

Task	When To Do It			
	Daily	Weekly	Quarterly	Every 6 Months
Perform Walk Around Safety Inspection	X			
Clean External Surfaces	X			
Check EMERGENCY STOP Button For Proper Operation	X			
Inspect Vacuum Cup Filters	X			
Clean Photo Eyes		X		
Inspect Glue Gun Nozzles & Hoses		X		
Inspect Conveyor Belts			X	
Lubricate Drive Chains			X	
Inspect Chain Tensions			X	
Check Fastners				X
Grease Zerk Fittings				X
Inspect Gearbox Seals				X

Table 7-1 - Periodic Maintenance Schedule

7.2. Daily Tasks

7.2.1. Walk Around Safety Inspection



Before continuing with any maintenance checks, shut off power supply to machine. You can be severely injured if you do not.

At the beginning of each day, do a daily safety inspection of the machine and its surrounding area. Pick up any trash or obstacles around the machine. Wipe up any grease or spills.

Commodities like rolls of film should be placed conveniently, yet out of the way so an operator can move around safely.

The areas in red represent areas around the machine that should be kept clear so an operator can safely operate the equipment.

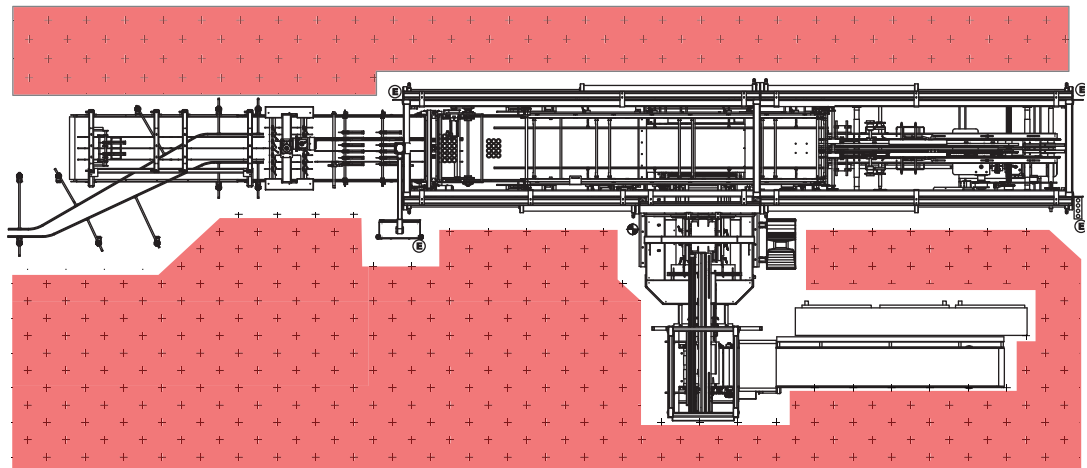


Figure 7-1 - Walk around inspection

7.2.2. Cleaning External Surfaces



Required Tools

You need the following special tools for this procedure:

- cleaning wipes or a soft, damp cloth



Warning

Turn off machine's main disconnect switch before servicing machine. You can get severely injured if you do not.

1. Use cleaning wipes to clean external surfaces of the machine.

7.2.3. Check Emergency Stop Button

Verify functionality of all Emergency Stop push buttons. With the machine cycling, press the **EMERGENCY STOP** button. The machine should stop immediately. Pull button back up and press RESET button to reset.



E-Stop in normal run state.



E-Stop activated.
(LED illuminated)

Figure 7-2 - Emergency Stop Push Button

7.2.4. Inspect Vacuum Cup Filters

Inspect the vacuum cups for corrugate dust. Use an air nozzle with low pressure to blow away debris.



7.3. Weekly Tasks

7.3.1. Cleaning Photo Eye

To clean the photo eye spray a small amount of window cleaner on it and wipe it clean with a cleaning wipe.

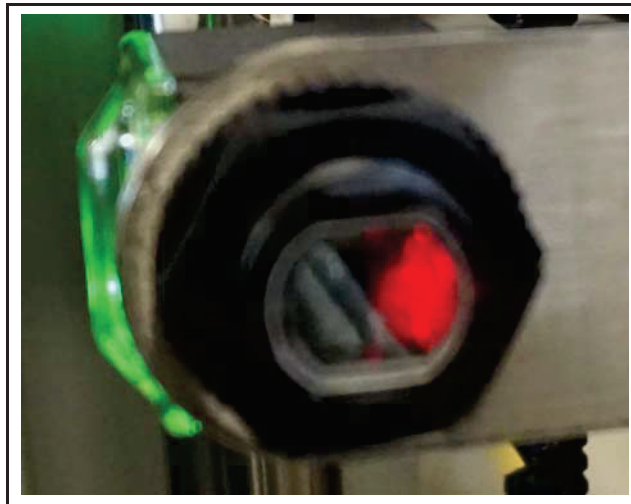
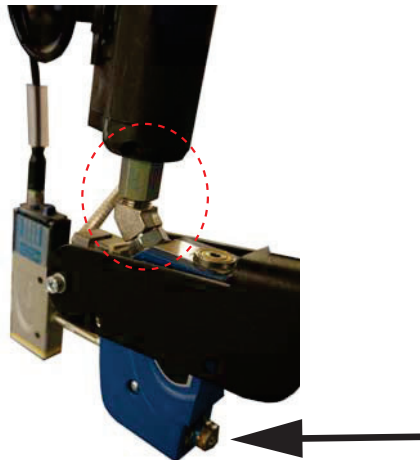


Figure 7-3 - Photo Eye Lens

7.3.2. Inspect Glue Guns & Hoses

The type of glue system depends on the application, but the principal is the same regardless. Inspect and clean as necessary all glue system components; nozzles, glue gun, hoses and connections.



7.4. Quarterly

7.4.1. Inspect & Clean Conveyor Belts

Inspect the plastic modular belting for any loose pins at the edges of the belt (1) or damaged links (2). Using cleaning wipes or a soft damp cloth, wipe remove any built up debris.

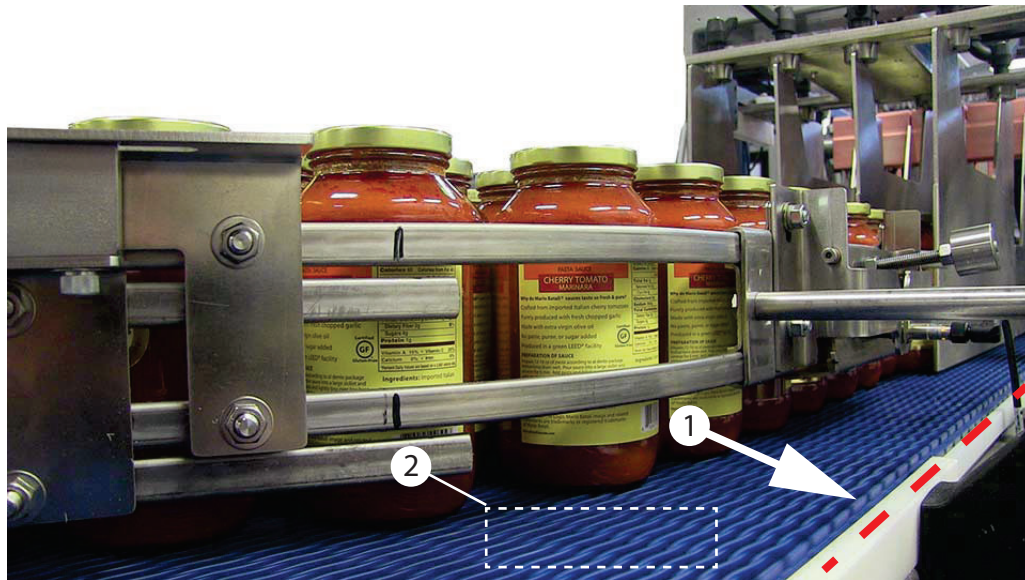


Figure 7-4 - Inspect Modular Belts

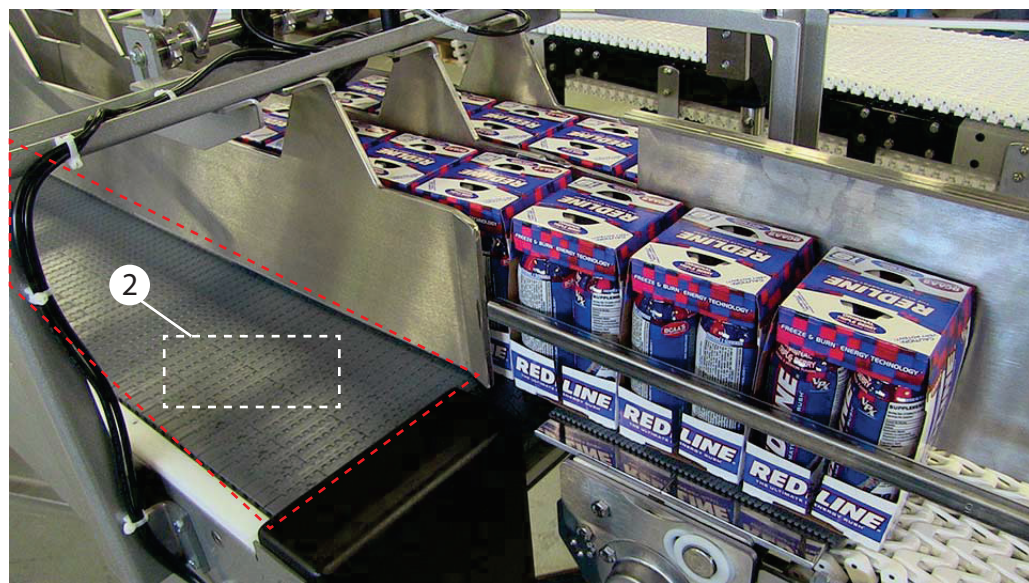


Figure 7-5 - Inspect Table Top In-feed Conveyor Belt

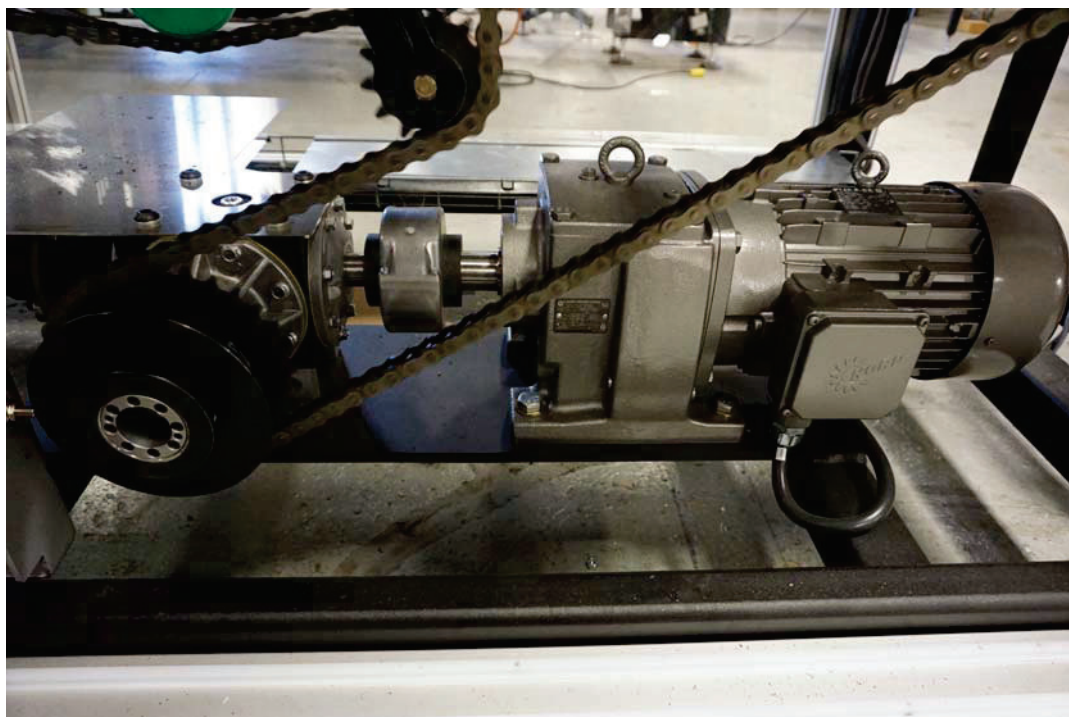
7.4.2. Clean & Lubricate Drive Chains



Required Tools

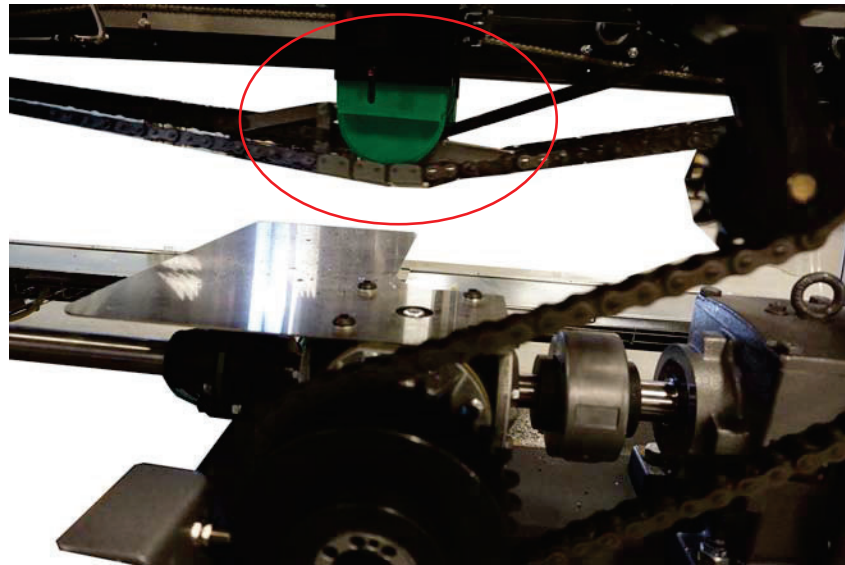
You need the following special tools for this procedure:

- cleaning wipes
- Light weight chain lubricant
- Applicator



7.4.3. Inspect Compression Chain Tension

Each of the Leading and Trailing Compression chains comes with a chain tensioner. Adjust as necessary.



7.5. B-Annual

7.5.1. *Checking Fasteners for Tightness*



Required Tools

You need the following special tools for this procedure:

- Adjustable End Wrench
- Medium Flat Tip Screwdriver
- Medium Phillips Tip Screwdriver
- Set of Hex Wrenches

Check/tighten all exterior fasteners.

7.5.2. *Inspect Gearbox Seals*

The gearbox types used on this equipment are referred to as: “SEALED”, meaning; according to the OEM, the gearboxes are sealed and do not require additional lubrication, but the seals at the motor/gearbox union should be inspected twice a year for leaks.

7.6. Chain & Bearing Maintenance

7.6.1. Chain Lubrication & Care

Proper lubrication is critical in achieving the maximum wear life of any roller chain. As the chain articulates around the sprockets, the pin and bushing wear. This wearing causes the elongation, or “stretch”, in the chain. Lubrication of these surfaces through proper lube application can greatly increase the wear life of the chain.

Recommended Lubricants

Ambient temperature: 20-40 F - SUS Viscosity 100 F of 200-400, SAE Engine oil of 20 Weight, SAE Gear Oil 80 W, ISO 46 or 68, and AGMA lubrication 1 or 2.

Ambient temperature: 40-100 F - SUS Viscosity 400-650, SAE Engine oil of 30 Weight, SAE Gear Oil 85 W, ISO 100, and AGMA lubrication 3.

Ambient Temperature 100-120 F - SUS Viscosity 650-950, SAE Engine oil of 40 Weight, SAE Gear Oil 90, ISO 150, and AGMA lubrication 4.

Ambient Temperature 120-140 F - SUS Viscosity 950-1450, SAE Engine oil of 50 Weight, SAE Gear Oil 90, ISO 220, and AGMA lubrication 5.

7.6.2. Bearing Lubrication & Care

Food Grade

LUBRIPLATE SFL-2 is a **synthetic multi-purpose food-grade grease**, which can be used throughout most modern food processing plants for most all grease lubrication requirements. This product has an approximate operating temperature range of -25 to 400°F. (white in color).

Non-Food Grade

MULTIPLEX RED #2 **lithium complex grease** developed for the lubrication of automotive and industrial equipment operating under heavy loads and at moderate to high temperatures. It is particularly recommended for use in applications that are too severe or require higher performance than provided by conventional extreme-pressure lithium greases.

These are just brands, there are many other comparable brands which can be used on industrial equipment use in secondary packaging.

They only need to be comparable in temperature range, viscosity, and application (food grade or not).