



Haas Factory Outlet

A Division of Lance Company

Recommended Maintenance Schedule Pallet Changer

The following is a list of required regular maintenance for the HAAS Automatic Pallet Changer. These specifications, **especially the daily routine maintenance**, must be followed in order to keep your machine in good working order and to protect your warranty.

Damage or misalignment may result from neglect of daily maintenance.

Daily

- ∞ Clean chips, coolant, and other debris from the APC and receiver areas.
- ∞ Pay special attention to the receiver clamping bars, and the pallet clamping rails and wipers.
- ∞ Clean chips and coolant from receiver pallet clamped switch.
- ∞ Apply a light coat of grease and work the grease into the plunger. **Do not over grease.**
- ∞ Clean the two locating pins in the receiver base and the corresponding bushings in the pallets.
- ∞ Apply a very light coat of general purpose grease to the pins and bushings, if needed.
- ∞ Clean excessive chips and coolant from pallet drive chain.

Weekly

- ∞ Remove the two 1/4" screws from the control panel and rotate to open position.
- ∞ Clean chips and coolant from the drive sprocket and limit switch.
- ∞ Apply a light coat of general purpose grease and work the grease into the switch plungers.
- ∞ Check air gauge/regulator at the VMC lube/air panel for 85 psi.
- ∞ Check condition of wipers. There are two wipers on each pallet.

Monthly

- ∞ Check door for proper operation.
- ∞ Clean and grease door side guide rails as required.

Maintenance and Service Questions please call 215.245.5500 and ask for the Service Department