

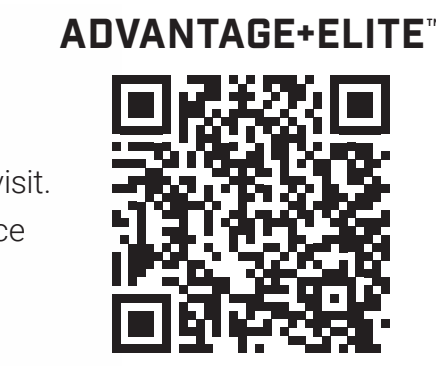
# HyPET<sup>®</sup> NX6 MAINTENANCE

The following items require periodic maintenance. Maintenance must be performed at the operating hours or cycles, whichever comes first. The procedures are repeated at multiples of the interval; for example every 320 hours or every 250,000 cycles. Calendar time is based on 24/7 machine operation and intended as reference only. Please refer to your Machine Manual, as well as Safety and Service Bulletins, for specific details, potential changes and safety information, or contact Husky Parts and Service.

PROCEDURE	INTERVAL BETWEEN MAINTENANCE <sup>(1)</sup>	ADVANTAGE+ELITE <sup>™</sup>	OEM PARTS
<b>PROGRAM A</b>	<b>320 OPERATING HOURS   250,000 CYCLES</b>	<b>INCLUDED IN PRO-ACT</b>	<b>MACHINE PREVENTATIVE MAINTENANCE KITS</b>
1 Drain water in the air regulator		○	
<b>PROGRAM B</b>	<b>2,700 OPERATING HOURS   500,000 CYCLES</b>		
2 Check the quality of the hydraulic oil and oil level in the hydraulic tank		●	
3 Inspect and clean the magnet drawer		○	
4 Check the purge guard switch functionality		✓	
5 Inspect the hydraulic tank desiccant breather cartridge		✓	
6 Inspect the electric clamp lock piston oil reservoir level		✓	
7 Lubricate the mold stroke column guide bushings		○	Grease Kit
8 Inspect the vacuum pump inlet air filter		✓	
9 Inspect the Z-axis linear bearings		✓	Grease Kit
10 Lubricate the Z-axis linear bearings		○	Grease Kit
11 Inspect all hydraulic cylinders, valves and manifolds		✓	
12 Inspect all hydraulic hoses		✓	
13 Inspect all pneumatic hoses		✓	
14 Inspect all cooling water components		✓	
<b>PROGRAM C</b>	<b>2,700 OPERATING HOURS   1,500,000 CYCLES</b>		
15 Check and Adjust the Bladder Accumulator Precharge Pressure		✓	
16 Replace the coalescing filter and silencer on the oil recovery unit		○	Consumables Kit
17 Check the vacuum pump oil level		✓	
18 Inspect the conveyor belt and drive chain and adjust the drive chain tension		○	
19 Inspect the vacuum silencer(s)		✓	
20 Inspect the Z-axis drive belt		✓	
<b>PROGRAM D</b>	<b>2,700 OPERATING HOURS   2,000,000 CYCLES</b>		
21 Lubricate the moving platen linear bearings		○	Grease Kit
22 Inspect all electrical components		✓	
<b>PROGRAM E</b>	<b>5,400 OPERATING HOURS   4,000,000 CYCLES</b>		
23 Lubricate the injection unit (extruder linear bearings)		○	Grease Kit
24 Check the gearbox oil level, oil color and leakage rate		○	
25 Check the drive housing oil level		✓	
26 Check and Adjust the Piston Accumulator Precharge Pressure		✓	
27 Inspect the mold stroke column guide bushings		✓	
28 Replace the vacuum silencer(s)		○	Consumables Kit
<b>PROGRAM F</b>	<b>8,100 OPERATING HOURS   6,000,000 CYCLES</b>		
29 Replace the hydraulic tank breather cap		○	Consumables Kit
30 Replace the injection housing and gearbox breather cap		○	Consumables Kit
31 Replace the oil retrieval filter element		○	Consumables Kit
32 Replace the gearbox oil (mineral oil only) <sup>(2)</sup>		○	Grease Kit
33 Check the automatic dump valve		✓	
34 Check the CEN Valve		✓	
35 Inspect the electric pump motor		✓	
36 Check the alignment of the purge guard switch and the switch actuator		✓	
37 In the absence of regular quarterly oil analysis, replace hydraulic oil every 8,100 hours		○	
38 Replace the electric clamp lock piston oil <sup>(3)</sup>		○	Consumables Kit
39 Replace the air regulator filter elements		○	Consumables Kit
40 Replace the vacuum pump inlet air filter		○	Consumables Kit
41 Replace the vacuum pump oil <sup>(4)</sup>		○	Consumables Kit
42 Drain water from the air storage tank(s)		○	
43 Torque the DC bus bar screws		✓	
44 Level the machine and adjust nozzle concentricity		✓	
45 Inspect robot cable track		✓	
<b>PROGRAM H</b>	<b>13,500 OPERATING HOURS   12,000,000 CYCLES</b>		
46 Replace the drive housing oil		○	Grease Kit
47 Clean the vacuum pump <sup>(5)</sup>		○	
<b>PROGRAM I</b>	<b>24,300 OPERATING HOURS   18,000,000 CYCLES</b>		
48 Replace the hydraulic oil every 24,300 hours of operation, with a complete reservoir cleaning		○	
49 Replace the hydraulic hoses		○	Hydraulic Hose Kit
50 Replace the pneumatic hoses		○	
<b>PROGRAM J</b>	<b>32,400 OPERATING HOURS   24,000,000 CYCLES</b>		
51 Replace the Uninterruptable Power Supply (UPS) Battery		○	
<b>PROGRAM K</b>	<b>WHEN APPLICABLE</b>		
52 Inspect and clean the hopper	Resin Change	○	
53 Replace the Pressure Filter Element	At alarm	○	Consumables Kit
54 Clean the machine interior and HMI	At maintenance stop, as needed	○	
55 Clean the nozzle tip, stationary platen and purge guard	Purge of Injection	○	
56 Lubricate the mold positioning device lifting wedge (if equipped)	Mold Change	○	Grease Kit
57 Clean the machine exterior, HMI and drool port area on the shooting pot	At maintenance stop, as needed	○	

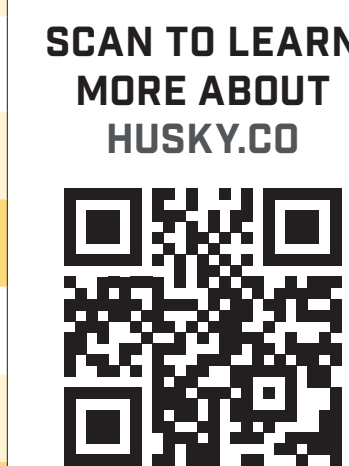
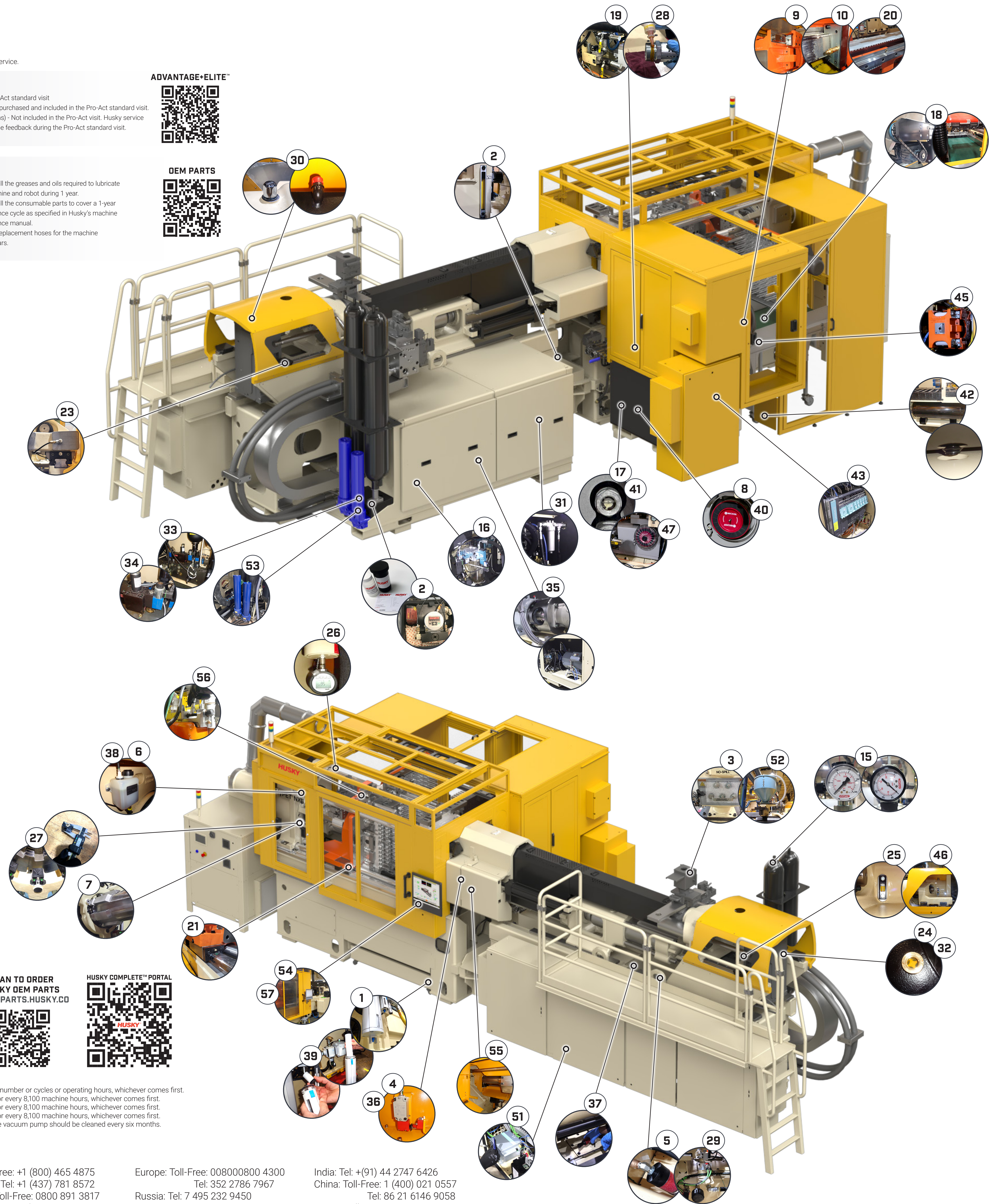
**LEGEND: Advantage+Elite**

- Included in the Pro-Act standard visit
- (Optional) - Can be purchased and included in the Pro-Act standard visit.
- (Husky Observations) - Not included in the Pro-Act visit. Husky service technician to provide feedback during the Pro-Act standard visit.



**LEGEND: OEM Parts**

- Grease Kit - Includes all the greases and oils required to lubricate your machine and robot during 1 year.
- Consumables Kit - Includes all the consumable parts to cover a 1-year maintenance cycle as specified in Husky's machine maintenance manual.
- Hydraulic Hose Kit - Includes replacement hoses for the machine after 3 years.



<sup>(1)</sup> Maintenance is performed at the number or cycles or operating hours, whichever comes first.  
<sup>(2)</sup> Perform every 6,000,000 cycles or every 8,100 machine hours, whichever comes first.  
<sup>(3)</sup> Perform every 6,000,000 cycles or every 8,100 machine hours, whichever comes first.  
<sup>(4)</sup> Perform every 6,000,000 cycles or every 8,100 machine hours, whichever comes first.  
<sup>(5)</sup> In extremely dusty conditions, the vacuum pump should be cleaned every six months.

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