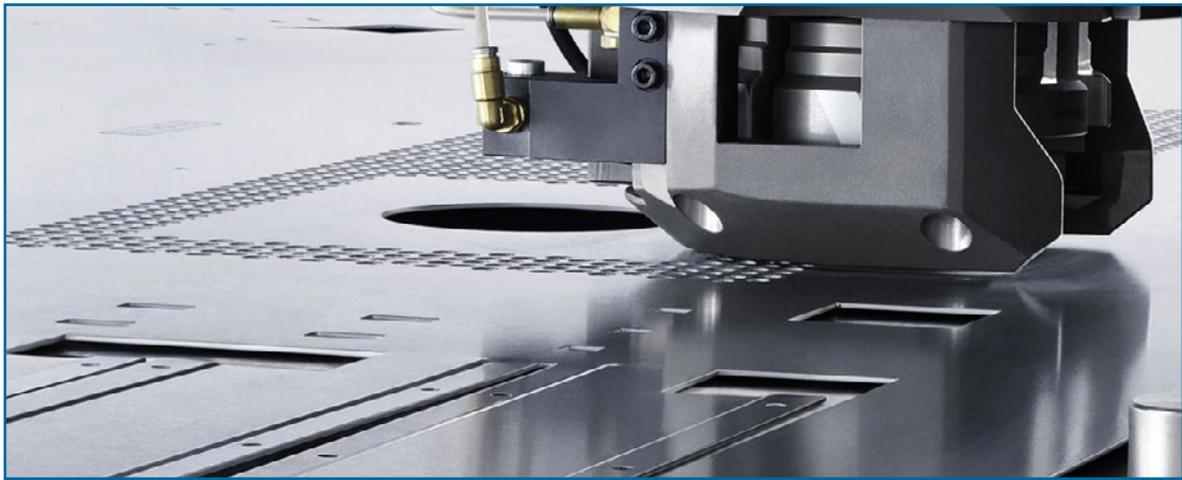


TRUMPF PUNCH / COMBINATION / BENDING MACHINES

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.

TRUMPF PUNCH / COMBINATION / BENDING / LASER MACHINES (CONTINUED)

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 MACHINES

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.

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