



C-Frame Press
6 Month and Annual Plan
Maintenance and Service Provision and Plan

Schedule

6 Months	First 6 Months Service & Maintenance Check
Year 1	Annual Service and Maintenance
Year 2	Annual Service and Maintenance
Year 3	Annual Service and Maintenance
Year 4	Annual Service and Maintenance
Year 5	Annual Service and Maintenance

NOTE to Terms and Conditions:

Service and Maintenance Packages come in 3-Year or 5-Year terms. This document outlines the 6 Month and Annual Service and Maintenance in detail. The annual service process will occur on or around the anniversary of purchase of the machine by the customer, and within reasonable proximity of the anniversary date each year. This service plan does not include emergency call outs or services.

A 2-year warranty exists from initial invoice date and covers workmanship and faulty components, but repair items and spares may be billable and the situation is evaluated on a case-by-case basis. Excessive use, wear and misuse precludes the warranty terms and conditions. Warranty issues are evaluated and carried out on case-by-case basis and the warranty is detailed in a separate document.

Hydraulic Oil is not included in the price of the plan. The customer is welcome to source appropriate hydraulic oil, or **The Workshop Press Company** can source the oil and bill the customer by pro-forma invoice accordingly and prior to when the service and maintenance occurs.

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First 6 Months Service & Maintenance Check Details

- Clean the hydraulic tank filter with a soft brush.
 - IMPORTANT: Do not allow swarf and dirt to fall into oil reservoir.
- Check the hydraulic oil level with spyglass.
 - Check must be made with the piston in its upper position.
 - If low, top up reservoir with (recommended Shell Tellus 46, DIN 52524 Port 2 HLP, or similar)
 - Fill to the top mark. Oil level checks must be made with the piston in its upper position. Furthermore, please make sure that the photocells are clean and well aligned, with the cables in good condition, prepared to work properly.
- Check photocells alignment and cleanliness
 - The cables in good condition, prepared to work properly.
 - Clean the photocell surfaces with a clean and soft cloth to avoid scratching.
- Emergency Stop Check
 - Power up machine and activate each E-Stop
 - This will require 2 resets of the machine.
- Clean the press slide and bolster tables and apply machine grade oil to prevent rust when not in use.
- Clean the press surfaces and surrounding area.
- Clean HMI surface with a clean and soft cloth.
- Hydraulic Fittings Review.
 - Check for sprung and loose connections and tighten accordingly.
- Lower Table Stud Bolts check.
 - Retighten as needed.
- Cylinder Connection Bolt Check
 - Check bolts under the cylinder group and the motor fixing bolts
 - Retighten as needed.
- Cylinder Entry Gland Check
 - If the oil leaks on the cylinder entry gland, the gland needs to be removed and replaced.

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Annual Service and Maintenance Details

- Hydraulic Unit Reservoir oil change.
 - Empty the oil tank reservoir through the plug situated on the underside of the reservoir.
 - Refill the tank with hydraulic oil
 - Recommended: Shell Tellus 46, DIN 52524 Port 2 HLP, or similar.
- Clean the hydraulic tank filter with a soft brush.
 - IMPORTANT: Do not allow swarf and dirt to fall into oil reservoir.
- After Oil Change, check the hydraulic oil level with spyglass.
 - Check must be made with the piston in its upper position.
 - If low, top up reservoir
 - Recommended: Shell Tellus 46, DIN 52524 Port 2 HLP, or similar.
 - Fill to the top mark. Oil level checks must be made with the piston in its upper position. Furthermore, please make sure that the photocells are clean and well aligned, with the cables in good condition, prepared to work properly.
- Hydraulic Fittings Review.
 - Check for sprung and loose connections and tighten accordingly.
- Lower Table Stud Bolts check.
 - Retighten as needed.
- Cylinder Connection Bolt Check
 - Check bolts under the cylinder group and the motor fixing bolts
 - Retighten as needed.
- Cylinder Entry Gland Check
 - If the oil leaks on the cylinder entry gland, the gland needs to be removed and replaced.
- Hydraulic Fittings Review.
 - Check for sprung and loose connections and tighten accordingly.
- Lower Table Stud Bolts check.
 - Retighten as needed.
- Cylinder Connection Bolt Check
 - Check bolts under the cylinder group and the motor fixing bolts
 - Retighten as needed.
- Cylinder Entry Gland Check
 - If the oil leaks on the cylinder entry gland, the gland needs to be removed and replaced.
- Check photocells alignment and cleanliness
 - The cables in good condition, prepared to work properly.
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- Emergency Stop Check
 - Power up machine and activate each E-Stop
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- Clean the press surfaces and surrounding area.
- Clean HMI surface with a clean and soft cloth.