
	GILES CHEMICAL ~ PREMIER MAGNESIA		
	Company Procedure		
	Title: PM Manual Line(s)	Number: M13-PR-200-035	
	Owner: Lee Cagle	Revision: 01	
	Effective Date: 07/24/2014	Page: 1 of 2	

1.0 Purpose

This procedure establishes the requirements for the monthly preventive maintenance for Manual Lines #1, #2, and #4.

2.0 Scope

This procedure applies to the manual lines #1, #2, and #4 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 manual lines
- Tools necessary for PM of taper



6.0 Procedure

AMS

1. Remove fill funnel from AMS and clean
2. Remove auger from AMS and clean
3. Remove adapter piece from AMS and clean
4. Remove cover from top of AMS and blow out with air and check to ensure drive belt is in proper condition and tensioned correctly
5. Remove cover from front of AMS and oil chain if needed (lightly).
6. Blow AMS motor fan out with air.
7. Replace all covers removed in prior steps.

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Sealers

1. Blow off machine
2. Remove Top plate(s) on in-feed rail
3. Lower in-feed rail
4. Check seal belts for wear or improper tracking
5. Clean in-feed rail with steam cleaner and then finish by blowing off with air
6. After cleaning, reverse steps to re-install rails
7. Replace top covers on rail
8. Open front control panel with screwdriver, blow off with air, and then reinstall
9. If speed controllers are available on sealer check to ensure they are not loose on motor

Video Jet Date Coder

1. Check hours on machine
2. Change cartridge as needed
3. Contact vendor for any maintenance needs

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 Manual Lines (M13-PR-200-F035)

8.0 Change Information

Combined documents *PM Manual Lines (M13-PR-200-035)* and *PM Tape Machines (M13-PR-200-034)* to make a PM procedure for the line as well as changed the frequency for the PM to be performed.

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