

## Preventative Maintenance (Technical Schedule)

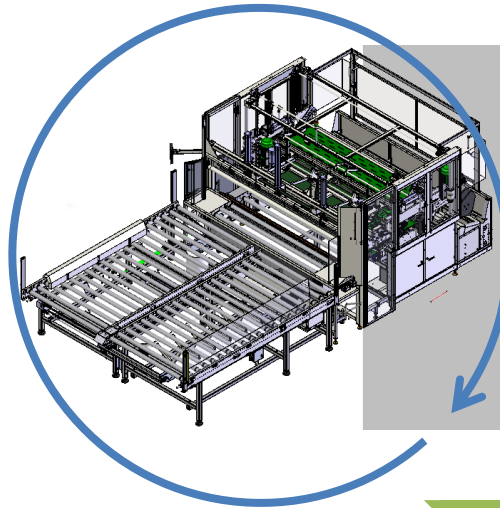


1. POWER DOWN AND LOCK-OUT THE ELECTRICAL AND THE PNEUMATIC POWER SOURCES ON THE MACHINE.
2. WAIT UNTIL SEAL BARS COOL OFF SUFFICIENTLY (APROX. 3 HOURS) BEFORE SERVICING THE SEAL BARS OR THE NEARBY AREAS OF THE MACHINE.

DAY WEEK MONTH

Safety is First Priority! Follow all Lockout/tagout procedures, before working on machine

## 1306FF Roll Pack Workstation

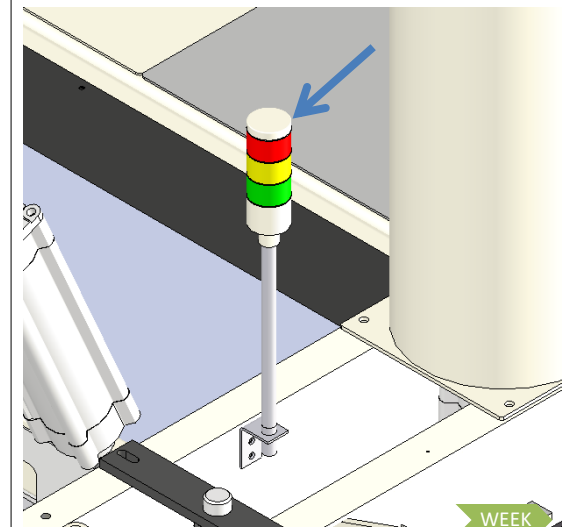


WEEK

1. Check for unusual noises and or air leaks.
2. Proceed with general cleaning of machine

## Frequency

DAY WEEK MONTH



WEEK

3. Check to see that Light tower functions properly.



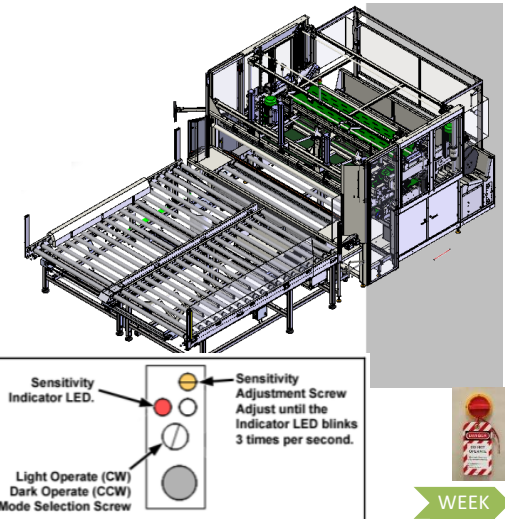
WEEK

4. Check screen operation, never use anything sharp to touch screen surface.



WEEK

5. Check air filter, drain condensation and replace as needed.



WEEK

6. Check and clean photo eyes and reflective tape in all feed area. Replace tape if damaged.

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Frequency

DAY WEEK MONTH



WEEK

6. a. Check and clean Laser eyes on both sides of in-feed conveyor.



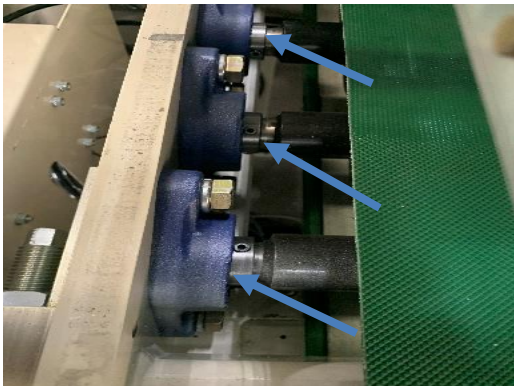
WEEK

6. b. Check, align and clean conveyor belts and chain. Lubricate chain, bearings.



WEEK

7. a. Clean area around conveyor belts, check all set-screws and lubricate bearings.



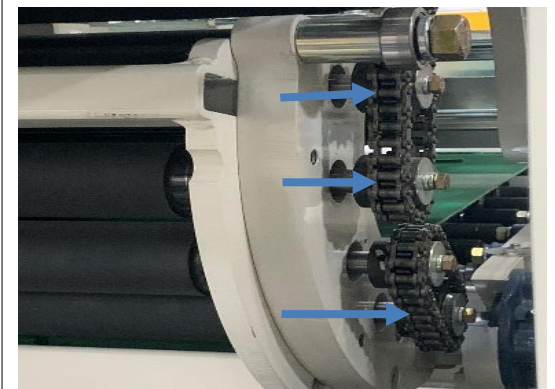
WEEK

7. b. Lubricate roller bearing, check all set screws. Each end of top and bottom conveyors.



caution WEEK

7. c. Lubricate roller bearing, gears, gear rack and check all set-screws. Upper Conveyor.



caution WEEK

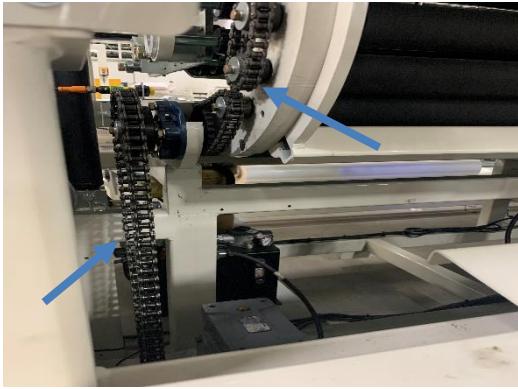
7. d. Lubricate chains, gears and check all set-screws on each end of rolling chamber.

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1306FF Roll Pack Workstation

Frequency

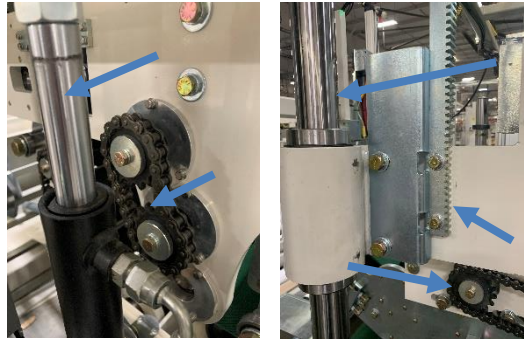
DAY WEEK MONTH



caution

WEEK

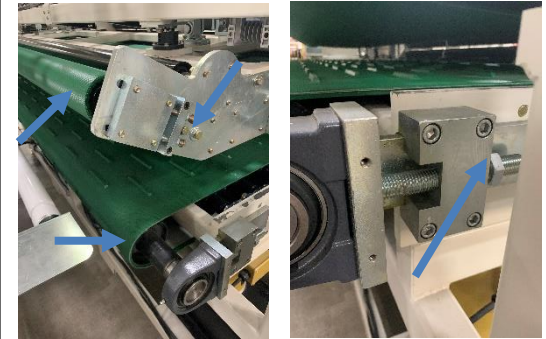
7. e. Lubricate chains, bearing and check set-screws on opposite side of rolling chamber.



caution

WEEK

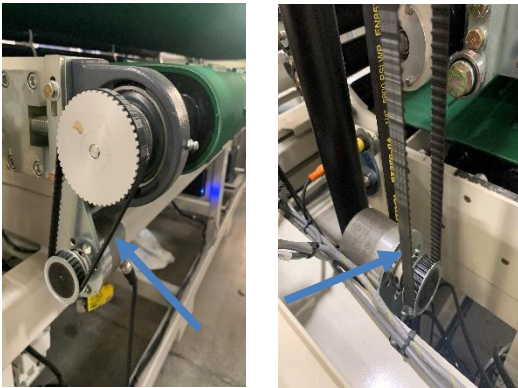
7. f. Clean, lube chains & bar guides, do not touch with bare hands. Check all set-screws.



caution

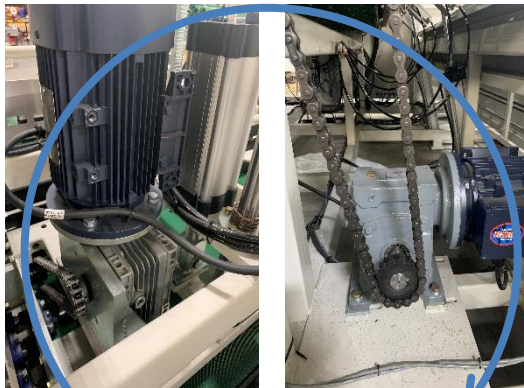
WEEK

8. Check the alignment and tension of the belts. Make sure they are tracking properly.



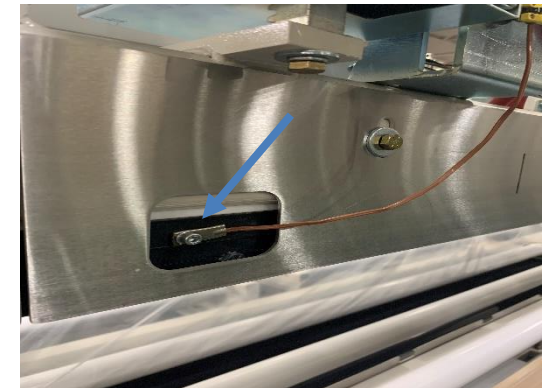
WEEK

9. Check gear set-screws, belt alignment and tension on encoders. Run and check tracking.



WEEK

10. Check sprocket set-screws, chain alignment and tension on all gear box drive motors.



caution

WEEK

11. Check tightness of thermocouple and clean seal bar, when cool with clean rag and WD-40

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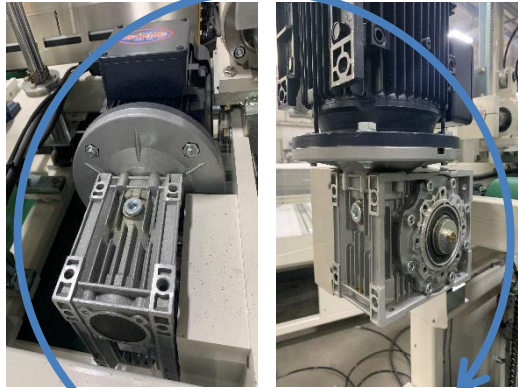
### VERY Important Message:

Upper seal bars have a coating of PTFE which is a non-stick material. Use extreme caution when inspecting seal bars. If everything looks perfect DO NOTHING. If this Teflon material is scratched or torn in some areas, it will cause buildup on the seal bar. If this happens, a clean thick rag with WD-40 sprayed on it, should be used to wipe the seal bar to keep it clean. By doing this it will prevent buildup and burn through.



11. a. Use extreme caution, when cleaning. Never clean when "HOT" !

### 1306FF Roll Pack Workstation



12. Check gear cases for proper oil level on upper and lower conveyor assemblies

Frequency



13. Check for leaks, proper pressure and hydraulic oil level in reservoir. Fill as required.

Additional Maintenance List or Notes:

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### \*\* Warning \*\* Never for any reason

- Enter Inside the machine
- Crawl under the machine
- Climb on top of the machine
- Reach inside the machine
- Place any body parts inside the machine

After pressing the start button, the infeed belts will run continuously and will automatically process materials or products

### \*\* Warning \*\* Never for any reason

Perform any machine maintenance unless the machine is properly powered down and cool.

Lockout/tagout procedures must be followed.

In manual mode, machine may be prompted to execute any of its functions. Only a properly trained operator or technician should work on or use the machine in manual mode of operation to prevent injury or machine damage.