
	GILES CHEMICAL ~ PREMIER MAGNESIA		
	Company Procedure		
	Title: PM Carton Machine Line	Number: M13-PR-200-040	
	Owner: Lee Cagle	Revision: 01	
	Effective Date: 07/26/2014	Page: 1 of 2	

1.0 Purpose

This procedure establishes the requirements for the monthly preventive maintenance for the Carton Machines.

2.0 Scope

This procedure applies to the Carton Machines 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 Carton Machines
- Tools necessary for PM of Weight Checker
- Tools necessary for PM of Tape Machine



6.0 Procedure

Carton Machines

1. Cover all sensitive/electronic component areas before washing down
2. Underneath machine clean with water
3. After cleaning both machines-remove all mats on the floor and platform-spray floor and platform with cleaning solution-take a course broom and scrub the floor and platform good-removing all grease between carton machine #1 and carton machine #2
4. Squeegee the floor to remove all standing water
5. Clean trench and drain out and remove all trash and wood from sump pit.
6. Grease all bearings underneath both machines with proper lubricant
7. Wash outside of machines s/s parts
8. Clean heater heads on top seal jaw area
9. Clean all salt and trash from conveyors and both drive motors and packing areas
10. Final sweep of floor
11. Clean blower intake filter.

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12. Check auto lube.
13. Check chain lube.
14. Check grease in drives and carriage.
15. Check air oil level.
16. Grease conveyor at 90° bends and ends; also check for salt build up at push table (clean and wash).
17. Grease un-loader on machine.
18. Grease all fittings on machine.

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.

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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 Carton Machine Line (M13-PR-200-F040)

8.0 Change Information

Combined documents *PM Carton Machines Part 1 (M13-PR-200-039)*, *PM Carton Machines Part 2 (M13-PR-200-040)*, *PM Weight Checker (M13-PR-200-033)* and *PM Tape Machines (M13-PR-200-034)* to make a PM procedure for the line as well as changed the frequency for PM to be performed and changed the title of the document.

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