



Triad Service / Inspection Sheet

Daily

- Inspect machine daily for any debris that may be stuck in the machine or guides. Keep machine clean.
- Inspect Weld Rollers to make sure they are clean and free of any debris. Check for cracks or pits. Check shape to see if very worn or rounded edges. Replace Weld Rollers when needed.
- Check Gas Shock by engaging the wedge or swinging the wedge in and out to see if there is plenty of pressure. If the gas shock is weak the weld quality will start to degrade. Replace when needed or if movement feels weak.
- Inspect Hot Wedge for shape and buildup of any material. Clean if needed lightly with a wire brush, only to remove any loose material. The black color will not damage or cause harm to the welding but, If the wedge shape is deformed, bent, chipped, or damaged, replace before using as damage to Job or Machine may occur. Inspect the wedge temperature on the controller as you turn on the machine. The Temperature should rise fairly quickly to the set point. If the wedge takes a very long time to reach temperature, this may indicate a faulty heater and should be replaced. If not replaced, the temperature will drop dramatically during welding and could cause failures sporadically in the welded areas. Acceptable temperature drop during welding not to exceed 45 degrees over a 3 meter distance. Replace when needed.

Weekly

- Complete all Daily Inspections.
- Check under carriage rollers for any debris that may be caught around axles or built up on wheels. Clean with Isopropyl Alcohol if needed. Replace if damaged, Cracked or coming off the core / bearings.
- Check the drive roller underneath the lower weld roller. Make sure it is free of any debris and that the wheel can be engaged and disengaged and the movement is not impaired. Replace if any damage or flat spots in roller.
- Check guides for overall condition. Replace if damaged or worn with grooves.

Monthly

- Complete all Daily and Weekly Inspections.
- Check chains to make sure they have not stretched; the chain rubs and tensioners are tight and do not have too much wear causing chains to be loose. Do this by first lifting the handle to open the rollers, move them with your fingers to see how much slack or movement before engaging the drive motor. If the movement is more than a few mm's the chains can be tightened. Remove chain covers on each side of the machine and check nylon rubs for condition, use tensioners to tighten chains. 1mm - 2mm of slack maximum. Replace rubs when wear reaches 2mm deep from chain edges. Use a very little amount of grease to lubricate the chains if needed.
- Check all functions of machine for proper operation. Forward/Reverse, Auto/Manual, Speed Control moves freely and speed responds accordingly, Temperature Controller Up and Down arrows change the set point and controller responds accordingly.

Please Note: If any of the electronics do not work or the drive motor does not move when wedge is engaged. First check to make sure the machine controls are in the proper settings for welding. Auto - Forward. If settings are correct, proceed to check the fuses on the top of the machine. Change if needed. Always perform these services with the power off and disconnected from power source to avoid harm. If any other issues requiring the inspect of the internal workings of the machine, please contact Miller Weldmaster or your Local distributor for assistance.