
	<b>GILES CHEMICAL ~ PREMIER MAGNESIA</b>		
	<b>Company Procedure</b>		
	Title: <b>PM Combi Pack Station</b>	Number: <b>M16-PR-200-060</b>	
	Owner: <b>Thomas Evans</b>	Revision: <b>00</b>	
	Effective Date: <b>03/08/2016</b>	Page: <b>1 of 2</b>	

## 1.0 Purpose

This procedure establishes the requirements for monthly preventive maintenance for Combi Pack Station(s).

## 2.0 Scope

This procedure applies to Combi Pack Station(s) 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 case erector
- Tools necessary for PM of conveyor(s)
- Tools necessary for PM of taper/gluer



## 6.0 Procedure

### Combi Pack Station

1. Clean salt dust and corrugate dust from inside case erector.
2. Check all filter regulators for correct labeled psi and drain water if needed.
3. Check vacuum cups for visible wear and tears. Replace if cracked or worn.
4. Check for loose belts on belt drive. Tighten if needed. Tensioning procedure in Combi Operating Manual if needed.
5. Check all air line for cracks, leaks, or kinks. Replace if needed.
6. Clean all photo eyes and reflectors. Do not use solvent based cleaners.
7. Clean all threaded adjustment rods with mild cleaning solution.
8. Check mufflers on main valve bank. Replace or clean if dirty.
9. Lube all grease fittings.

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10. Check all bolts and fasteners for looseness. Tighten as needed.
11. Clean and wipe down all doors and components.

### **Conveyor**

1. Clean conveyor chain(s) with a mild cleaning solution.
2. Clean salt and trash from around end rollers.
3. Check drive chain and lubricate as required for proper operation.

### **Tape Machine**

1. Check all air lines for cracks, leaks, or kinks. Replace if needed.
2. Clean off photo eyes and reflectors.
3. Clean all threaded adjustment rods with a mild cleaning solution.
4. Check knives and clean.
5. Oil pads that knives stop on.
6. Clean up and blow out all trash from inside and under machine.
7. Check all springs to see if they are in proper operating condition and operating properly.
8. Check drive belts for wear (if worn bad replace them).
9. Clean any glue from belts and compression rollers.
10. Clean and inspect glue nozzles.
11. Clean and wipe down all doors and components.
12. Check all bolts and fasteners for looseness. Tighten as needed.

## **7.0 Reference Documents**

*PM Combi Pack Station form*

*(M16-PR-200-F060)*

## **8.0 Change Information**

New Document

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