

Dear Customer,

Please read through our handy hints to help you with your **TRUMPF Punch / Combination / Bending** machine shutdown in preparation for extended shutdown periods.

Punch machines:

1. Unload tools from punching head
2. Ensure backup batteries are either newly replaced or in good condition prior to shutdown (more critical on TruMatic 200 / 500 series machines)
3. Move the X & Y axes to the middle position for even balance
4. Shutdown the machine as per standard operating procedure
5. Switch off Hydraulics, air.

TruMatic (Combination Punch / Laser Machines):

1. Unload tools from punching head
2. Move the x and y axis to the middle position
3. Change nozzle at the laser cutting head to smallest diameter 0.8mm – 1.0mm
4. Shutdown the machine as per operator manual procedure
5. Switch off Hydraulics, Air & Oxygen.
6. If possible, leave nitrogen line open. TRUMPF prefer to keep the nitrogen purging inside the machine during switch-off periods. The volume of gas usage is outlined in the operator's manual, chapter 2. However, if the nitrogen is switched off at the tank, please ensure that nothing is done in the factory during the holidays that could affect the internal optics of the machine. This includes:
 - *Removing the cutting head (CO₂) or removing the protective glass (Fiber).*
 - *Painting, floor, sealing, or other activity that diffuses fumes or solvents near the machines.*
7. SheetMaster / Automation components: no preparation necessary.

Bend machine:

1. Ensure backup batteries are either newly replaced or in good condition prior to shutdown
2. Rest the Beam down on pair of wooden blocks (Placed underneath the cylinders)
3. Shutdown the machine as per standard operating procedure
4. Switch off Hydraulics, air.

Please read through our handy hints below to help you with your **TRUMPF Laser** machine startup following extended shutdown periods.

Before shutdown:

1. Pallet changer: hydraulics lowered
2. Keep cutting head connected. Do not leave a large nozzle in the cutting head. If possible, change to a small nozzle.
3. CO₂ and Fiber: TRUMPF prefer to keep the nitrogen purging inside both machines during switch-off periods. The volume of gas usage is outlined in the operator's manual, chapter 2. However, if the nitrogen is switched off at the tank, please ensure that nothing is done in the factory during the holidays that could affect the internal optics of the machine. This includes:
 - *Removing the cutting head (CO₂) or removing the protective glass (Fiber).*
 - *Painting, floor, sealing, or other activity that diffuses fumes or solvents near the machines.*
4. Liftmaster-Z / Liftmaster Compact: no preparation necessary.

Starting up CO₂:

1. Ensure the Helium is turned on LAST when opening the three laser gas bottles.
2. Ensure that the water level is sufficient in the cooling tanks of the machine and that no water has leaked during the off-period.
3. Spin up laser. When it starts operating, spin down then spin up once more before starting production (Purify the gas).
4. After starting the CO₂ laser, the RF Generator will extend the pre-heating time of the End-Stage Tube for approximately 40 minutes. At this time the machine will issue the warning error number: "TLF1: 13.100520". The machine will not produce during this extended warm up period.

Starting up TruDisk (Fiber Machines):

1. Ensure that the water level is sufficient in the cooling tanks of the machine and that no water has leaked during the off-period.
2. Turn on the machine as normal & run up the laser device. Let the machine idle for approximately one hour before putting the beam on for the first time (allowing the air cleaner of the TruDisk to remove any humidity inside the resonator is good practice for extended summer holiday periods.)

As always, support will continue during the holiday period. Please call 1300 138 285 if you need any service.

We wish you a very Merry Christmas and a Happy New Year.