

Tools & Production, Inc.

B. PUNCH UNIT MAINTENANCE

- *Lubricate gears every 4 weeks
- *Check gear backlash every 6 weeks and remove if necessary
- *Check shaft and key condition every 6 weeks – clean & remove burrs if necessary
- *Inspect dies for wear - every 6 months
- *Clean out punch and die cavities whenever punch and dies are replaced
- *Replace punch and die hold down screws whenever the screw's socket loses its shape.
- *Clean gear teeth, inspect and re-lubricate every 6 months
- *Check vacuum system if applicable and clean or replace filter if required every 6 weeks
- *Check, clean, & remove burrs from ring split lines if applicable – whenever rings are removed or replaced.
- *Sharpen socket head wrenches used on punch units, especially the smaller sizes, whenever they become dull.
- *Clean P&D shafts daily removing dust & debris.