

SEEDORFF
ACME Corporation



PREVENTATIVE MAINTENANCE FOR RESISTANCE WELDERS

Good housekeeping is a must and cannot be over-emphasized in today's world of safety-conscious regulations. A well-maintained and clean work environment results in more machine availability and less maintenance overall.

DANGER: Always "Lock Out" all sources of energy before entering or servicing any equipment.

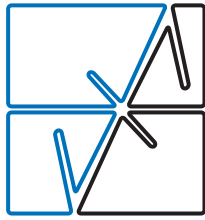
MACHINE RECORDS: Each machine should have two sections in an equipment record book. The first section should be weld schedules for specific model parts. A given welded part should be able to be duplicated if machine is properly maintained. The second section should be used to record preventative maintenance, required maintenance or repairs. If the records indicate that repetitive maintenance is required, it gives cause for corrective procedures to be implemented. The records can also be used to assist in troubleshooting by existing and new maintenance employees.

SUGGESTED PREVENTATIVE MAINTENANCE: The following general preventative maintenance suggestions are intended to cover all types of resistance welders. If unsure of any of the following procedures, please contact Seedorff ACME Corp. directly at: (714) 252-5330.

We also offer preventive maintenance programs performed by qualified Service Technicians, please consult factory.

DAILY CHECK LIST Start of Shift

- Wipe all surfaces clean of dirt, dust grease, oil and water.
- Clean up vicinity of the welder.
- Dust lenses of any light fixtures, windows and doors, and transparent covers.
- ***CAUTION: Do not use solvents for cleaning paint or Lucite windows.***
- Turn on the air supply.
- Turn on the water supply.
- Check for air pressure setting.
- Lubricate the required daily points.
- Turn on the power supplies.
- Check the settings on the weld control.
- Dry cycle the equipment a few times to make sure everything is functioning properly. If machine is erratic at start up and then becomes what appears to be normal, this is an indication that a problem exists.
- Refer to weld schedule. Check all variables after a few welds and verify that water, air, machine settings and contactors are working properly.
- Check the welds for required quality.



SEEDORFF
ACME Corporation



At Shift End

- Turn off power first.
- **CAUTION: Never leave power applied to an electronic contactor that is directly water-cooled,**
- Turn water off.
- Turn air off and release stored energy.
- Clean up vicinity of the machine.
- Look for metal chips, filings and/or arcing due to loose bolts or poor fit of current-carrying members.

WEEKLY

General:

- Investigate any unusual operation. (Talk to operator)
- Remove all oil spots from floor and walk areas.
- Wash down floor in area of machine.
- Check for air and water leaks.

Electrical System and Control:

- Check relays for evidence of wear or looseness.
- Check programmable controls for unauthorized changes in the program and correct before placing back into operation.
- Sequence machine through full manual sequence.

Electrodes and Dies:

- Make a thorough inspection of electrode and electrode holders.
- Clean electrode or die holders and clamps.
- Check for misalignment and realign as necessary.

Hydraulic System:

- Check cylinder rod locking nuts.
- Remove sample of oil from reservoir and test for deterioration or contamination. (Testing interval will depend on fluid used, and its age.)

Air System:

- Check cylinder rod locking nuts.
- Check cylinder mounting and tighten if necessary.

QUARTERLY

Cooling System:

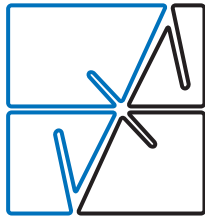
- Check water system thoroughly and replace components, which show wear or corrosion.

Hydraulic System:

- Change or clean oil filters.

Air System:

- Check air gages and regulators with pressure indicator.
- Replace damaged regulators and gages or those that are sluggish and need calibration.
- Regulator diaphragms should be checked carefully.
- Replace worn or cracked air hoses with new hoses. Be sure connections are tight. Poor connections may blow off and cause injury.
- Clean or replace lubricators and filters.



SEEDORFF
ACME Corporation



Electrical System:

- Polish all secondary contact surfaces to remove corrosion.
- Use a good cleaning solution or in the case of excessive corrosion, a fine abrasive.
- Tighten all connections for good contact.
- Check protective and overload devices.

ANNUALLY

General:

- A minor overhaul of the machine should be made annually.
- Remove all grease and rust from machine and apply a coat of machinery paint.
- Check and replace worn or damaged parts.

Cooling System:

- Reverse flush system and replace hoses where required.

Electrical System and Control:

- Check calibration of timing and adjust if necessary.
- Check primary electrical connections. Using a weld monitor, check specific current and secondary voltage.

Air System:

- Replace air hoses where required.

Hydraulic System:

- Change oil if necessary.

PERIODIC INSPECTION AND SERVICE

Cooling System:

- Check for water flow.
- Check solenoid water valve, for chatter or hum to indicate possible problem.
- Check for water leaks and repair.
- Check hydraulic cooling systems.

Electrical System and Control:

- After turning on air and water, turn on electricity. Be cautious if moving parts on power up.
- Check for chattering relays or switches and repair.
- Check timers and controls for proper dial settings according to schedule chart.
- Listen for noises indicating loose secondary connectors.
- Check for burned out bulbs in indicator lights, enclosure lights and other illumination features.
- Check foot switch and connection cord.
- Check initiation buttons and anti-tie down system if so equipped.

Air System:

- Check for air leaks and repair.
- Check line pressure, welding pressure, and electrode force.
- Empty airline filters if not equipped with auto-drain.
- Replace filter elements every six months.
- Check lubricator oil level if applicable.
- Feel solenoid valves for overheating - listen for hum indicating improper seating of spool.



Mechanical Equipment:

- Check for broken or loose components.
- Check for loose attachment of cylinders, mechanical arms, worn key ways - Have it repaired with new parts, not just patched. Patched repairs can lead to safety problems.

Hydraulic System:

- Wipe top of reservoir.
- Check for fluid leaks and repair.
- Listen for unusual pump noises.
- Check pressure gauge settings.

Electrodes and Dies:

- Check water hoses to electrode holders.
- Check lubrication of seam welding heads.
- Check for pitted, worn or dirty tips.
- Check for groves or marking of dies.
- Clean or replace as required.
- Check electrode and die alignment

REMOVING EQUIPMENT FROM SERVICE

If a component of the resistance welding equipment is being removed from service for a period of time, the following should be done to prevent unnecessary damage during idle time:

- Isolate and drain water lines and airlines to keep unwanted bugs from plugging up the lines.
- If machine is to be stored in warehouse, it may be wise to wrap in plastic or shrink-wrap to prevent rodents from eating insulation on wires and hoses.
- Equipment should be stored in dry area to prevent problems with moisture in electrical or solid-state components.
- Drain and blow out water from all cooling lines, especially: Weld controls, including SCR packages, welding transformers, and electrode holders.
- Protect all non-painted surfaces from rust and corrosion.
- Protect cylinders inside and out from rust.
- Cover the equipment to prevent excessive dirt buildup.
- When disconnecting complex welders or welders that require control to be separated a qualified electrical/mechanical person should be used to mark all electrical, mechanical and plumbing connections. Wires, hoses, etc. should be bundled up and tied to machine to prevent problems later