

Lift Table 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 for the following component or assembly:

- **Lift Table Wet Application**

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.

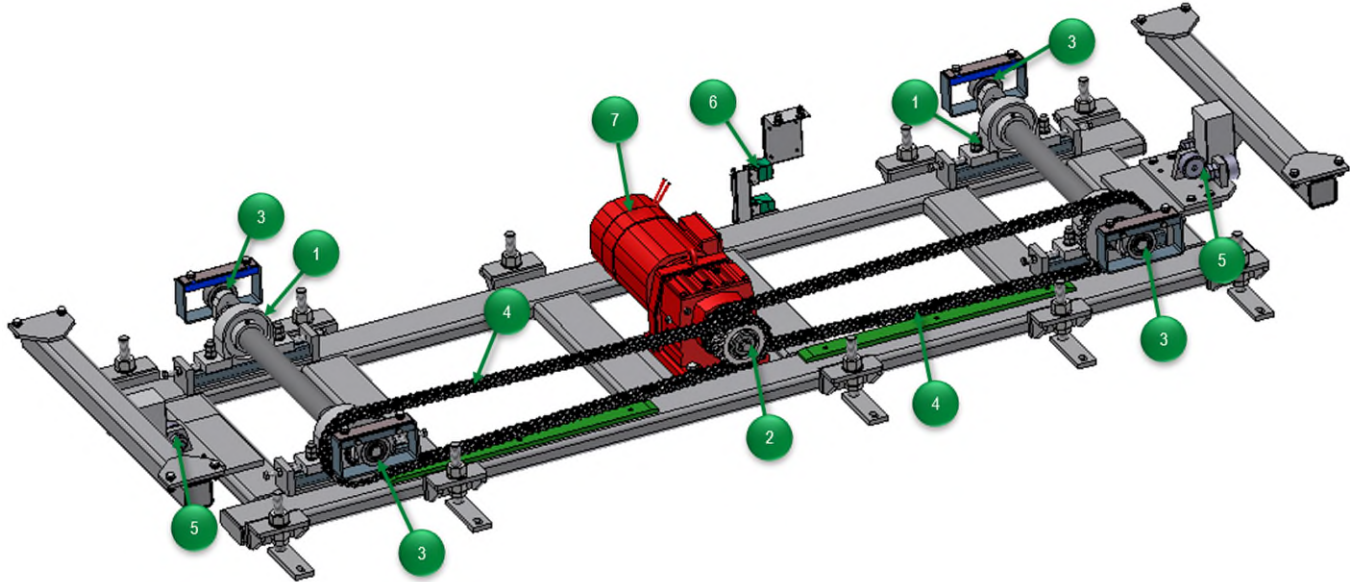
Mechanical Preventive Maintenance - key

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.

Lift Table Wet Application 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, to apply grease, carefully pump grease into the zerk fitting. Bearing is fully lubricated when you see grease squeeze out around shaft. Clean off all excess grease. | |
| 2 | Drive Sprocket | Inspection | <ul style="list-style-type: none"> Check drive sprocket teeth for damage and wear. | |
| 3 | Cam Roller | Inspection | <ul style="list-style-type: none"> Check for steady running, wear or damage. | |
| 4 | Chain | Inspection | <ul style="list-style-type: none"> Check for sufficient tension, if necessary, replace chain. Index the table. Check that chains run freely and without excessive noise Check for stretched links. | |
| 5 | Guide Roller | Inspection | <ul style="list-style-type: none"> Check for excessive wear or damage. Change as necessary. | |

| Item No. | Item Name | Required Operation | Description | Interval |
|----------|------------------|--------------------|--|-----------|
| 6 | Proximity Switch | Inspection | <ul style="list-style-type: none"> • Check for proper operation and secure mounting. • Check that cables are connected securely. | 6 Months |
| 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. | |
| | | Lubrication | <ul style="list-style-type: none"> • Replace the oil in the gearbox after 3 years of use. | 36 Months |

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.

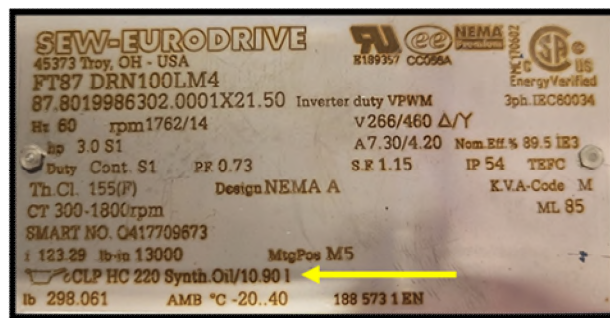
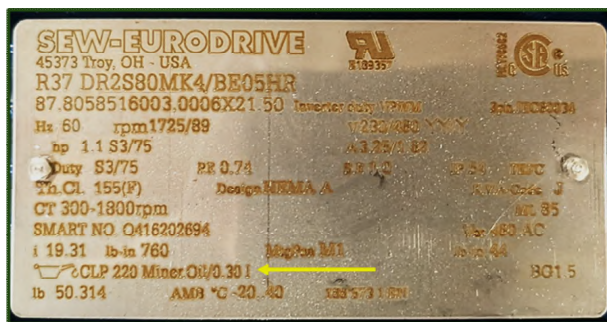
NOTICE

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 |
|------------------------------|----------------|--|--|
| Molub-Alloy 860/220-1 | <i>Castrol</i> | Lift Table Turn Table Shuttle Vertical Drop Lifter Cross Transfer 1-Strand Chain 2-Strand Chain 2-Strand Oven Chain | Bearings Cardan Shafts Rollers Wheels |
| Tribol 290/220 | <i>Castrol</i> | 1-Strand Chain 2-Strand Chain 2-Strand Oven Chain | Chain |

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.