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|  | GILES CHEMICAL ~ PREMIER MAGNESIA | |  |
| | Company Procedure | | |
| | Title: PM Autopouch Line #7 | Number: M18-PR-200-064 | |
| | Owner: Thomas Evans | Revision: 00 | |
| | Effective Date: 02/16/18 | Page: 1 of 2 | |

1.0 Purpose

This procedure establishes the requirements for monthly preventive maintenance for Autopouch Line #7.

2.0 Scope

This procedure applies to Autopouch Line #7 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 autopouch
- Tools necessary for PM of conveyor(s)
- Tools necessary for PM of taper(s)



6.0 Procedure

Auto Pouch #7 Machine

1. Remove and Clean pull belts (quantity of 2).
2. Clean all film feed rollers.
3. Clean all zipper feed rollers.
4. Clean print head on Video Jet date coder (Isopropyl Alcohol only).
5. Check air lines for any noticeable leaks or cracks. Repair and/or replace as needed.
6. Check all drive and timing belts for wear. Replace if needed.
7. Clean seal bars and change Teflon tape.
8. Clean pan on top of machine under platform.
9. Check leakage on scale (above platform toward machine).
10. Clean and blow down scale on top of machine.

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Conveyor(s)

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.

Metal Detector

1. Check plastic belt for wear or broken links. Replace as necessary.
2. Clean and blow out salt from around end rollers and inside detection tunnel.
3. Check air lines for leaks or cracks. Repair and/or replace as necessary.

Combi Case Erector and Case Sealer

1. Clean salt dust and corrugate dust from inside case erector and sealer.
2. Check all filter regulators for correct labeled psi air pressure and drain water if needed.
3. Check and clean all vacuum generators and filters.
4. Check vacuum cups for visible wear and tears. Replace if cracked or worn.
5. Check for loose belts on belt drives. Tighten if needed. Tensioning procedure in Combi Operating Manual if needed.
6. Clean salt and trash from around end rollers on white plastic product conveyor belt and black packing conveyor belt.
7. Check all air lines for cracks, leaks, or kinks. Replace if needed.
8. Clean all photo eyes and reflectors. Do not use solvent based cleaners.
9. Clean all threaded adjustment rods with mild cleaning solution.
10. Lube all grease fittings.
11. Check all bolts and fasteners for looseness. Tighten as needed.
12. Clean and wipe down all doors and components.
13. Check tape knives and clean.
14. Oil pads that knives stop on.
15. Check all springs to see if they are in proper operating condition and operating properly.

7.0 Reference Documents

PM Autopouch Line #7 form (M18-PR-200-F064)

8.0 Change Information

New Document

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