

Maintenance

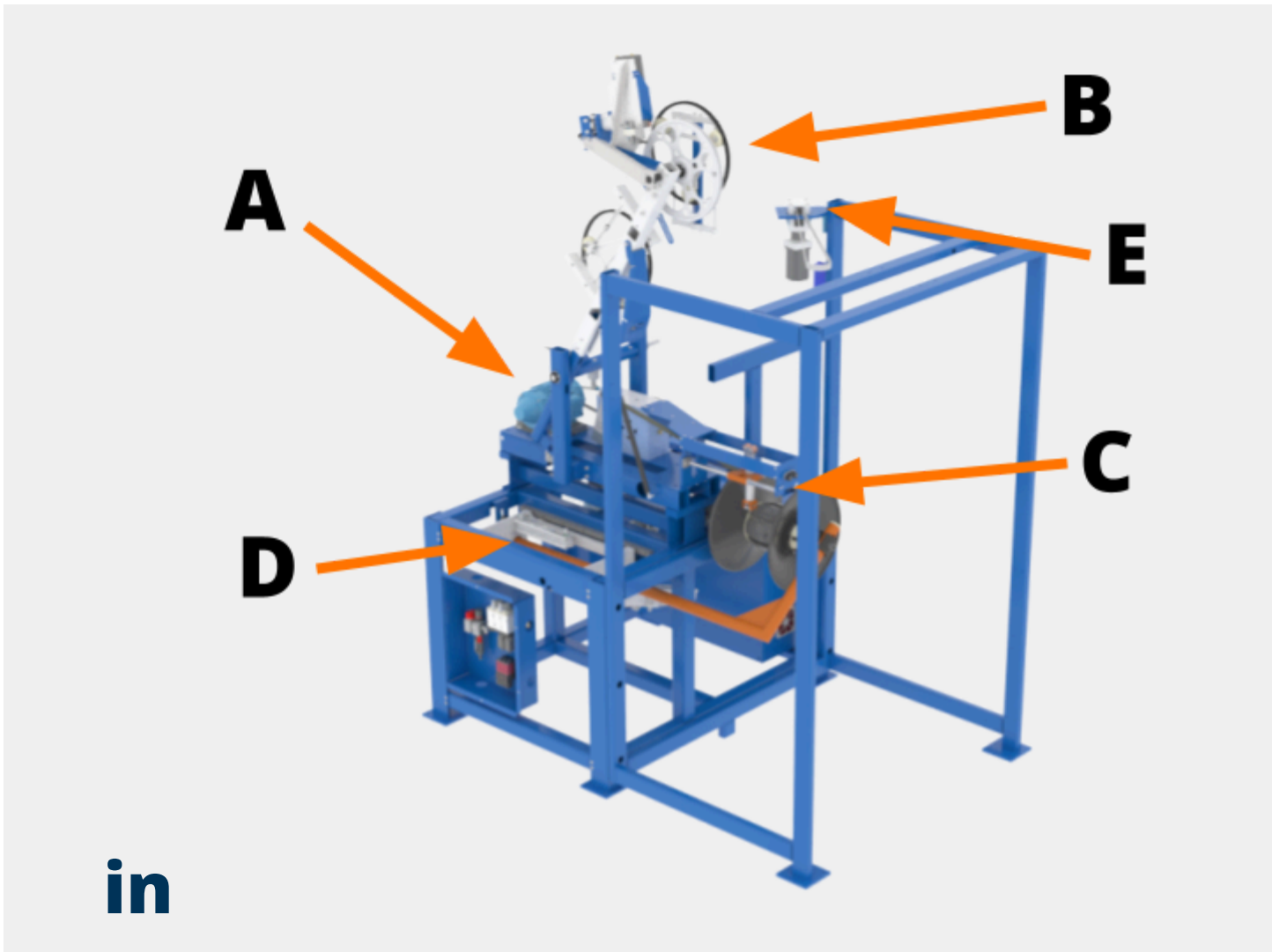
S320 REELEX Coiling Machine

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S320 Maintenance

The REELEX S320 Single-Spindle coiling machine is designed to operate with minimal maintenance. However, the following preventative maintenance should be performed as described in order to maximize the life of the machine and its components.

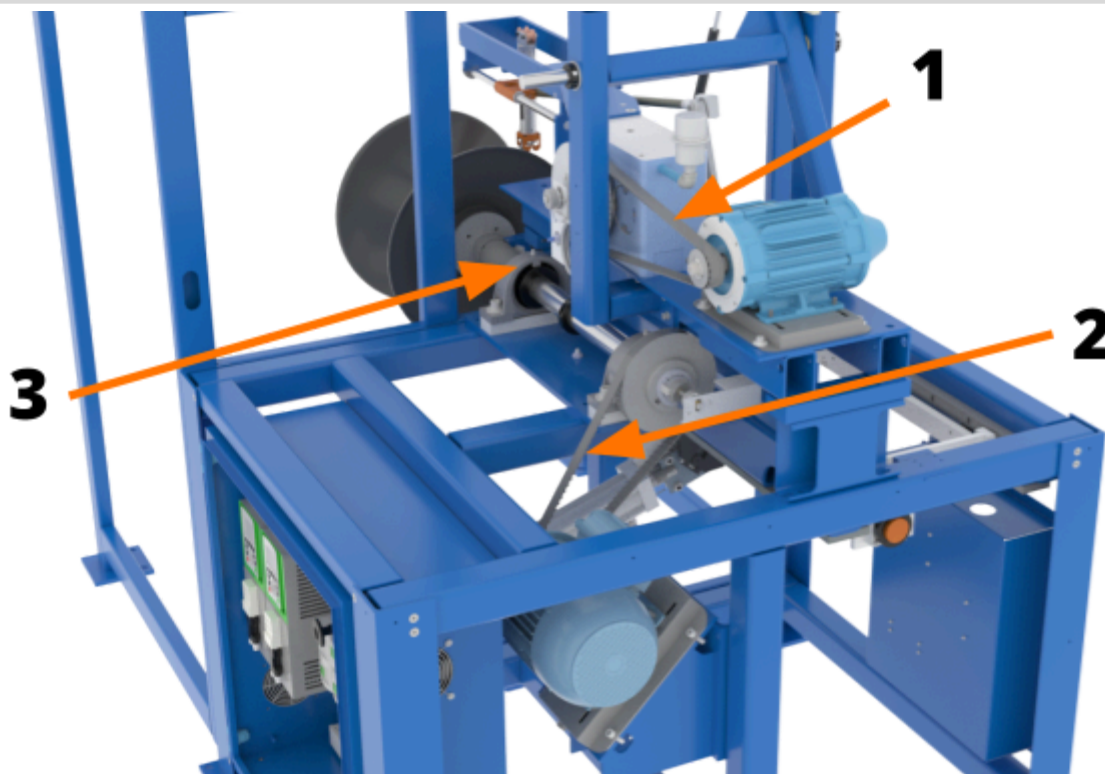
Maintenance Locations



A - Motors and Shafts

References:

- [32006 - SPINDLE ASSY.pdf](#)
- [32011 - TRAVERSE/CAMBOX ASSY.pdf](#)



Item	Action	Type	Time Period
1.	Inspect traverse belt monthly. Check for dry rot, excessive wear, and tightness. Tighten belt when needed, until about ¼ inch of play. To do so, loosen the 4 bolts securing the motor to the adjustable base, and use the jack screw on the base for adjustment. Tighten all bolts after desired tension is obtained.	Inspect and replace when necessary.	Monthly
2.	Inspect spindle belt monthly. Check for dry rotting, excessive wear, and tightness. Tighten belt when needed, until about ¼ inch of play. To do so, loosen the 4 bolts securing the motor to the adjustable base, and use the jack screw on the base for adjustment. Tighten all bolts after desired tension is obtained.	Inspect and replace when necessary.	Monthly
3.	Add grease until visually coming out of bearing, then wipe off excess.	Grease	Monthly

B - Buffer and Anti-Reverse Clamp

The buffer unit is essential to winding quality REELEX coils. The buffer should be regularly checked for good operation, and all springs and bearings should be replaced when worn. Not doing so could have adverse effects on the REELEX coil, including increased stress on the product (leading to poor electrical performance and other issues).

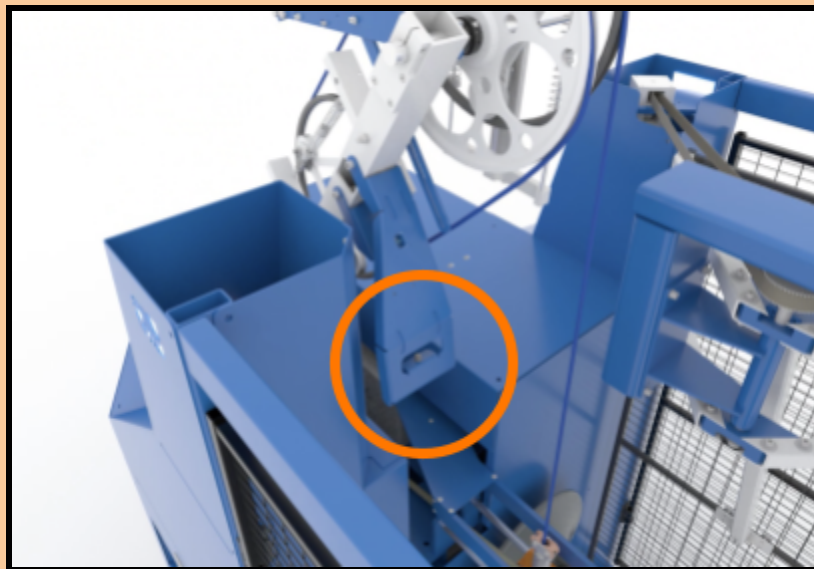
The wire buffer unit is designed to be raised and lowered as necessary. When raised, the buffer is in its normal operation position. There is a lockout switch system, which prevents the machine from starting unless the buffer is in the full up position.

The wire buffer is designed to compensate for changes in wire length during winding. The slider block shaft requires an application of silicone spray weekly, as the bearings in the buffer slider block are subjected to high velocity and cycle rates. Inspect all rollers and sheaves for serviceability. Check all securing devices, i.e. nuts, bolts, set screws, and lock rings and tighten if necessary.

The buffer slider block is equipped with a cam follower bearing, which tracks in a raceway. Check the cam follower bearing and raceway for wear and apply a small amount of silicone spray weekly.

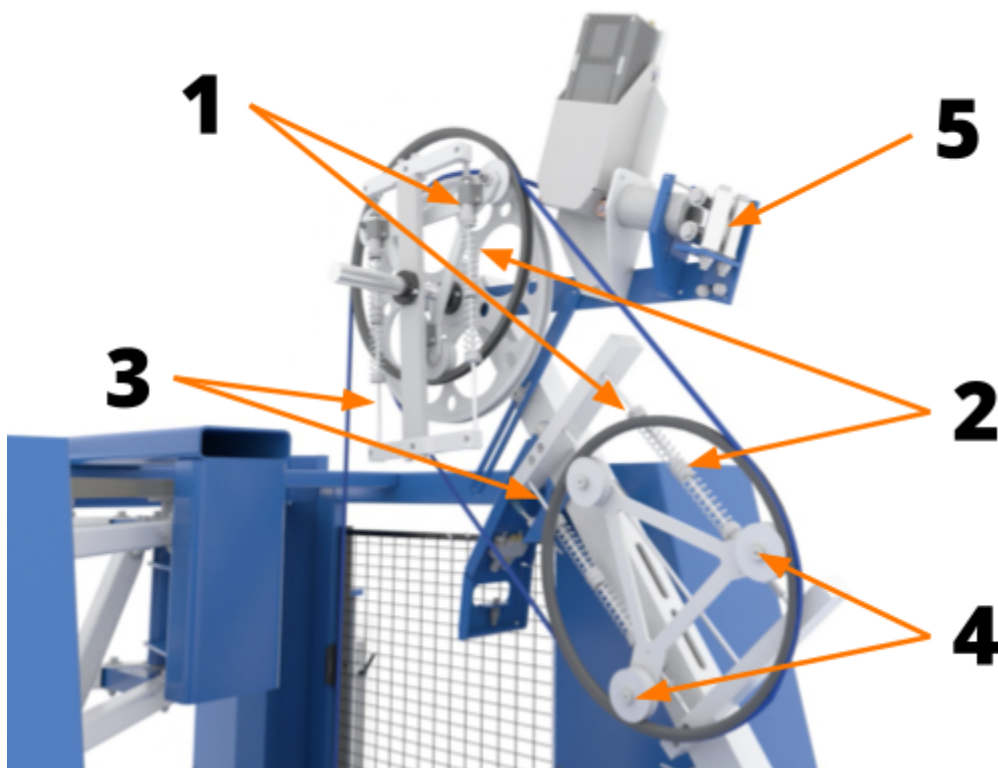
Anti-Reverse Clamp Release

NOTE: To release the anti-reverse clamp, press the button located on the buffer handle and lower the buffer until you hear air release from the clamp. The clamp is not engaged when the buffer is in the lowered position.



References:

- [Drawing 32008](#) - Buffer Assembly



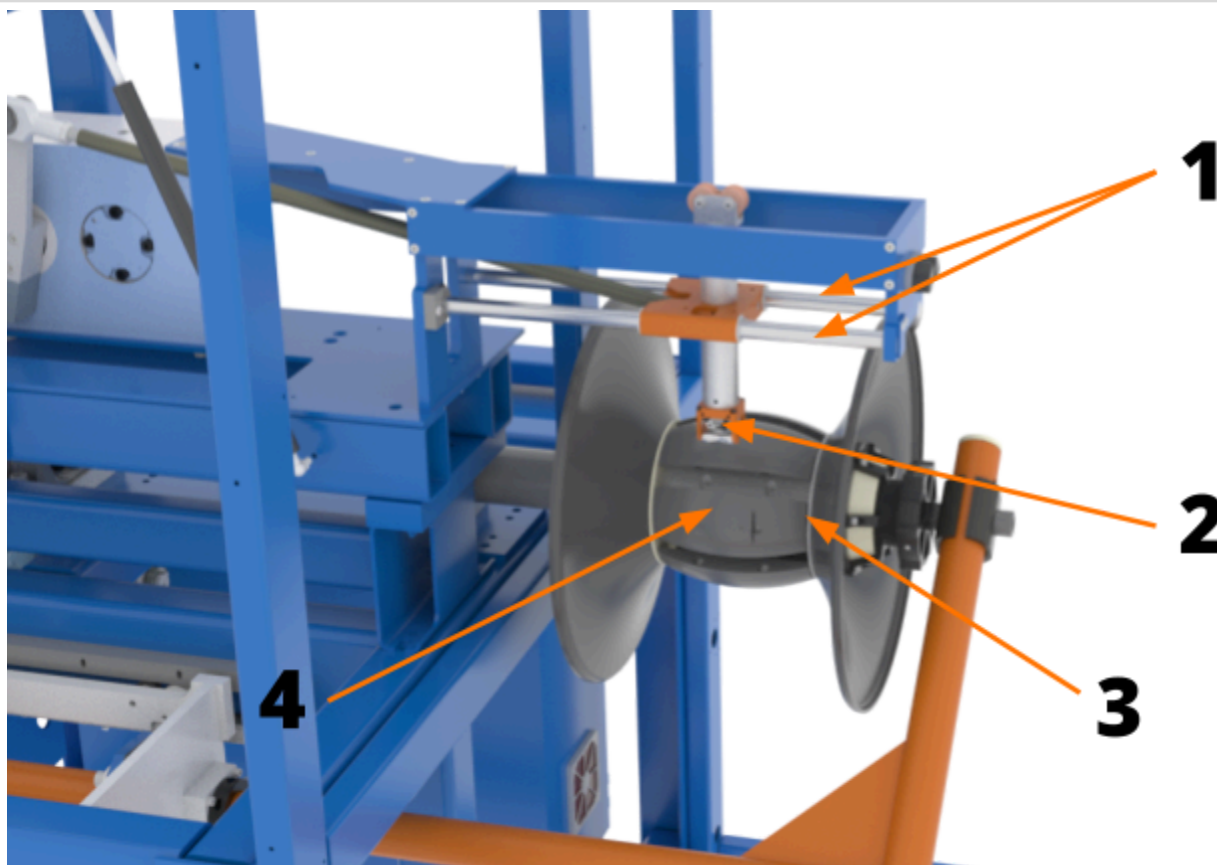
Item	Action	Type	Time Period
1.	Buffer Cam Follower Bearing and Raceway	Silicone Spray	Weekly
2.	Replace worn or broken buffer springs	SPRING-L800L-12	When springs do not provide adequate cushion for sheaves.
3.	Buffer Slider Block Shaft (Thompson)	Silicone Spray	Weekly
4.	Buffer Roller Block Bearings and Wheels	Silicone Spray	Weekly
5.	Inspect all steel wire guide rollers on the machine and dancer. Replace if groove is forming.	Replace	Weekly

C - Traverse, Mandrel and Endform

The new REELEX traverse design is generally built to be lubrication-free, however REELEX recommends the addition of synthetic bearing grease on the traverse shafts to prolong bearing life.

References:

- [32011 - TRAVERSE/CAMBOX ASSY.pdf](#)

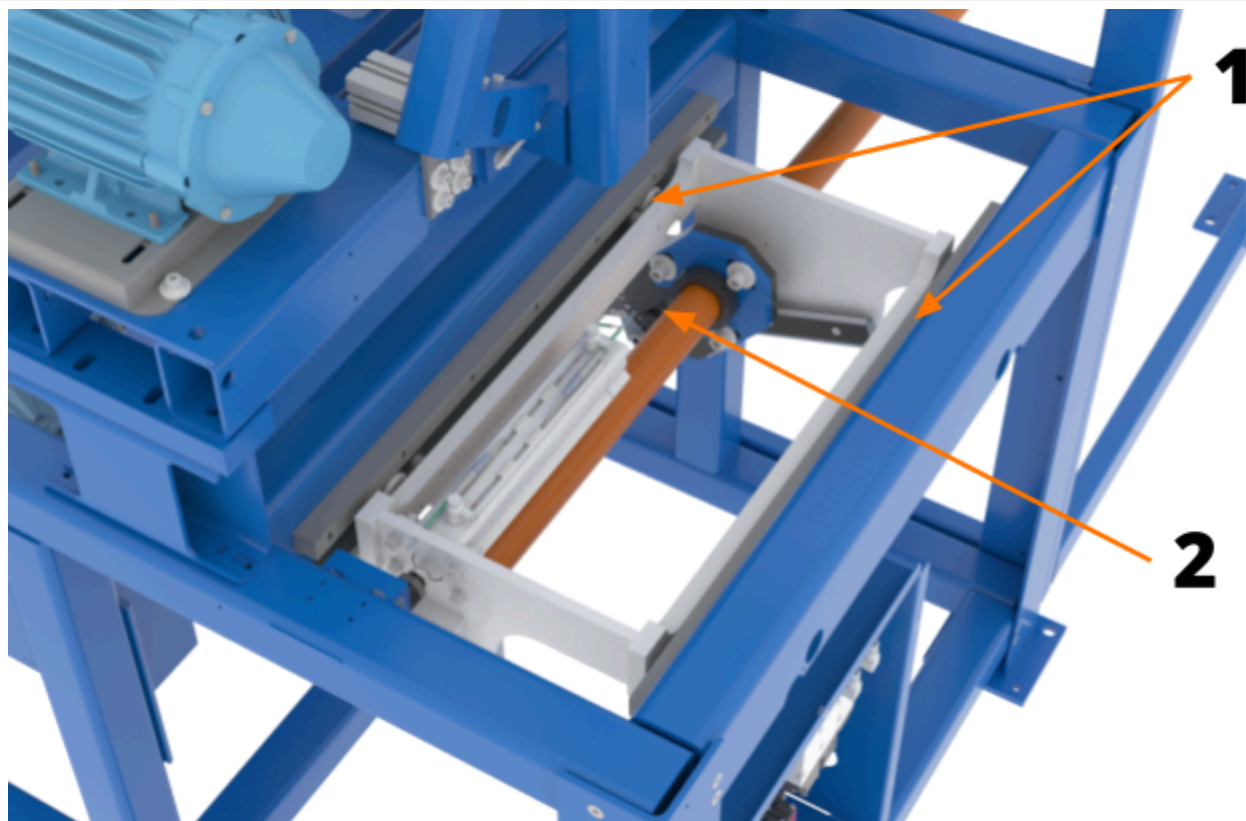


Item	Action	Type	Time Period
1.	Traverse Shaft lubrication x 2	Molykote BG20 Grease	When needed - check every two weeks
2.	Inspect adjustable wire guide for play, grooves, wear. Change springs when needed.	WIRE-AWG-ADJ	Monthly
3.	Check white nylon rings on inner and outer endforms.	Inspect and replace if worn.	Monthly
4.	Check Mandrel segments for play.	Inspect and center if needed.	Monthly

D - Endform Rails, Geneva Mechanism

References:

- [34048 - TABLE ASSY, ENDFORM ARM.pdf](#)



Item	Action	Type	Time Period
1.	Inspect v-roller bearings. Check for play.	Inspect	Monthly
2.	Inspect Geneva mechanism for wear and play. Lubricate when needed.	Grease	Monthly