
	GILES CHEMICAL ~ PREMIER MAGNESIA		
	Company Procedure		
	Title: PM Autopouch Line #3	Number: M14-PR-200-052	
	Owner: Lee Cagle	Revision: 01	
	Effective Date: 07/24/2014	Page: 1 of 2	

1.0 Purpose

This procedure establishes the requirements for monthly preventive maintenance for Autopouch #3 line.

2.0 Scope

This procedure applies to Autopouch #3 line 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 scales
- Tools necessary for PM of autopouchers
- Tools necessary for PM of tapers



6.0 Procedure

Scale

1. Clean scales out (all salt from vibrators & clean all pans and buckets).
2. Clean fill switch in Flexicon, remove all buckets and pan.
3. Check all linkages on buckets for wear (round nylon bushing).
4. When remounting buckets make sure that they are on bracket mounts good before trying to run the scales.
5. Check mounting brackets on bottom of pan to make sure they're not broken.
6. Make sure all salt is out from underneath machine and around scale stand.

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Auto Pouch #3 Machine

1. Clean up all salt inside and out.
2. Clean gripper jaws.
3. Check vacuum cups for wear and replace as necessary.
4. Check vacuum lines for dust and blow out any trash or dust that is noticeable.
5. Change all vacuum filters.
6. Check all bearings for sticking/ not moving freely, if sticking replace as necessary (bolt size on mounting bearings are M3X20 SHCS A-2 and will be located in the PM box labeled Auto 3).
7. Grease all grease fittings inside the cabinet with food grade grease and wipe off any excess grease.
8. In back of cabinet, where cams are located, use Extreme grease on cam, Red grease on fitting, Chain Lube on all chains, and check the springs for wear.
9. Change Teflon tape on seal bars and cooling bars.
10. Check all door switches for salt build-up and blow them out with compressed air.
11. Check the drive belt on the conveyor for wear and replace as necessary.
12. Check leakage on scale.
13. Drain water from air tank in the back of the cabinet.
14. Wash with diluted Dawn detergent; do not get electrical switches wet.

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 #3 Line form (M14-PR-200-F052)

8.0 Change Information

Combined documents *PM Autopouch #3 (M14-PR-200-052)* and *PM Tape Machines (M13-PR-200-034)* to make a PM procedure for the line.

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