

HyPET® 6E / HPP6e MAINTENANCE

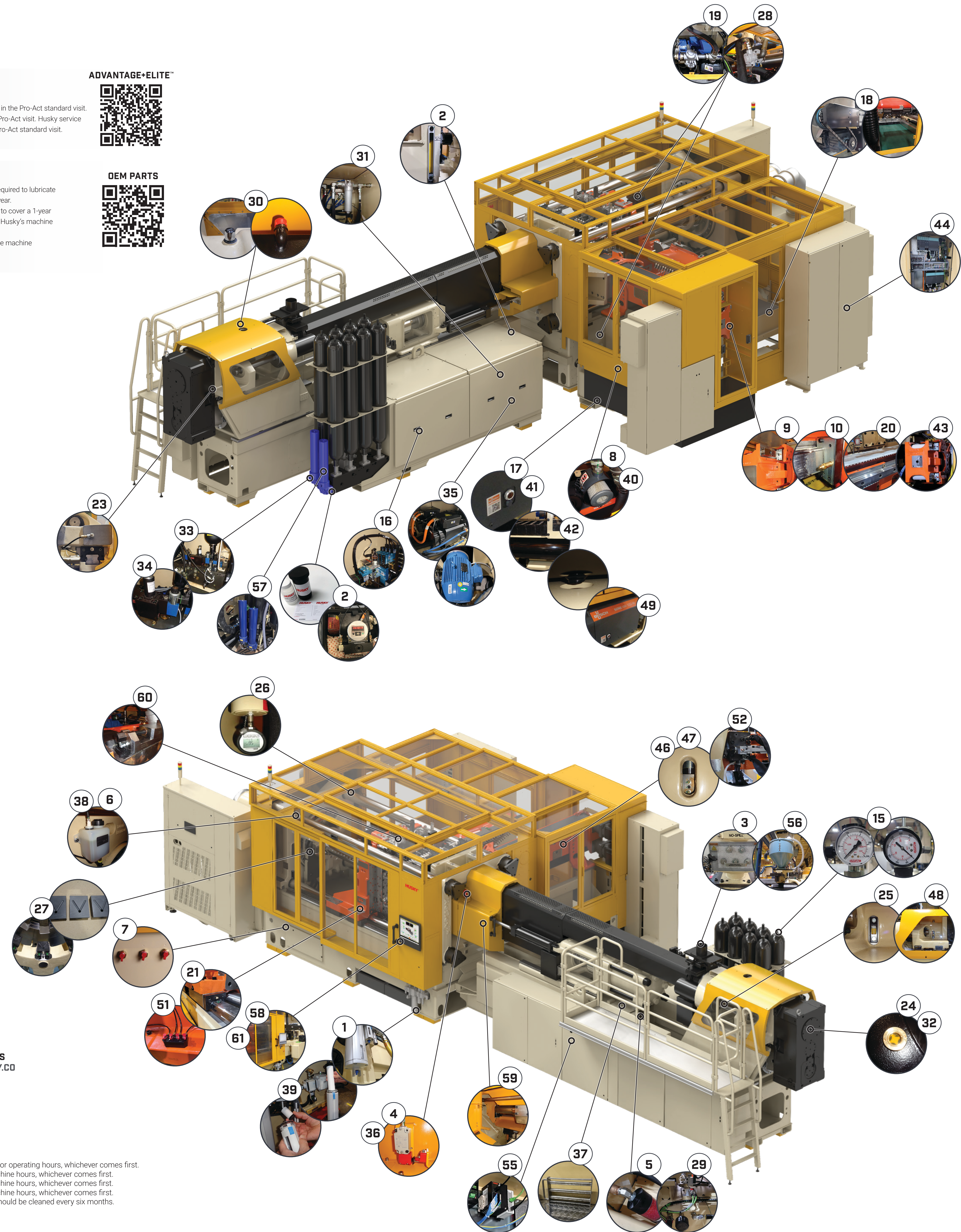
The following items require periodic maintenance. Maintenance must be performed at the operating hours or cycles, whichever comes first. The procedures are repeated at multiples of the interval, for example every 320 hours or every 250,000 cycles. Calendar time is based on 24/7 machine operation and 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™	DEM PARTS
PROGRAM A	320 OPERATING HOURS 250,000 CYCLES	INCLUDED IN PRO-ACT	MACHINE PREVENTATIVE MAINTENANCE KITS
1 Drain water in the air regulator		○	
PROGRAM B	2,700 OPERATING HOURS 500,000 CYCLES		
2 Check the quality of the hydraulic oil and oil level in the hydraulic tank		●	
3 Inspect and clean the magnet drawer		○	
4 Check the purge guard switch functionality		✓	
5 Inspect the hydraulic tank desiccant breather cartridge		✓	
6 Inspect the electric clamp lock piston oil reservoir level		✓	
7 Lubricate the mold stroke column guide bushings		○	Grease Kit
8 Inspect the vacuum pump inlet air filter		✓	
9 Inspect the Z-axis linear bearings		✓	Grease Kit
10 Lubricate the Z-axis linear bearings		○	Grease Kit
11 Inspect all hydraulic cylinders, valves and manifolds		✓	
12 Inspect all hydraulic hoses		✓	
13 Inspect all pneumatic hoses		✓	
14 Inspect all cooling water components		✓	
PROGRAM C	2,700 OPERATING HOURS 1,500,000 CYCLES		
15 Check and Adjust the Bladder Accumulator Precharge Pressure		✓	
16 Replace the coalescing filter and silencer on the oil recovery unit		○	Consumables Kit
17 Check the vacuum pump oil level		✓	
18 Inspect the conveyor belt and drive chain and adjust the drive chain tension		○	
19 Inspect the vacuum silencer(s)		✓	
20 Inspect the Z-axis drive belt		✓	
PROGRAM D	2,700 OPERATING HOURS 2,000,000 CYCLES		
21 Lubricate the moving platen linear bearings		○	Grease Kit
22 Inspect all electrical components		✓	
PROGRAM E	5,400 OPERATING HOURS 4,000,000 CYCLES		
23 Lubricate the injection unit (extruder linear bearings)		○	Grease Kit
24 Check the gearbox oil level, oil color and leakage rate		○	
25 Check the drive housing oil level		✓	
26 Check and Adjust the Piston Accumulator Precharge Pressure		✓	
27 Inspect the mold stroke column guide bushings		✓	
28 Replace the vacuum silencer(s)		○	Consumables Kit
PROGRAM F	8,100 OPERATING HOURS 6,000,000 CYCLES		
29 Replace the hydraulic tank breather cap		○	Consumables Kit
30 Replace the injection housing and gearbox breather cap		○	Consumables Kit
31 Replace the oil retrieval filter element		○	Consumables Kit
32 Replace the gearbox oil (mineral oil only) ⁽²⁾		○	Grease Kit
33 Check the automatic dump valve		✓	
34 Check the CEN Valve		✓	
35 Inspect the electric pump motor		✓	
36 Check the alignment of the purge guard switch and the switch actuator		✓	
37 In the absence of regular quarterly oil analysis, replace hydraulic oil every 8,100 hours and clean tank magnet		○	
38 Replace the electric clamp lock piston oil ⁽³⁾		○	Consumables Kit
39 Replace the air regulator filter elements		○	Consumables Kit
40 Replace the vacuum pump inlet air filter		○	Consumables Kit
41 Replace the vacuum pump oil ⁽⁴⁾		○	Consumables Kit
42 Drain water from the air storage tank(s)		○	
43 Inspect the robot cable track		✓	
44 Torque the DC bus bar screws		✓	
45 Level the machine and adjust nozzle concentricity		✓	
PROGRAM G	10,800 OPERATING HOURS 10,000,000 CYCLES		
46 Lubricate the rod eye		○	Grease Kit
47 Lubricate the Y-axis bushings		○	Grease Kit
PROGRAM H	13,500 OPERATING HOURS 12,000,000 CYCLES		
48 Replace the drive housing oil		○	Grease Kit
49 Clean the vacuum pump ⁽⁵⁾		○	
PROGRAM I	24,300 OPERATING HOURS 18,000,000 CYCLES		
50 Replace the hydraulic oil every 24,300 hours of operation, with a complete reservoir cleaning		○	
51 Inspect all grease tubes		✓	
52 Inspect the Y-axis bushings and rod eye		✓	
53 Replace the hydraulic hoses		○	Hydraulic Hose Kit
54 Replace the pneumatic hoses		○	
PROGRAM J	32,400 OPERATING HOURS 24,000,000 CYCLES		
55 Replace the Uninterruptable Power Supply (UPS) Battery		○	
PROGRAM K	WHEN APPLICABLE		
56 Inspect and clean the hopper	Resin Change	○	
57 Replace the Pressure Filter Element	At alarm	○	Consumables Kit
58 Clean the machine interior and HMI	At maintenance stop, as needed	○	
59 Clean the nozzle tip, stationary platen and purge guard	Purge of Injection	○	
60 Lubricate the mold positioning device lifting wedge	Mold Change	○	Grease Kit
61 Clean the machine exterior and HMI	At maintenance stop, as needed	○	

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.



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⁽¹⁾ Maintenance is performed at the number or cycles or operating hours, whichever comes first.
⁽²⁾ Perform every 6,000,000 cycles or every 8,100 machine hours, whichever comes first.
⁽³⁾ Perform every 6,000,000 cycles or every 8,100 machine hours, whichever comes first.
⁽⁴⁾ Perform every 6,000,000 cycles or every 8,100 machine hours, whichever comes first.
⁽⁵⁾ In extremely dusty conditions, the vacuum pump should be cleaned every six months.

Americas - English: Toll-Free: +1 (800) 465 4875
 Tel: +1 (437) 781 8572
 Americas - Portuguese: Toll-Free: 0800 891 3817
 Tel: 55 11 3181 0607
 Americas - Spanish: Tel: 52 55 9085 3008

Europe: Toll-Free: 008000800 4300
 Tel: 352 2786 7967
 Russia: Tel: 7 495 232 9450

India: Tel: +(91) 44 2747 6426
 China: Toll-Free: 1 (400) 021 0557
 Tel: 86 21 6146 9058
 Japan: Toll-Free: 01 2098 8896
 Tel: 03 6316 2444

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