



PRESS BRAKE PREVENTIVE MAINTENANCE PROGRAM

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PREVENTIVE MAINTENANCE PROGRAM

Structured inspections, measurable accuracy and condition tracking, machine-specific addendums, photographic documentation, and prioritized follow-up for hydraulic, mechanical, servo-electric, and hybrid press brakes.

Reduce unplanned downtime

Identify hydraulic leakage, alignment changes, backgauge wear, electrical deterioration, cooling problems, and developing failures before they stop production.

Improve bending accuracy and consistency

Track Y1/Y2 synchronization, ram-to-bed parallelism, backgauge backlash and repeatability, crowning response, hydraulic pressure, temperature, and test-bend results.

Turn findings into action

Provide photographs, baseline comparisons, Critical/High/Medium/Monitor priorities, parts requirements, and a separate repair quotation workflow after the PM visit.

Service coverage: United States, Mexico, and Canada

Programs are quoted according to machine configuration, service level, travel requirements, requested testing, tooling, and production availability.



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THREE LEVELS OF PRESS BRAKE PREVENTIVE MAINTENANCE

Choose the level that matches production demands, machine condition, accuracy requirements, and available downtime.

1

Basic Inspection PM

A focused condition inspection and functional review intended to identify visible or developing service concerns.

Includes: Operator and maintenance interview; safety-device functional observations; hydraulic, lubrication, cooling, ram, tooling, backgauge, electrical, and control inspection; pressure/fluid checks; cabinet and filter service as applicable; representative production test; written findings.

Best suited for: Lower-use machines, annual condition reviews, or customers needing an economical inspection before planning repairs.

2

Standard PM

A detailed preventive-maintenance service with backups, measured values, trending, photographs, and accuracy checks.

Includes: Everything in Basic plus parameter and program backup where supported; battery checks; hydraulic pressure and temperature; Y1/Y2 or ram parallelism; backgauge backlash and repeatability; crowning and clamping review; test-bend results when authorized; baseline update; photo log; prioritized recommendations.

Best suited for: Most production press brakes and customers who want measurable records and clearer maintenance planning.

3

Comprehensive PM, Alignment & Calibration

The highest level for critical machines, recurring angle problems, relocations, crashes, control retrofits, or major hydraulic repairs.

Includes: Everything in Standard plus machine leveling; ram-to-bed and Y1/Y2 alignment/calibration; backgauge X/R/Z calibration; crowning verification; tooling centerline checks; test bends at left/center/right; documented before-and-after measurements; permanent baseline.

Best suited for: Critical production machines, high-use environments, accuracy complaints, relocation acceptance, or machines with recurring synchronization and backgauge concerns.

SERVICE-LEVEL COMPARISON

Inspection / deliverable	Basic	Standard	Comprehensive
Operator interview and documented machine history	Included	Included	Included
Safety-device functional observations	Included	Included	Included
Hydraulic, lubrication, ram, tooling, backgauge, electrical, and control inspection	Included	Included	Included
Cabinet/filter cleaning and representative production test	Included	Included	Included
Parameter/program backup where supported	-	Included	Included
Pressure, temperature, battery, oil/filter dates, and baseline data	Current readings	Recorded and compared	Permanent baseline
Y1/Y2 or ram parallelism and backgauge backlash/repeatability	Visual / basic	Measured	Measured and calibrated
Crowning, clamping, and test-bend review	Functional	Measured as required	Verified and documented
Photo documentation and evidence log	As needed	Included	Included
Machine leveling and ram-to-bed alignment	-	Optional	Included
Backgauge X/R/Z calibration	-	Optional	Included
Before-and-after measurement report	-	As required	Included



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A COMPLETE PRESS BRAKE PM WORKFLOW

The program creates useful records before, during, and after the service visit.

- 1 Pre-service review**
Confirm manufacturer, model, serial number, control, drive type, safety system, backgauge axes, known problems, recent crashes or repairs, production demands, and requested PM level.
- 2 Core inspection and controlled testing**
Complete the integrated fillable report and the machine-specific addendums that apply. Use suitable tooling, material, guarding, and customer authorization for functional tests.
- 3 Permanent baseline and trend comparison**
Track hydraulic pressure, oil and cabinet temperature, Y1/Y2 or ram parallelism, backgauge backlash and accuracy, crowning response, bend-angle results, battery voltage, oil/filter dates, and operating hours.
- 4 Photographic evidence**
Attach photographs of leaks, worn tooling interfaces, damaged wiring, contamination, collision damage, unsafe conditions, alignment findings, and completed repairs.
- 5 PM completion sticker**
Apply a numbered sticker showing the report number, completion date, next PM due date, service level, and engineer.
- 6 Prioritized repair quotation**
Classify findings as Critical, High, Medium, or Monitor, then transfer them to a separate repair and parts quotation worksheet.
- 7 Customer delivery and follow-up**
Email the completed PDF report, applicable addendums, baseline record, photographs, and a separate repair quotation when follow-up is required.

Recommended service frequency

Every 6 months	High-use, multiple-shift, critical-production, dirty, hot, or demanding environments.
Annually	Typical production machines with regular operator and in-house maintenance.
Every 18-24 months	Lower-utilization machines with a stable baseline and documented maintenance history.
After relocation, crash, control retrofit, or major hydraulic repair	Comprehensive PM, alignment, and calibration before full production is recommended.

Deliverables

- Completed fillable PM report suitable for printing or emailing
- Applicable machine-specific addendums
- Baseline and trend comparison record
- Photo and evidence log
- Prioritized repair and parts recommendations
- PM completion sticker record
- Separate repair quotation worksheet when follow-up is required



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MACHINE-SPECIFIC ADDENDUMS

Only the addendums that match the machine configuration are attached to the core report.

Mechanical press brake

Flywheel, clutch/brake, crankshaft, pitmans, gibs, counterbalance, depth control, stopping consistency, and mechanical lubrication.

Torsion-bar / conventional hydraulic

Torsion-shaft synchronization, mechanical depth stops, cylinder balance, hydraulic sequence, manual backgauge, and conventional controls.

Synchronized hydraulic Y1/Y2

Linear scales, proportional valves, amplifier electronics, closed-loop synchronization, cylinder drift, calibration, crowning, and angle consistency.

Servo-electric / hybrid

Servo motors, belts/spindles, brakes, regenerative or energy-storage components, hybrid pump systems, load distribution, and position repeatability.

CNC control and data backup

CYBELEC, ESA, Delem, Amada, Cincinnati, and other controls: parameters, programs, tools, materials, batteries, axis configuration, alarms, and communication.

Laser guard / light curtain / safety system

DSP, Fiessler AKAS, LaserSafe, light curtains, safety PLCs, muting/blanking, safe-speed signals, restart inhibit, and controlled functional checks.

Multi-axis backgauge and crowning

X, X1/X2, R, Z1/Z2, Delta-X, gauge fingers, backlash, accuracy, coordinated movement, and mechanical or hydraulic crowning.

Program advantages

More useful than a simple checklist

Measured values, photographs, baseline comparisons, and configuration-specific addendums create a practical maintenance record.

Better continuity between visits

Future service engineers can compare current hydraulic, alignment, backgauge, and angle results with the established baseline.

Clear repair priorities

Critical, High, Medium, and Monitor classifications help customers plan production, parts, shutdowns, and capital decisions.

Professional customer communication

The completed report can be saved, printed, emailed, and paired with a separate repair quotation.

Schedule a Press Brake Preventive Maintenance Service

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Safety note: Preventive-maintenance observations and controlled functional checks do not replace the machine risk assessment, formal safety validation, OEM instructions, lockout/tagout procedures, or applicable regulations and standards.