
	GILES CHEMICAL ~ PREMIER MAGNESIA		
	Company Procedure		
	Title: PM Autopouch Line #2	Number: M13-PR-200-029	
	Owner: Lee Cagle	Revision: 01	
	Effective Date: 07/25/2014	Page: 1 of 2	

1.0 Purpose

This procedure establishes the requirements for monthly preventive maintenance for Autopouch Line #2.

2.0 Scope

This procedure applies to Autopouch Line #2 at the Repackaging Facility. This procedure shall be performed monthly at a minimum or as necessary.

3.0 Responsibility

Maintenance will lead PM of machines with assistance of assigned production employees.

4.0 Safety Considerations

All Contractors/Service Personnel are expected to observe all safety rules and regulations while on Giles Chemical property.

Safety is a condition of employment. Employees are not authorized to work in an unsafe manner and are prohibited from harming the environment of the facility or community.

5.0 Materials/Equipment

- Tools necessary for PM of Autopouchers
- Tools necessary for PM of Weight Checker
- Tools necessary for PM of Conveyor
- Tools necessary for PM of Tapers



6.0 Procedure

Auto Pouch #2 Machine

1. Clean out all-fill and wash out with water (remove cups and bottom plate...**Note: Do not allow motor to get wet!**)
2. Steam clean gripper arm and all linkages connecting gripper arms.
3. Clean all vacuum filters (be careful they will break).
4. Check all vacuum cups for defects
5. Grease all fittings on top and bottom and on cams
6. Replace all grease caps on fittings
7. Wash down machine using water on all stainless parts

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8. Clean door and all Plexiglas panels with clean water only
9. Inspect tape on sealing and cooling bars and replace as necessary
10. Inspect discharge belt to ensure there is no salt under belt, it is tracking properly, and tension is appropriate to maintain proper operation.
11. Inspect floor and clean all salt from under machine and all-fill stand.

Weight Checker

1. Clean all rollers removing all salt.
2. Check belts on all 3 sections of machine (in feed, middle weight, and exit).
3. Make sure all salt is out from under conveyor including load cell on middle section.
4. Clean around all air and electrical connections.
5. Check chain on conveyor and use air to blow out chain.

Conveyor

1. Check belt connector wires for proper connection and repair and/or replace if necessary.
2. Clean salt and trash from around end roller.
3. Check drive chain and grease/oil as required for proper operation.

Tape Machine

1. Check knives and clean.
2. Oil pads that knives stop on.
3. Clean up and blow out all trash from machine.
4. Check all springs to see if they are in proper operating condition and operating properly.
5. Check drive belts for wear (if worn bad replace them).

7.0 Reference Documents

PM Autopouch Line #2 form (M13-PR-200-F029)

8.0 Change Information

Combined documents *PM Autopouch #2 (M13-PR-200-029)*, *PM Conveyor (M12-PR-200-020)*, *PM Weight Checker (M13-PR-200-033)* and *PM Tape Machines (M13-PR-200-034)* to make a PM procedure for the line, changed the frequency which PM is to be performed and changed the name of the procedure.

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