



Sinterstation® 2500^{Plus} and above. Customer Preventative Maintenance Checklist
 Please order part number-5000-20108

Machine No: G/V

Date:

Application version: Windows NT PLC version: Scanner version:

Filtration and Cooling

<i>IR coolant flow 200lpm</i>	<i>Every build</i>
<i>Laser coolant flow 480lpm</i>	<i>Every build</i>
<i>Coolant level check</i>	<i>Weekly</i>
<i>Chiller air filter</i>	<i>3-6 months depending on environment</i>
<i>Plenum intake filters</i>	<i>Every 6 months</i>
<i>Plenum exhaust filters</i>	<i>Every 6 months 3 months if running metals</i>
<i>Charcoal filter</i>	<i>6 months to 12 months</i>
<i>IR coolant filter</i>	<i>Every 6 months</i>
<i>Chiller coolant filter</i>	<i>Every 6 months</i>
<i>Part piston belt tension</i>	<i>Every 6 months</i>
<i>Cylinder heater straps tight?</i>	<i>Every 6 months</i>
<i>Chamber exhaust filter</i>	<i>Every 12 months</i>

Thermal controls

Left feed Right feed Part bed Part piston Cylinder heater

Lubrication

<u>Feed piston jack screw</u>	<u>Every 6 months (HTG)</u>
<u>Part piston lead screw</u>	<u>Every 6 months (HTG)</u>
<u>Roller bearing block</u>	<u>Every 6 months (HTG)</u>
<u>Chamber door hinge</u>	<u>Every 6 months (LMO)</u>
<u>Four bar link and latch</u>	<u>Every 6 months (LMO)</u>
<u>Laser window O-rings</u>	<u>Change every 6 months</u>
<u>Clean cylinder walls</u>	<u>Every 6 months (Boron)</u>
<u>Part piston seals</u>	<u>Every 6 months</u>

Leak rate (<50) Pre: - Post:
 Facilities N2 from 50 to 90 PSI?
 Laser window N2 set?
 N2 purge set to 280 scfh?
 Exhaust valve clean and clear?

Laser coolant flow >9.0 lpm? IR coolant =200 ccm?

- Copy of Ctable.out - Copy of Laser power files

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 | |