



2500

Customer Preventative Maintenance Checklist

Machine No: N

Date:

Software versions

Application version:

PLC version:

Scanner version:

Backup Copy of Ctable.out

Backup Copy of Laser power files

Filtration and Cooling

Laser coolant flow 1.6 gpm	Daily
IR coolant flow 2 gpm	Daily
Coolant level check	Weekly
Feed T/C placement check (roller to T/C tip space = 0.002 to 0.005")	Monthly
16x16 fiberglass filter	Every 3 – 6 months depending on environment
Plenum exhaust filters	Every 6 months
Charcoal filter	Every 6 – 12 months
Downdraft filter cleaned	Every 6 months if used
Chamber Pre-filter	Every 6 months
Downdraft screen cleaned	After every Build
Plenum intake filters	Every 6 months
IR coolant filter	Every 6 months
Laser coolant lines verified	Every 6 months
Coolant reservoir screen	Every 6 months
Part piston belt tension	Every 6 months
Belt seal scraper maint.	Every 6 months
Cylinder heater straps tight?	Every 6 months

Lubrication

Laser chiller pump	(LMO)	Every 6 months
A/C cooling fan motor	(LMO)	Every 6 months
Feed piston jack screw	(HTG)	Every 6 months
Part piston lead screw	(HTG)	Every 6 months
Roller bearing block	(HTG)	Every 6 months
Roller lead screw	(HTG)	Every 6 months
Process chamber door	(LMO)	Every 6 months
Four bar link and latch	(LMO)	Every 6 months
Laser window O-ring	Change	Every 6 months
Clean cylinder walls	(Boron)	Every 6 months
Part piston seals	(Change)	Every 6 months

Gas/Coolant usage and sensors

Laser window N2 set?	Every build
Leak rate (<50)	Every 6 months
Facilities N2 from 50 to 90 PSI?	Every 6 months
N2 purge set to 280 scfh?	Every 6 months
Exhaust valve clean and clear?	Every 6 months

System Cleaning and Inspection

- | | |
|--|--|
| <input type="checkbox"/> - Clean/change computer air filters | <input type="checkbox"/> - Inspect Freon lines and ports for leaks |
| <input type="checkbox"/> - Wipe down exterior of system | <input type="checkbox"/> - Clean under machine |
| <input type="checkbox"/> - Clean Frost from ducts and blower | <input type="checkbox"/> - Clean and inspect RBO/BOS |
| <input type="checkbox"/> - Clean shaker tray of Air handler | <input type="checkbox"/> - Test Air handler timer |

Integra Services International, Inc. recommends a complete PM be preformed every 6 months. To order PM kit for a 2000. Call Integra @ 254-933-2970 and order PN# 5000-20109
Integra Services International, Inc. 2003