

Skids 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:

- **Paint Skid**
- **Dip Skid**

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.

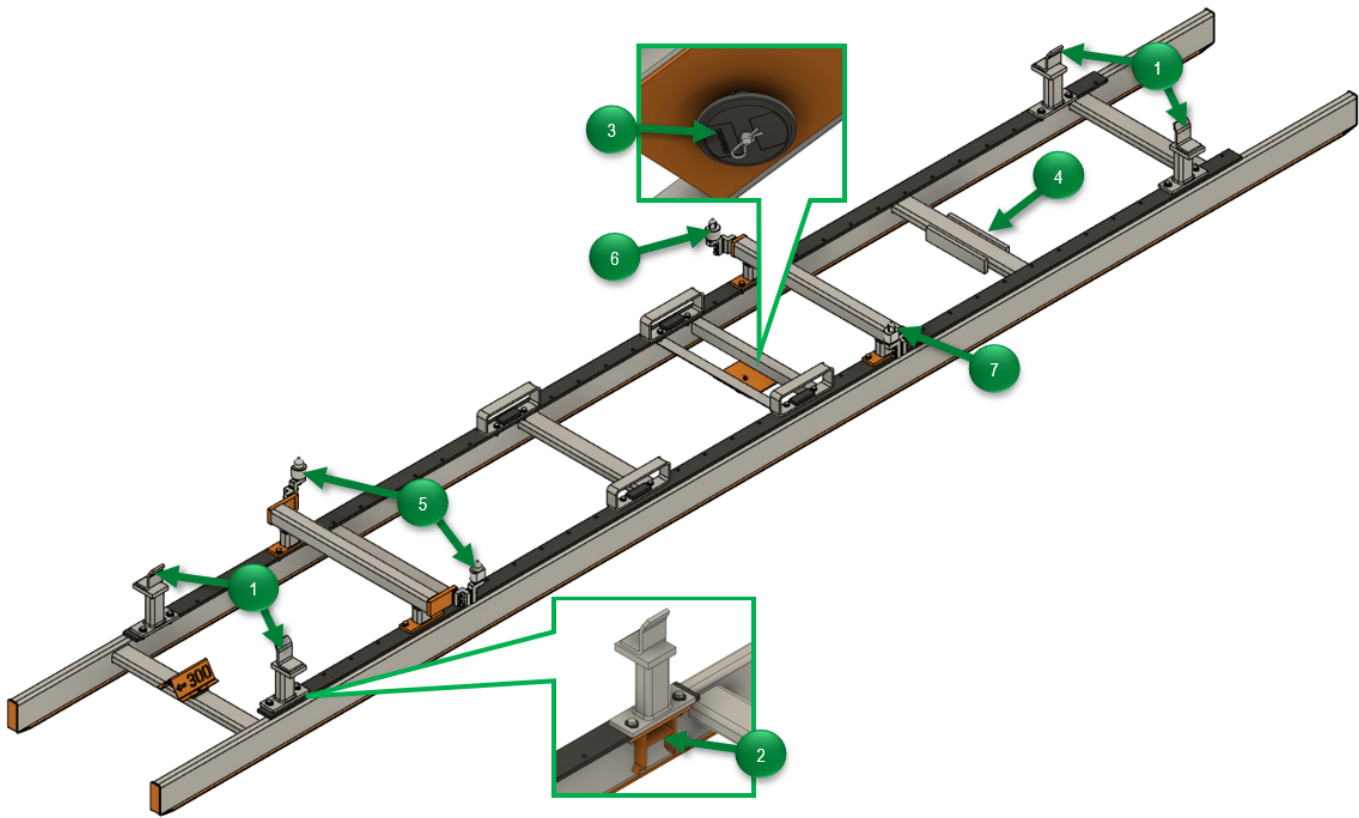
Mechanical Preventive Maintenance - key

Preventive Maintenance tables consists of:

A	B	C	D	E
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.

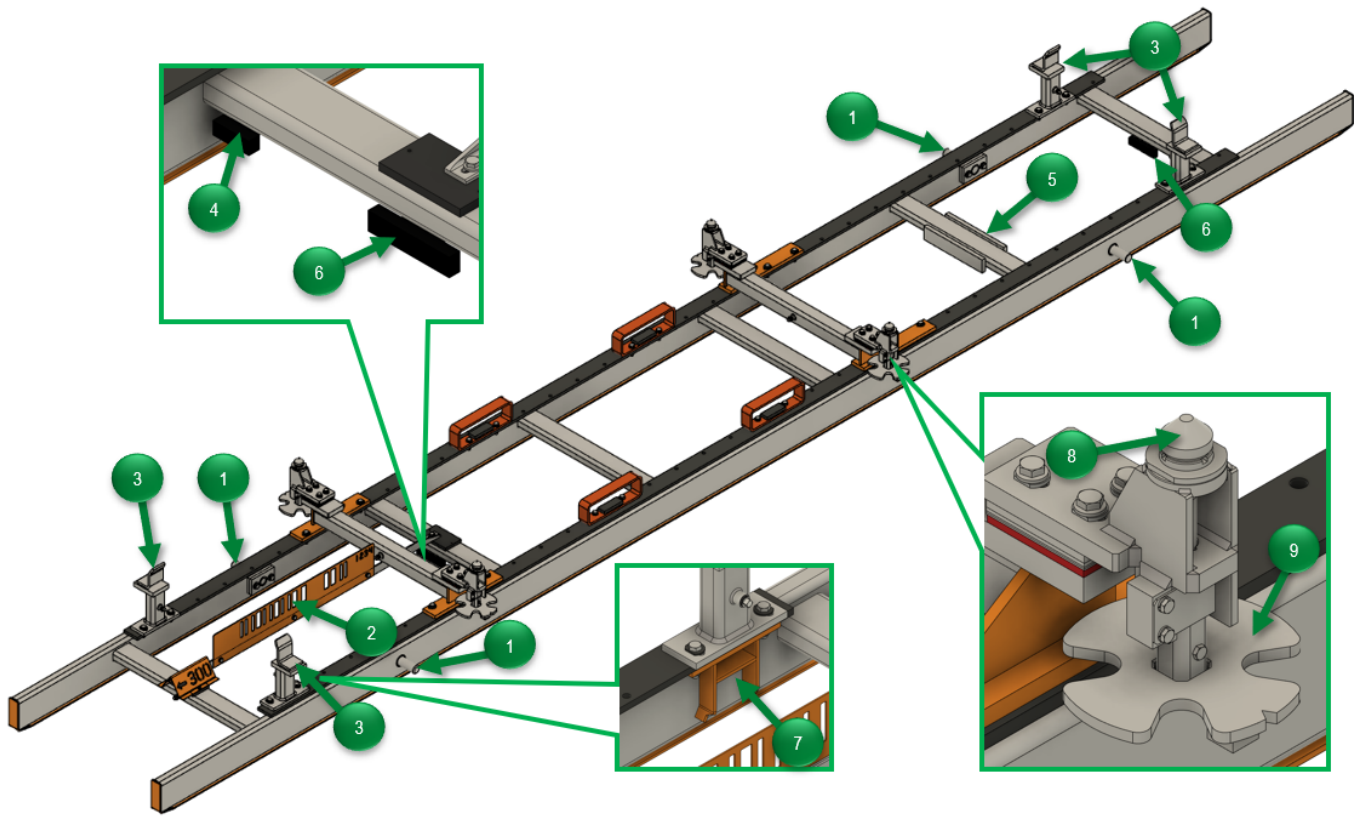
Paint Skid Preventive Maintenance



Item No.	Item Name	Required Operation	Description	Interval
-	Paint Skid	Wash Cycle	<ul style="list-style-type: none"> Direct the skid to the Dip Skid Washing Station and complete the Washing Cycle. 	1 Month
-	Fasteners	Inspection	<ul style="list-style-type: none"> Verify all fasteners are secure and torque tightened. 	6 Months
1	Skid Stacking Rest Pads	Inspection	<ul style="list-style-type: none"> Check for excessive damage and replace if necessary. 	
2	Skid Stacking Guide	Inspection	<ul style="list-style-type: none"> Check if guide is bent and correct if necessary. 	
3	RFID Puck	Inspection	<ul style="list-style-type: none"> Verify the correct skid number is assigned. Check for excessive damage and replace if necessary. 	
4	Positioner Strike Plate	Inspection	<ul style="list-style-type: none"> Check for excessive damage and replace if necessary. 	
5	Product 4-Way Pin	Inspection	<ul style="list-style-type: none"> Check for excessive damage and replace if necessary. 	

Item No.	Item Name	Required Operation	Description	Interval
6	Front Product 2-Way Pin	Inspection	<ul style="list-style-type: none"> • Verify pin is facing front/rear. • Check for excessive damage and replace if necessary. 	6 Months
7	Rear Product 2-Way Pin	Inspection	<ul style="list-style-type: none"> • Verify pin is facing cross product. • Check for excessive damage and replace if necessary. 	

Dip Skid Preventive Maintenance



SKIDS – PREVENTIVE MAINTENANCE

Item No.	Item Name	Required Operation	Description	Interval
-	Dip Skid	Wash Cycle	<ul style="list-style-type: none"> Direct the skid to the Dip Skid Washing Station and complete the Washing Cycle. 	1 Month
-	Fasteners	Inspection	<ul style="list-style-type: none"> Verify all fasteners are secure and torque tightened. 	6 Months
1	Pendul Pins	Inspection	<ul style="list-style-type: none"> Check that pins are straight and free from buildup. Remove buildup if necessary. 	
2	Smart ID	Inspection	<ul style="list-style-type: none"> Verify the Smart ID Tag number matches the skid number. Check for excessive damage and replace if necessary. 	
3	Skid Stacking Rest Pads	Inspection	<ul style="list-style-type: none"> Check for excessive damage and replace if necessary. 	
4	Anti-Backup	Inspection	<ul style="list-style-type: none"> Check for excessive damage and replace if necessary. 	
5	Positioner Strike Plate	Inspection	<ul style="list-style-type: none"> Check for excessive damage and replace if necessary. 	
6	Inlet Pusher Strike Plate	Inspection	<ul style="list-style-type: none"> Check for excessive damage and replace if necessary. 	

Item No.	Item Name	Required Operation	Description	Interval
7	Skid Stacking Guide	Inspection	<ul style="list-style-type: none"> Check if guide is bent and correct if necessary. 	6 Months
8	Locking Pin	Inspection	<ul style="list-style-type: none"> Verify proper movement when Clover Leaf is engaged. Complete full revolution to test. Check for excessive buildup and remove as needed. 	
		Procedure	<ul style="list-style-type: none"> Each Pin must be reconditioned to ensure proper function. <i>(See Dip Skid Locking Pin Conditioning Procedure)</i> 	12 Months
9	Clover Leaf	Inspection	<ul style="list-style-type: none"> Check for excessive damage and replace if necessary. Check for excessive buildup and remove as needed. Confirm weldment block is facing external when Locking Pin is in open position. 	6 Months