
SEASONAL MAINTAINANCE GUIDELINES

with checklist

Abstract

Preventive maintenance procedures for the pneumatic press to ensure safe operation, reliable performance, and maximum service life. It describes the required maintenance activities before, during, and after the production season, including lubrication, inspection, functional testing, and safety verification.

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MAINTENANCE

Maintenance of the control box and elements of the electric drive is permitted only by qualified personnel. Authorized service is provided by the manufacturer and local dealer.



WARNING! The machine must be isolated during maintenance:

- *press the **STOP** switch,
- * **disconnect the press from the power supply,**
- *turn the main switch to position 0 and lock it.

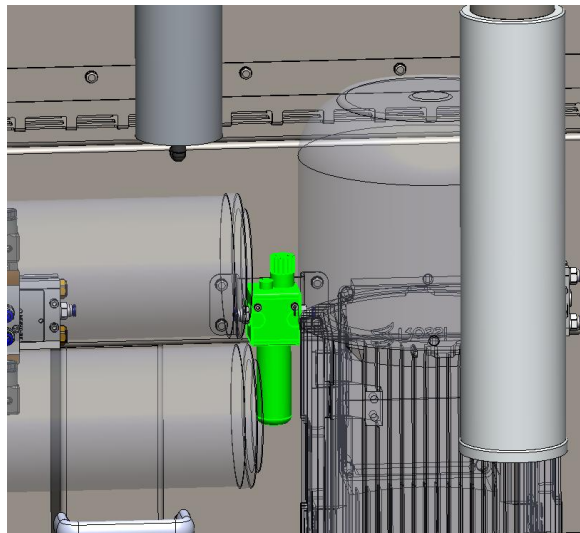


All maintenance procedures are described in the manual. Do not attempt to carry out maintenance work or any other procedures not covered in the manual.
Reading and understanding these instructions is a prerequisite for the safe use of the press and its long service life.

MAINTENANCE WORK BEFORE THE SEASON

Check oil level in preparation group

Proper lubrication of the pneumatic air supply is essential for the reliable operation and long service life of pneumatic components such as cylinders, valves, rotary union and actuators.



Oil level in lubrication cup must be controlled and never run dry.

- 1- Disable source of compressed air
- 2- Release pressure from pneumatic system



DANGER

WARNING! Before opening the cup for pneumatic air lubrication, make sure that pneumatic pressure in system is 0 bar

- 3- Rotate oil cup counter-clockwise. And remove it.
Take care over thin O-ring at the top.
- 4- Pour purpose oil for pneumatic systems into the cup.
- 5- Instal full oil-cup back to its position, tighten in clockwise direction.
- 6- Enable source of compressed air.

Tighten membrane holding screws

Due to temperature differences and sealing material properties, membrane sealing can harder. Before season check tightness of membrane screws.

Use manual wrench (nuts) and hexagonal key (bolts), manually tighten until it feels tightness.

Test membrane tightness

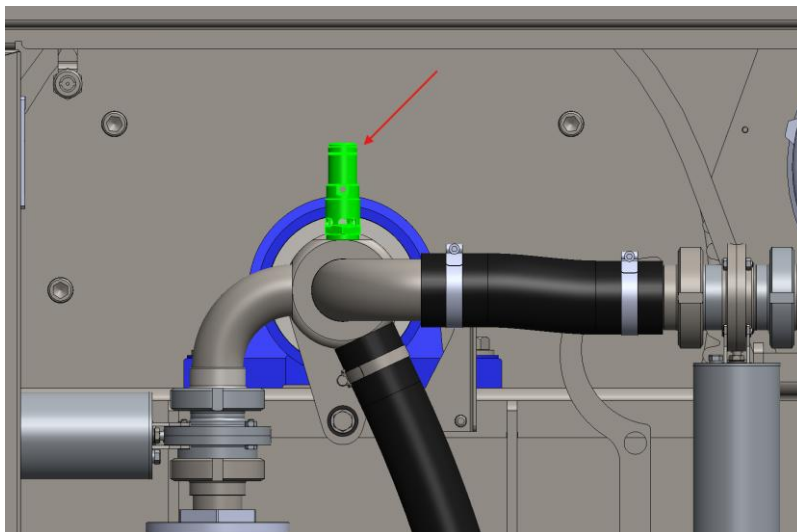
Load ballast to press cylinder (isolation, carton, cloth, ...), over drainage channels. Close press door and inflate membrane up to 0,2 bar.

Listen to see if you can hear any air leaking. You can use a soapy solution to check for any pressure leaks.



Test pressure safety valve

Each pneumatic press is equipped with 'Pressure safety valve' which protects pneumatic system against excessive pressure situations.



When pressure behind membrane is 0,2 bar untighten bolt on the top. Conical valve must release pressure.

Tighten bolt back – now it will release pressure at 1,8 bar as declared.

Lubricate the two main cylinder bearings with multipurpose grease

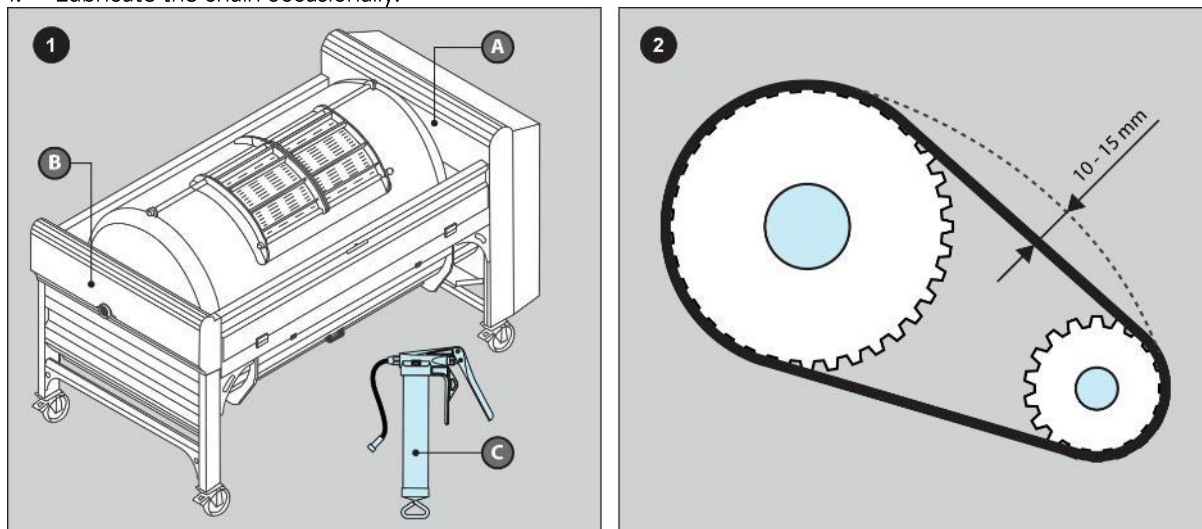
- The first lubricator is located on the front cover of the electronic drive (A).
- The second is located on the back cover (B).
- Lubricate with a manual grease gun (C).

Chain tension

Check chain tension always in position with doors down (6 o'clock). In this position tension of the cylinder to chain is in equilibrium.

The slack should be 5 – 8 mm (4 mm up and down). Too much or too little slack can damage the machine.

1. Lubricate the chain occasionally.



INFORMATION

Some presses do not have a lubricator on the rear axle of the drum.

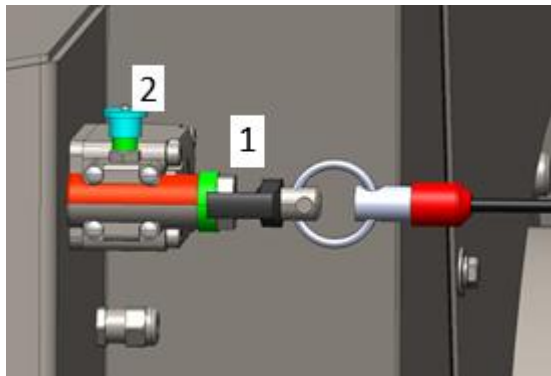


DANGER

WARNING! Do not use food incompatible grease for lubrication. There is a risk of food contamination!

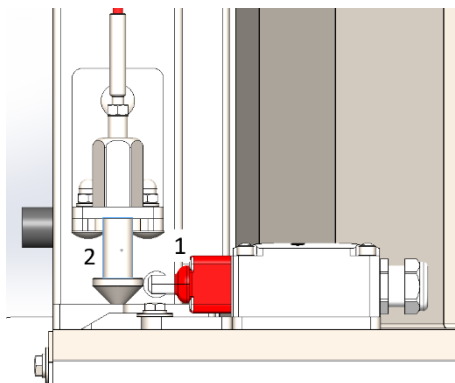
Safety wires

Safety wires protect operator against mechanical impact. Wires must be properly tightened, indicator (1) must be inside green zone, so it allows to charge trigger (2). Trigger is released, when operator (by purpose or accidentally) touches safety wire.



All triggers lifted up (green zone visible) are main condition to enable 'Reset button' and allow press operation.

Pneumatic presses equipped with side openings include position switches (1) that interact with conical element (2):



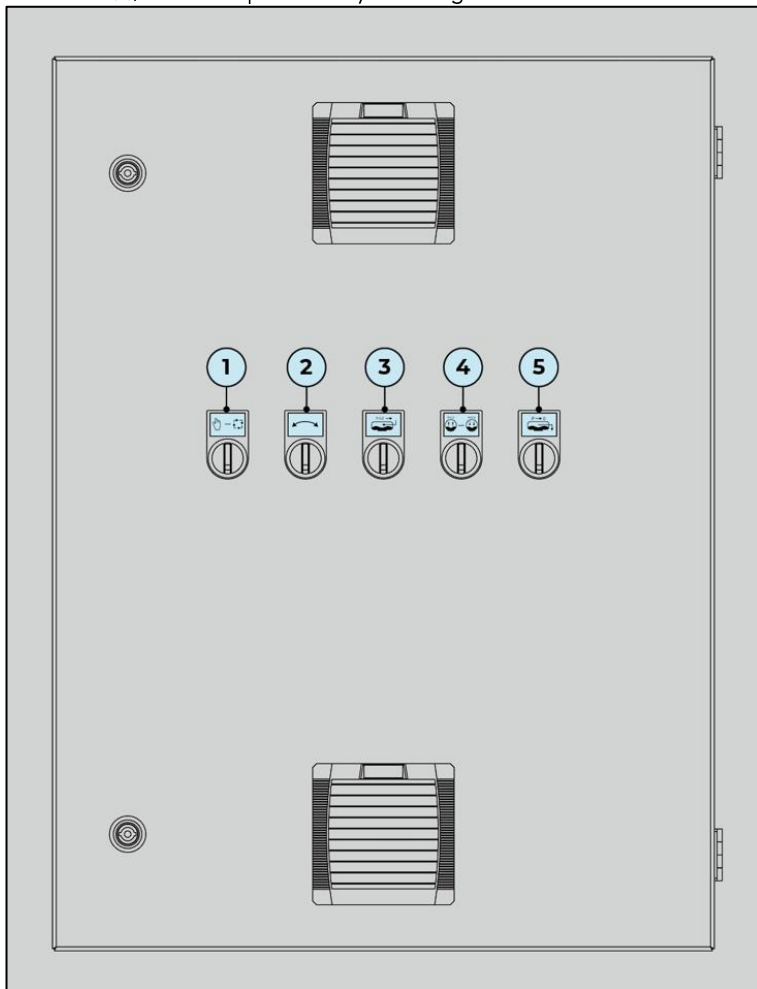
Close side openings and check position of conical element. Adjust tension of safety wire, so conical element will trigger safety switch.

All safety switches triggered are main condition to enable function of 'Reset button'.

Test press functions

Manual functions

Switch press to manual mode (1), confirm operation by enabling 'Reset button'.



By switching test following functions:

Cylinder rotation:

Use switch 2, turn it to **left**. Cylinder must rotate to **left** direction. Rotation must be smooth, without and disturbing sound. Turn switch to neutral position cylinder must stop immediately, without drift.

Use switch 2, turn it to **right**. Cylinder must rotate to **right** direction. Rotation must be smooth, without and disturbing sound. Turn switch to neutral position cylinder must stop immediately, without drift.

During cylinder rotation check interaction between inductive plate on large gear and inductive sensor installed on frame:

- Check tightness of sensor
- Check distance between inductive plate and inductive sensor. It must be 1-2mm.
- Light on sensor must be turned ON, when inductive plate is close to sensor.

Blink of position sensor re-sets timer, based on which automatic positions of the cylinder are enabled.



INFORMATION

Pneumatic presses equipped with variable frequency drive allways rotate in correct direction.
Allways activate and check:
compressor – when active, must inhale air.
Vacuum turbine – when active, must exhale air.

Compressor:

Load ballast to press cylinder, cover drainage channels (cloth, isolation, carton, ...). Toggle compressor switch (3), to start inflating membrane. Compressor must start smoothly, compressor must inhale air form atmosphere. Inflate membrane up to 0,2 bar.

Pressure release:

Toggle switch (5) for pressure release. Electro-magnetic or pneumatic (larger press models) must open to neutralise pressure behind membrane with atmospheric pressure.
 Position switch to neural. Valve must close.

Vacuuming:

Toggle switch (4) to position for membrane vacuuming. Membrane or pneumatic valve must open and vacuum turbine activate.

Check if turbine is exhausting air out.

Automatic functions

Select automatic functioning, confirm operation by enabling 'Reset button'



In manual mode (1) check functions:

2 – Rotation to left

By activation of function, press first establishes vacuum (~150 mbar) and rotates to left.

5– Rotation to right

By activation of function, press first establishes vacuum (~150 mbar) and rotates to right.

3– Membrane inflation

By activation of function, press activates compressor and inflates membrane up to defined pressure. Test inflation up to 0,2 bar.

6– Membrane vacuuming

By activation of function, press activates vacuum turbine. When vacuum reaches ~150 mbar, turbine automatically stops.

4– Discharge function

By activation of function, press first establishes vacuum (~150 mbar) and rotates to right.



7- Loading function

Offers two loading options:

- A- Door loading – by function activation press establishes vacuum (~150 mbar) and rotates until door is oriented upwards
- B- Axial loading – press first establishes vacuum (~150 mbar) and rotates with drainage outlet on side.

Check if door positions are correct.

8- Door positions

Offers 4 pre-set door positions: at top, at top-left, to bottom, to bottom-left.

Check if door positions are correct.

By accessing to the service menu and logging with code **1883**, you can recover door position by changing the time interval of rotation.

Vacuum turbine

- Check that vacuuming turbine and vacuuming valve activate together.
- Check that air is blows from vacuuming turbine.
- Inspect the blower for abnormal noise or vibration.
- Check that cooling air passages are unobstructed.
- Verify the filter on suction site is clean.
- Check for air leaks in piping and fittings.
- Ensure ventilation openings and silencer are clean.
- Remove dust from cooling fins and fan cover.
- Inspect electrical cables and connections for damage.

Compressor with graphite vanes

The main advantage of graphite vanes is minimal maintenance, but they require attention at specific points:

- Inspection of vane wear.
- Cleaning the air filter:
Clean the filter before season or replace it if necessary.
- Cleaning graphite dust:
During operation, fine graphite dust accumulates inside the compressor as a result of vane wear. It is recommended that a service technician occasionally clean the internal channels and cooling surfaces.
- Cooling and ventilation:
Make sure that the air openings on the press housing are unobstructed and that dust does not accumulate on the compressor cooling fins.

Visual inspection

Visual review of press is also important factor to determine press status and decision for required maintenance.

1. General Condition

- Machine is clean and free of excessive dirt, dust, or product residues.
- No visible damage, dents, or deformation of the frame or covers.
- Condition is acceptable with no signs of severe corrosion.
- Machine stands firmly on its supports.

- Adjustable feet are secure.
- Wheels (if fitted) rotate freely and locking devices function.
- Doors open and close correctly.

2. Safety Guards and Covers

- All guards and protective covers are installed and securely fastened.
- No cracks, missing parts, or modifications.
- Safety labels and warning signs are present and legible.

3. Fasteners

- Bolts, nuts, and screws are present and appear tight.
- No loose or missing fastening elements.

4. Control Devices

- Push buttons and switches are undamaged.
- Emergency stop buttons are accessible and not damaged.
- Indicator lights are intact.
- No visible damage to exposed shafts, couplings, chain or guards.
- Components appear correctly aligned.

5. Product Contact Areas

- Surfaces are clean and hygienic.
- No corrosion, scratches, or contamination that could affect product quality.

Acceptance Criteria

- No visible damage affecting safety or machine performance.
- No fluid or air leaks.
- All guards and safety devices are installed.
- Labels and identification remain legible.
- Machine exterior is clean and ready for operation.

MAINTENANCE WORK DURING THE SEASON

Membrane maintenance:

At the end of the working day, wash the inside of the press and the membrane according to the procedure described in section 7.5.



INFORMATION

If the membrane is damaged by a sharp object (such as scissors in a cluster), it can be repaired as soon as possible by authorised personnel.

MAINTENANCE WORK AFTER THE SEASON

- After the season, wash the press according to the previously described procedures
- Close the cylinder door and turn it down.
- Carefully inflate the membrane until the wrinkles disappear.
- Lubricate front and rear bearing, lubricate chain.





INFORMATION

Do not excessively lubricate bearings or chain. Two or three pushes with manual applicator is usually enough. Excessive grease can crawl on the surface and pollutes other components.



DANGER

Complete the process by isolating the press:

- *press the STOP switch,
- * disconnect the press from the power supply,
- * turn the main switch to the "O" position and lock it.



MAINTENANCE SCHEDULE

Part of the press	Job description	Frequency
Membrane	Washing	Daily
Membrane	Crimping the membrane screws	After the first season, then every other season
	Leak test	Visual inspection at each wash, detailed inspection at the end of the season
Grease gun (A)	Lubrication	Before the working season or every 100 working hours
Grease gun (B)	Lubrication	Before the working season or every 100 working hours (some presses do not have a lubricator on the rear axis of the cylinder)
Chain	Lubrication	At the beginning of the working season
Drive motor reducer	Checking the oil level	Every 5 years
Compressor	Checking the slats	information is available on the compressor

SRAML SUPPORT

Visit SRAML YouTube channel with supportive videos and guidelines



SRAML support:
00386 30 304 380 (mr. Admir)
support@sraml.com

Seasonal Equipment Maintenance Checklist

Machine: _____

Model: _____

Serial No.: _____

Working Hours: _____

Date: _____

Technician: _____

A. Safety

Inspection Item	OK	NOK	N/A	Remarks
STOP button activated	☐	☐	☐	
Power supply disconnected	☐	☐	☐	
Main switch locked (LOTO)	☐	☐	☐	
Pneumatic pressure released (0 bar)	☐	☐	☐	

B. Pneumatic System

Air Preparation Unit

Inspection Item	OK	NOK	N/A	Remarks
Lubricator oil level correct	☐	☐	☐	
Correct pneumatic oil used	☐	☐	☐	
Lubricator cup clean	☐	☐	☐	
O-ring in good condition	☐	☐	☐	
No pneumatic leaks	☐	☐	☐	

Membrane

Inspection Item	OK	NOK	N/A	Remarks
Membrane screws tightened	☐	☐	☐	
Membrane visually inspected	☐	☐	☐	
Leak test performed (0.2 bar)	☐	☐	☐	
No air leakage detected	☐	☐	☐	

Pressure Safety Valve

Inspection Item	OK	NOK	N/A	Remarks
Valve opens during test	☐	☐	☐	
Valve resealed correctly	☐	☐	☐	
Relief pressure verified	☐	☐	☐	

C. Mechanical Components

Bearings

Inspection Item	OK	NOK	N/A
Front bearing lubricated	☐	☐	☐
Rear bearing lubricated (if installed)	☐	☐	☐
Food-grade grease used	☐	☐	☐

Chain Drive

Inspection Item	OK	NOK	N/A
Chain tension 10–15 mm	☐	☐	☐
Chain lubricated	☐	☐	☐
Chain wear acceptable	☐	☐	☐
Sprockets in good condition	☐	☐	☐

D. Safety System

Safety Wires

Inspection Item	OK	NOK	N/A
Wire tension correct	☐	☐	☐
Green indicator visible	☐	☐	☐
Trigger releases correctly	☐	☐	☐

Safety Switches

Inspection Item	OK	NOK	N/A
Side switches operate correctly	☐	☐	☐
Reset function enabled	☐	☐	☐
Door interlocks functional	☐	☐	☐

E. Electrical & Sensors

Inspection Item	OK	NOK	N/A
Position sensor secure	☐	☐	☐
Sensor gap 1–2 mm	☐	☐	☐
Sensor LED switches correctly	☐	☐	☐
Electrical cables undamaged	☐	☐	☐

F. Functional Test

Manual Mode

Function	OK	NOK	Remarks
Left rotation	☐	☐	
Right rotation	☐	☐	
Immediate stop in neutral	☐	☐	
Compressor operation	☐	☐	
Membrane inflation	☐	☐	
Pressure release	☐	☐	
Vacuum function	☐	☐	

Automatic Mode

Function	OK	NOK	Remarks
Left rotation	☐	☐	
Right rotation	☐	☐	
Membrane inflation	☐	☐	
Membrane vacuum	☐	☐	
Discharge	☐	☐	
Door loading	☐	☐	
Axial loading	☐	☐	
Door positions	☐	☐	

G. Vacuum Turbine

Inspection Item	OK	NOK	N/A
Vacuum valve activates correctly	☐	☐	☐
Air discharge from turbine verified	☐	☐	☐
No abnormal vibration	☐	☐	☐
No abnormal noise	☐	☐	☐
Cooling passages clean	☐	☐	☐
Suction filter clean	☐	☐	☐
Air piping leak-free	☐	☐	☐
Cooling fins clean	☐	☐	☐
Fan cover clean	☐	☐	☐
Electrical wiring intact	☐	☐	☐

H. Compressor (Graphite Vanes)

Inspection Item	OK	NOK	N/A
Graphite vane wear inspected	☐	☐	☐
Intake filter cleaned/replaced	☐	☐	☐
Internal graphite dust removed	☐	☐	☐
Cooling fins clean	☐	☐	☐
Ventilation openings unobstructed	☐	☐	☐

I. Visual Inspection

General Condition

- ☐ Machine clean
- ☐ No corrosion
- ☐ No structural damage
- ☐ Machine level and stable
- ☐ Wheels/feet in good condition
- ☐ Doors operate correctly

Safety

- ☐ Guards installed
 - ☐ Covers secure
 - ☐ Safety labels legible
 - ☐ Emergency stop operational
-

Fasteners

- ☐ Bolts tight
- ☐ Nuts secure
- ☐ No missing fasteners

Controls

- ☐ Push buttons functional
- ☐ Indicator lights operational
- ☒ *Shafts and couplings undamaged*

Product Contact Parts

- ☐ Hygienically clean
 - ☐ No corrosion
 - ☐ No contamination (biofilm of bacteria colony)
 - ☐ No scratches affecting product quality
-

J. Seasonal Maintenance

During Season

- ☐ Membrane washed after each working day

After Season

- ☐ Machine completely washed
 - ☐ Membrane stored slightly inflated
 - ☐ Bearings lubricated
 - ☐ Chain lubricated
 - ☐ Machine isolated and locked
-

K. Final Assessment

Item	Result
Machine ready for operation	☐ YES ☐ NO
Additional repairs required	☐ YES ☐ NO
Spare parts required	☐ YES ☐ NO

Parts Replaced

Corrective Actions

Technician: _____

Customer Representative: _____