



General X Table Maintenance Procedures & Suggested Replacement Parts List

May 2016

support@torchmate.com

Recommended Spare parts

1. Spur Gears (400 hrs. estimated life on Long Axis, 800 hrs. estimate life on Short Axis)

Part Number per Item: TMS-434-0025-01 (3/8" Bore 24 tooth)

Part Number per Item: TMS-434-0024-02 (3/8" Bore 48 tooth)

Part Number per Item: TMS-434-0025-01 (22mm Bore 48 tooth)

2. Torchmate AVHC Spring Coupler/Lead Screw/Bronze Nut/Bearings (1000 hrs. estimated life with proper maintenance and oiling)

Part Number for Rebuild Kit: TMS-101-1000-06

3. Motor Cable(s). Replace as necessary due to cuts, pinches, and burns. If Damage is found, specify number of cable sections needed.

Part Number for single 50' Section XLR to XLR Connector: TMS-402-0011-01

Part Number for single 50' Section XLR to Molex Connector: TMS-402-0010-01

4. 35MM Felt Wipers (replace as necessary due to drying out, being broken off, or failing to clean the rails)

Part Number, quantity two per cassette, sold individually: TMS-430-0056-01

5. Replacement Torch Mounting sleeve, or Torch head, in case of damage. Part number depends on Torch model.

Spare parts can be ordered by contacting the Torchmate Parts Department at 866-571-1066 x59217, or torchmateparts@lincolnelectric.com

Consumable life & Plasma Cutter Maintenance

1. Life of consumable pieces Depends on Plasma cutter, speed, and height settings.

2. Plasma Cutter maintenance, consult the specific model's user guide for procedures.

Cleaning, machine maintenance

- Once a day:

1. Blow off the machine, gears, and gear rack with compressed air. Wipe any water off of the machine rails
2. Check Gantry for square (Burny Phantom run homing Procedure)
3. Check pinion gear integration with gear rack. There should be a small amount of backlash across the entire length of the table.

- Once a week:

1. Lightly oil the machine rails with WD40 or some other light oil to keep them from rusting.
2. Clean, and then oil the AVHC Lifter station lead screw and bronze nut with 3 in 1 oil, or similar weight oil (Torchmate Lifter Station only) for Inova lifter station see Inova Height Control Manual
3. Check Water level in table, fill as necessary.

- Once every other month:

1. Remove the cover off of the Plasma cutter power supply, and blow it out with compressed air.
2. Remove the cover off of the Torchmate Control box with the Fan and blow it out with compressed air.
3. Remove the PC side cover and blow it out with compressed air.
4. Check motor cable connections for any sign of wear, or pulling & snagging that may cause motor cable connection failure.
5. Inspect Cable Carrier system for any damage to cables or strain on the cables.
6. Re-check square on the gantry and hard stops to ensure gantry is still running true, and all CAM Followers
7. Put a flat piece of material on the table, and square the torch head to the material in the X & Y dimension, adjust if necessary.