

# GUNNAR RAPIDO 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 Rapido 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.

Because the GUNNAR Rapido has now become superseded, as time goes on it will become more difficult and more expensive to service and replace parts on this machine, especially the electronic controller boxes which are expensive to replace. For this reason, we **strongly** recommend Rapido owners take the following steps to look after their machines as suggested below:

- **Make sure your Rapido is operated in a cool, clean and preferably air-conditioned environment. Overheating of the controller can cause them to fail, and thus require an expensive replacement unit.**
- **Make sure your Rapido has a power flow stabilizing UPS (Uninterruptable Power Supply) & battery backup, to help protect the controller box from power fluctuations and blackouts.**

A replacement controller for a Rapido can be costly, so you may also wish to take these simple steps to ensure your GUNNAR Rapido is sufficiently protected, and also insured.

**HANDY TIP:** Controllers can be easily damaged when they are turned off, and turned back on again straight away. If ever you turn your controller off, even by accident, please make sure you leave it switched off for at least 30 seconds before switching it back on again.

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 fans are working & clean the fan filters	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Controller	Make sure the controller (and the machine!) is operated in a cool, clean & preferably air-conditioned environment.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Controller	Check the customer has a power flow stabilizing UPS & battery backup installed to protect the controller.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Cutting table	General cleaning of the machine.	<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 from filter.	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Cutting table	Check the condition of the slipmat covering the cutting table.	<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 the cable chain for open links		<input type="checkbox"/>	<input type="checkbox"/>
Cutting table	Check digitzer cable wire plugs (white plugs) are all firmly secured in X, Y and Z motors.		<input type="checkbox"/>	<input type="checkbox"/>
Miscellaneous	Check & calibrate blade depths of blade holders ( <i>cut through 3 sheets of paper, and not the 4<sup>th</sup></i> )		<input type="checkbox"/>	<input type="checkbox"/>
Miscellaneous	Check condition of blade holders, and replace if required.		<input type="checkbox"/>	<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		<input type="checkbox"/>	<input type="checkbox"/>

	(& customer) permitting.		<input type="checkbox"/>	<input type="checkbox"/>
Software	Check opening size correction, and margin corrections (start correction X & Y) in "Settings→ Software Settings" dialogue.		<input type="checkbox"/>	<input type="checkbox"/>
Software	Check & calibrate overcuts & hooks (straight correction) for:		<input type="checkbox"/>	<input type="checkbox"/>
	- Back Cut			
	- Front Cut			
	- Reverse Bevel			
	- V-Groove			
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"/>
Cutting table	Slightly lubricate the belt tension pulleys to avoid corrosion.			<input type="checkbox"/>
Cutting table	Check length of blade head initialization pin on Y-Arm.			<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	Dismantle, check & clean the throttle valve for the Z-Head. Replace internal spring if required.			<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 \_\_\_\_\_