

## DI-ACRO MACHINE PREVENTATIVE MAINTENANCE GUIDE

### Model 1 Bender:

- Keep machine surfaces clean and free of debris
- Lubricate bearings per the table below via the Drive Fitting (Item 5 in the parts breakdown) in the side of the Paddle (Item 2) or handle weldment (models 1a, 2, and 3 bender) with a NLGI GC-LB or SAE J310 grease per the lubrication guide, below.

DI-ACRO MACHINE LUBRICATION GUIDE		
DUTY	HOURS/WEEK	LUBRICATION INTERVAL
LIGHT	LESS THAN OR EQUAL TO 32	MONTHLY
MODERATE	MORE THAN 32, UP TO 80	MONTHLY
HEAVY	BETWEEN 80 AND 120	EVERY TWO WEEKS
SEVERE	MORE THAN 120	WEEKLY

- To prevent corrosion in environments where the machine is used periodically, the top of the mounting plate, sliding surfaces of the handle and nose holder assemblies, and other non-lubricated bare metal surfaces may be protected with a suitable film coating such as paste wax, beeswax, Boeshield T-9, or similar.

### Bender Models 1A, 2, and 3:

- Keep machine surfaces clean and free of debris
- Lubricate bearings per the table below via the Drive Fitting (Item 5 in the parts breakdown) in the side of the Handle Arm Weldment (Item 2) with a NLGI GC-LB or SAE J310 grease per the lubrication guide, below.

DI-ACRO MACHINE LUBRICATION GUIDE		
DUTY	HOURS/WEEK	LUBRICATION INTERVAL
LIGHT	LESS THAN OR EQUAL TO 32	MONTHLY
MODERATE	MORE THAN 32, UP TO 80	MONTHLY
HEAVY	BETWEEN 80 AND 120	EVERY TWO WEEKS
SEVERE	MORE THAN 120	WEEKLY

- To prevent corrosion in environments where the machine is used periodically, the top of the mounting plate, sliding surfaces of the handle and nose holder assemblies, and other non-lubricated bare metal surfaces may be protected with a suitable film coating such as paste wax, beeswax, Boeshield T-9, or similar.

**Model 4 Bender:**

- Keep machined surfaces clean and free of debris.
- Lubricate bearings via the Drive Fitting (Item 8 in the parts breakdown) in the side of the Handle Arm Weldment (Item 7) with a NLGI GC-LB or SAE J310 grease per the Lubrication Guide, shown below.
- Lubricate the contact surfaces of the Check Pawls (Items 50 and 51) and the Ratchet Pawl (Item 62) per the Lubrication Guide below with a light coating of the grease used on the roller bearings if the ratchet function is used during your operation of the bender.

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DUTY	HOURS/WEEK	LUBRICATION INTERVAL
LIGHT	LESS THAN OR EQUAL TO 32	MONTHLY
MODERATE	MORE THAN 32, UP TO 80	MONTHLY
HEAVY	BETWEEN 80 AND 120	EVERY TWO WEEKS
SEVERE	MORE THAN 120	WEEKLY

- To prevent corrosion in environments where the machine is used periodically, the top of the mounting plate, sliding surfaces of the handle and nose holder assemblies, and other non-lubricated bare metal surfaces may be protected with a suitable film coating such as paste wax, beeswax, Boeshield T-9, or similar.

**Shears:**

- Keep machined surfaces clean and free of debris.
- Lubricate with Velocite No. 6 or SAE equivalent motor oil via the Oil Hole Covers (Item 28) in the Shaft Bearing Assemblies (Item 29) and Shaft Links (Item 27) per the table below.

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LIGHT	LESS THAN OR EQUAL TO 32	MONTHLY
MODERATE	MORE THAN 32, UP TO 80	MONTHLY
HEAVY	BETWEEN 80 AND 120	EVERY TWO WEEKS
SEVERE	MORE THAN 120	WEEKLY

- To prevent corrosion in environments where the machine is used periodically, the table and other non-lubricated bare metal surfaces may be protected with a suitable film coating such as paste wax, beeswax, Boeshield T-9, or similar.
- If cutting performance is not adequate, follow the blade adjustment procedure.

**Model 24 Finger Brake:**

- Keep machined surfaces clean and free of debris.
- Lubricate the shaft via the Drive Fitting in the side of the handle weldment with a NLGI GC-LB or SAE J310 grease per the Lubrication Guide, shown below.

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LIGHT	LESS THAN OR EQUAL TO 32	MONTHLY
MODERATE	MORE THAN 32, UP TO 80	MONTHLY
HEAVY	BETWEEN 80 AND 120	EVERY TWO WEEKS
SEVERE	MORE THAN 120	WEEKLY

- To prevent corrosion in environments where the machine is used periodically, the Fingers, Folding bar Front, and other non-lubricated bare metal surfaces may be protected with a suitable film coating such as paste wax, beeswax, Boeshield T-9, or similar.

**Model 36 Finger Brake:**

- Keep machined surfaces clean and free of debris.
- Lubricate the shaft via the Drive Fitting in the side of the handle weldment with a NLGI GC-LB or SAE J310 grease per the Lubrication Guide, shown below.

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DUTY	HOURS/WEEK	LUBRICATION INTERVAL
LIGHT	LESS THAN OR EQUAL TO 32	MONTHLY
MODERATE	MORE THAN 32, UP TO 80	MONTHLY
HEAVY	BETWEEN 80 AND 120	EVERY TWO WEEKS
SEVERE	MORE THAN 120	WEEKLY

- To prevent corrosion in environments where the machine is used periodically, the Fingers, Folding bar Front, and other non-lubricated bare metal surfaces may be protected with a suitable film coating such as paste wax, beeswax, Boeshield T-9, or similar.

**No. 2 Rod Parter:**

- Lubricate the Center Stud Bolt via the Drive Fitting in the side of the handle weldment with a NLGI GC-LB or SAE J310 grease per the Lubrication Guide, shown below.

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MODERATE	MORE THAN 32, UP TO 80	MONTHLY
HEAVY	BETWEEN 80 AND 120	EVERY TWO WEEKS
SEVERE	MORE THAN 120	WEEKLY

- If parting performance is not adequate, follow the procedure to remove and sharpen the cutting dies.
- To prevent corrosion in environments where the machine is used periodically, non-lubricated bare metal surfaces may be protected with a suitable film coating such as paste wax, beeswax, Boeshield T-9, or similar.

**Model 2 Punch Press:**

- Keep the non-lubricated machined surfaces, dies, and punches clean and free of debris.
- Lubricate the Cam Roller Pin via the Drive Fitting in the side of the handle weldment with a NLGI GC-LB or SAE J310 grease per the Lubrication Guide, shown below.
- Lubricate the three vertical surfaces on the Ram with a light coating of the same grease used on the Cam Roller Pin per the lubrication guide.

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MODERATE	MORE THAN 32, UP TO 80	MONTHLY
HEAVY	BETWEEN 80 AND 120	EVERY TWO WEEKS
SEVERE	MORE THAN 120	WEEKLY

- To prevent corrosion in environments where the machine is used periodically, non-lubricated bare metal surfaces may be protected with a suitable film coating such as paste wax, beeswax, Boeshield T-9, or similar.

**Model 2 Tab Notcher:**

- Keep the non-lubricated machined surfaces, dies, and punches clean and free of debris.
- Lubricate the Cam Roller Pin via the Drive Fitting in the side of the handle weldment with a NLGI GC-LB or SAE J310 grease per the Lubrication Guide, shown below.
- Lubricate the three vertical surfaces on the Ram Weldment with a light coating of the same grease used on the Cam Roller Pin per the lubrication guide.

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MODERATE	MORE THAN 32, UP TO 80	MONTHLY
HEAVY	BETWEEN 80 AND 120	EVERY TWO WEEKS
SEVERE	MORE THAN 120	WEEKLY

- To prevent corrosion in environments where the machine is used periodically, non-lubricated bare metal surfaces may be protected with a suitable film coating such as paste wax, beeswax, Boeshield T-9, or similar.

**Slip Rollers:**

- Keep the non-lubricated machined surfaces, dies, and punches clean and free of debris.
- Lubricate the Upper Pinch Roll on the right side of the machine where it rides in the Side Frame RH Assembly with a light coating of NLGI GC-LB or SAE J310 grease per the Lubrication Guide, shown below.
- Lubricate the Gears with the same grease as above per the same intervals.
- Lubricate the interface between the Idler Roll Boxes and the Idler Cam with a light coating of the same grease per the same intervals.
- Place a few drops of machine oil into the holes in the Pivot Block, Lower Pinch Roll Blocks, and Idler Roll Blocks per the same intervals.

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HEAVY	BETWEEN 80 AND 120	EVERY TWO WEEKS
SEVERE	MORE THAN 120	WEEKLY

- To prevent corrosion in environments where the machine is used periodically, non-lubricated bare metal surfaces may be protected with a suitable film coating such as paste wax, beeswax, Boeshield T-9, or similar.