

Part / Area	Check	Setting	Measures	Description	Test frequency			
					D	W	M	H
Seam	Seam monitoring	According to specification	Set seaming rolls if necessary, according to specification of can supplier.	Every 4 h	x			
Seaming rolls	No resistance when turning		Replace if difficult to turn.	1 x at the start of the shift	x			
	Setting		Set, check if necessary.					
	Condition of the seaming roll profile		Remove metal buildup or replace the seaming roll in the event of wear or damage.	1 x per shift	x			
	Preventative maintenance		Change oil in seaming roll.					2500*
Seaming chucks	Check for damage.		Replace.		x			
	Check for wear.		Replace.			x		
End feed	Check the separator knife.		Replace if damaged or worn.	2 x per shift	x			
	Metal debris		Clean. Readjust the end feed.			x		
	Retaining knife		Replace if damaged or worn.			x		
	Play between retaining knife and feed screw	0.15-0.25 mm	Set.			x		
Knock-out pads	Distance of knock-out pad to end in ascent	-0.1-0 mm	Set.				x	
	Wear, damage		Replace.		x			
Lifting stations	Base plate pressure		Check, set.				x	
	Spring deflection, base plate	See chapter "Settings" of the operating instructions	Check.				x	
	Oil leakage		Replace seal. If this occurs, always inform Ferrum Packaging Ltd. Customer Support!		x			
	Condition of the base plate		Replace if damaged or worn.			x		
	Radial play	Max. 0.35 mm	Replace the bearing bushings if the play tolerance is exceeded.			x		
	Axial play	Max. 0.25 mm	Replace the cam roller if the play tolerance is exceeded.			x		

D = daily / W = weekly / M = monthly / H = operating hours

* Based on experience.

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					D	W	M	H
Can seamer height	Pin height	Depending on can	Set using can height gauge. Check again after every height adjustment.			x		
Compressed air system	Pressure	4.5-6 bar	Adjust setting.		x			
	Water buildup		Drain water.		x			
Centralized oil lubrication	Oil level	The oil must be visible in the sight glass.	Refill.		x			
	Oil condition		Change oil if water has become mixed into the oil. If this occurs, always inform Ferrum Packaging Ltd. Customer Support! Empty condensed water from the oil tank using the drainage valve.		x			
	Periodic maintenance		Change oil.					2500*
			Clean oil filter (coarse).				x	
			Replace oil filter (fine).					2500*
End guides	Metal buildup		Clean.			x		
Guides at infeed table and can discharge	Wear, damage		Set/replace.		x			
Infeed chain	Voltage		Set.			x		
	Damaged, deformed or worn fingers		Replace.		x			
Toothed belt	Tension or wear		Correct tension. If this occurs, always inform Ferrum Packaging Ltd. Customer Support!				x	
Drive, can seamer	Wear, damage						x	
Safety devices and equipment	Function/alignment		Set. If this occurs, always inform Ferrum Packaging Ltd. Customer Support!			x		
Cleaning			Carry out in accordance with the operating instructions.		x			
Minor maintenance			Spare parts range. If this occurs, always inform Ferrum Packaging Ltd. Customer Support!					7500 22500
Major maintenance			Spare parts range If this occurs, always inform Ferrum Packaging Ltd. Customer Support!					15000 30000

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