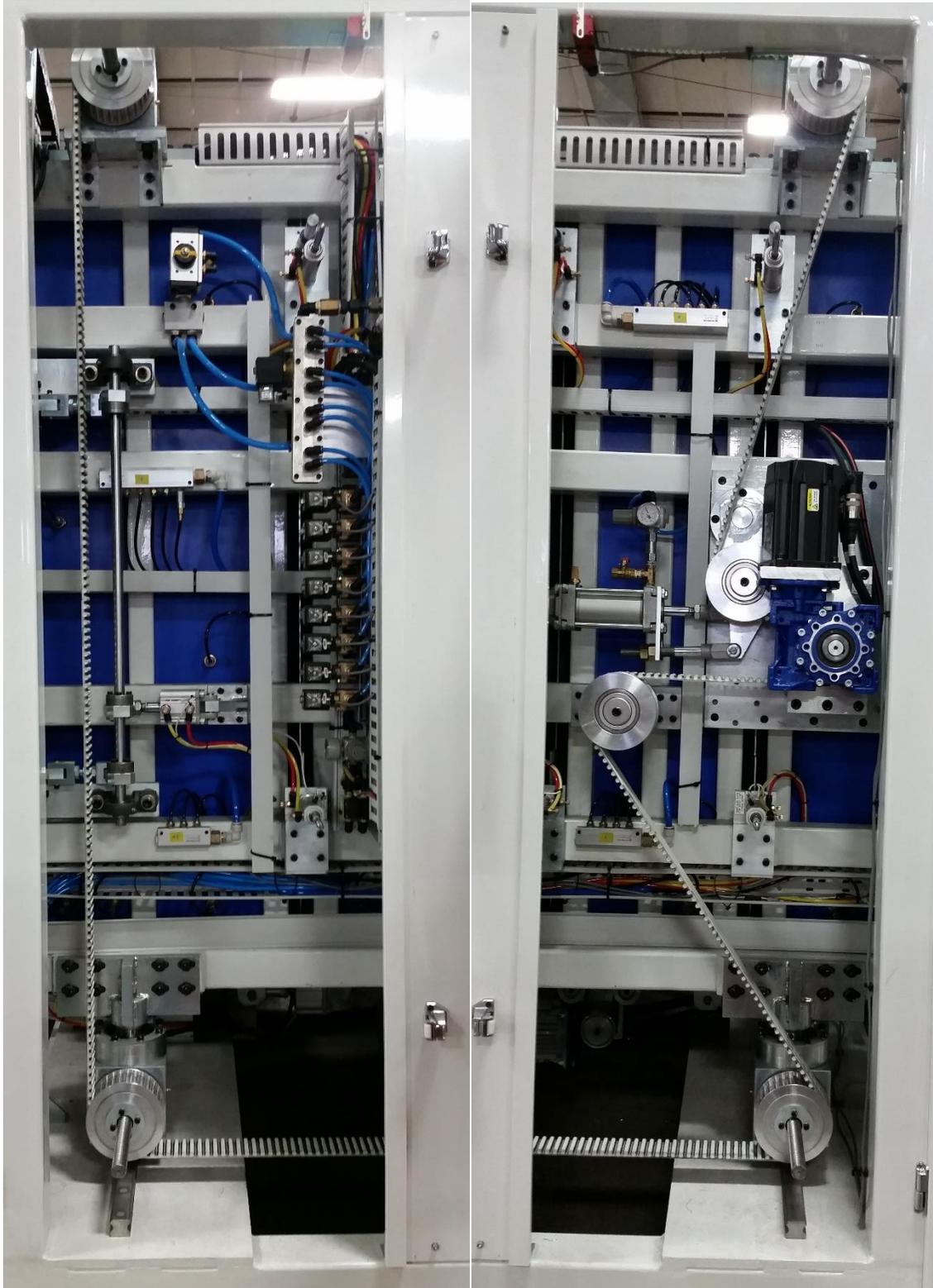


GAS PRESS

MAINTENANCE INSTRUCTIONS







1. Gear Box

- a. Location: Front and back press, press drive, conveyor drive, gas nozzle drive
- b. Motovario gearboxes are lubricated for life, no additional maintenance required



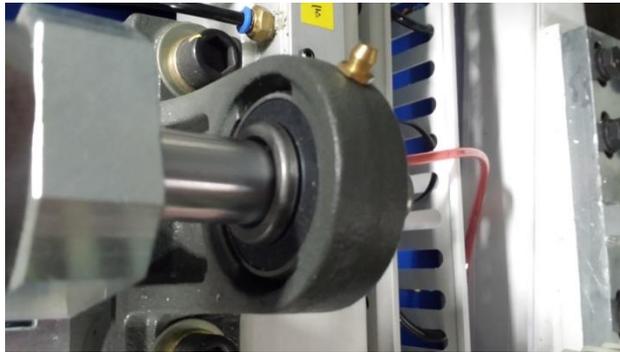
2. Bearing

- a. Location: Transfer belt pulleys, front and back press, Drive belt pulleys, front and back press
- b. Sealed and lubricated from the factory
- c. Inspect and replace as needed



3. Bearing

- a. Location: Top and bottom, front and back press
- b. Type: NLGI 2 EP Lithium
- c. Frequency: Grease every 219,000 units



4. Dodge bearings

- a. Location: Front and back press, gas nozzle control
- b. Type: NLGI 2 EP Lithium
- c. Frequency: Grease every 219,000 units



5. Air cylinder

- a. Location: Front and back press, suction cup control, tensioner, chamber door control, transfer wheel, conveyor raise and lower
- b. Wipe any contaminants such as dust or silicone from rod surface



6. THK bearings

- a. Location: Bottom
- b. Pay special attention to Blocks and Rails
- c. Wipe any contaminants such as dust or silicone from rail surfaces daily at minimum, between shifts is preferred
- d. Type: NLGI 2 EP Lithium
- e. Frequency: Grease every 20,000 units



7. Linear bearing, round shaft

- a. Location: Gas nozzle shift
- b. Wipe any contaminants such as dust or silicone from rail surfaces daily at minimum, between shifts is preferred
- c. No Lubrication required, replace as needed



8. Suction cups

- a. Location: Front and back press
- b. Clean with lukewarm water. A mild soap may be used, dry with a soft cloth.
- c. Replace when damaged



9. Conveyor Belt

- a. Location: Front and back shuttle
- b. Use a soft bristle brush to clean off belting.
- c. Check for dust, silicone build up. Check for tension, wear, abrasions. Replace per manufacturer's instructions and recommendations



10. Timing belt

- a. Location: Front and back press
- b. Clean with lukewarm water. A mild soap may be used, dry with a soft cloth.
- c. Check for dust, silicone build up. Check for tension, wear, abrasions. Replace per manufacturer's instructions and recommendations



11. Air filter

- a. Location: Back, back press blower motor, Top, front press blower motor
- b. Type: F885SP PAPER FILTER
- a. Frequency: Replace as needed