

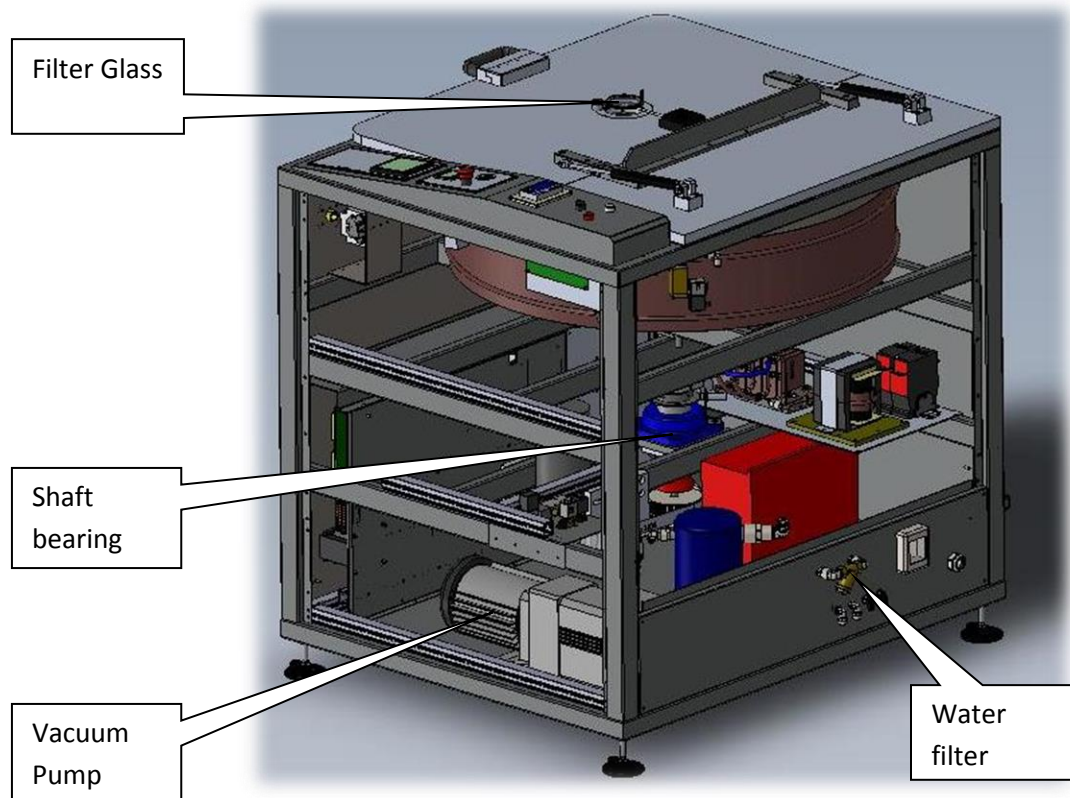
## ANNUAL MAINTENANCE LIST:

The steps below are recommended for performing at least once a year for a proper and reliable operation of the system. Only qualified technicians should be performing the maintenance.



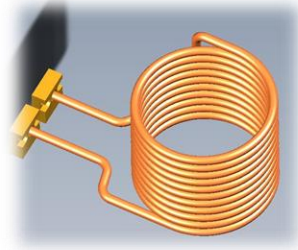
**WARNING:** ALWAYS ENSURE THAT THE CIRCUIT BREAKER IS TURNED OFF WHEN PERFORMING MAINTENANCE. REFER TO THE USER MANUAL FOR MORE SAFETY AND MAINTENANCE INFORMATION.

1. Clean the exterior of the machine from dust, dirt or residue. Use compressed air and wet cloth.
2. Thoroughly clean the inside of the casting chamber, removing molten metal residue or metal chips. (Fig.4)
3. Check cooling water quality.



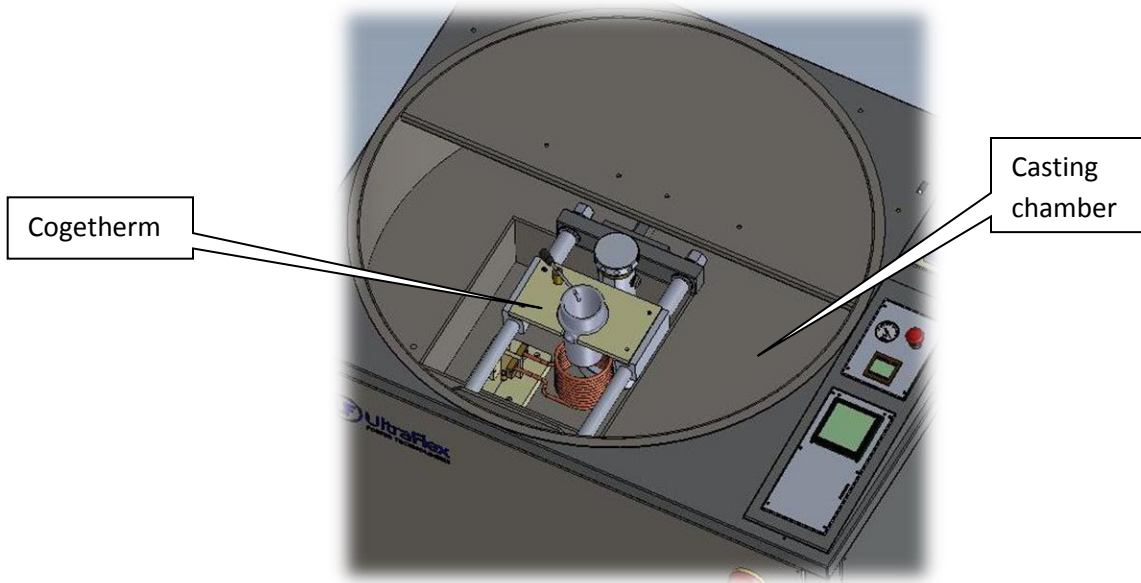
**Fig. 1** Filter Glass, Vacuum Pump, Shaft bearing and Water filter position

- a) Inspect all water hoses and connections for leaks.
  - b) Replace the water filter (*Fig. 1*)
4. Inspect induction coil – It is recommended the coil to be replaced, if the coil’s insulation sleeve is visibly damaged or worn out.



**Fig. 2** Coil

5. Inspect Cogetherm plate and Paper Protector below the Coil – if Cogetherm/Paper protector is burned out or damaged, replace it (*Fig.3*)
6. Replace the casting chamber’s gasket providing the vacuum seal. (*Fig.3*)
7. Open the front and side panels and inspect all wiring;
  - a) Visually inspect all electronic components, modules and wires for any burnt spots or damages
  - b) Check all wires and connectors for loose connections. Check if all screws are tightened.
  - c) Clean the PC Boards and electronic modules from accumulated dirt or dust by blowing compressed air.
8. Thoroughly clean the visor filter glass on the cover of the chamber(*Fig.1*):
  - a) All components may be cleaned with a standard, low-alkaline, non-abrasive detergent.
  - b) Routinely inspect surfaces for chips and scratches.
  - c) Certain oils may remove markings from glassware. Avoid getting oil on the outside of the filter holder.



**Fig. 3** Components position

9. Inspect vacuum pump (Fig.1)

- a) Check oil level and add oil if necessary (Fig.5)

*We recommend checking the oil level 15 to 20 minutes after shutting down so you can have all the oil in the oil pan to get an accurate measurement.*

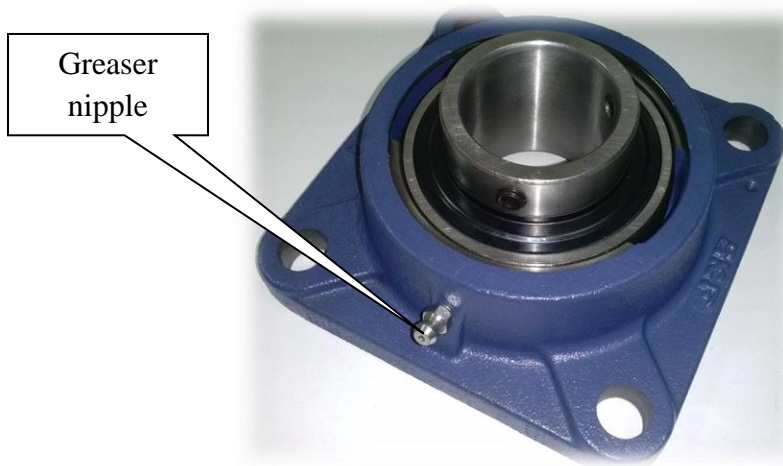


**Fig. 4** Oil level

- b) Inspect all vacuum connections for visible damages or lose connections.
- c) Replace the air filter for the vacuum pump

10. Grease the Shaft bearing (Fig.1)

Bearings should only be lubricated with a hand grease gun. When lubricating, purge the old grease from the bearing by gradually adding grease until a bead of new grease appears at the bearing seal. Only use one of the following greases, as they are compatible with the one installed at the factory – SKF-LGHP2™.



**Table1** Revision Table:

No	Ver.	Date	Create/Change by:
1	1.0	12.2016	M.Nikolova