

For an optimum working of your SERDI machine, the following verifications should be done:

- The upper bed slides must be clean and dry.
- The pneumatic working pressure for the air-cushions must show at least **6 bars**.
- Control the level of the machine.
- When the workhead is clamped, the vacuum gauge must show **0.6 bar** minimum. Clean or change the vacuum generator filter located at the rear of the machine. (For SERDI 1.0AD, S1.1, S3.0 Large and S4.0 Power)

I. Once a week (i.e. every Monday morning):

- Clean the spindle and the sphere to get a clean and dry surface.
- Clean with light oil (i.e. WD40) on the upper slide and on the top of the sphere. Clean carefully the extra oil in order to keep the vacuum generator filter clean.
- Control the level of the machine.

II. Every morning:

- Clean the bed of the workhead to get a clean and dry surface.
- Control the water level in the filter tank.
- Clean the upper part of the sphere with a dry rag (do NOT use any solvent).
- Unlock the workhead with the pedal or with the switch depending on your machine: move it from left to right and front to back. If the workhead slides with restraint, adjust the regulators of the air-cushions.
- Unlock the sphere, and let it move in freely then adjust the air-cushion of the sphere if necessary.
- Check the sphere cylinder's air-cushion only on the S1.0 AD, S1.1, S3.0 and S4.0 Power.
- Make sure to only use a vacuum cleaner, a rag or a brush to remove the chips from the machine. Never use a blow gun to clean the machine.

III. Maintenance:

- Always use the genuine SERDI parts and tooling to ensure the best quality work and durability for your machine.
- Have a preventive maintenance at least once a year depending of the use of your machine by your SERDI technician.
- Regularly visit our website www.serdi.com to get the latest on the SERDI products and important technical information for your machine.