

Power Roll Bed Wet Application Preventive Maintenance

WARNING

- Before attempting any maintenance on this equipment all involved personnel should follow plant internal regulations along with any state, federal, or province regulations.
- The maintenance inspection, checks, and procedures listed in the preventive maintenance tables are assumed with the gated area electrically locked out.
- Before attempting any maintenance or service operation, make sure that:
 - You do not begin any repair procedure until the proper shutdown procedures and the appropriate power lockout procedures have been applied.
 - The system is de-energized; main electrical switches are open.

NOTICE

The maintenance inspection, checks, and procedures listed in the preventive maintenance tables and corrective procedures should be performed when the equipment is immobilized and locked out.

This section contains preventive maintenance schedules with recommended lubrication intervals. Assemblies in this section include:

- **Power Roll Table WA**

Daily Checks

Observe

- Obvious signs of damage to the equipment. Listen to the conveyors - an unusual sound like screeching, grinding, or whining, are indicators of a problem.
- Damage or noticeable wear on the carrying and guide rollers.
- Signs of oil leaks on the equipment or on the floor below any gearbox.

Evaluate


- If you notice any of the above issues, evaluate the cause and the risk involved.

Act

- Schedule or perform necessary maintenance repairs as appropriate.

Mechanical Preventive Maintenance - key

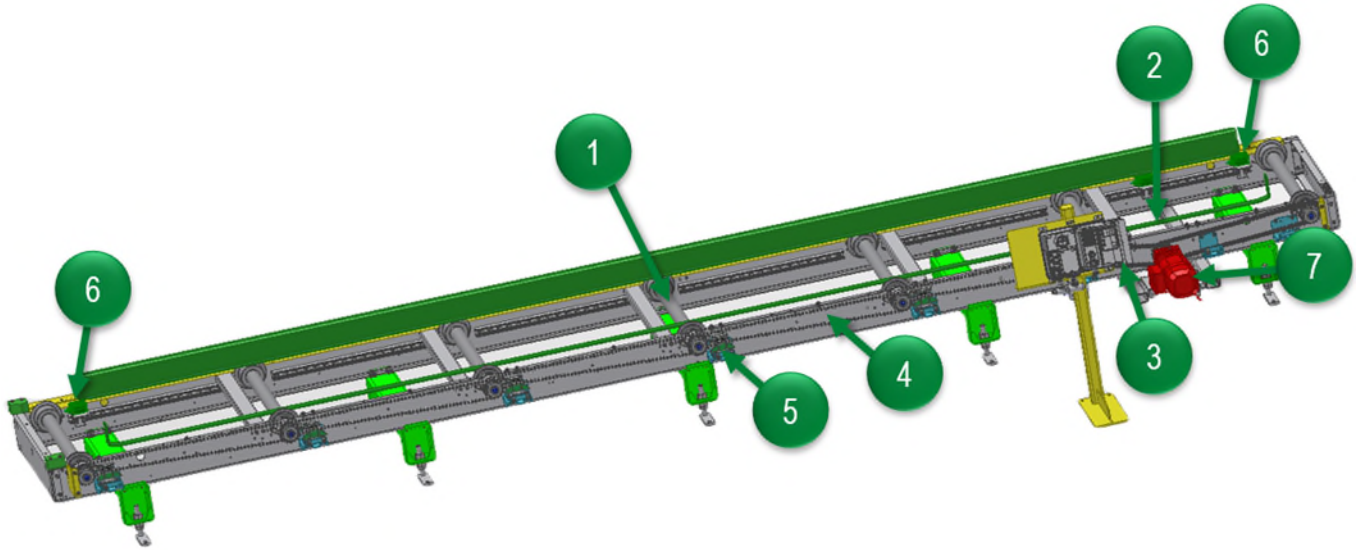
Preventive Maintenance tables consists of:



Item No.	Item Name	Required Operation	Description	Interval
1	Gearmotor	Inspection	<ul style="list-style-type: none"> • Visually inspect gear unit for oil leakage. Check for oil film or grease deposits – clean if necessary. • Check mounting hardware, check paint marks... 	6 Months

- A. Indicates the callout number associated on the schematic drawing, image or figure.
- B. Component name within the assembly.
- C. Required preventive maintenance operation - i.e., inspection or lubrication.
- D. Detailed description of the operation(s) to be performed.
- E. Recommended frequency of PM task.

Power Roll Bed Wet Application Preventive Maintenance Items



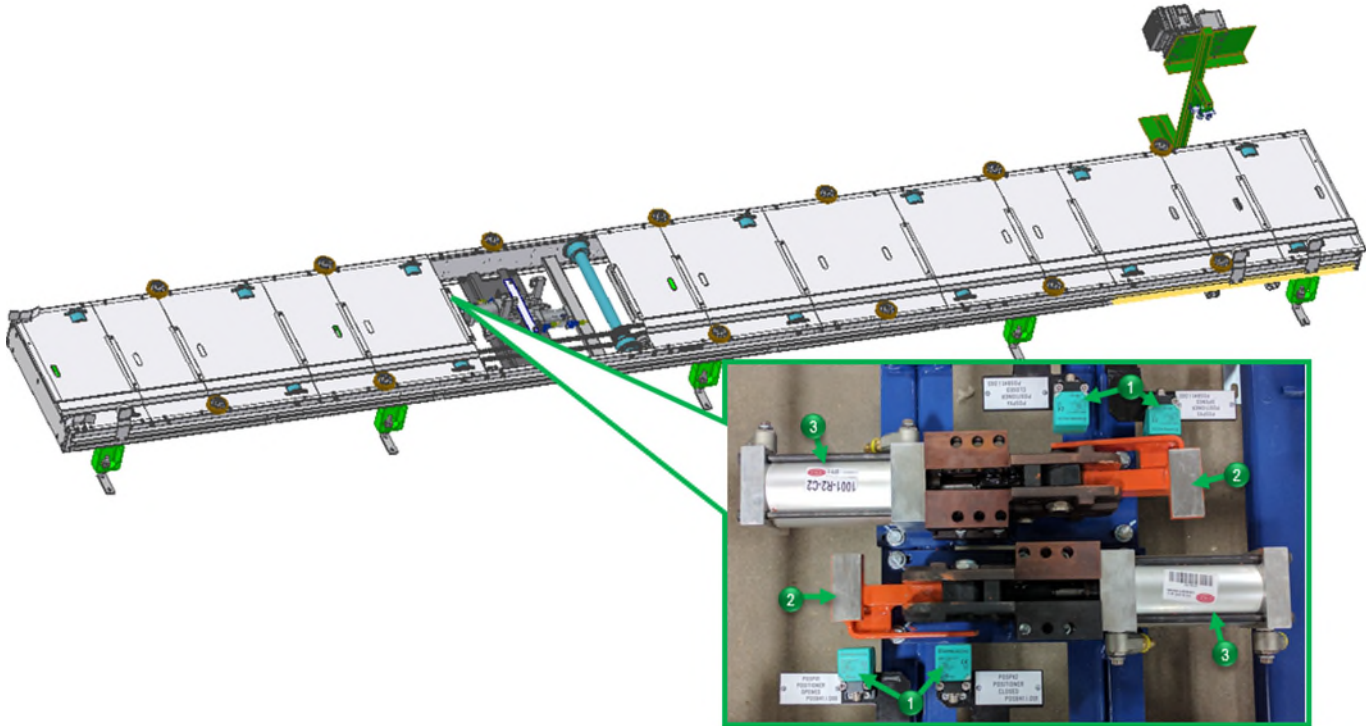
Item No.	Item Name	Required Operation	Description	Interval
1	Roller	Inspection	<ul style="list-style-type: none"> Check rollers for bearing clearance, damage, and wear. Abrasion should not exceed 5 mm on diameter (minimum diameter is 120 mm), unevenness at the surface maximum 3 mm. 	6 Months
2	Motor Drive Sprocket	Inspection	<ul style="list-style-type: none"> Check secure mounting on drive shaft. 	
3	Drive Chain	Inspection	<ul style="list-style-type: none"> Check for sufficient tension, if necessary, replace chain. Check for stretched links. 	3 Months
4	Driven Chain	Inspection	<ul style="list-style-type: none"> Index the table. Check that chains run freely and without excessive noise Check for stretched links. 	
5	Chain Sprocket	Inspection	<ul style="list-style-type: none"> Observe for smooth operation. Check for proper alignment with other pulleys and for any broken cogs. 	6 Months
		Lubrication	<ul style="list-style-type: none"> Apply grease into zerk fitting. Clean off all excess grease. 	
6	Proximity Switch	Inspection	<ul style="list-style-type: none"> Check proximity switches for secure mounting and successful operation. 	

Item No.	Item Name	Required Operation	Description	Interval
7	Gearmotor	Inspection	<ul style="list-style-type: none"> • Use the oil sight glass or remove the oil level plug to check the level of oil. • Check that all electrical connections are secure. If loose, tighten. • Check the electrical connections for evidence of arcing. If evidence of arcing has occurred, replace the damage connection. 	6 Months
		Lubrication	<ul style="list-style-type: none"> • Replace the oil in the gearbox after 3 years of use. 	36 Months

Power Roll Bed WA Optional Items

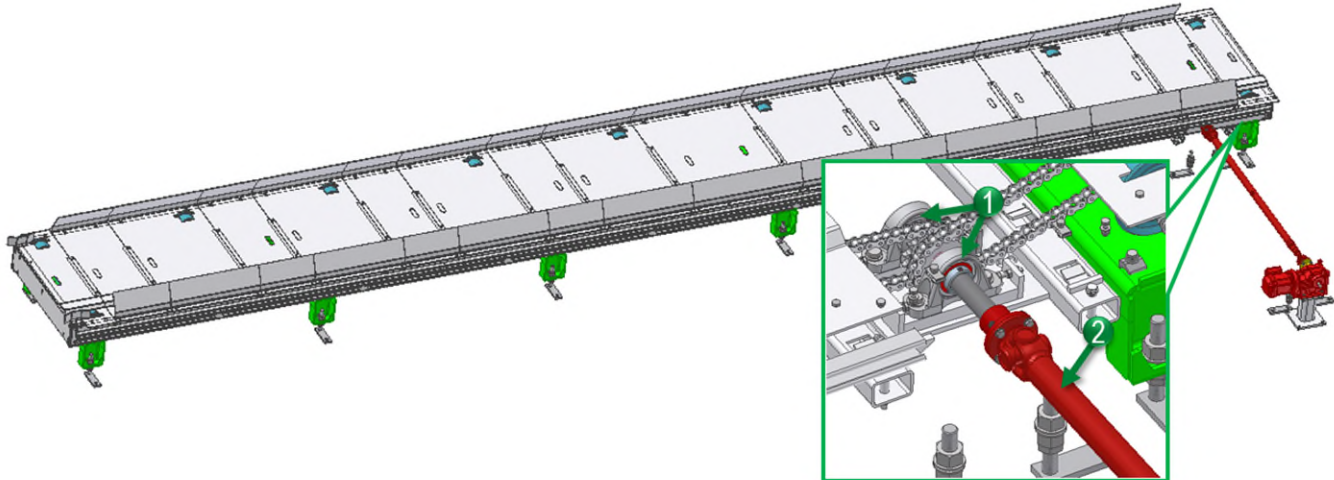
The following option items appear on specific Power Roll Beds and are not typical components. Check the plant METL to verify which station contains the identified options.

Pneumatic Positioner Preventive Maintenance Items



Item No.	Item Name	Required Operation	Description	Interval
1	Prox Switch	Inspection	<ul style="list-style-type: none"> Check for proper operation and secure mounting. Check that cables are connected securely. 	6 Months
2	Clamp	Inspection	<ul style="list-style-type: none"> Check for leaks, smooth operation. 	
3	Cylinder	Inspection	<ul style="list-style-type: none"> Check for excessive free play noise or binding 	

Extended Shaft Preventive Maintenance Items



Item No.	Item Name	Required Operation	Description	Interval
1	Pillow Block Bearing	Inspection	<ul style="list-style-type: none"> Check mounting hardware for proper tightness. Look for paint mark alignment on hardware – retighten if necessary. Check for housing damage. Check for binding or sticking in the bearing housing. Check alignment of the shaft between bearings. 	6 Months
		Lubrication	<ul style="list-style-type: none"> Grease directly with grease gun, or manifold if present, carefully pump grease into the zerk fitting. Bearing is fully lubricated when you see grease leak around shaft. Clean off all excess grease. 	
2	Cardan Shaft	Inspection	<ul style="list-style-type: none"> Inspect all connections and make sure they are secure, check all paint marks. Retighten as necessary. Inspect shaft and flanges for any cracks or damage, replace if damage is found. 	3 Months
		Lubrication	<ul style="list-style-type: none"> Use a grease gun to apply grease, carefully pump grease into the zerk fitting. Coupling is fully lubricated when you see grease leak from all four seals. Clean off all excess grease. 	

Lubrication Requirements - Gearmotor Oil Lubrication

Gearmotor oil can be determined by reading the attached data plates on each gearmotor. The examples below highlight the location to observe the required oil on the data plates. Do not mix oil grades when adding oil. Refer to the manufacturer's instruction manual for additional service requirements and technical data.

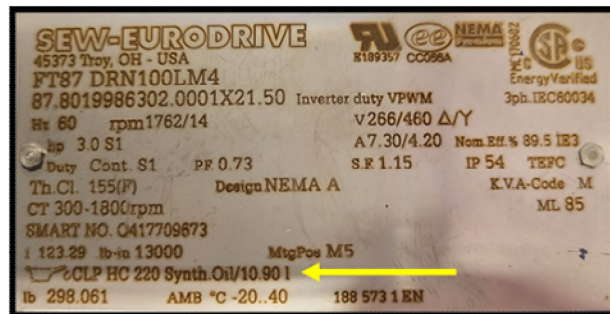
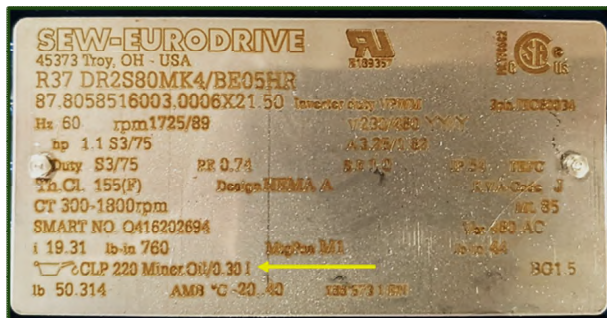
NOTICE

If you are doing a lubricant drain and refill, gearmotor manufacturers typically recommend that you use the same brand of lubricant originally supplied. If you are refilling the gearbox with a non-compatible lubricant, FATA recommends that you first remove any residual with a petroleum solvent or a hot water wash.

CAUTION

Do not use trichloroethylene as a washing solvent.

Data plates on the gearmotors identify the oil type and quantity that they use.



Gearmotor Data Plate Examples

Lubrication Requirements - Grease

The table below lists the plant approved lubricants to use in conveyor components that need lubrication.

Plant Approved Lubrication Chart

Lubrication Name	Manufacturer	Conveyor Asset	Application Points
<i>See complete manual for plant approved lubricants.</i>			

Re-Lubrication Best Practices:

- Always clean the grease fitting of all dirt before attaching the grease gun. Failure to clean the grease fitting before applying grease could result in introducing contaminants into the component resulting in increased wear or clogging the grease fitting orifice so as not to allow the entry of grease. Inspect and replace any damaged fittings. It is helpful to use grease-fitting caps to keep them clean, but still wipe fittings clean before applying grease.
- Always make sure the dispensing nozzle of the grease gun is clean before using. Pump a small amount of grease out of the dispensing nozzle, then wipe the nozzle off with a clean rag or lint-free cloth before attaching it to the grease fitting.
- Do NOT over lubricate or apply excessive amounts of grease. This could lead to ruptured seals and excessive grease outside the fitting, which can attract contaminants and create additional unwanted conditions.
- Know that some greases are not compatible with each other. Ensure that the proper grease is used at every grease point. Applying the wrong grease can cause an incompatibility problem which can quickly cause failures.
- Once relubrication service is complete, clean off old grease and contaminants from the boot, grease/zerk fittings and surrounding components.