

# HYPET® 5E / HPP5E MAINTENANCE

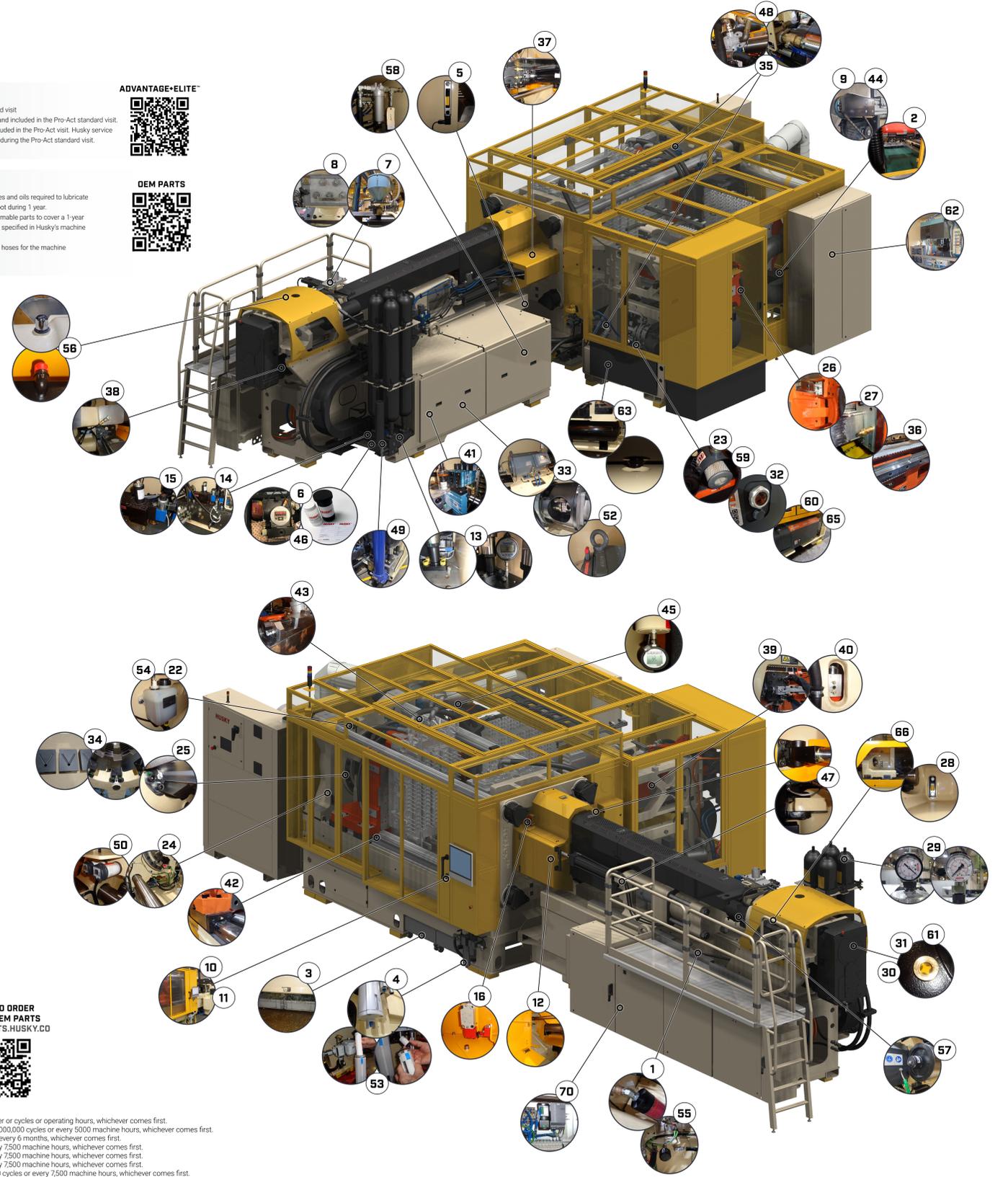
The following items require periodic maintenance. Maintenance must be performed at the operating hours or cycles, whichever comes first. The procedures are repeated at multiples of the interval, for example every 160 hours or every 125,000 cycles. Calendar time is based on 24/7 machine operation and 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>	DEM PARTS	MACHINE PREVENTATIVE MAINTENANCE KITS	DATE SCHEDULED	DATE COMPLETED	OPERATOR NOTES	CHECK
<b>PROGRAM A 160 OPERATING HOURS   125,000 CYCLES</b>								
1	Inspect the hydraulic tank desiccant breather cartridge	✓						
2	Check the conveyor belt operation	✓						
3	Empty the process material bins	○						
<b>PROGRAM B 320 OPERATING HOURS   250,000 CYCLES</b>								
4	Drain water in the air regulator	○						
<b>PROGRAM C 2,500 OPERATING HOURS   500,000 CYCLES</b>								
5	Check the oil level in the hydraulic tank	✓						
6	Check the quality of the hydraulic oil <sup>(2)</sup>	●						
7	Inspect and clean the hopper	○						
8	Inspect and clean the magnet drawer	○						
9	Inspect the conveyor belt and drive chain	✓						
10	Clean the machine exterior and HMI	○						
11	Clean the machine interior and HMI	○						
12	Clean the nozzle tip, stationary platen and purge guard	○						
13	Check the hydraulic system pressure	✓						
14	Check the automatic dump valve	✓						
15	Check the CEN Valve	✓						
16	Check the alignment of the purge guard switch and the switch actuator	✓						
17	Inspect all cooling water components	✓						
18	Inspect all electrical components	✓						
19	Inspect all hydraulic cylinders, valves and manifolds	✓						
20	Inspect all hydraulic hoses	✓						
21	Inspect all pneumatic hoses	✓						
22	Inspect the electric clamp lock piston oil reservoir level	✓						
23	Inspect the vacuum pump inlet air filter	✓						
24	Inspect the hydraulic clamp lock grease tubes	✓						
25	Lubricate the mold stroke column guide bushings	○		Grease Kit				
<b>PROGRAM D 2,500 OPERATING HOURS   1,000,000 CYCLES</b>								
26	Inspect the Z-axis linear bearings	✓						
27	Lubricate the Z-axis linear bearings	○		Grease Kit				
<b>PROGRAM E 2,500 OPERATING HOURS   1,500,000 CYCLES</b>								
28	Check the drive housing oil level	✓						
29	Check the bladder accumulator precharge pressure	✓						
30	Check the gearbox oil level	✓						
31	Inspect gearbox oil color in sight glass	○						
32	Check the vacuum pump oil level	✓						
33	Inspect the electric pump motor	✓						
34	Inspect the mold stroke column guide bushings	✓						
35	Inspect the vacuum silencer(s)	✓						
36	Inspect the Z-axis drive belt	✓						
37	Inspecting the direct shutoff system	✓						
38	Lubricate the injection unit (extruder linear bearings)	○		Grease Kit				
39	Inspect the Y-axis bushings and rod eye	✓						
40	Lubricate the Y-axis bushings and rod eye	○		Grease Kit				
41	Replace the coalescing filter and silencer on the oil recovery unit	○		Consumables Kit				
<b>PROGRAM F 2,500 OPERATING HOURS   2,000,000 CYCLES</b>								
42	Lubricate the moving platen linear bearings	○		Grease Kit				
43	Lubricate the mold positioning device lifting wedge	○		Grease Kit				
<b>PROGRAM G 5,000 OPERATING HOURS   4,000,000 CYCLES</b>								
44	Adjust the conveyor drive chain tension	○						
45	Check the piston accumulator precharge pressure	✓						
46	Check the quality of the hydraulic oil <sup>(2)</sup>	●						
47	Inspect the carriage cylinder bushings and pins	✓						
48	Replace the vacuum silencer(s)	○		Consumables Kit				
49	Replace the pressure filter element	○		Consumables Kit				
50	Replace the hydraulic clamp lock auto-lube cartridges <sup>(3)</sup>	○		Consumables Kit				
<b>PROGRAM H 7,500 OPERATING HOURS   6,000,000 CYCLES</b>								
51	Level the machine and adjust nozzle concentricity	✓						
52	Lubricate the electric pump motor bearings <sup>(4)</sup>	○		Grease Kit				
53	Replace the air regulator filter elements	○		Consumables Kit				
54	Replace the electric clamp lock piston oil <sup>(5)</sup>	○		Consumables Kit				
55	Replace the hydraulic tank breather cap	○		Consumables Kit				
56	Replace the injection housing and gearbox breather cap	○		Consumables Kit				
57	Replace the transfer cylinders breather cap	○		Consumables Kit				
58	Replace the oil retrieval filter element	○		Consumables Kit				
59	Replace the vacuum pump inlet air filter	○		Consumables Kit				
60	Replace the vacuum pump oil <sup>(6)</sup>	○		Consumables Kit				
61	Replace the gearbox oil (mineral oil only) <sup>(7)</sup>	○		Consumables Kit				
62	Torque the DC bus bar screws	✓		Grease Kit				
63	Drain water from the air storage tank(s)	○						
<b>PROGRAM I 8,000 OPERATING HOURS   6,500,000 CYCLES</b>								
64	In the absence of regular quarterly oil analysis, it is recommended to replace oil every 8,000 hours	○						
<b>PROGRAM J 12,500 OPERATING HOURS   10,000,000 CYCLES</b>								
65	Clean the vacuum pump <sup>(8)</sup>	○						
<b>PROGRAM K 15,000 OPERATING HOURS   12,000,000 CYCLES</b>								
66	Replace the drive housing oil	○		Grease Kit				
<b>PROGRAM L 24,000 OPERATING HOURS   18,000,000 CYCLES</b>								
67	It is recommended to replace the hydraulic oil every 24,000 hours of operation, with a complete reservoir cleaning	○						
<b>PROGRAM M 25,000 OPERATING HOURS   18,000,000 CYCLES</b>								
68	Replace the hydraulic hoses	○		Hydraulic Hose Kit				
69	Replace the pneumatic hoses	○						
<b>PROGRAM N 32,500 OPERATING HOURS   24,000,000 CYCLES</b>								
70	Replace the Uninterruptable Power Supply (UPS) Battery	○						

**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> This check must be performed every 4,000,000 cycles or every 5000 machine hours, whichever comes first.  
<sup>(3)</sup> Perform every 5,000 machine hours or every 6 months, whichever comes first.  
<sup>(4)</sup> Perform every 6,000,000 cycles or every 7,500 machine hours, whichever comes first.  
<sup>(5)</sup> Perform every 6,000,000 cycles or every 7,500 machine hours, whichever comes first.  
<sup>(6)</sup> Perform every 6,000,000 cycles or every 7,500 machine hours, whichever comes first.  
<sup>(7)</sup> Replace the gearbox oil every 6,000,000 cycles or every 7,500 machine hours, whichever comes first.  
<sup>(8)</sup> In extremely dusty conditions, the vacuum pump should be cleaned every six months.

Americas - English: Toll-Free: +1 (800) 465 4875      Europe: Toll-Free: 008000800 4300      India: Tel: +(91) 44 2747 6426  
 Tel: +1 (437) 781 8572      Tel: 352 2786 7967      China: Toll-Free: 1 (400) 021 0557  
 Americas - Portuguese: Toll-Free: 0800 891 3817      Russia: Tel: 7 495 232 9450      Tel: 86 21 6146 9058  
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