

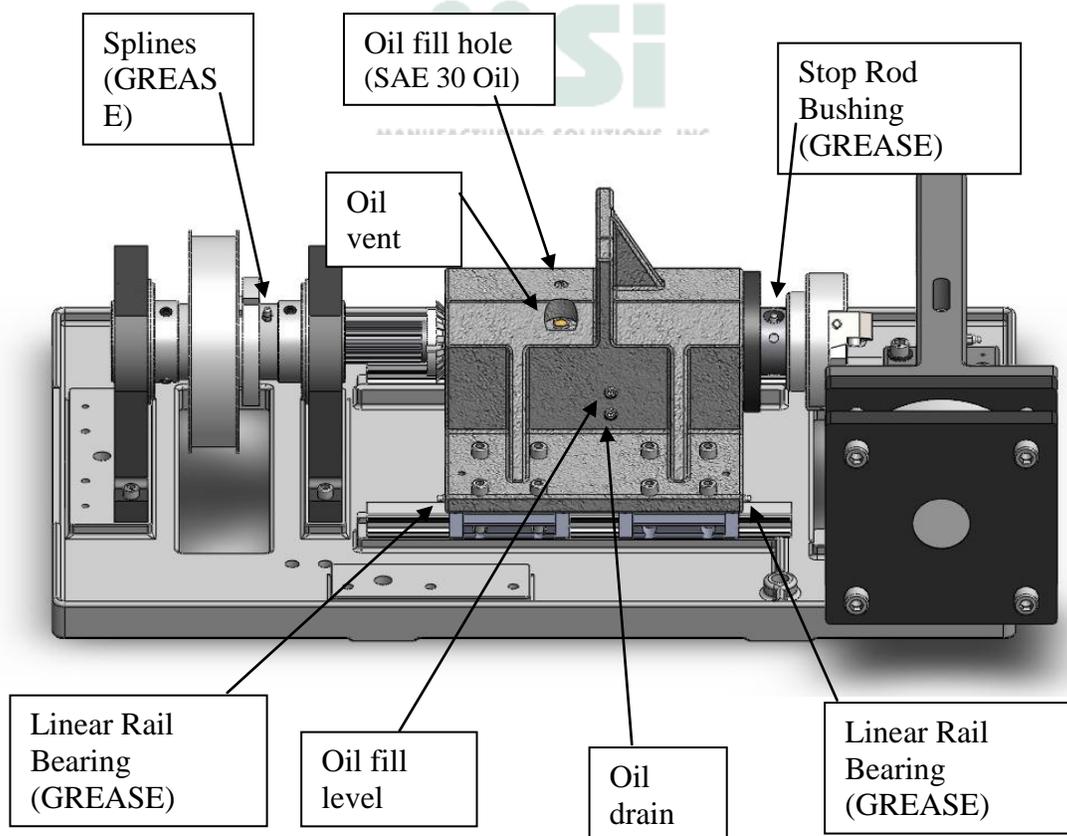
MAINTENANCE

MAIN SPINDLE BEARINGS – The main spindle bearings are lubricated via the oil in the spindle housing. The oil level in the spindle housing needs to be checked on a monthly basis. This is done by removing the pipe plug that is installed at an angle in the right hand side of the spindle housing when standing in front of the machine. The oil level should up to the bottom of the fitting hole. SAE 30 oil is installed in the spindle housing from the factory. The oil should be completely drained and refilled on a yearly basis. There is a drain hole provided on the left hand side of the spindle housing.

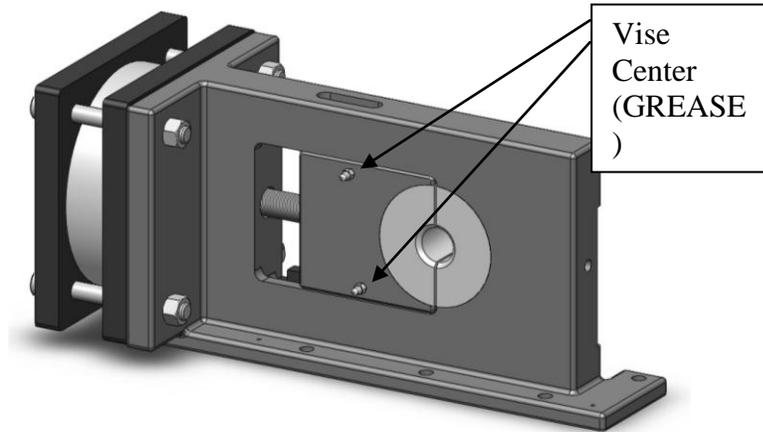
SPLINES – Grease monthly through zerk on rear drive hub. Supply one full pump from standard grease gun

LINEAR RAILS AND BEARINGS – The linear rails and bearings require monthly lubrication. This is done by SLOWLY supplying one full pump from a standard grease gun to each of the four zerks located on the linear rail bearings. The linear bearing manufacturer suggests using grease that complies with DIN 51825 consistency class 2. It is imperative that greases with solid lubricant content (such as graphite or MoS2) **NOT** be used!!!

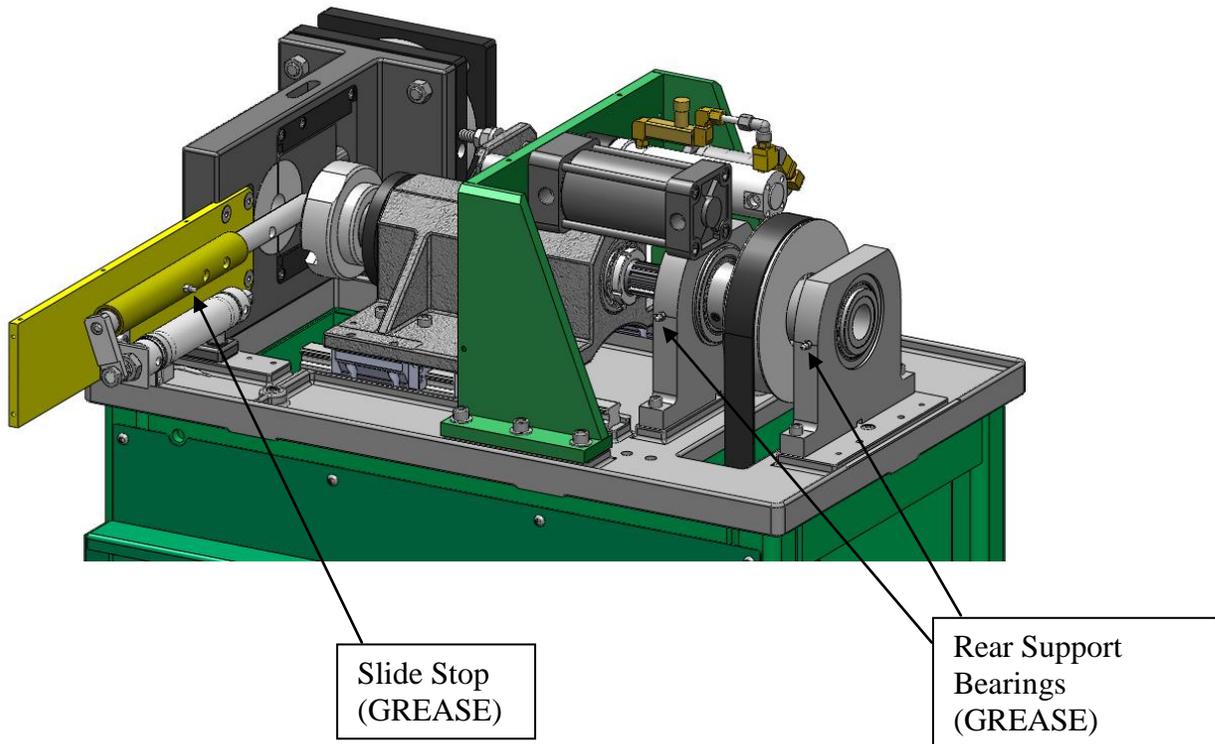
STOP ROD BUSHING – Grease monthly through zerk on spindle near chamfer head.



WISE CENTER – Grease monthly thru the two zerks on the front of the vise.



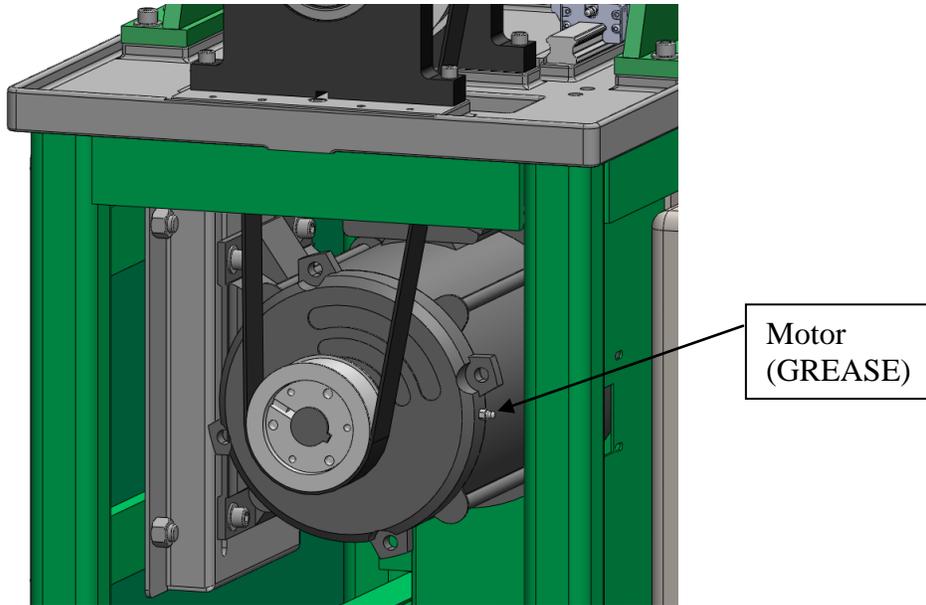
REAR SUPPORT BEARINGS – The rear support bearings need to be greased on a monthly basis also. This is done by SLOWLY supplying one full pump from a standard grease gun, with the machine running about 1000 RPM, to each of the two rear bearing zerks.



SLIDE STOP – If your machine is equipped with a slide stop it should be greased monthly thru the zerk on the slide stop.

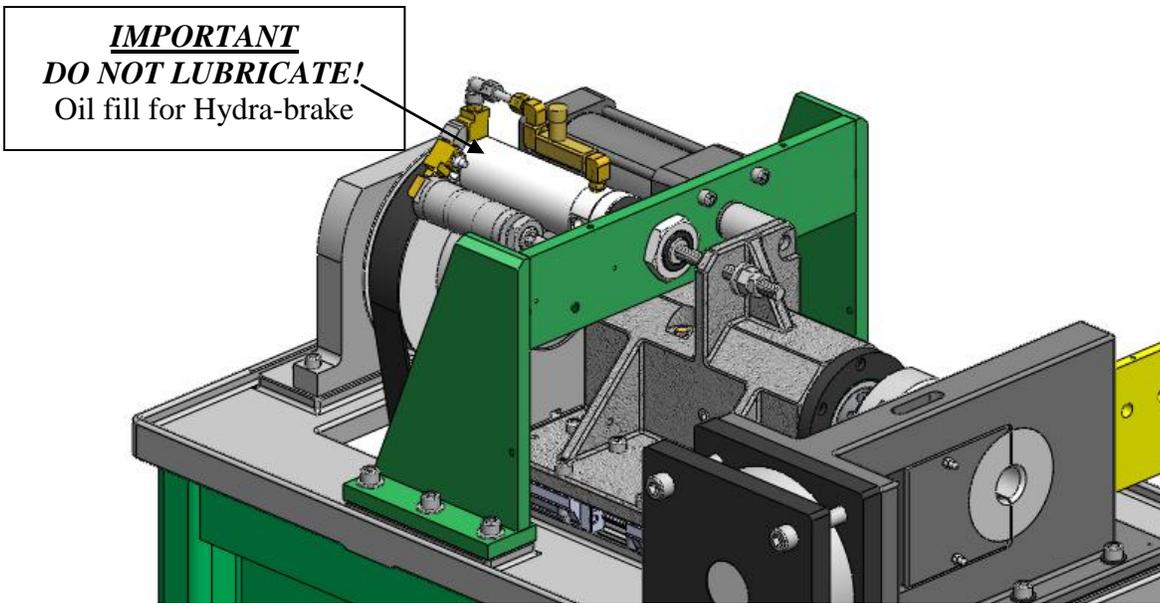
AIR LINE LUBRICATOR – Fill reservoir with 10 wt. Hydraulic oil as needed and adjust to supply one drop of oil with each 4 to 5 cycles of machine.

MOTOR – Grease annually with bearing grease.



CLEANING - Empty chip pan as needed. Wipe exterior of machine clean with a towel dampened with household type spray cleaner. Do not use harsh solvents or blowgun to clean machine.

HYDRA-BRAKE –There is an oil fitting located on the hydra-brake. This IS NOT a lubrication point. The hydra-brake requires no normal maintenance. If required, consult factory for refilling.



TROUBLE SHOOTING GUIDE

Machine Will Not Run

- A: Check incoming power
- B: Check fuses in machine panel (ATQ-15 & ATQ-1)
- C: Check disconnect switch assembly is on (M10132)
- D: Check limit switch on top cover (M10167)

Machine will run but not cycle when foot pedal is depressed

- A: Check air pressure is set to at least 75 PSI on regulator (M10571)
- B: Check pressure switch (M10055) is set at 45 PSI

Vise closes and head begins to travel forward, then retracts and completes cycle

- A: Check air pressure is set to at least 75 PSI

Inserts breaking:

- A: Check insert (M10600) is not contacting part in rapid traverse
- B: Check condition of seat (M10361) and seat screw (M10362) is tight
- C: Check Hydra-Brake (13201) for excessive feed rate
- D: Change to insert suited for material

Excessive chatter:

- A: Check condition of insert (M10600), seat (M10361) and seat screw (M10362).
- B: Check wedge (11400) is tight
- C: Adjust RPM and feed rate
- D: Check condition of spindle bearings (M10317 and 12552)
- E: Check condition of linear rails and bearings assembly (M10773)
- F: Check collets fit part properly

Vise will not open when head is retracted:

- A: Check rear limit switch (M10167) is being activated by the screw mounted in the spindle housing.

Part is not chamfered when tool holder is set right and head travel is at maximum

- A: Check axial position of stop rod (11795). Should be set ½” behind vise

Chamfer is off center:

- A: Check for proper size collets
- B: Check parts are not out of round, over/under size etc
- C: Re-center vise. Consult factory.

Fine feed rate is not adjustable, spongy, or inconsistent:

- A: Hydrocheck (13201) may require maintenance. Consult factory.

RPM's of machine slow down as part is being machined:

- A: Check condition of belt and sprockets
- B: Slow down feed rate (13201)
- C: Adjust RPM to better suit material and diameter

Spindle assembly slams forward or reverse:

- A: Adjust flow controls (M10686 – located stacked under the solenoid valve that controls the feed cylinder, adjusted using a straight blade screwdriver)

For other problems, consult factory.

