



maintenance report

customer and machine information

Customer:	Syddansk Erhvervsskole		
Contact person:	Kasper Moesgaard		
Service agreement:	Basic	Date current maintenance:	26.01.2026
Type of maintenance:	Einmal Wartung	Date next maintenance:	26.01.2027
		Date last maintenance:	08.10.2024
Machine type:	TruPrint 1000 (G01)		
Machine number:	S0711Q0147	Operating hours NC:	19426
Laser type:	TP-210-AC	Laser on:	19450
Laser number:	423857	Beam on:	1634
TRUMPF technician:	FROST	WCLM Version:	06.08.2020

Report Machine status

● Machine can produce unrestricted.

R 1. Summary of needed repairs and spare parts

Nr. maintenance point	Comment TRUMPF technician		
1.03	Leckagerate exceeded allowed Value		
Nr. maintenance point	Needed spareparts	TRUMPF Mat-Nr.	Amount:

① For the purpose of repair commission or spare part order, please get in contact with your TRUMPF Service.

R 2. Further comments

R 3. Customer adverted to open points / repairs not needed
 customer adverted to the maintenance points according to the user manual,
 which have to be performed between the yearly maintenance interval. not needed
 k2:8364753 k3:S0711Q0147 FormFile01:maintenancechecklist

R 4. Signature

Signature and short name TRUMPF technician: Frost / TITA500fr

Date: 26.01.2026

Name & signature customer: _____

maintenance checklist

Machine type: TruPrint 1000 (G01)
 Machine nr: S0711Q0147
 Customer: Syddansk Erhvervsskole
 Version: 6

Maintenance contract: Basic
 Maintenance coverage: Einmal Wartung
 Date current maintenance: 26.01.2026
 Version: 06.08.2020

Options: Zirox sensor, Glove-Box, Singlelaser, Powder Bed Monitoring

Nr.	Icon ID	maintenance point	maintenance operation	actual value	status
1.00 maintenance preparation					
1.01			check of the last maintenance list		yes
1.02			dialogue with the customer about machine problems		yes
1.03			leakage test before maintenance		✗

Status legend:

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2.00 Exterior area of the machine					
2.01	159	Enclosed protective housing	Machine covering must be cleaned		👁️ ✓
2.02	166	Machine leg	Leveling of the machine must be set		👁️ ✓
			Measuring variable [mm/m]: < 0,05		👁️ ✓
2.03	6	Enclosed protective housing - rear side	Filter mats must be replaced		🔧 ✓

3.00 Shielding gas system					
3.01	45	Shielding gas system	Oxygen sensors safety must be replaced		🔧 ✓
3.02	88	Machine gas connection	Gas inlet pressure must be checked	Pressure [bar]: <u>5,0</u>	👁️ ✓ 🔧 ✓
3.03	18	Internal pressure control device	Pressure must be checked	Pressure [bar]: <u>2,5</u>	👁️ ✓ 👁️ ✓
3.04	16	Operating panel	Gas valves (V1, V2, Boost, Fine): flow rate must be set	Flow rate [l/min]: <u>2,9</u> Flow rate [l/min]: <u>25,0</u> Flow rate [l/min]: <u>11,5</u> Flow rate [l/min]: <u>11,5</u>	👁️ ✓ 👁️ ✓ 👁️ ✓ 👁️ ✓
3.05	24	Flow sensor	Flow sensor must be checked		👁️ ✓
3.06	90	Operating panel	Oxygen sensors: operating hours must be reset		🔧 ✓
3.08	160	Drain valve	Fine filter previous to pressure reducer must be checked		🔧 ✓
3.09	161	Main filter	Main filter must be replaced		👁️ ✓
3.10	8	Pipe installation	Piping to the main filter must be cleaned		🔧 ✓
3.12	19	Main filter	Pipe clip: seals must be replaced		🔧 ✓
3.13	25	Overpressure and drain valve	Drain valve: fine filter must be replaced		🔧 ✓
3.14	27	Circulation pump	Safety filter must be checked		🔧 ✓

4.00 Control					
4.01	29	Operating panel	Machine data must be saved		👁️ ✓
4.02	35	IPC	Buffer battery must be replaced		🔧 ✓
4.03	34	IPC	Connector must be checked		👁️ ✓
4.04	32	Rear side of the machine	Temperature and moisture sensor must be cleaned		👁️ ✓
4.05	37	Process chamber monitoring	Camera image must be checked		👁️ ✓

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Options: Zirom sensor, Glove-Box, Singlelaser, Powder Bed Monitoring

Nr.	Icon ID	maintenance point	maintenance operation	actual value	status
5.00 Process chamber					
5.01	44	Process chamber	Surfaces must be cleaned		✖ ✓
5.02	40	Supply and build cylinder	Mechanical components must be cleaned		👁 ✓
5.03	42	Process chamber	LED lighting must be cleaned		👁 ✓
5.04	52	Overflow container	Clamping mechanism must be set		👁 ✓
5.05	50	Process chamber	Door seals must be replaced		✖ ✓
5.06	53	Overflow container	Seal must be checked		👁 ✓
5.07	94	Process chamber	Camera protective glass must be cleaned		👁 ✓
5.08	47	Process chamber - rear space	Coater drive: belt tension must be checked		👁 ✓
5.09	56	Process chamber - rear space	Rear space must be cleaned		✖ ✓
5.10	49	Process chamber - rear space	Coater: cover strip must be replaced		✖ ✓
5.11	48	Process chamber - rear space	Coater: mechanics must be checked		👁 ✓
6.00 Drive housing					
6.01	58	Piston actuator	Piston rod seal must be checked		👁 ✓
6.02	57	Piston actuator	Piston must be cleaned		✖ ✓
6.03	60	Piston actuator	Belt tension must be checked		👁 ✓
7.00 Optics					
7.01	70	Scanner	Fan must be checked		👁 ✓
7.02	68	IPC	Scanner plug - RTC5 board: firm fitting must be checked		👁 ✓
7.03	67	Scanner	Scanner to base plate must be leveled		👁 ✓
			Measuring variable [°]: < 0,03		👁 ✓
			Measuring variable [mm/m]: <0,5		👁 ✓
8.00 Laser					
8.01	82	Laser housing	Fan must be cleaned		👁 ✓
8.02	83	LLC (Laser light cable)	LLC visual inspection must be performed		👁 ✓
9.00 Electrics					
9.01	13	PILZ safety relay	Safety functions must be checked		👁 ✓
			Emergency Switch : O.K		👁 ✓
			Laser Off, Pump Off when O2: O.K		👁 ✓
9.02	7	Switch cabinet	Input voltage must be measured		👁 ✓
			Voltage [V]: 231,5		👁 ✓
9.03	12	Power pack	15 V voltage supply must be measured		👁 ✓
			Voltage [V]: 15,1		👁 ✓
9.04	11	Power pack	24 V voltage supply must be measured		👁 ✓
			Voltage [V]: 24,1		👁 ✓
9.05	9	Switch cabinet	Fan function must be checked		👁 ✓
11.00 Zirom sensor					
11.01	23	Process chamber - rear side	Oxygen sensor process control 100ppm (Zirom) must be checked		👁 ✓
12.00 Glove-Box					
12.01	41	Glove box	Gloves must be checked		👁 ✓

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13.00 Singlelaser					
13.01	63	Substrate plate	Focal position must be checked		👁️ ✓
13.02	180	Substrate plate	Scanfield must be calibrated		✖️ ✓
13.03	69	Plane-field lens	Rubber collar must be checked		👁️ ✓
13.04	71	Process chamber	Scanner: protective glass must be cleaned		✖️ ✓
13.05	80	Substrate plate	Laser power must be measured		👁️ ✓
			Measuring point 1 ± 5% [W]: 31,6		👁️ ✓
			Measuring point 2 ± 5% [W]: 90,7		✖️ ✓
			Measuring point 3 ± 5% [W]: 152,5		✖️ ✓
			Measuring point 4 ± 5% [W]: 201,8		✖️ ✓
			:		
13.06	91	Operating panel	Operating hours must be documented		👁️ ✓
			Operating hours NC [h]: 19426		👁️ ✓
			Operating hours laser On [h]: 19450		👁️ ✓
			Operating hours beam On [h]: 1634		👁️ ✓
14.00 Powder Bed Monitoring					
14.01	135	Process chamber - interior	LED flash protective glass must be cleaned		👁️ ✓
14.02	144	Process chamber - interior	Powder Bed Monitoring must be calibrated		✖️ ✓
16.00 Final activities					
16.01		leakage test after maintenance			👁️ ✓
16.02		walkthrough the maintenance list with customer			yes
16.04		leaving maintenance checklist at the customer und send it via SIS-Mobile			👁️ ✓
16.05		reset passwords and pull of service key and short-circuit plug			👁️ ✓
16.06		fixing small problems up to max. 30min			🕒

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Overview consumables

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Basic

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Consumable designation	Material number	Amount	ME
Rear filter element white 6 pcs, G4	2447113	1	Stück
Oxygen sensor Pewatron PO2ES-103P	2619082	1	Stück
Oxygen sensor safety MAX-250B	2249087	1	Stück
Set filter bin spin on 1pc	2436446	1	Stück
Pipe cleaning brush	2447119	1	Stück
Quick-release coupling seal	2091126	4	Stück
Fine filter insert	2064537	2	Stück
Filter element 10µm, pack of 3,	2261280	1	Stück
Lithium battery Renata CR2477N	0129563	1	Stück
Process chamber door seal	2531246	2	Stück
Cleaning tissue PROSAT soaked with alc.	1433449	2	Stück
Belt coater motion	2064355	1	Stück
Focal position - calibration plate	2566039	1	Stück
Scanner - calibration plate	2435712	5	Stück