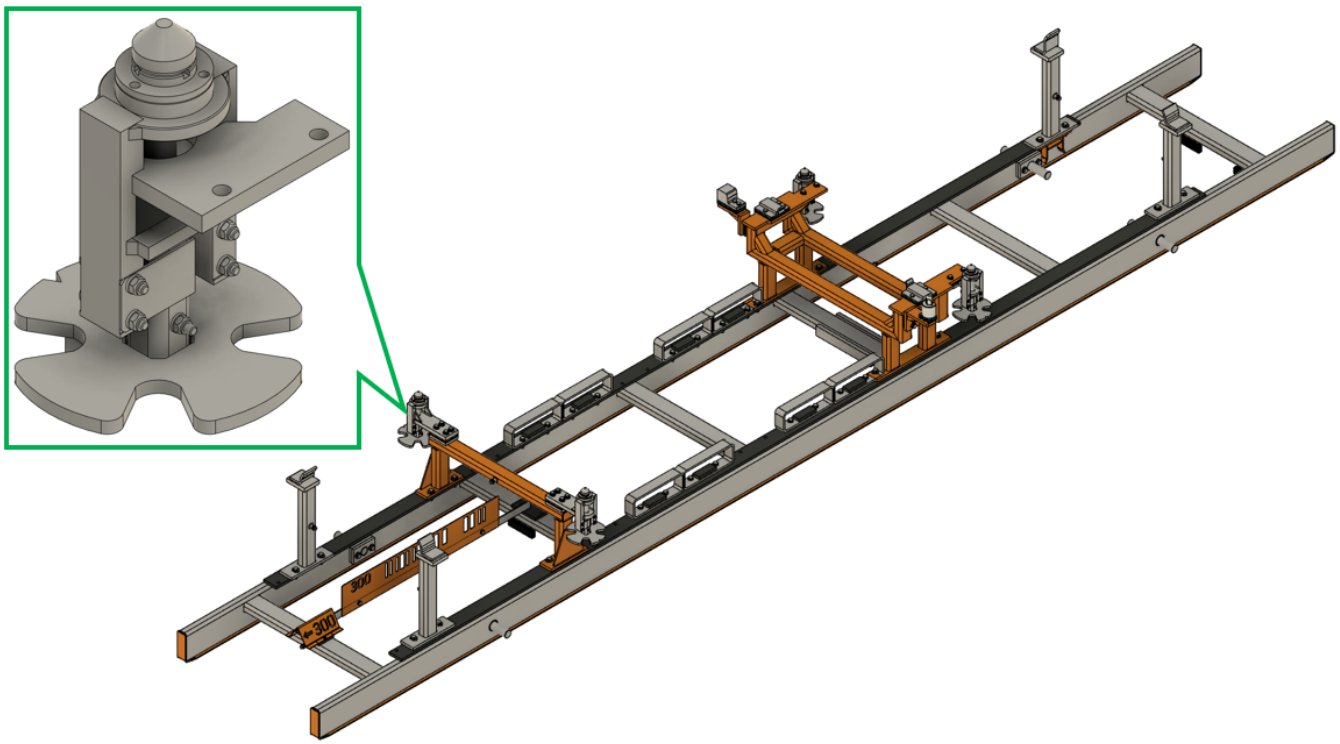
FATA AUTOMATION

Dip Skid Locking Pin Conditioning Procedure

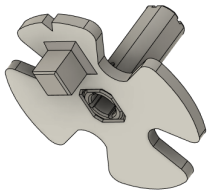
Service Instructions

Project #C20101 | 2025 Edition

Dip Skid Locking Assembly



Dip Skid Locking Assembly Spare Parts

Clover Leaf	Locking Pin
1	2
	
FATA Part: 6002557	***FATA Part: 6002558***

Dip Skid Locking Assembly Preventive Maintenance

Item No.	Item Name	Required Operation	Description	Interval
1	Clover Leaf	Inspection	• Verify clover leaf can properly actuate with Lock Operators. Remove excessive build-up if necessary.	**6 Months**
2	Locking Pin	Inspection	• Verify free movement for full rotation.	
		Procedure	• Each Pin must be reconditioned to ensure proper function. (***See Dip Skid Locking Pin Conditioning Procedure***)	**12 Months**

Dip Skid Locking Assembly

⚠ WARNING ⚠

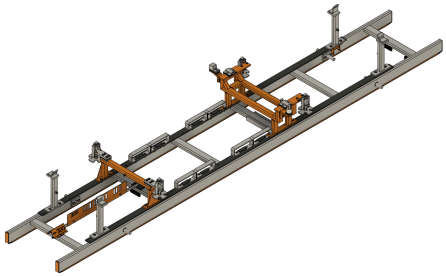
- Only qualified and trained personnel should perform the disassembly and assembly of electrical and mechanical components.
- Before attempting any maintenance on this equipment, all involved personnel should follow plant internal regulations along with any state, federal, or province regulations. Do not begin any repair procedure until the proper shutdown procedures and the appropriate power lockout procedures have been applied.

Dip Skid Locking Pin Conditioning Procedure

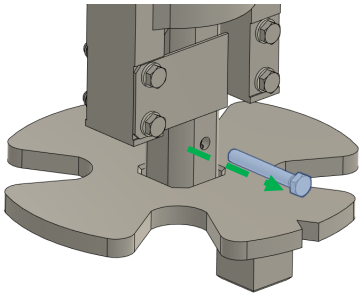
⚠ CAUTION ⚠

This procedure must be completed for all Dip Skids in production at least once per year to ensure proper functionality. Failure to follow the outlined conditioning steps may cause the locking pin to operate improperly, leading to potential safety concerns and operational delays. It is essential to complete this process within the specified time frame to prevent any disruptions in production.

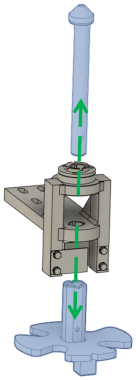
1 Direct the Dip Skid to be removed from production and transferred to the repair area.



2 Remove the M6 hex-head bolt at the base of the Locking Assembly and set aside to use later. This will now free the Clover Leaf and Locking Pin.

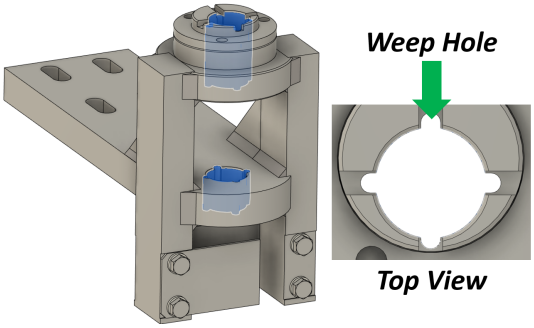


3 Remove the Clover Leaf and Locking Pin from the Locking Assembly and set aside.



DIP SKID LOCKING PIN CONDITIONING PROCEDURE

4 Clean the inner housing and Weep Holes of the Locking Assembly using a flapper wheel to remove all buildup.

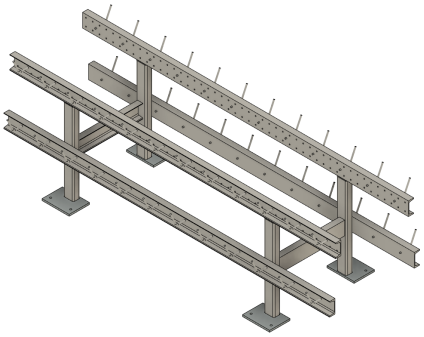


5 ***Gently*** sand the Locking Pin to remove any buildup. ***Avoid using excessive force as it may damage the metal.***

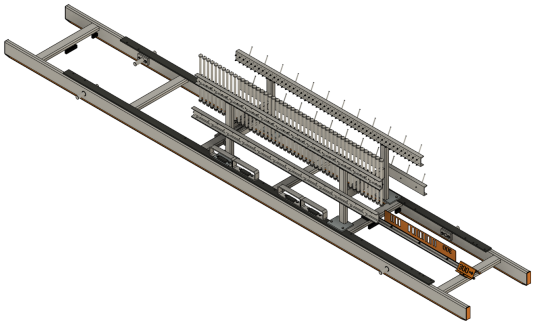
6 Repeat steps 2-5 to remove all other Locking Devices from the Dip Skid.

NOTE *It's recommended that multiple sets of Dip Skid Locking Pins be prepared as a large quantity can complete the conditioning process.*

7 Mount and secure the Dip Skid Parts Rack onto an available Dip Skid.

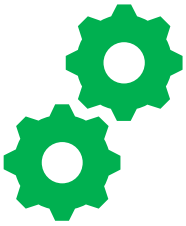


8 Secure all available cleaned Locking Pins to the Dip Skid Parts Rack using the original fasteners.

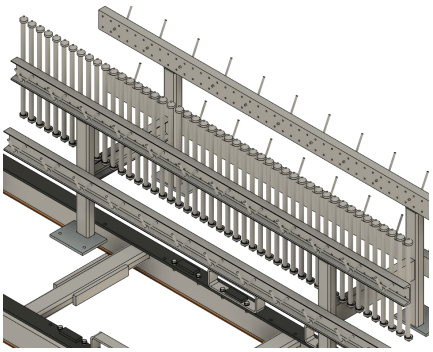


8 Return the Dip Skid with secured Locking Pins to production. Track the skid as it completes the ***Pretreatment***, ***E-Coat***, and ***Baking*** processes.

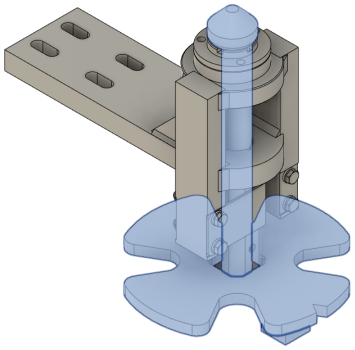
Remove from production after completion and return to the skid to the repair area.



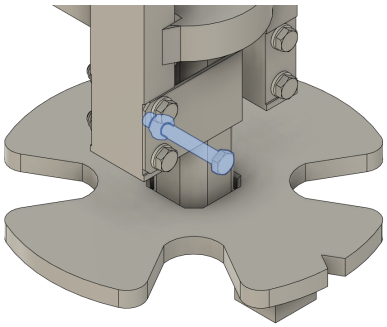
9 Remove the secured Locking Pins from the skid.



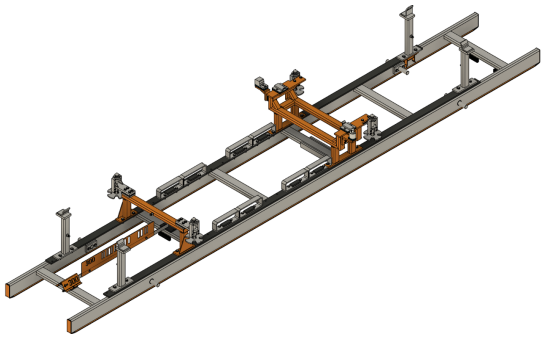
10 Return the Locking Pin and Clover Leaf to the Locking Device.



11 Secure the Locking Pin and Clover Leaf with a new M6 hex-head bolt and washer. ***Do not reuse original fasteners.***



12 Verify that each Locking Pin and Clover Leaf properly functions and return to standard production.



FATA AUTOMATION

Do You Have Service Questions or Need Spare Parts?

(248) 724-7660

service@fatainc.com
spareparts@fatainc.com

2333 E Walton Blvd. Auburn Hills, MI 48326
www.fataautomation.com