

National Acme Preventative Maintenance Check List

Operator Machine Care

- The lube oil filter handle should be turned at least twice each shift
- Frequently check the oil flow in the sight glass.
- At the beginning of every shift check for adequate coolant flow to all tooling cutting edges and that coolant flow is directed away from spindles.
- Clean dirt and grit from bars before loading into the machine and then coat with grease. This will aid in reducing noise and load on the feeding mechanism.
- Before loaded into the machine, all leading ends of bars should be chamfered for easier entry into pushers and collets.
- Both the floor and machine should be kept free of accumulated oil, dirt and debris.
- The main disconnect should be turned to OFF at the end of each shift. Clean slides, gibs and toolholders of all chips and grit at the end of each shift. Do not use an air hose to clean. High pressure air is dangerous and drives grit into slides, gibs and other mechanisms.
- DO NOT ATTEMPT TO FORCE THE MACHINE TO OPERATE if there is a malfunction. If there is a hang up, poor indexing, improper clutch operation or any other problem turn OFF the machine and contact a supervisor.
- Clutches must be properly adjusted for machine operation.
- Collet adjustment should be checked and readjusted if necessary when loading new bars.

- After loading new bars pusher tube guard disc should be closed and locked before starting machine.
- Do not run machine with feed OFF and collet half OPEN or half CLOSED. This will result in rapid shoe wear.
- When the machine is stopped on half index the chucking shoe and spool must be in alignment before completing index.
- After each cam change, the roll clearance between the lead and guard cams should be checked.
- Each time a cam is changed, check the condition of cam roll and stud. The path should be greased generously.

Daily Maintenance

- Check the lubricating oil level in the main reservoir.
- Check the oil level in coolant pump and chip conveyor gearboxes.
- Check the oil level of independent motor driven accessories.
- Check the oil supply in oil reservoir of stock reel support.
- Check the oil supply in air line lubricator.
- Check the oil supply in all oil cups and those in the stock reel support.
- Check dripping rate for all oil cups.
- Check the coolant level in pan reservoir.

- Check the coolant intake pipe or pump screen and clean as necessary.
- Check grease fittings and add grease as necessary.
- Check chucking shoe for wear. Oil drip should contact shoe.
- Check condition and alignment of the stock reel and stock reel stand.
- Check delivery of lubricating oil to the spindle bearings.
- Cycle time with a stop watch. If too fast or slow refer to section G, Troubleshooting, in the machine manual.

Bi-Weekly Maintenance

- Air filter trap should be drained. Or more often as needed.
- The screen of lube oil intake pipe should be cleaned.
- The sludge should be drained from the oil filter.
- Inspect the brake adjustment and clutch adjustments.