

Technical Datasheet # 60

Preventative maintenance

Keep your machine in good condition

Regular planned preventative maintenance is far better than unexpected, unplanned, machine downtime due to a component failure.

Machine performance & accuracy will suffer if worn or damaged parts are not replaced promptly.

Regular inspection is vital to avoid unscheduled breakdowns.



1. Monitoring during operation: Consumables:

Consumable items such as knife blades and caterpillar belts should be visually checked on a regular basis for wear.

If these items are not kept in a reasonably condition, the machine performance will almost certainly deteriorate over time.

1.1 Knife blades:

It is difficult to define when a blade requires replacing. However, for the efficiency of the Servo-Torq® cutter, it is essential that a sharp cutting edge be maintained on the blade. This ensures that:

- A clean, swarf-free, cut edge is maintained on the extrusion.
- Undue stress is not placed on the cutter motor.

If in doubt as to the sharpness of the blade, fit a new blade by following the operating instructions that came with your machine.

FOR SAFETY, IT IS ESSENTIAL THAT THE MAIN POWER ISOLATOR SWITCH SHOULD BE TURNED OFF DURING THE BLADE CHANGING OPERATION.

1.2 Caterpillar belts:

Keep the belts clean & free from grease or oil.

The belts should be replaced if the surface is torn, split or otherwise excessively worn.

Belt damage may cause variations in cut length measuring accuracy.

To change the caterpillar belts follow the operating instructions that came with your machine.

2. Monitoring during operation: Safety:

The operation of all safety interlocks, switches & emergency stops should be checked daily to ensure they are safe to use.

DO NOT OPERATE THE MACHINE IF IN ANY DOUBT WHATSOEVER ABOUT THE OPERATION OF ANY SAFETY SWITCH, INTERLOCK OR EMERGENCY STOP BUTTON.

3. Preventative measures: Regular inspection:

Regular maintenance inspection is vital if unscheduled breakdowns are to be avoided.

Please follow the maintenance schedule listed below on page 2.

It is designed to identify problems before they cause production downtime.

For more information & technical assistance:

www.gillardcutting.com/technical

email: tech@gillardcutting.com

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4. Recommended planned maintenance schedule:

Daily:

1. Check the condition of the knife blade. If worn or damaged replace with a new, sharp, blade.
2. Check the condition of the caterpillar belts. If dirty, clean them. If worn or damaged replace with new belts.
3. Check the safety guard operation. Open each guard in-turn. Check that the machine stops urgently as soon as the guard is opened. Check the machine won't re-start with the guard open.
4. Check the emergency stop push-button operation. Check the machine stops urgently as soon as the button is pressed. Check the machine won't restart with the button in the "down" position.

PLEASE REFER TO DATASHEET # 61 WHICH FEATURES A RECOMMENDED DAILY & MONTHLY OPERATOR SAFETY CHECK LIST.

Weekly:

1. If the blade lubrication system is being used, check & clean the wet cutter block reservoir of any debris left over from the cutting process.
2. Replace any dirty lubrication liquid with fresh liquid.

Monthly:

1. Check drive belts for wear. This will only apply to older, non-direct drive, machines.
2. Check the caterpillar belts are correctly tensioned.
4. Check the caterpillar belt height adjustment screw for ease of movement. Brush with light oil (Mobil DTE 24 or similar) if dry.
5. Lubricate the caterpillar belt hand-wheel bearings with light oil (Mobil DTE 24 or similar).

4. Recommended planned maintenance schedule: Continued:

Monthly (continued):

6. Lubricate the chromed vertical caterpillar support pillars with light oil (Mobil DTE 24 or similar).
7. Lubricate the slide-away cutter head chromed bearing shafts with light oil (Mobil DTE 24 or similar).

Six monthly:

1. Visually check for loose wires.
2. Visually check for loose bolts, fasteners & screws etc.
3. Check all hinges & opening lids/doors for damage.
4. Check the caterpillar belts stop when the touch-screen control panel speed adjustment field is set to zero (0.00).
5. Run the caterpillar belts at full speed and check for excessive noise.
6. Check that the knife blade head is square to cutter bush holder block.

Yearly:

1. Lubricate the caterpillar belt drive bearings using the nipples provided. Recommended lubricant Shell Gadus S2 V100 3 (Alvania Grease RL 3) or similar.
2. Lubricate the caterpillar belt tension adjusting screws with Shell Gadus S2 V100 3 (Alvania Grease RL 3) or similar.
3. Lubricate the caterpillar belt height adjustment nuts (rear) with Shell Gadus S2 V100 3 (Alvania Grease RL 3) or similar.
4. For belt drive cutter motors only: remove cutter motor cover & lubricate the main cutter shaft bearings using the nipples provided. Recommended lubricant Shell Gadus S2 V100 3 (Alvania Grease RL 3) or similar.

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For more information & technical assistance.

For technical assistance.
Please contact us as below.

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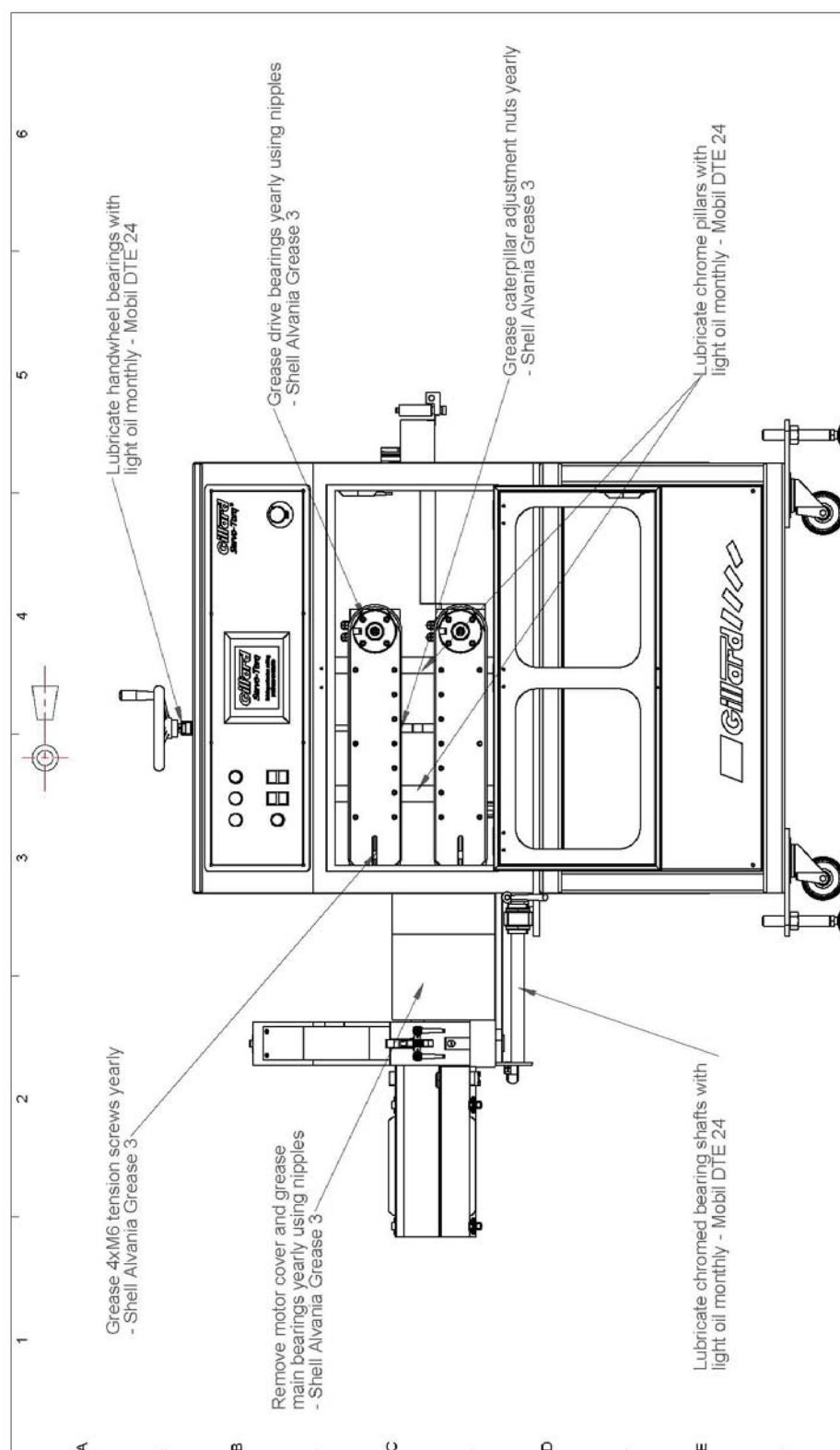
Email: tech@gillardcutting.com

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R- L Feed machine shown.
Guard detail may differ.

ISS		DATE	DRAWN	REVISION	UNITS		SCALE	1:12	DESCRIPTION		SHEET No	1	of	1	DRAWING No	STLTUA75LUB010	Alt
A		27/09/2008		NEW DRAWING	mm				Gillard Cutting Technology		ST-LT Cutter + UA75 Caterpillar						
B									Alexandra Way, Ashchurch Business Centre								
C									Tewkesbury, Gloucestershire, GL20 8NB, England - UK								
D									Tel: 01684 290243								
E									E-mail: tech@gillardcutting.co.uk								
F									This drawing is the property of Gillard Cutting Technology & must not be reproduced in any form without written consent.								

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