

GUNNAR F1 Maintenance & Service

No matter what machine you own, all machines require regular service, and there is never a "convenient time" for your machines to break down.

Regular maintenance and service of your GUNNAR F1 will contribute towards the long-term, stable performance of your machine.

You can help protect your investment and your asset by performing a few simple, regular tasks to help keep you machine performing properly.

It is important to make sure that you check the following points in the described period:

The **weekly** service can be performed by operators & users.

The **monthly** service can be performed by a trained user or a technician.

The **yearly** or 25'000 – 50'000 cut service is designed to be performed by an authorized GUNNAR technician.

Location	Description	Week	Month	Year
Controller	Check the ventilator fan is working.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Cutting table	General cleaning of the machine (<i>see user manual</i>)	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Cutting table	Clean the roller bearing guide rails in X and Y direction.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Cutting table	Check the regulator air supply pressure. Drain water if there is a filter attached to machine's airline.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Cutting table	Check the condition of the protection plate covering the cutting table.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Cutting table	Check the condition of the slipmat covering the cutting table & protection plate.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Cutting Table	Clean underneath the X & Y clamping arms.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Cutting table	Check (listen) for air leaks in the clamps.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Miscellaneous	Check stock of blades, blade holders, clamping tubes & any other required parts.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Cutting table	Check (listen) for air leaks in the pneumatic system.		<input type="checkbox"/>	<input type="checkbox"/>
Cutting table	Check the squareness of the Y-arm to the Y-clamp.		<input type="checkbox"/>	<input type="checkbox"/>
Cutting table	Check the condition & tension of all three tooth belts.		<input type="checkbox"/>	<input type="checkbox"/>
Cutting table	Check screws are tight. (e.g. Controller and Y-arm sensors).		<input type="checkbox"/>	<input type="checkbox"/>
Cutting table	Check the rubber bumper at the DBD pin.		<input type="checkbox"/>	<input type="checkbox"/>
Cutting table	Check the cable chain for open links.		<input type="checkbox"/>	<input type="checkbox"/>
Miscellaneous	Check & calibrate blade depths of blade holders (<i>cut through 3 sheets of paper, and not the 4th</i>)		<input type="checkbox"/>	<input type="checkbox"/>
Miscellaneous	Check condition of blade holders, and replace if required.		<input type="checkbox"/>	<input type="checkbox"/>
Z-Head	Check the distance from the Z sensor to the white gear. 0.7mm ±0.3mm.			<input type="checkbox"/>
Software	Take a complete backup of the system, & important saved files. (<i>Backup and maintenance of the PC and operating system is entirely customer's responsibility</i>)		<input type="checkbox"/>	<input type="checkbox"/>
Software	Take a backup copy of the configuration files – use the "save info and ini" function in the "Help→About" dialogue.		<input type="checkbox"/>	<input type="checkbox"/>
Software	Update the software to the latest version available, operating system (& customer) permitting.		<input type="checkbox"/>	<input type="checkbox"/>
Software	Check opening size correction, and margin corrections (start correction X & Y) in "Setting→Software Settings" dialogue.		<input type="checkbox"/>	<input type="checkbox"/>
Software	Check & calibrate overcuts & hooks (straight correction) for: <ul style="list-style-type: none"> - Back Cut - Front Cut - Reverse Bevel - V-Groove 		<input type="checkbox"/>	<input type="checkbox"/>
Software	Defrag system hard drive.		<input type="checkbox"/>	
Blade head	Clean the blade head and apply lubricant to brass sliding block if required.			<input type="checkbox"/>
Blade head	Check condition of return spring.			<input type="checkbox"/>
Blade head	Measure the height of the lower part of the nylon guide block. If it is below 4.4mm it needs replacement. <i>Note - replacement will require re-calibration of blade holder depths.</i>			<input type="checkbox"/>
Blade head	Check the condition of the finger screw.			<input type="checkbox"/>
Controller	Open the controller box lid and carefully blow out any dust.			<input type="checkbox"/>

Cutting table	Check for deep scratches in the cutting table and smooth them out if required.	<input type="checkbox"/>
Cutting table	Check roller bearing tension in both X & Y axis.	<input type="checkbox"/>
Z-Head	Check the cable and pneumatic hose connections on the Z-Head.	<input type="checkbox"/>
Z-Head	Check for any play or backlash between the drive gears, and check that any grub screws are secure.	<input type="checkbox"/>
Z-Head	Clean & slightly lubricate the main shaft.	<input type="checkbox"/>
Z-Head	Check throttle valve settings for circle start/stop mark.	<input type="checkbox"/>

Accomplished by _____ Date _____ Total Cuts _____ Software Version _____