

HYPET® 5E / HPP5E MAINTENANCE

The following items require periodic maintenance. Maintenance must be performed at the operating hours or cycles, whichever comes first. The procedures are repeated at multiples of the interval, for example every 160 hours or every 125,000 cycles. Calendar time is based on 24/7 machine operation and intended as reference only. Please refer to your Machine Manual, as well as Safety and Service Bulletins, for specific details, potential changes and safety information, or contact Husky Parts and Service.

PROCEDURE	INTERVAL BETWEEN MAINTENANCE ⁽¹⁾	ADVANTAGE+ELITE™	OEM PARTS
PROGRAM A	160 OPERATING HOURS 125,000 CYCLES	INCLUDED IN PRO-ACT	MACHINE PREVENTATIVE MAINTENANCE KITS
1 Inspect the hydraulic tank desiccant breather cartridge		✓	
2 Check the conveyor belt operation		✓	
3 Empty the process material bins		○	
PROGRAM B	320 OPERATING HOURS 250,000 CYCLES		
4 Drain water in the air regulator		○	
PROGRAM C	2,500 OPERATING HOURS 500,000 CYCLES		
5 Check the oil level in the hydraulic tank		✓	
6 Check the quality of the hydraulic oil		●	
7 Inspect and clean the hopper		○	
8 Inspect and clean the magnet drawer		○	
9 Inspect the conveyor belt and drive chain		✓	
10 Clean the machine exterior and HMI		○	
11 Clean the machine interior and HMI		○	
12 Clean the nozzle tip, stationary platen and purge guard		○	
13 Check the hydraulic system pressure		✓	
14 Check the automatic dump valve		✓	
15 Check the CEN Valve		✓	
16 Check the alignment of the purge guard switch and the switch actuator		✓	
17 Inspect all cooling water components		✓	
18 Inspect all electrical components		✓	
19 Inspect all hydraulic cylinders, valves and manifolds		✓	
20 Inspect all hydraulic hoses		✓	
21 Inspect all pneumatic hoses		✓	
22 Inspect the electric clamp lock piston oil reservoir level		✓	
23 Inspect the vacuum pump inlet air filter		✓	
24 Inspect the hydraulic clamp lock grease tubes		✓	
25 Lubricate the mold stroke column guide bushings		○	Grease Kit
PROGRAM D	2,500 OPERATING HOURS 1,000,000 CYCLES		
26 Inspect the Z-axis linear bearings		✓	
27 Lubricate the Z-axis linear bearings		○	Grease Kit
PROGRAM E	2,500 OPERATING HOURS 1,500,000 CYCLES		
28 Check the drive housing oil level		✓	
29 Check the bladder accumulator precharge pressure		✓	
30 Check the gearbox oil level		✓	
31 Inspect gearbox oil color in sight glass		○	
32 Check the vacuum pump oil level		✓	
33 Inspect the electric pump motor		✓	
34 Inspect the mold stroke column guide bushings		✓	
35 Inspect the vacuum silencer(s)		✓	
36 Inspect the Z-axis drive belt		✓	
37 Inspecting the direct shutoff system		✓	
38 Lubricate the injection unit (extruder linear bearings)		○	Grease Kit
39 Inspect the Y-axis bushings and rod eye		✓	
40 Lubricate the Y-axis bushings and rod eye		○	Grease Kit
41 Replace the coalescing filter and silencer on the oil recovery unit		○	Consumables Kit
PROGRAM F	2,500 OPERATING HOURS 2,000,000 CYCLES		
42 Lubricate the moving platen linear bearings		○	Grease Kit
43 Lubricate the mold positioning device lifting wedge		○	Grease Kit
PROGRAM G	5,000 OPERATING HOURS 4,000,000 CYCLES		
44 Adjust the conveyor drive chain tension		○	
45 Check the piston accumulator precharge pressure		✓	
46 Check the quality of the hydraulic oil ⁽²⁾		●	
47 Inspect the carriage cylinder bushings and pins		✓	
48 Replace the vacuum silencer(s)		○	Consumables Kit
49 Replace the pressure filter element		○	Consumables Kit
50 Replace the hydraulic clamp lock auto-lube cartridges ⁽³⁾		○	Consumables Kit
PROGRAM H	7,500 OPERATING HOURS 6,000,000 CYCLES		
51 Level the machine and adjust nozzle concentricity		✓	
52 Lubricate the electric pump motor bearings ⁽⁴⁾		○	Grease Kit
53 Replace the air regulator filter elements		○	Consumables Kit
54 Replace the electric clamp lock piston oil ⁽⁴⁾		○	Consumables Kit
55 Replace the hydraulic tank breather cap		○	Consumables Kit
56 Replace the injection housing and gearbox breather cap		○	Consumables Kit
57 Replace the transfer cylinders breather cap		○	Consumables Kit
58 Replace the oil retrieval filter element		○	Consumables Kit
59 Replace the vacuum pump inlet air filter		○	Consumables Kit
60 Replace the vacuum pump oil ⁽⁴⁾		○	Consumables Kit
61 Replace the gearbox oil (mineral oil only) ⁽⁷⁾		○	Grease Kit
62 Torque the DC bus bar screws		✓	
63 Drain water from the air storage tank(s)		○	
PROGRAM I	8,000 OPERATING HOURS 6,500,000 CYCLES		
64 In the absence of regular quarterly oil analysis, it is recommended to replace oil every 8,000 hours		○	
PROGRAM J	12,500 OPERATING HOURS 10,000,000 CYCLES		
65 Clean the vacuum pump ⁽⁸⁾		○	
PROGRAM K	15,000 OPERATING HOURS 12,000,000 CYCLES		
66 Replace the drive housing oil		○	Grease Kit
PROGRAM L	24,000 OPERATING HOURS 19,000,000 CYCLES		
67 It is recommended to replace the hydraulic oil every 24,000 hours of operation, with a complete reservoir cleaning		○	
PROGRAM M	25,000 OPERATING HOURS 19,000,000 CYCLES		
68 Replace the hydraulic hoses		○	Hydraulic Hose Kit
69 Replace the pneumatic hoses		○	
PROGRAM N	32,500 OPERATING HOURS 24,000,000 CYCLES		
70 Replace the Uninterruptable Power Supply (UPS) Battery		○	

LEGEND: Advantage+Elite

- Included in the Pro-Act standard visit
- (Optional) - Can be purchased and included in the Pro-Act standard visit.
- (Husky Observations) - Not included in the Pro-Act visit. Husky service technician to provide feedback during the Pro-Act standard visit.

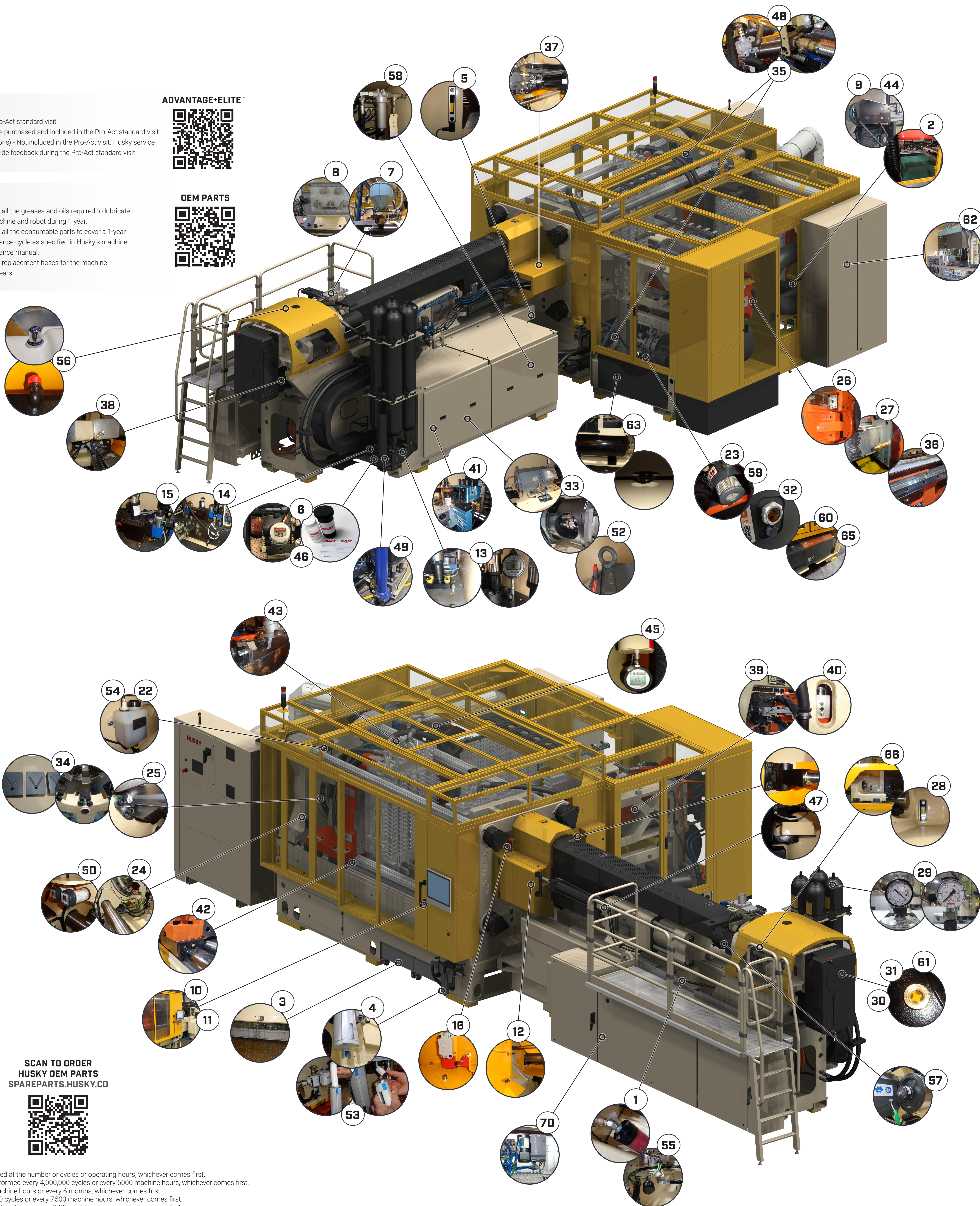
LEGEND: OEM Parts

- Grease Kit - includes all the greases and oils required to lubricate your machine and robot during 1 year.
- Consumables Kit - includes all the consumable parts to cover a 1-year maintenance cycle as specified in Husky's machine maintenance manual.
- Hydraulic Hose Kit - includes replacement hoses for the machine after 3 years.

ADVANTAGE+ELITE™



OEM PARTS



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- ⁽¹⁾ Maintenance is performed at the number or cycles or operating hours, whichever comes first.
- ⁽²⁾ This check must be performed every 4,000,000 cycles or every 5,000 machine hours, whichever comes first.
- ⁽³⁾ Perform every 5,000 machine hours or every 5 months, whichever comes first.
- ⁽⁴⁾ Perform every 6,000,000 cycles or every 7,500 machine hours, whichever comes first.
- ⁽⁵⁾ Perform every 6,000,000 cycles or every 7,500 machine hours, whichever comes first.
- ⁽⁶⁾ Perform every 6,000,000 cycles or every 7,500 machine hours, whichever comes first.
- ⁽⁷⁾ Replace the gearbox oil every 6,000,000 cycles or every 7,500 machine hours, whichever comes first.
- ⁽⁸⁾ In extremely dusty conditions, the vacuum pump should be cleaned every six months.

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