lifetime depends on maintaining	
33	1.20.14.0000073	Slider (body)	HGH20CAZOC	4	1000~6000h	Lifetime depends on maintaining	
34	1.20.04.0000063	The electromagnetic valve	4V110-06/DC24V	1	500~6000h		
35	1.20.04.0000223	Air source processing element	GF300-08	1	1000~3000h	Replace the filter	
36	1.20.10.0000057	fuse	20A	1			
37	1.10.03.0004598	X direction gear	Module	1 set	5000	Replace if bearing fails	

Note: All spare parts in the list must be replaced regularly according to the prescribed time. Equipment problems caused by non-periodical replacement are not within our responsibility. Maintenance costs due to problems during the warranty period of the equipment will be charged extra.

5 Easy to wear spare parts list

NO.	Spare parts code	Name	Specifications	Qty.	Type	lifetime	Notes	Picture
1	1.10.03.0001496	GLS Slide block		2	easy to wear	500h	Vibrating knife running noise becomes louder after wearing	
2	1.10.01.0004335	GLS blade slot	GLS.05-030A	2	easy to wear	500h	The cutting accuracy of the sample becomes worse or jump after abrasion	
3	1.10.01.0004320	GLS Slip sleeve	GLS.05-014A	1	easy to wear	1000h		
4	1.10.01.0004355	GLS Head gear	GLS.05-048	1	easy to wear	3000h	The cutting accuracy of the sample becomes worse after abrasion	
5	1.10.01.0004435	GLS Beam gear	GLS.04-014A	2	easy to wear	3000h	The cutting accuracy of the sample becomes worse after abrasion	
6	1.20.06.0000160	flat belt		2	easy to wear	1000h	Vibration knife lags or stops after failure	
7	1.20.01.0000840	Rubber cushion	D30*H30 M8	2	easy to wear	2000h	Vibrating knife running noise becomes larger after aging	
8	1.10.03.0001508	Sharpening circle belt		4	easy to wear	1000h	Grinding wheel stops or slips after failure	

9	1.20.02.0000147	Black felt brick		20	easy to wear	4000h	The film will be sucked in when the needle broken	
10	1.10.01.0004309	Pressing plate spring	GLS.05-097	4	easy to wear	2000h		
11	1.20.18.0000157	GLS Blade	GLS.05-099	refer to order	consumable	10~80h	Varies on materials	
	1.20.18.0000195	GLS Slotted blade	GLS.05-299					
12	1.10.01.0003167	GLK Sharpening wheel	GLK1820-05-06-031	4	consumable	100~300h		
13	1.20.10.0000057	Fuse	20A	1	easy to wear			

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