Daily Saw Maintenance

**Note:** Certain conditions, including damp environments or certain types of wood (SYP), may require extra cleaning and lubrication, adjust as necessary.

**Lubrication**: Use a mixture of motor oil and kerosene (1:16) to clean out excessive resin buildup and lubricate. Very light lubricants and dry lubricants (graphite) should be used on all sliding metal surfaces as needed. The lubrication of the slides varies quite a bit depending on the type of wood being cut and the environmental conditions.

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| Task  |  | Comments/Notes |
| Clean the Saw |  |  |
| * Remove the sawdust and debris

 (Don’t forget to clean out the material in feed conveyors "in and out" and Energy Chain Track) |  |  |
| * Wipe down surfaces
 |  |  |
| Lubricate  |  |  |
| * Lubricate slides with pump sprayer
 |  |  |
| * Lubricate castings
 |  |  |
| * Lubricate chains
 |  |  |
| * Clean pitch from the blades and moving components
 |  |  |
| Check the E-Stop System  |  |  |
| * Test Emergency Stop function
 |  |  |
| * Replace or repair any damaged components
 |  |  |
| Check the Blade Brakes  |  |  |
| * Check for any signs of wear or malfunction
 |  |  |
| * Ensure brakes engage and release
 |  |  |

Technician Name: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Signature: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Date: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

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| Task  |  | Comments/Notes |
| Check Air Filter/Oiler  |  |  |
| * Ensure Oiler is functioning properly
 |  |  |
| * Ensure the oil is at the appropriate level and add any additional if needed (recommended oil: CLIsyntec Air Tool Lubriant- Premium Industrial Pneumatic Tool Oil)
 |  |  |
| Check for and Fix Any Leaks  |  |  |
| * Inspect hoses and connections for leaks
 |  |  |
| * Replace or repair any damaged components
 |  |  |
| Check Saw Blades |  |  |
| * Inspect for sharpness and damage (Change if needed)
 |  |  |
| Check Angles and Centerlines  |  |  |
| * Inspect for any build of debris and clean as necessary to ensure proper operation.
 |  |  |

Weekly Saw Maintenance

Technician Name: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

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Date: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

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| Task  |  | Comments/Notes |
| Check the Actuator of the Worm Gearbox  |  |  |
| * Use 2-3 pumps of grease (Mobile grease XHP 461).
* Stop if grease comes out of the seal near the encoder.
* Do not over lubricate.
* (Older Joyce Actuator version) Not required on new chain centerlines.
 |  |  |
| Check Saw Blade Hubs  |  |  |
| * Inspect for tightness.
* NOTE: Do not remove or try to take apart
* Saw blades should be tightened between 18-20 ft lbs.
* Hubs with bushing size #2517 should be tightened to 35.8-39.4 ft lbs. (most common type)
* Hubs with bushing size #1215 should be tightened to 14.6-16 ft lbs. (Old style)
 |  |  |
| Check Saw Squareness  |  |  |
| * Verify squareness and adjust and realign as needed.
 |  |  |
| Check Material Feed Chains  |  |  |
| * Inspect the tightness of the material feed chains.
* Check for proper tension and adjust tightness as necessary.
 |  |  |
| Check Infeed Conveyor Chains |  |  |
| * Inspect the tightness of the Infeed Conveyor chains.
* Check for proper tension and adjust tightness as necessary.
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Monthly Saw Maintenance

Technician Name: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Signature: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_­­­­\_\_\_\_\_\_\_\_\_

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| Task  |  | Comments/Notes |
| Grease Blade Motors |  |  |
| * Clean the grease gun and fittings before greasing.
* Blades 1,2,3,4 (5500 hrs. operation) Blade 5 (9500 hrs. operation) 1-2 pumps.
* Use Polyrex EM or compatible grease.
* Do not mix grease types.
* Do not over-lubricate.
 |  |  |
| Check Tightness of Carriage Encoder  |  |  |
| * Inspect and tighten carriage encoder if necessary.
 |  |  |
|  Check Tightness of Spur Gears |  |  |
| * Inspect spur gears for proper tightness.
 |  |  |
| * Adjust or replace gears if necessary.
 |  |  |
| Check Tightness of Motor Torque Limiter  |  |  |
| * Inspect motor torque limiter for tightness.
 |  |  |
| * Ensure it is functioning correctly.
 |  |  |
| Check Encoders |  |  |
| * Inspect encoders for damage and check connections to their shafts
 |  |  |
| * Clean or change any components if needed
 |  |  |
| Check For Rust in Movements |  |  |
| * Inspect angle and centerline movements for rust
 |  |  |
| * Clean and treat any rusted areas.
 |  |  |
| Fully Clean Out the Gear Rack  |  |  |
| * Remove debris and buildup from the gear rack
 |  |  |
| * Inspect for wear and tear
 |  |  |
| Vacuum Out Electrical Panels  |  |  |
| * Use a vacuum to remove sawdust from electrical panels
* Avoid blowing air into panels to prevent pushing debris into electronics
 |  |  |

 Yearly Saw Maintenance

Technician Name: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Signature: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_­­­­\_\_\_\_\_\_\_\_\_

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