

# Pneumatic Hold Table 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:

### Pneumatic Hold Table

#### 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.

##### Evaluation

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

##### Act

- Schedule or perform necessary maintenance repairs as appropriate.

##### Service Immediately

- Sudden loss of pneumatic cylinder speed/power, excessive end-stroke impact despite cushion adjustment, or visible rod seal leakage, require immediate service.

## Mechanical Preventive Maintenance - Key

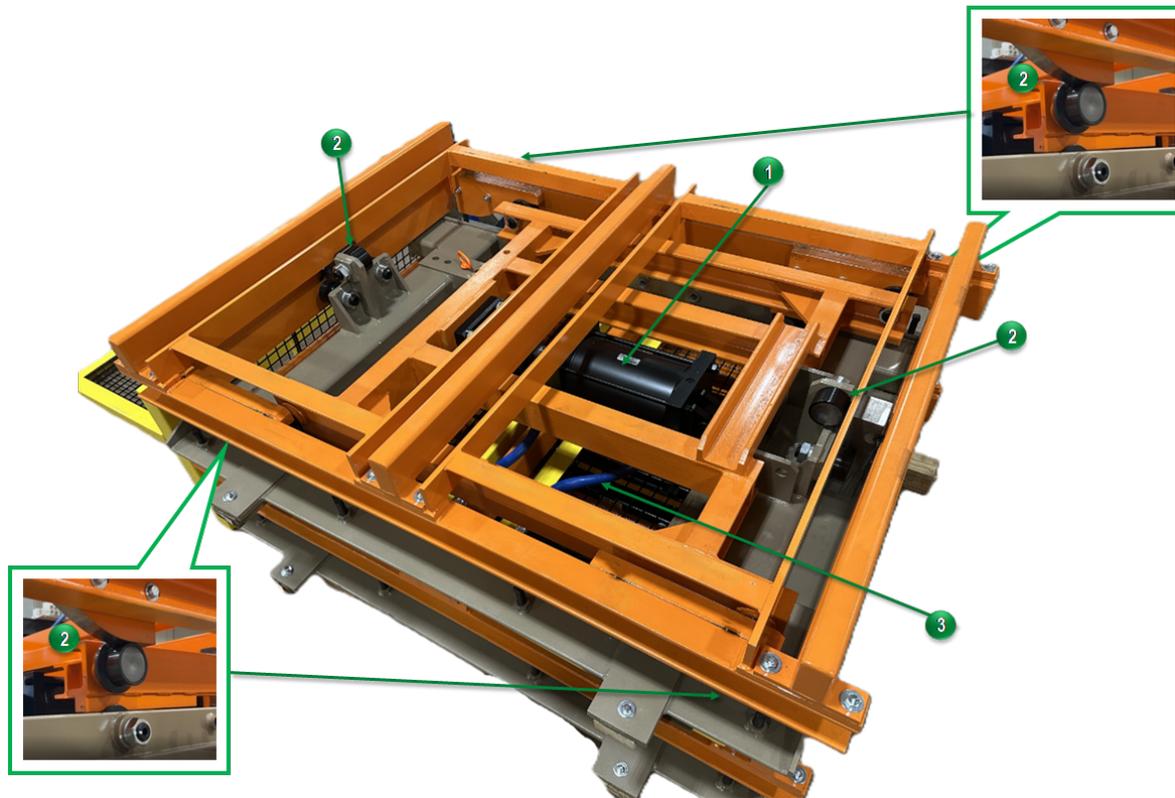
Preventive Maintenance tables consist of:

A
B
C
D
E

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

- 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.

## Pneumatic Hold Table - Preventive Maintenance Items



Item No.	Item Name	Required Operation	Description	Interval
1	Pneumatic Cylinder	Inspection	<ul style="list-style-type: none"> <li>Clean piston rod and wiper seal with lint-free cloth. Replace it if worn.</li> </ul>	<b>3 Months</b>
		Inspection	<ul style="list-style-type: none"> <li>Check seals for leakage or dust bypass.</li> </ul>	<b>3 Months</b>
		Inspection	<ul style="list-style-type: none"> <li>Inspect and verify proper cylinder alignment with load and check mounts for wear.</li> </ul>	
		Inspection, Adjustments and Replacement	<ul style="list-style-type: none"> <li>Inspect piston rod for scoring, or uneven wear.</li> <li>Re-torque end cap bolts to manufacturer specifications.</li> <li>Replace full seal kit (rod, piston, wear bands, cushion seals).</li> <li>Clean bore and piston surfaces if disassembled.</li> </ul>	<b>Annually (8,000 to 10,000 Hours)</b>
2	Cam Rollers	Inspection	<ul style="list-style-type: none"> <li>Check for steady running, wear or damage.</li> </ul>	<b>3 Months</b>
3	Air Lines	Inspection	<ul style="list-style-type: none"> <li>Examine airline connections for signs of wear, cracks, abrasions, or leaks.</li> <li>Check for secure attachment to cylinder.</li> </ul>	<b>3 Months</b>